



We missed a couple issues. My daughter, Emily, got married so I had to take some time off and go to Hawaii.

A young filer with a great question

At the 2012 Western saw filers meeting I had lunch with a group of people including a young saw filer, Hector Torres, who works for John Owens at Warm Springs Forest Products.

He saw Carbide Processors on my name tag so he asked a carbide question. His question was about round saws where every so often some of the tips, just on one side of the blade, would have little chips out of the corner. This was more an operations question than a carbide question so we referred it to couple of guys near by. Before too long, the young filer was talking to Burl Swinger, Norm Brown and Mike West. These three have a tremendous amount of experience and were happy to help a young filer. They pretty well decided that it was not a filing issue. Their best guess was that the saw blade was occasionally hitting one of the prongs on a feed chain. I see two lessons in this. Over the years I have heard some great questions from some young filers at Warm Springs. This is obviously an organization that hires bright people and encourages them to think. The other thing is that there is an answer to almost every filing question if you just know who to ask. What saw filer groups do best is put people in touch with other people who know the answers to their problems."

How We Help People

Emily just helped a customer who wanted a source for second hand knife grinders. That is not us but we did know a few folks who could help him. We gave him those names even though a couple are really our competitors.

Carbide Processors, Inc.

Northwest Research Institute, Inc.

Newsletter January 2013

3847 S. Union Ave. Tacoma, WA. 98409 (800) 346-8274

sales@carbideprocessors.com www.carbideprocessors.com

2nd Annual Mike West Saw Filer Fishing Trip - Westport, WA



Whitney from Carbide Processors & Jimbo Davis – 2012 Trip
Email Mike West for details
westwm@chwa.com

New Promo Item



Hard Hat Light See P.3

ISKA Meeting

March 1 in Nashville

A truly excellent program on financial management – You really need to attend. (More P. 4)

Get a custom hammer at a discount

February only – 10% off any custom hammer from Dan Lines – Call Emily
800 346-8274
sales@carbideprocessors.com

Dan's hammers are so good that even people who get free hammers from Simonds want a Dan Lines custom hammer.

Notes:

1. This offer is only through Carbide processors.
2. I don't know how Simonds decides who gets free hammers. You have to ask them.

Top Quality Carbide at the Very Best Prices Anywhere

We don't sell cheap carbide because it is not dependable. Some batches work and some do not.

Carbide is a pretty small part of any operation. If you bought the cheapest, crappiest carbide you could find you would never save enough to pay for the lost customers and extra downtime.

Free Saw Filer Advertising

We will advertise your sawfiler meeting free. Just let us know when where and who to contact.

We also have a postcard program we have been doing for the WSFEA and CWSFEA. We design, print and mail meeting notice postcards - all at our expense. We start the mailings early so people get multiple cards, about one a month works best. This significantly increases attendance. We also mail to Mill Managers so that they understand the value of sending filers and paying for the trip.

How Can We Spend So Much More Money Helping You Than The Big Boys?

Last year we spent many thousands of dollars supporting saw filer activities. We spent much more than our much larger competitors. We also spent many, many thousands of dollars solving problems for customers.

We do business by mail and over the phone without outside salespeople. We can give you much better quality at much lower prices, give superior customer service, be generous with saw filer groups and still charge a lot less than the big boys do for the same quality. (More P. 4)

Notes from the WSFEA Western Saw Filers Educational Association meeting Sept. 2012

(This is only part of the training and I apologize to those I missed. However it will give you an idea of how good the program was.)

Bohler Uddeholm Steel

Peter Hopper spoke and Roy Davis helped answer questions about direct applications. Peter Hopper started by talking about steel and how it is made.

Uddeholm has a handout about different steels and their properties that is available from Peter Hopper or Roy Davis. Roy Davis - 912 856-0891
Roy.Davis@uddeholmstrip.com

Nickel adds toughness (ductility) to steel. Under 0.043 inches thickness steel does not have nickel because it doesn't need it.

Uddeholm has a straightness chart giving tolerances. Tolerances vary as the length varies but it's not a straight line progression.

Edger saws can have a tendency to bend in a particular direction based on rolling of the steel.

On the really large saws, say 10 feet in diameter, they cross roll which is where they roll it down a little bit in one direction and then roll it down a little bit at 90° and then back in the first direction and so on.

