QUICKMILL
COMMUNICATOR
Published for Quickmill Customers, Employees, Distributors and Friends

What's Inside:

May 2010

- **Seamless transition to new leadership at Quickmill Inc.**
- **New Quickdrill Installation in Louisiana 2 years after Hurricane Gustav & Ike came ashore**
- **Valley Blade's New Eliminator B1640 milling machine allows them to compete Globally**
- **Quickmill's New Laser Scanner System will greatly reduce processing time for Header Boxes**

QUICK NEWS

Over the last 3 years David Piggott, Founder and VP Technology and Joseph Lipsett, President & CEO (Retired) have been working towards a smooth and seamless transition to new leadership at Quickmill. Quickmill's policy has always been to promote from within wherever possible.

During the past 3 years as Joseph Lipsett and David Piggott gradually backed away from day-to-day operations the day-to-day management team took on more of the leadership role. Effective May 1, 2010 this process is now complete and as planned, seamless.

From Left to Right: David Piggott, Gord Buchholz, Joseph W. Lipsett

Joseph W. Lipsett, President & CEO announced his retirement to the Quickmill Inc. staff on April 26, 2010 to be effective May 28, 2010. He was further pleased and proud to announce on behalf of the Board of Directors that Gordon Buchholz, a 19 year veteran and key manager at Quickmill will take over as President and CEO reporting to the Board of Directors.

David Piggott, Founder and Vice President of Technology remains with the company in his key innovator role and as a member of the Board of Directors. Mr. Lipsett also continues as a member of the Quickmill Inc. Board of Directors and will act as a consultant to the company supporting its continued growth and development.

As we grow and move forward at Quickmill Inc. we understand that change will always be a part of a companies future. Our team at Quickmill will continue to innovate and keep on the cutting edge of technology. I can assure you that we will not change our core values of Exceptional Customer Service, Trust, and Commitment to our Partners, our Customers and our Venders.

Gordon Buchholz
President & CEO
Quickmill Inc.

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QUICKMILL - OUR SHOP

OUR PRODUCTION FLOOR

Below are two standard Eliminator Gantry machines built by Quickmill in our Canadian Facility.

***ELIMINATOR®* 96-460-42**
(2.4m-11.7m-1.1m)
Milling Machine for South America
Industry - Heat Transfer

***ELIMINATOR®* 60-460-42**
(1.5m-11.7m-1.1m)
Milling Machine for United States
Industry - Defence

STOCK MACHINE PROGRAM

Quickmill has implemented a stock machine inventory program to offer our clients quick deliveries on our most popular models.

Currently In Stock

QUICK**DRILL**

Bridge 160 x 200

INTIMIDATOR

Gantry 120 x 120 x 24

ELIMINATOR

Bridge 1640
Bridge 1230

NEW PRODUCT SHOWCASE

New QUICKDRILL Gantry!

New *QUICK*DRILL installation visited 2 years after Hurricanes Gustav & Ike came ashore.

Louisiana Heat Exchanger, LLC was founded in 1974 and is located in Baton Rouge LA, the companies main focus is repair and service of shell & tube heat exchangers for the local chemical and refining industry. The company was purchased in 2002 by EST Group and continued to expand and add capabilities over coming years.

In 2008 EST purchased their new QUICKDRILL 96 to drill holes and to machine ring and pass grooves for shell and tube heat exchangers. The machine was delivered in August of 2008 during the time when Hurricanes Gustav & Ike were battering the coast. The installation and training was a struggle for both Quickmill and EST but working together over the coming weeks the machine was successfully installed and operational.

Allen Blythe the Operations Manager at EST with over 40 years of experience in the heat transfer industry commented that the company has seen a 66% reduction in machine hours since the new QUICKDRILL installation.

When we set out to look for a drilling machine, we knew that our competitors were using the Quickmill Products and had been successful doing so. QUICKMILL products are known for consistent quality, speed and accuracy in the heat transfer industry and the benefits for EST are not only the increase in productivity on the machine, but the assembly of the final product on the shop floor.

We also purchased a considerable Tooling Certificate from Quickmill in which their tooling and applications department specified all the tooling for the machine for specific work we had to produce once the machine arrived.

After the machine was installed their application specialist came down to train our staff on the proper use and cutting conditions of our production parts. This helped our operators to be up to speed as quick as possible with the use of modern tooling. The training was so helpful that we are planning to get some additional training in the future so we are up to speed on the latest tooling developments.

We are very pleased with the purchase of our new Quickdrill 96 as it has exceeded our expectations and we will consider Quickmill in our future expansion plans as well.

