

TIP TALK

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www.iscar.co.nz

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COOL STUFF COMING

The ER Collet Chuck System is the most popular system in the civilised world.

It's quick, accurate, flexible, and inexpensive...but now with HIGH HELIX angle solid carbide cutters, it is possible for a cutter to pull out on a job under certain loads...most have experienced this.

Coming from Iscar is a new ER Collet. It will fit your existing Collet Chucks but PREVENT ANY SOLID CARBIDE CUTTER FROM PULLING OUT!

No matter how hard you push it!!!

It can be used with any standard cylindrical or Weldon shank cutter, and you won't need any new holders.

It's super clever and super simple. Check out this ER-SURE Collet below...how does it work?



Register your interest with your engineer for the ER-SURE Collets.

grabatool.co.nz

for great tooling bargains!

OLD GIRLS

Last year we started a hunt for the oldest CNC machine running in the country. The first entry that appeared to kill all others entering was this **1979 Mori Seiki SL3 at Segedins Engineering.**



Since this machine was first turned on it has seen out **8 Prime Ministers of New Zealand** and **6 Presidents of the USA.**

Rob Muldoon was still the Prime Minister, Bill Rowling was leader of the Opposition, and do you remember Bruce Betham and the Social Credit Party?

It was 3 years before Space Shuttle would take its maiden flight.

It was 17 years before mobile phones looking like bricks would be sold in New Zealand.



Microsoft had 11 employees... that's them in the picture.

World oil prices soared from around US\$13 a barrel up to US\$32 after the Iranian revolution.

Air New Zealand sightseeing flight TE901 over Antarctica crashed into the lower slopes of Mt Erebus near Scott Base.

Random Facts About 1979

- **Song of the year in New Zealand:** "Be Mine Tonight" by the Dudes
- **First commercial rap hit:** "Rapper's Delight" was released in New York
- **Album of the Year:** *Saturday Night Fever*, Bee Gees
- **Song of the Year:** "Just the Way You Are", Billy Joel
- **Sony introduces the Walkman...** that's a small cassette tape machine with headphones, that you could carry around like an iPod, but way bigger
- **McDonald's introduces the Happy Meal**
- **The PC is still three years away**, and will have
 - 128 kB of RAM
 - 360 kB double-sided 5.25 in floppy disk drive
 - 10 MB hard drive
 - 4.077MHz CPU (that's 0.00407 GHz),
 - The price will be US\$1500 (your smart phone has nearly 500 times more power; Quad-core 1.9GHz or speed, 2GB of RAM, and 32GB storage).

Some things never change..

- Soviet invasion of Afghanistan
- France performs a nuclear test at Mururoa Island
- 62 Sheiks are killed in Aleppo, Syria
- Iran's Ayatollah Khomeini declares the US "The Great Satan", and takes over Iran
- A white man receives a light sentence for killing San Francisco Mayor and Supervisor, Harvey Milk. Gay men in the city riot.

And finally, in 1979 the guy who programmed this Mori Seiki was paid about \$5.00 per hour.

THORIUM - Fuel for the Future?

What is named after Thor (the Scandinavian god of war) that could be the world's best energy source?

Thorium is a source of nuclear power. There is probably more untapped energy available for use from Thorium in the minerals of the earth's crust than from combined uranium and fossil fuel sources.

It is found everywhere. Thorium is four times as abundant as uranium and as common as lead. It is estimated that there is enough thorium in the United States alone to power the country at its current energy level for over 1,000 years.



Thorium-powered concept car

QUICK FACTS

- Hazardous waste will be a thousand times less than with uranium.
- The radioactivity of the resulting waste also drops down to safe levels after just a few hundred years, compared to tens of thousands of years needed for current nuclear waste to cool off.
- It's not new...there were Thorium reactors in the USA from the 60's, but they were shut down in 1973... who knows why? Maybe because you couldn't make weapons out of the by-product.
- One ton of Thorium can produce as much energy as 3,500,000 tons of coal.

The good news is that lots of countries are now researching modern thorium nuclear reactors due to their significantly lower chance of catastrophic and explosive meltdown like Chernobyl, or a partial meltdown like Japan's Fukushima-Daichi.

Google it...**THORIUM.**



SWEET VIBRATIONS



One of the biggest problems when boring small holes is when you need to bore more than three or four times the diameter of the hole you are creating.

Usually some lovely harmonic vibrations are generated and your boring bar "sings loudly" due to long overhang, creating a very poor finish.

Up until recently any Anti Vibe or "tuned" bar was extremely expensive; up to 5-10 times more than a regular tool.