There is another handout on causes/faults and woodworking bandsaw. There is an Uddeholm bandsaw manual.

Roy.Davis@bustripsteel.com

Neal Davis on hammering saws

Neal Davis is incredibly analytical. He started out by talking about the importance of having and maintaining tools well.

He uses a granite plate to check straight edges monthly. He has a special bench grinder with a sliding table that is used only for grinding saw gauges.

He brought up the point that about half of the saw mills do not have good straight gauges. Then he spent some time demonstrating how to straighten a saw gauge with a special bench grinder and a sliding table (from Simonds). It is extremely important that you do not heat the saw gauge at all when you are grinding it straight. You can make a pass or maybe two passes and then you stop and let it cool before you make another pass. You can tell when you're straight edge truly is straight by the sparks it makes or by the sound it makes.

In the demonstration the gauge was a little hollow in the middle so starting out you only saw sparks and heard the grinding noise when it was grinding at one end or the other. Gauges from manufacturers may not be good enough.

Neal then went on to show how to grinding a saw filing hammer. He strongly recommended that people get custom-built hammers from Dan Lines. You need a hammer designed for you and how you use it. How you use it depends on how tall you are, how you hold your hand, and how you like to hit things.

You can get a soft anvil and put an oil and chalk mixture on it which would give you some idea of how the hammer is hitting. You can put blue chalk on a hammer face and hit a piece of paper. This process is sort of like biting down on a blue piece of paper at the dentist.

You need a belt grinder with a plate on one side and no plate on the other side so that you have a hard side and a soft side. Neal showed how you sort of roll your hammer against the belt to change the face.

Dan Lines says he builds his hammers with kind of sharp edges on the face of the people can take them down the way they want them. He also says that he heat treats his hammers so the hard face is really thick, somewhere around three quarters of an inch to an inch.

Neal pointed out that, with this much depth in the hard face; you don't have

to be afraid to work on your own hammer because hammer faces are hard and deep.

Bill Saily brought up the point that the hammer face arc should be the same as the arc on your stretcher roll. Bruce Doroshuk, President of the BC saw filers, brought up the idea of using a marker to color the face of the hammer and then hitting a piece of paper on top of the anvil.

Scott Emmert of SawPro, Inc.

gave his approach to saw filing. He also has an excellent problem solving handout of six pages. He talked about a paddle system for guides. In order to determine if your guides are spaced right you cut a piece out of the saw blade and pass that through.

Rob Woods - Simonds - talked about bandsaw rubbings and the need for accurate, clear, and easy to understand rubbings.

Norm Brown of Simonds talked about a new, free, saw design program they offer.

Saw Filer Training Programs

There was a discussion about programs to certify saw filers. Umpqua community college is working on this. Hayward community college in North Carolina had something like this going. They dropped it when the market got so bad but are thinking about restarting it. Bruce Doroshuk talked about the saw filers certification program in British Columbia. **(We have a copy of the BC Training Outline and are happy to share it.)**

The question-and-answer session had 90 people in attendance +7 people on the panel. The discussion about crowns on bandsaw wheels was extremely comprehensive. I lost count but there were better than a dozen different explanations on different sizes and shapes of crowns to solve different problems and to compensate for different conditions in different size saw blades. John Guthridge of Bank's Lumber had some really clear, concise explanations as did many others.

Ripped Shoulders

It was pretty well agreed that the major problem with lost tips and ripped shoulders was due to feed rolls. If you do anything to change the feed rate of the mill you need to make sure that the feed rolls are also adjusted. You cannot just add more horsepower and run the saws faster and expect to feed faster. One story was told about a new maintenance man been assigned to the feed rolls and suddenly tips were coming off and shoulders were ripping. The need for excellent maintenance on the feed rolls to prevent ripped shoulders was emphasized several times.

Kockums

Several people mentioned that Kockums has excellent literature on bandsaws.

Amps to Horsepower

The question was asked about how you convert amps to horsepower. No one knew right off but the comment was made that you need to consider tare horsepower. This is like tare weight. It takes about 12% of the horsepower just to run the motor so that it can deliver more horsepower to the saws. This 12% that it takes to run the motors is called tare horsepower when it needs to be subtracted from the total horsepower when you are using horsepower in your calculations.