Allen Blythe
Operations Manager
EST Heat Exchanger
A Business Unit of Curtis Wright Flow Control Company
Baton Rouge, LA

Call QUICKMILL for pricing on a NEW QUICKDRILL machine for your shop!

Your Regional Sales Manager will be happy to walk you through the features on a new QUICKDRILL and provide you with a quotation that will satisfy your unique application!

CUSTOMER PROFILE

Valley Blades new milling capability allows Ontario bla

ELIMINATOR BRIDGE 1640
GENERAL SPECIFICATIONS

Control = Fanuc 18i
Spindle = 50hp (37kW) 0-6000rpm
with 2 speed gear box
X Axis = 165.35" (4200mm)
Y Axis = 90.55" (2300mm)
Z Axis = 39.37" (1000mm)

ELIMINATOR B1640

FEATURES
Chip conveyors
Automatic Tool Changer

In 1962 Valley Blades Ltd. began as a small manufacturing plant in Cambridge, Ont. The small 6,000-sq.-ft. facility originally was used to manufacture carbon snow blades and grader blades for the local market.

Fast-forwarding to the mid-'70s, the small Cambridge facility was closed and the company relocated its headquarters to nearby Waterloo, Ont., where the manufacturing facility still flourishes today. In 1977, Valley Blades expanded its facilities and its market share by building a 15,000-sq.-ft. manufacturing plant in Edmonton, Alberta, which has since grown to become an integral part of the Valley Blades manufacturing and distribution system.

Dale Baier, president and CEO of Valley Blades Ltd, purchased the company in 1974, when it was a six-person operation and with his hands-on dedication to the business has watched the company grow ever since. In September of 2007 Valley Blades Ltd became ISO 9001 certified and in November, of that same year, the company was awarded the IAPA Level II Health & Safety Achievement Award for Health & Safety excellence in the workplace. Today, Valley Blades still manufactures cutting edges and snow plow blades for the heavy snow removal market but also manufactures wearing and cutting edges for any OEM machine servicing the construction and heavy machinery markets.

The Waterloo facility has grown to occupy more than 65,000 sq. ft. of manufacturing and warehousing space and throughout their expansion, the increasing catalogue of products manufactured by Valley Blades, comes in at almost 36,000 different blades, wearing-edges and parts for machinery such as Caterpillar, Komatsu, John Deere, Case, Terex, Volvo and more. These products are distributed to approximately 40 markets around the world, utilizing a worldwide dealer network, created by Valley Blades, which supplies its products and services to its customers.

New Machining Capability

Now, after months of planning and development, Valley Blades has added new machining capabilities to its shop floor. Historically, base edges for buckets were beveled using a torch. While this method was fast, according to the company, it left something to be desired in terms of tolerances and surface finish.

Valley Blades now uses new technology from machine tool builder Quickmill Inc. to machine bevel even the most complicated profiles. These new capabilities allow for the production of custom and OEM-spec base edges with very short lead-times. As part of this project, the company will also be stocking some common base edges and related components from various OEMs that will be available for same-day shipment.

CUSTOMER PROFILE

-de manufacturer to better serve its worldwide market.

Earlier this year, the company purchased its second machine from Quickmill following a 2001 installation of a CNC drilling machine in its Waterloo location. Now eight years later, another machine has been delivered and installed to increase capacity on the milling side of the business.

"We were so pleased with the quality of the gantry-style machine that we have recently purchased our second Quickmill machine, the Eliminator B series 1640 milling machine," explained Dale Baier, President and CEO of Valley Blades Ltd. "We turned to them again for our solution as our experience working with a local Canadian company proved that Quickmill has responded quickly and effectively with our support and service needs, along with understanding the demand of the heavy equipment industry and just-in-time processes."

The first machine, installed in 2001, is still being used for heavy drilling and boring of bolt-hole patterns in the wear components that are mass-produced for this type of industry. "2001 was Valley Blades' first acquisition of a CNC machining center and the installation was complex but necessary to maintain the intricate accuracies of the machine," explained Mr. Baier. "We are a 24-hour/6-days-a-week operation, and the Quickmill gantry-style machine has performed with minimal to no downtime, meeting the demands of the wear edge market and our customers."

Adding CNC technology has allowed the company to eliminate a manual process. "We were looking to add milling capabilities to a range of product lines that we produced using manual technology and we needed to compete using a more modern CNC machine," said Baier.

