

Woodworkers Club OF HOUSTON

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APRIL MEETING

Mike Dietrich of Falcon-Auger, Inc. presented us with a program on bandsaw blades and bandsaws.

All bandsaws, no matter how much or how little you pay for one----they all need to be tuned up.

There are some very good articles available to instruct you on how to tune up that saw.

Each time you install a new blade you should first---dress the blade, by applying a stone to the back of the blade then round over the back edges of the blade--this will create sparks so be sure you clean all of the sawdust from the side of the saw first. The rounding of the back edges prevents work hardening of the blade.

Because of the low cost of manufacturing wood cutting bandsaw blades, the manufacturer sometimes will let the milling cutter get dull which can leave a burr on the blade which in turn leaves a washboard effect as you cut.

To eliminate this washboard cut--take some cuts in hardwood with a very slow feed rate--this should clean up the burr.

Blades are available in skip, hook and regular rake. The hook tooth has a 7 degree positive rake angle and will last longer than the skip tooth which has a zero degree rake angle but cuts smoother.

Most manufacturers of wood cutting blades are getting rid of the skip tooth blade. Bandsaw blade manufacturers are more interested in the metal cutting Bi-Metal blades because of money. Wood cutting blade stock sells for 30 cents a foot as opposed to \$3.00 a foot for the Bi-Metal stock.

Blades start out as flat steel, the teeth are milled into it, secondary operation the set is placed into the blade, then the teeth are heat treated and the back edges are annealed so the edges are soft so they can flex around the bandsaw wheels.

Blades tend to wear out as they lose the set

wood doesn't dull the teeth, just the set from the side of the blade.

If you do a lot of resawing or aggressive cutting a Hook tooth would be a better choice.

The hook tooth because of the 7 degree rake angle draws the wood into the blade--where the skip or regular rake with its zero degree rake angle does not have an aggressive cutting action. The skip tooth has a square bottom gullet to allow more room for the chips.

To keep the wood your'e cutting from sticking to the blade, use a non oil based--no lanolin soap like Ivory soap. This will lubricate the blade and not affect the finish you place on the wood. This will also make your blade last longer.

Wood cutting blades come in Flexback and Hardback types--basically they are all carbon blades the difference is in the alloy that makes them superior.

Mike recommends the flexback blade--the main reason is that the teeth will stretch on the saw as you tension it. When they weld a blade--the teeth are a little concave so as you tension the blade you stretch the teeth, not the back edge, this gives the strength to the teeth and not the back edge.

Most of us have switched to cool blocks instead of the metal guides. Mike says you can save money by going to a plastics dealer and picking up a block of Teflon--Teflon is basically what cool blocks are--a high heat, high resistant plastic. You can pick these up as scrap pieces and make your own cool blocks.

On 1/8 th and 1/16 th inch blades its best to set that rear thrust bearing a little forward for extra support. All other blades a good rule of thumb is to fold a dollar bill in half (double thickness) and set your rear thrust bearing such.

Why does a blade break in the weld? Blades are welded parent to parent material and after welded, they anneal the blade soft and then grind the excess slag and file the back.

When annealing the blade you must go by the color--you cannot be color blind. You can over or under anneal the blade--if the blade is over annealed its shot. When you anneal a blade you are putting all of the molecules back in order(like little soldiers). When the blade is over annealed the molecules inside the blade are all over the place. Under annealed the blade will snap right away.

If a blade breaks in the weld and upon examination, if the teeth still have set and no stress cracks--the blade should be rewelded at no charge!

The blades that Mike sells is a commercial grade quality, 25,000 thick, the same thickness that furniture manufacturers use. The blades that you buy at your local dealer are 15,000 thick.

Because the saws are set for the thinner blades--you are not putting enough tension on the blades, especially 1/4 inch and larger .

Rule of thumb--forget about the tensioning guide on the back of the bandsaw--as you tighten the blade, keep tweaking it till the blade tone sounds like a deep bass guitar string--a clear tone that does not resonate.

If the blade is not tight enough it will wander.

A bandsaw blade should take 30,000 pounds of actual tensil strength. Bandsaw blades will stretch as you use them--so retension as needed.

A lot of people tend to under tension a blade--if you have tensioned a blade properly it should cut a straight line.

Can you over tension? Yes but only the 1/16 and the 1/8 inch blades, the 1/4 thru one inch cannot be over tensioned with the saws that are out there! The tension spring on the back of the saw should not be able to rip that blade apart.

Over time the back edge of the blade running against the thrust bearing will work harden and the blade will break. Once you have work hardened the blade you have brought it up to 60 Rockwell. You get real fine cracks at the back edge of the blade and the blade is shot, the cracks will be pulling the blade apart.

Is it worth while to save a broken blade and have it rewelded? If the blade still has set and under magnification the blade does not have stress cracks, yes it should be rewelded.

Should you remove the tension from a blade? If your'e using the saw on a daily basis--NO. If you use one blade a year--remove that tension.