Calculating Horsepower from Amps

$Hp \times 746 \text{ Watts} / \text{Voltage} = \text{AMPS}$
Example: 10 Hp Motor at 220 Volts

$10 \text{ Hp} \times 746 \text{ Watts} / 220\text{V} = 33.90$
Amps

Voltage may be rated at 110 and 220 volts, 115 and 230 volts or 120 volts 240 volts.

Actual voltage may be different than rated voltage. In my experience, that would be the way to bet. Also delivered electricity fluctuates. Years ago we had machine problems and got the city to put a graph recorder on our power supply. Amazing how the power fluctuated.

Rule Of Thumb for Small Motors

Where 'I' is power

1 HP=746 watts.

$HP=I \times V \times PF \times EFF / 746$

where PF(Power Factor)=.86 and EFF (Motor Efficiency)=.81. Using this formula current can be calculated as follows for a 1HP single phase motor.

$I = HP \times 746 / (V \times PF \times EFF)$ or,

$I = 1 \times 746 / (120 \times .86 \times .81)$ or,

$I = 8.9$ amps.

Current for the same Motor connected to 240 would be.

$I = 1 \times 746 / (240 \times .86 \times .81)$ or,

$I = 4.46$ Amps.

The Art of Manliness

<http://artofmanliness.com/>

Kind of an interesting web site. Of course, none of my readers need lessons on manliness but you might want to see how other guys do it. As near as I can figure out the whole thing is funded by a store selling really fancy guy stuff The store is Huckberry.com.

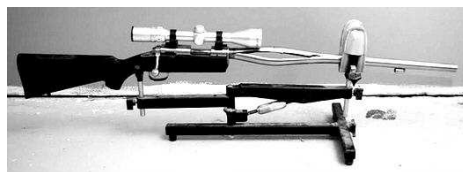
The Ex-wife

One evening, Tim was assembling some loads for an upcoming hunt. His wife was standing there at the bench watching him. After a long period of silence she finally speaks. Honey, I've been thinking, now that we are married I think it's time you quit hunting, shooting, handloading, and fishing. Maybe you should sell your guns and boat.

Tim gets this horrified look on his face. She says, "Darling, what's wrong?"

"There for a minute you were sounding like my ex-wife." "Ex wife!", she screams, "I didn't know you were married before!"

"I wasn't "



Handloading – no such thing as too safe

Update and correction on the M-1 Garand

(I am continually amazed by the depth and breadth of knowledge and interests among sawfilers. Here is another example.)

From Randy Seaman at Sierra Pacific
"Subject: SEPTEMBER NEWSLETTER

Tom: I know that you want to give out the best information in your newsletter that is possible. But your article on the M-1 Garand is not accurate. President Obama did not keep them from coming into the country. It was the M-1 .30 Carbine that he kept out. You can still get the M-1 Garand through the directorate of civilian marksmanship (DCM) program. www.odcmp.com/

My dad was a medic in WW2 over in Germany. (Battle of the Bulge). He brought home a 9mm Luger pistol that he took off of a German officer. My sister still has it.

I started out as an MP (1973-1976) and later transferred over to a Marksmanship Unit (USAMTU#6) stationed out of Fort Ord, CA. I used to own a .30 carbine but traded it while I was still in the service. Quite a few of the civilians that I shot against in competition (service rifle matches) used to shoot the Garand.

They had a fixed magazine and when you would load them with a clip full of ammo you had to make sure you got your fingers out of the way because the bolt would automatically close when you pushed the ammo all the way in. They called it the "M-1 thumb" when you failed to extract it quickly enough!!!

Have a good day,
Randy Seaman"

Civilian Marksmanship Program

<http://www.thecmp.org/>

Randy was right, of course. Actually The CMP is cooler than I expected. You really can get an M1 Rifle at a good price. From what I saw they are not real pretty but all are in safe, shootable condition.

ISKA Meeting March in Nashville

This is the same great speaker that was so popular in Palm Springs two years ago. There was a lot of demand for a similar program in the east so this year he is in Nashville. He gives a very entertaining and immediately practical program on: analyzing profits, cash flow and how to read financial statements. If you do not know enough about this to do your own books then you really need this course.

Contact Steve Bergerson
805 216 9565 steveb@westernsaw.com

New Promo Item



Hard Hat Light

LED, long battery life

We were going to do some sort of promotion where you had to buy stuff or hop up and down on one leg. But we have been really busy and we like you. If you want one or more just call. Better hurry, we only bought 100.