We are very pleased to tell you we have in stock a selection of small ANTI VIBE bars that will not break the bank (under \$250). Using patented technology they can bore much deeper than standard counterparts without vibration.

All three bars take the TCMT 110204 size insert as standard, and all are featured on our **GRABATOOL website**, so log on to grabatool.co.nz and catch yourself a sweet deal!

- 8992486 S10M STFCR-11 ANTIVIB 10mm boring bar
- 8992487 S12M STFCR-11 ANTIVIB 12mm boring bar
- 8992488 S16R STFCR-11 ANTIVIB 16mm boring bar



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5 Reasons Why You Should Go 5-Axis

1. Eliminate multiple set-ups required to reposition the work-piece at complex angles
2. Eliminate costly tooling and fixtures required to hold the work-piece in place
3. Eliminate manual millwork and handwork required to clean up surfaces
4. Less engineering skill-set required by operator, clamping, accuracy, second operation set-ups
5. Fewer competitors: higher profit margins

One of the most popular 5-axis machines in New Zealand is available now for immediate delivery.



SPINNER U5-620

iCNC INTEGRATING
MACHINES - TOOLING - KNOW HOW

DON'T BE NEGATIVE



Iscar's new DOVEIQ Mill, so named because the inserts are held rigidly by a dove tail shape, also features one of the cleverest designs ever seen in a milling insert.

8 cutting edges? - Ok so that's not new you say, except the way each and every edge is presented as a positive cutting edge, despite its double-sided design.

What do you get? A very soft cut due to a high-positive cutting edge inclination, that contributes greatly to smooth entry into and exit from the component being machined. That and the Dove tail locking of the insert makes it first choice for any FACING cutter.

"The Dove tail locking of the insert makes it first choice for any facing cutter."

This is a cool design, characterised by high-positive pocket inclination, not typical for milling cutters with double-sided inserts, allows for free-cutting action, less power consumption and thus less generated heat with depths of cut up to 4.6mm.

ADVANTAGES

- Smooth and stable cut
- Produces excellent surface finish (sometimes may eliminate the need for finish grinding)
- Low power consumption
- Applicable on a wide range of face milling operations. Both roughing and finishing on many types of engineering materials, including hard-to-cut austenitic stainless steel.



CMS App for your smart device

FIND THE RIGHT PRODUCT FOR GROOVING, MILLING, AND TURNING

ISCAR is introducing a new app which enables downloading of the new CMS catalogue set. This app covers all of ISCAR's cutting tool and tool holder lines for Grooving, Turning, Milling, Hole Making, and Tooling.

ISCAR's new app also contains catalogue information, product specifications, user guides, video clips, and animations which demonstrate how the tools function and enhance user experience.

ALWAYS WEAR UNDERWEAR...

Always wear underwear in public, especially when working under your vehicle.



A couple drove their car to the shopping centre, only to have the car break down in the car park. The man told his wife to carry on with the shopping while he fixed it.

The wife returned later to see a small group of people near the car. On closer inspection, she saw a pair of hairy legs protruding from under the chassis.

Unfortunately, although the man was in shorts, his lack of underpants turned his private parts into glaringly public ones. Unable to stand the embarrassment, she dutifully stepped forward and quickly put her hand up his shorts, and tucked everything back into place.

On regaining her feet, she looked across the bonnet and found herself staring at her husband who was standing idly by watching. The mechanic, however, had to have three stitches in his forehead.

VIPER CUTTERS NZ's FIRST CHOICE



VIPER cutters are made to very tight tolerances

- +/- 0.005 on the radius
- +/- 0.01 on the diameter

The VIPER range of cutters has become very popular with New Zealand tool rooms, for the machining of hard steels. These are small-diameter, long-reach cutters (also known as rib processing), from 0.15mm up to 6mm in diameter.

We keep a huge range of VIPER stock, including different choices of flute length per size, and it is very well priced for high-quality cutters.

The popular styles are:

- Hog Nose (small radius)
- Ball Nose
- Sharp Corners
- Hog Nose Tapered

We have created wall posters of the VIPER range held in our warehouse to make your choice of cutter very easy and reliable (ask your engineer).

VIPER cutters are just a phone call away, and most are priced between \$27-\$37.

VIPER

All cutters are available in ultra-fine (0.2um) micron grain carbide with TISN-N coating, and also CBN.



Grabatool at a great price with grabatool.co.nz!

Grab some BT40 Holders, collet chucks, end mills, face mills

You can now charge your Iscar account!

Check it out today!

Charities we proudly supported in 2013