What about a flat spot on a tire because of blade tension? Tires wear out on their own volition--Mike says he has never seen a blade make an impression on a tire.

What about those rewelding kits, you do yourself? These kits use a silver solder and are ok in a pinch. Mike suggests that you cut the blade material on an angle to allow more surface to solder.

Why does a blade thump? Misalignment on the weld. The blade can vary in thickness, which will also cause a thumping sound.

Can a blade cause a bandsaw to shake and shutter? Bandsaw blades shouldn't cause the wheels to shake--its probably the pulleys and or the motor.

What is the best blade for resawing? Hook tooth 3 or 4 TPI, 1/4" blade or larger.

Most popular blades for the woodworker are 6, 10 and 14 tooth blades.

What about Bi Metal blades for cutting wood? The problem with a Bi Metal is that the teeth are stronger but the backing material is weaker and cannot take cutting contours--it will make straight cuts all day long. Also carbon blades cost \$5 to \$7.00----for a Bi Metal blade multiply times three.

We would like to thank Mike for this program and for answering all the questions that we ask of him at his shop.

APRIL RAFFLE

The April raffle of Bandsaw blades donated by Falcon-Auger, Inc. were won by John McGuigan and Ted Cooper. They each got their choice of any bandsaw blades up to \$25.00 each. We would like to thank our friends Mike and Donna for their generous donation.

Remember that the profits from these raffles go to items that all of the members can benefit from. We have made enough money from the January, February and March raffles to buy the following video tapes:

1. The Woodfinishing Video by Michael Dresdner
2. Mastering Your Tablesaw by Kelly Mehler
3. Master Woodworking Machines by Mark Duginske
4. Mastering Your Bandsaw by Mark Duginske
5. Small Shop Projects: Boxes by Jim Cummins

These will be a great addition to our library and as we can we will purchase some more. If you run across a tape that you think would be of interest to the members let one of the officers know and we will consider the tape on our next purchase.

MAY RAFFLE

Right now we have one item to raffle at the May meeting and its a Jacket donated by Norton Abrasives. We will have some other items but at the time of this printing we are still hustling up something else.

Tickets are still only a sawbuck, uno dinero, one single dollar, same as the lotto but the odds are millions better that you will win.

PROBLEMS AND SOLUTIONS

Fred Jacobson needed a way to permanently mount paper to wood, it was suggested that he use the same system that photographers use--Dry Mount available at your camera store.

Walt Turpening wanted to know if anyone used a bandsaw mill to cut up lumber. It was suggested that he talk to Jimmie Harp.

WANT TO BUY

Walt Turpening is looking to purchase a 20 inch bandsaw.

SHOW AND TELL

Robert Sandlin made a potpourri scroll saw box.

Don Sloan made some interesting marquetry veneer plates. He cut thin pieces of white pine the same thickness as the bandsaw kerf, to place between the cut out pieces. The plates were then turned on the lathe.

Ronnie Derks made a Koala Bear intrasia project.

Ervie Jenkins made Red Cedar Bowls and an Ash Sand Time Piece.

One of the members showed off a walking Stick turned on a Shopsmith lathe.

Bill Hochmuth showed how you can make turnings on a router--plans for the jig are in the Jan/Feb. issue of Wood.

Walt Turpening showed us a bench with wedged splayed legs and a wooden nutcracker with wood threads.

APRIL'S FEATURE OF THE MONTH--PUZZLES

Denis Muras showed us his three dimensional elephant puzzles and his Aggie Puzzle.

Norm Newberry made monkey puzzles that he had to cut out using a 1/16 inch bandsaw blade.

MAY'S FEATURE OF THE MONTH

Feature of the month will be bookends and magazine racks.

SAFETY-----BANDSAWS

By Zatis Murphy

The first thing that you must always do is to keep that bandsaw in good working order.

Before beginning any repairs or adjustments on your saw unplug it from the electrical outlet.

Make sure that those bearing are in good working order and that the tires on the wheels have not stretched out of shape, that the tires are clean and not full of gunk.

Get a straight edge and check that the wheels are in alignment.

Check the tracking, then adjust the thrust bearings, the guide blocks--line up the back of the gullet--its a better choice to use cool blocks instead of the steel blocks that most saws come equiped with.

You should always keep the guide block, bearing assembly no more that 1/4 of an inch above the wood that you are cutting.

Keep those fingers away from the blade by using push sticks or jigs.

When cutting small pieces make a sliding table out of hardboard with a runner under the table to fit your miter slot.

For round objects use a wooden hand screw.

For odd shaped pieces make a jig.

Always use sharp blades--as a sharp blade is safer than a dull blade.

Hone the back side of the blades and round over the edges.

Do not cut too small a radius with too large of a blade.

Keep the table top clear--use push sticks or the erasure end of a pencil to push little pieces away from the blade.

When making long cuts--do not back out the blade while the motor is running.

As always wear safety glasses and eye protection.

Do not stand out to the side--if a blade breaks it could whip out and nick you. Always stand perpendicular to the blade.