800 346-8274 or email
sales@carbideprocessors.com

Wood Machining Institute Seminar (Dr. Szymani)

Really good – Warren Bird (California Saw & Knife – Calsaw) has a really simple solution for ripped shoulders. Warren is really smart and it showed in his speech. He presents things scientifically and then he covers the down to earth applications.

Timber Processing & Energy Expo (The New Portland Show)

A great show – See the videos
<http://www.timberprocessingandenergyexpo.com/category/video-coverage/>

(Note: It really was a great show and my opinion is not influenced (much) by the fact that I fell in love with the Hatton Brown receptionist. I don't know who she is or what she looks like but she has a beautiful southern voice and a happy, laughing attitude.)

Chinese Carbide

The Chinese can make good carbide but you cannot depend on it. Sometimes it is good and sometimes it is not good. We will not sell carbide if we have any doubts about quality. Carbide is pretty cheap compared the cost of an unscheduled saw change or lost customers.

Can you afford to have a salesman call on you at your mill?

It turns out that it can cost up to \$200,000 to have a salesman on the road for a year. A salesman can make between one and 4 calls a day on the average. Salary \$65,000 to \$90,000. Drive 1500 miles per week. If you have to have a salesman call on you to place an order then you have to pay that person between \$200 and \$800 per sales call. Figure that only half the people buy, then the people that do buy have to pay the salesperson between \$400 and \$1,600 for every sales call.

If you can use the phone

Carbide Processors has two very charming, bright young ladies who answer the phone and take orders. They are paid much better than the average with full medical and other great benefits because they are worth it. They can take and process and order in well under ten minutes. This means it costs about \$5 to place an order with us.

Testing Finished Saws and Tools



Hit it with a stick.

Put the tips on the saw then beat on them with a Stick. I like this because it is a good test, it worked very well and the guy that came up with it made a lot of money because his saws worked better. He was also criticized because he was having problems and no one else was.

Note: Many years ago this customer called me in because he was having problems with tip loss. On the way down I stopped to see another customer and asked him if he had a tip loss problem, the first guy said he didn't have a problem. I talked to the second guy and then stopped into see the first customer again. Again I asked him if he was having a problem with tip loss. He said that he wasn't having a problem. Sure the tips came off sometimes but it wasn't a problem. The difference was in whether you considered tip loss a problem.

Hit It with a Stick Good and Bad

Put the tips on the saw then beat on them with a stick
Problems:

1. No way to measure the force accurately
2. Everybody hits differently
3. This isn't the way impact is applied in actual use
4. Takes too long
5. Costs too much

Benefit: It works

All We Ask Is Your Carbide Business

We know it is not much. Everybody else wants to sell you saws and plate and machines. That is fine with us.

We sell carbide.

We sell carbide and braze alloy for carbide. We buy carbide scrap. It is a sideline for the big boys but it means the world to us.

With this very little part of your business we can feed our kids, pay our rent and have a pretty good life. There is money for this newsletter and to support filer programs with a few dollars left over for really cool freebies.

We are small and very efficient with very low overhead so we can sell really great carbide and braze alloy for really great prices.

Please, could we have your carbide business?

Ole.... A born salesman

Ole, the smoothest-talking Swede in the Minnesota National Guard, got called up to active duty. Ole's first assignment was in a military induction center. Because he was a good talker, they assigned him the duty of advising new recruits about government benefits, especially the GI life insurance, to which they were entitled.

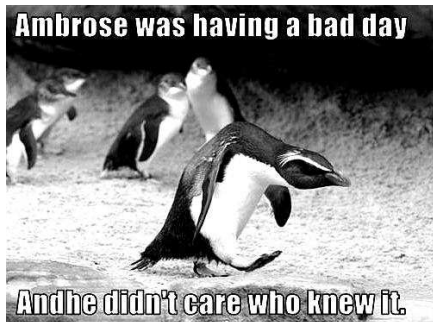
The officer in charge soon noticed that Ole was getting a 99% sign-up rate for the more expensive supplemental form of GI insurance. This was remarkable, because it cost these low-income recruits \$30 per month for the higher coverage, compared to what the government was already providing at no charge. The officer decided he'd sit in the back of the room at the next briefing and observe Ole's sales pitch.

