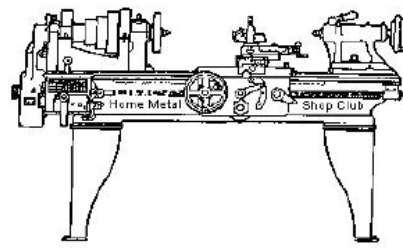




April  
2006

## Newsletter

Volume 12 Number 4



Visit Our Home Page [www.homemetalshopclub.org](http://www.homemetalshopclub.org)

**Statement of Purpose:** *Membership is open to all those interested in machining metal and tinkering with machines. The club provides a forum for the exchanging of ideas and information. This includes, to a large degree, education in the art of machine tools and practices. Our web site endeavors to bring into the public domain written information that the hobbyist can understand and use. This makes an organization such as this even more important. -- Founder - John Korman (deceased)*

<b>President</b>	<i>Doug Chartier</i>	<b>Secretary</b>	<i>Dennis Cranston</i>	<b>Webmaster</b>	<i>Gene Horr</i>	<b>SIG</b>	<i>Dennis Cranston</i>
<b>Vice President</b>	<i>Jan Rowland</i>	<b>Treasurer</b>	<i>Emmett Carstens</i>	<b>Librarian</b>	<i>Dennis Cranston</i>	<b>Coordinators</b>	<i>Richard Pichler</i>

### Next Meeting May 13, 2006

To be announced.

### Minutes of the April 8, 2006 Meeting

by Dennis Cranston

#### Business Meeting

The business meeting was held at Lyndons BBQ prior to the regular meeting.

Doug Charter talked about the need for volunteers to

#### General Meeting

The president, Doug Charter, opened the meeting.

The guest speaker was Thomas Janicki of Iscar Metals, Inc. Thomas discussed the area of inserts as used on lathe tools. His review covered the various materials used in making inserts and the matching of insert types with the material being turned.

Iskar produces a wide range of inserts for all aspects of turning, including grooving, cutoff, threading as

run for HMSC officers. There will be several club officer positions open and members will need to step up and help.

well as general turning. For additional information on Iscar insets, they have a web site:

[www.iscarmetals.com](http://www.iscarmetals.com)

During the meeting, a grooving tool was misplaced. If anyone knows what happened to it please pass the word to Doug.



## Machining Temperatures

MILD STEEL	1,200 DEG.
ALLOY STEELS	1,700-2,300 DEG.
STAINLESS STEEL	1,800-2,500 DEG.
HIGH TEMP ALLOYS	3,500 + DEG.
COBALT	1,400 DEG.

## Carbide Technology

### How carbide works

Influence of **SPEED**

Influence of **FEED & DOC**

Tool-life

Carbide Grades & Materials

# INCREASING THE UTILITY OF THE POPULAR 4 X 6 HORIZONTAL BANDSAW

Leo Reed

An inexpensive drill press vise, a block of wood and some plastic pipe can make sawing small pieces of metal easy. As the pictures show, it allows you to saw right next to the vise. I have used this setup several times and am pleased with the results.

The photo below shows the vise mounted to the block of wood with the blade-down-limit stop tethered to it. You must have the stop to keep from sawing through the vise, or keeping the blade from falling to the saw's base.



There is not much that is critical in the setup, but there are a few points that have to be considered:

- 1) The drill press vise must be mounted above the jaws of the saw's vise, so the adjusting screw of the drill press vise will be in the clear.
- 2) In order that the saw blade will not cut into it, the drill press vise must be mounted at an angle. The blade and the bottom holding area of the vise should be on the same plane.
- 3) So the blade will not continue to cut after it cuts through the work piece, a method of limiting the drop of the blade is needed. The plastic pipe stop accomplishes this. (Note that the stop is tethered to the vise, so you are reminded to install it.)

One drawback is the automatic cut off will not be activated. You must manually switch off the saw.

The first photo shows the front view of the saw with the vise mounted. Note that the automatic motor cutoff will not work, you have to flip the switch manually.



The above photo shows the top view of the saw with the blade in the vertical position.