If you are looking to purchase a bandsaw, American Woodworker's current issue has a good comparison of a variety of sizes and cost of bandsaws.

In this article it explains how they had to tune up almost all of the bandsaws that they tested. Its a good article even if you already have a bandsaw.

UPCOMING PROGRAMS

JUNE---Tim McCoy of Houston Hardwoods will present a program on Hardwoods--How to handle and how to properly store them.

JULY--Art is working on program about the table saw---How to properly adjust a table saw.

If you have any suggestions or ideas please pass them along. If you see or hear of an interesting program do the same.

FIELD TRIP

Art's been having a hard time nailing down an exact date for the field trip to the Rocking Chair manufacturer in Tomball. He has got a time, the only available day will be a Monday 10:30 A. M. till Noon, with a maximum of 25 people. Hopefully we will have a definite date by the May meeting.

WANTED WOODWORKERS

Woodcraft is looking for skilled woodworkers to conduct demonstrations usually Saturday at Noon. They are also in need of woodworkers to conduct classes. If you have a particular skill and would like to pick up a few extra dollars contact Mark Henry at Woodcraft 681-5200.

PRESIDENT'S CORNER

By Sharon Buckley

In baseball the saying is build it and they will come.

For woodworkers the saying should read give them something for free and they will Show and Tell it.

We have tried everything to get more participation in the Show and Tell.

A free raffle ticket made it work--All kidding aside I would like to Thank everyone that brought a Show and Tell item in April---keep up the good work in May.

We are still offering a FREE raffle ticket for that Show and Tell item.

Jimmie Harp suggested that we look through our shops to see if there is anything that we would like to donate to the raffle maybe as a White Elephant portion to the raffle--last month Jimmie donated a vise that was won by Denis Muras.

I would Thank Robert St. Jean for the photographs that he took at the Bar-B-Que, I got so busy I completely forgot about pictures. I am in the process of placing them in an album so that everyone can take a look. Thanks again Robert for the photos.

We should start back with recording all of our events, field trips, etc. I did take some photos when we cut up all of the Birch Plywood for the footlockers and will put them in the album. If you have taken any photos of recent or not so recent events would you make some copies for the club.

We have scheduled the Rice Faculty Club for our Christmas Dinner, the problem is that I have just received their new price list. Wow, they have more than doubled the price of the facility and prices for food have also been increased. It looks like we will have to find a new location for our Dinner--if you have any suggestions would you please let me know. Because of the December date we will have to find a new location soon. So let me know.

BOOK ORDER

Steve will be placing an order for books after the May meeting if you want books--place your order with Steve at the May meeting. You must include you check with your order.

MAY MEETING

WHEN: MAY 14, 1994 9:00 A. M.

WHERE: BAYLAND COMMUNITY CENTER
ON BISSONET AT HILLCROFT

PROGRAM: Our guest speaker will be Kevin Hayes of Norton Abrasives. Some of the questions Kevin will be answering will include the following:

1. What is sandpaper?
2. What is the difference in the various types of sandpaper?
3. What is the best way to store sandpaper?
4. How is sandpaper manufactured?


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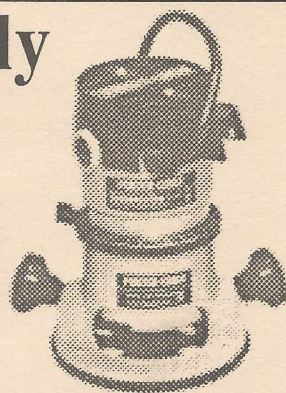
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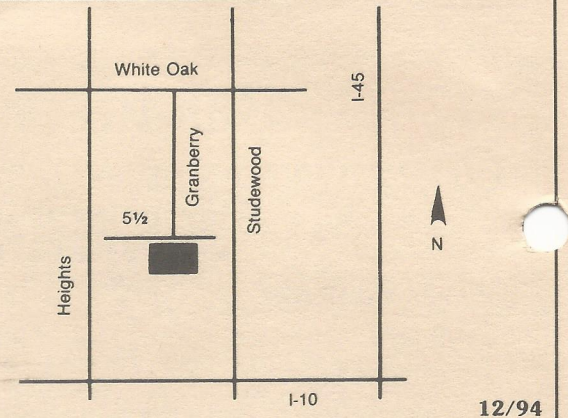
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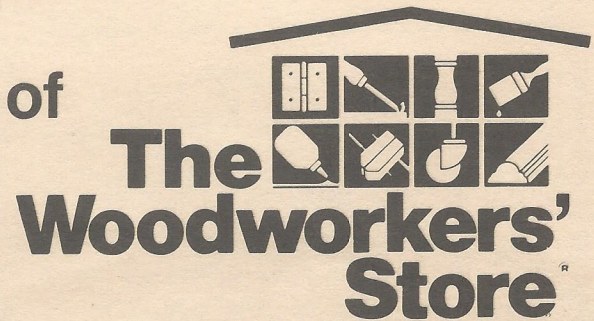
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