Ole stood up before the latest group of inductees and said, "If you haf da normal GI insurans an' yoo go to Afghanistan an' get yourself killed, da governmenten' pays yer beneficiary \$20,000. If yoo take out da supplemental insurans, vich cost you only t'irty dollars a mont, den da governmenten' got ta pay yer beneficiary \$200,000!"

"Now," Ole concluded, "Vich bunch you tink dey gonna send ta Afghanistan first?"

If you are really serious about your ice cream

Put the almost empty ice cream carton in the microwave for 15 seconds and drink the last few bites. Don't forget to lick inside the lid. Scoop ice cream into low, wide bowls so you can lick those clean, too.



**WHISKEY
Tooth Paste!**

**Genuine 6 Proof Stuff
SCOTCH • BOURBON**

Why fight oral hygiene—enjoy it! Here's real he-man toothpaste, best argument yet for brushing 3 times a day. 2½ oz. tubes flavored with the real thing—Scotch or Bourbon. Night-before feeling on the morning after. Rinse with soda instead of water if you prefer. Per tube ppd. **\$1**

Greenland Studios
DEPT. HG-114, MIAMI 47, FLORIDA

correction

Due to incorrect information received from the Clerk of Courts Office, Diane K. Merchant, 38, ██████████ SW, was incorrectly listed as being fined for prostitution in Wednesday's paper. The charge should have been failure to stop at a railroad crossing. The Public Opinion apologizes for the error.

fire call

OPEN FOR BUSINESS

James Klindt, who spent more than a year in the Quad-City spotlight for murdering and dismembering his wife, has opened a tiny eatery at 4th and Howell streets in Davenport, called Eats and Sweets.



NO SMOKING

IT IS AGAINST THE LAW TO SMOKE IN THESE PREMISES. Also there is to be no rape, pillage, murder, theft, kidnapping, roller-blading, ball games, trapeze acts, bathing in blancmange, fox hunting, bear baiting, hare coursing, hot air ballooning, driving of double decker buses nor any activity which patronises the congregation in the way our government forces us to patronize you by obliging us to display this ridiculous notice.

**WARNING
UNATTENDED
CHILDREN WILL
BE SOLD AS
SLAVES**

**PRIVATE SIGN
DO NOT READ**



The college class was told to write a short story in as few words as possible. The story had to contain; religion, sexuality and mystery. There was only one A+ in the entire class.

"Good God, I'm pregnant; I wonder who did it.

Super "C" Carbide Grade

Tougher than C1 - Better wear than C3
What Makes Super C Tips Truly Superior

1. Superior Abrasion Resistance - Abrasion or straight wear is countered by smaller, better grain size.
- 2 & 3. Superior Adhesion and Diffusion Resistance (corrosion and chemical attack) Super C grade of carbide has an extremely fine structure so there is very little binder presented to the material being cut. This, combined with the special metallurgical formulation the Super C binder (hint - it's not just plain Cobalt) creates an extremely wear and corrosion material for use in wood, plastic or non-ferrous metals.
4. Superior Fatigue Resistance

And People Really Like Them - Call Today To Try Them - Most Sizes Readily Available

Super C Hardness (HRA) T.R.S. (psi)
92.2 - 92.4 530,000 +

Typical C2 values	Hardness (HRA)	T.R.S. (psi)
C2	92.1	334,000
C2	91.8	334,000
C2	91.5	377,000
C2	90.4	435,000

Typical C Values	Hardness	T.R.S. (psi)
C1	89 - 92.4	350,000 - 360,000
C2	91.2 - 92.9	250,000 - 400,000
C3	91.4 - 93.6	270,000 - 350,000
C4	89.6 - 93	260,000 - 450,000

Sawmill Grade Tips

- * Transverse rupture strength well above 500,000 psi.
- * Rockwell A hardness above 92
- * Alloy binder for corrosion resistance
- * Grain structure to inhibit both crack initiation and crack propagation
- * Micro grain or mixed grain for superior wear

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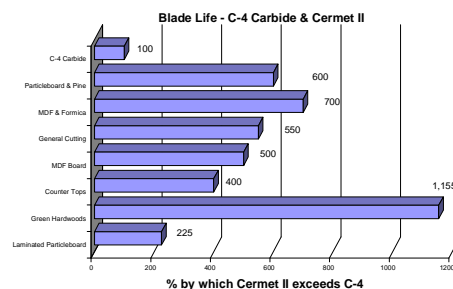


Cermet II® 8 days instead of 5 in MDF

Three weeks and three full loads of double side melamine laminate instead of 1 week and 1 load with carbide

1. 5 blades with standard C-4 carbide cutting 45 lb. single and double sided vinyl-laminated particle board
* Cermet II - 15,088 meters / old grade - 6706 meters for **225% as much run life**
2. KM-16 industrial saw cutting 101.6 mm x 152.4 mm (4" x 6") Green hardwoods, oak, hickory, maple and walnut using 11 blades with standard C-4 carbide
* Cermet II / 462 hrs / old grade - 40 hrs
1,155% as much run life
3. 406 mm (16") 100 teeth cutting countertops
* Cermet II - 4 weeks / old grade - 1 week (4 times) **400% as much run life**
4. 406 mm (16") 80 teeth cutting MDF Board
* Cermet II - 10 days / old grade - 2 days (5 times) **500% as much run life**
5. 305 mm (12") 100 teeth TCG Miter cutting oak, Compressed Fiber Board, Plastic
* Cermet II - 154 hrs / old grade - 28 hrs (5.5 times) **550% as much run life**
6. 305 mm (12") 60 teeth cutting MDF, High Pressure Laminate (Formica)
* Cermet II - 56 hrs / old grade - 8 hrs (7 times) **700% as much run life**
7. G 1060A on Chop Saw cutting Particle Board and Pine Dowel Rods
* Cermet II - 48 hrs / old grade - 8 hrs (6 times) **600% as much run life**

Use Cermet 2 instead of carbide and make your life much easier



Cermet II® Successes

1. Several times the life in a window and door plant.
2. 3 times the life in Corian.
3. 8 days instead of 5 in MDF and we have an even better grade coming.
4. Twice the life in beetle killed Lodge Pole pine.

Benefits You Get

- * Grinds like regular carbide
- * Gives a better edge than carbide
- * Stays sharper longer than carbide
- * Great increase in fracture toughness.
- * More corrosion-resistant
- * Better at high temperatures
- * Cuts faster
- * Cuts faster & longer yet is tougher
- * Longer runs and less downtime.

Report from Marvin Windows

On the saw that we tried. How many times we sharpen a blade before we order new or have retipped we are not sure. Most blades get damaged by hitting something so we have the carbides retipped a lot. How often do regular blades have to be sharpened? We normally have our carbide tipped blades sharpened every week.

The new Cement II blade normally lasts twice as long before it gets damaged. The best so far is four weeks and one and a half million cuts before we changed it out which is four times longer.

Hope this helps and keep up the good work on those tips.
Nathan Hull, Grinderman
Marvin Wood Products

Carbide Processors, Inc.
3847 S. Union Ave.
Tacoma, WA 98409

Updated rough mill simulator tool ROMI 4.0 released

U.S. Forest Service, Virginia Tech release improved tool for rough mill managers to simulate real-world scenarios.

The U.S. Forest Service and Virginia Tech have released an improved version of the rough mill simulator, ROMI 4.0, a tool for rough mill managers allowing the simulation of real-world scenarios in rough mills to help increase yield, operations and schedules.

This free software enables secondary wood products manufacturers to simulate their rough milling processes. In particular, ROMI 4.0 simulates the cut up of lumber using two common processing modes: rip-first and chop-first. Additionally, the latest version of ROMI allows users to analyze each board's yield when processed in either rip-first or chop-first mode.

The software also allows users to model simulate and examine the relationship among cutting bills; part dimensions, quantities and qualities; processing options; and lumber grade mixes.

Other improvements to ROMI include a combined rip-and-chop option and a new user interface.

To download a free copy of the software, user's manual and related documents, please visit: <http://www.woodproducts.sbio.vt.edu/ROMI4>, or contact Ed Thomas at the U.S. Department of Agriculture Forest Service Northeastern Research Station at 303.431.2324 or email ethomas@fs.fed.us.



We support the right of women to wear bikinis fishing

Venison vs. Beef: The controversy is FINALLY settled..!

Controversy has long raged about the relative quality and taste of venison and beef as gourmet foods. Some people say venison is tough, with a strong "wild" taste. Others insist venison's flavor is delicate. An independent food research group was retained by the Venison Council to conduct a taste test to determine the truth of these conflicting assertions once and for all.

First, a Grade A Choice Hereford steer was chased into a swamp a mile and a half from a road and shot several times. After some of the entrails were removed, the carcass was dragged back over rocks and logs, and through mud and dust to the road. It was then thrown into the back of a pickup truck and driven through rain and snow for 100 miles to the nearest bar. After several hours of "bragging time", it was transported to a tree behind a house where it hung out in the sun for a day.

It was then lugged into a garage where it was skinned and rolled around on the greasy floor for a while. Strict sanitary precautions were observed throughout the test, within the limitations of the butchering environment. For instance, dogs and cats were allowed to sniff and lick the steer carcass, but most of the time were chased away, along with the pesky flies, when they attempted to bite chunks out of it.

Next, a sheet of plywood left from last year's butchering was set up in the basement on two saw horses. The pieces of dried blood, hair and fat left from last year were scraped off with a wire brush last used to clean out the grass stuck under the lawn mower.

The skinned carcass was then dragged down the steps into the basement where several inexperienced but enthusiastic and intoxicated men worked on it with meat saws, cleavers, hammers and dull knives while watching a football game on a small TV. The result was 375 pounds of soup bones, four bushel

baskets of meat scraps, three badly cut and bleeding fingers, and a half dozen steaks that were an eighth of an inch thick on one edge and an inch and a half thick on the other edge.

The steaks were seared on a glowing red hot cast iron skillet to lock in the flavor. When the smoke cleared, rancid bacon grease was added, along with three pounds of onions, and the whole conglomeration was fried for twenty more minutes.

The meat was gently teased from the frying pan and served to three intoxicated and blindfolded taste panel volunteers. Every member of the panel thought it was venison. One volunteer even said it tasted exactly like the venison he has eaten in hunting camps for the past 27 years.

The results of this scientific test conclusively show that there is absolutely no difference between the taste of beef and venison...!!

Congress Popularity

Congress is less popular than:

Cockroaches
Traffic Jams
Lice
Brussels Sprouts
NFL Replacement Refs
Root Canals
Used Car Salesmen
Being Stuck In Traffic
And Donald Trump

Congress is (barely) more popular than:

Lindsey Lohan
Playground Bullies
Telemarketers
Kardashians
Fidel Castro
Gonorrhoea
Ebola
Communism
And Meth Labs



A puppy – just to clear your mind of congress

Carbide Processors, Inc.
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Tacoma, WA 98409

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Tacoma, WA
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ADDRESS SERVICE REQUESTED

Sawfiler Education

“The saw filer is at the heart and soul of the mill. As an example take a \$500 log and a 2.25 overrun. If you can take the overrun to 2.26 it can be worth a quarter million dollars a year more to the mill. If you can go from 2.25 to 3 it can be worth \$1.26 million per year to the mill.

Bob Lewis
President / Owner
Columbia Vista Sawmill
Keynote speech to WSFEA

Free Sawfiler Advertising

We will advertise your meeting free.
Just contact us.
sales@carbideprocessors.com
800 346-8274

Sawfiler Jobs

Mike West keeps a list
westwm@chwa.com

Sell Scrap and Sludge Now!

The Price Is Still Dropping

The price of tungsten and thus tungsten scrap is dropping. It is down by \$0.50 as I write this and looks to be dropping even more. It is till about \$150 - \$200 per 2# coffee can but that is down from \$350.

Ship Scrap Cheaply

USPS Flat Rate boxes. We recommend 11 x 8.5 x 5.5 size with tape on it. It cost \$10.95 to ship anywhere in the US. It holds maybe \$400 to \$500 worth of scrap. Scrap prices vary daily. Today, July 14, we are paying \$8.00 with braze alloy on it and \$8.50 per pound with no braze alloy. It helps if you put the scrap into coffee cans, boxes, or plastic bottles and then put those in the box.

Speakers Wanted For Saw Filer
Meetings – email
president@carbideprocessors.com

New Promo Item



Hard Hat Light

Powerful LED with long battery life.
Strap to fit around a hard hat.

Judge a supplier by their guarantee
We have a 100% satisfaction guarantee so our stuff has to work. We have been doing this for 30 years. Our competition has a no return policy but they sell a little cheaper than we do.

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10% Discount on great tools
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