Other Technology

In addition to CNC drilling and milling, the company also heat treats most of its blades and wearing-edge components in both the Waterloo and Edmonton manufacturing facilities, to produce products that are both impact-resistant and have a long wear life. The blades

are heated and then rapidly cooled, or quenched. This process reorganizes the crystals in the metal's microstructure, hardening and strengthening the steel, thereby greatly improving its wear life.

After quenching, the blades and wearing-edge components are very hard and strong; however, further heat treatment, known as tempering, ensures toughness and ductility in the material. According to the company, this three-step process yields the best combination of impact resistance and long wear life.

Valley Blades also employs a range of CNC equipment in the manufacture of its blades and wearing-edge components. These machines are well-suited to high-production environments as repetitive tasks are carried out at consistent rates on a daily basis. The company uses many CNC technologies such as plasma and saw cutting, boring, and machining, even the punching process of the blades and wearing-edges uses the benefits of CNC technology on the company's shop floor.

Solid Modeling

Keeping up with rapidly changing technology in the field of CAD (computer-aided design) software has given Valley Blades the opportunity to design more geometrically complex products. These designs ensure that wear material is located in critical areas of the part, increasing wear life and reducing the amount of scrap material overall, which benefits the customers, the customer's bottom line and the environment.

For more information, visit www.quickmill.com and www.valleyblades.com.

As seen in Canadian Industrial Machinery - July 2009 Issue.

NEW PRODUCT SHOWCASE

New QUICKSCAN Laser Scanner System

Laser Scanning Speeds Holemaking Operations

A laser scanning system offers an alternative to touch probing for quickly finding numerous hole positions in heat-exchanger workpieces.

Plates used to form large, air-cooled heat exchanger weldments often require hundreds of holes. It's typically not extremely tight tolerances that make it challenging to create these holes. The issue is that the heat of welding distorts the plates with existing undersized holes. Bringing these holes to final size and geometry requires a lengthy measuring routine to determine the true XYZ position of each hole.

For example, air-cooled heat exchanger header boxes have opposing faces, each with as many as 400 through holes to accommodate inner tubes. To create a header box, undersized holes are first drilled in plates that will become the box's top and bottom faces. Those plates are welded to other plates to complete the box. The box (which can be as large as 36 x 200 x 8 inches) is then delivered back to the machine tool for subsequent holemaking operations.

The undersized holes on the box's bottom face require drilling, reaming and grooving operations. Drilling, tapping and counterboring operations are required for the holes in the top face, each of which accommodates a sealing washer and plug. Oftentimes shops with CNC machines use touch probing to locate the XYZ position of each hole. (Determining the actual Z-axis position for holes in the top face is especially critical because counterbore depth must be consistent for every hole.) While touch probing is effective in locating holes on these components, probing every hole can take as long as 3 hours. Quickmill, a manufacturer of CNC drilling and milling machines, has developed a laser scanning system that can determine all hole positions in minutes, greatly reducing spindle down time.

The scanning laser is mounted to a tapered holder for installation in a Quickmill machine's spindle. The laser is wired to an auxiliary PC that communicates with the machine's control. Moving linearly at a rapid traverse rate, the laser scans one face of the header box to determine X, Y and Z axis offsets for all holes in that face. The system's software stores the XYZ data for each hole in a table. Once scanning is complete, macros pull the measured XYZ position for each hole to be machined into the control so the machine knows the proper position and tool offset. After the machining operations on one face are complete, the part is flipped and the scanning and machining processes are repeated for the opposing face.

The laser scanning system is available on all Quickmill drilling and milling machines. Although the system was developed for the air-cooled heat exchanger industry, the company says it may be a quicker alternative to touch probing for determining offsets on other large-part applications. It can be especially effective when Z-axis feature heights are irregular, according to the company.

As seen in Modern Machine Shop, August, 2009

QUICKMILL'S QUICKCARE TEAM

Our Dedicated Team of Telephone Service Support

Gordan Milicic
Director of Service

Tracey Manns
Customer Service Coordinator

Jeremy Turcotte
CNC Service Technician

John MacCallum
Sr. Technical Advisor

Rob McArthur
CNC Service Technician

Call 1-800-295-0509 or 1-705-745-2961 to talk to our Customer Service Team.

As a part of Quickmill's corporate mission to provide our customers with exceptional value, Quickmill's Service Team provide a wide range of services to our customers. Our dedicated team of highly skilled service professionals meet customers needs in areas like installation of machines, warranty responses, preventative maintenance, repair of machines, offering spare parts, and providing support via phone, email, on site and in person.

Over the past several years we have initiated a machine retrofit program for our customers with older machines, providing them with economical solutions for machine upgrades. Through this program, we have been able to provide our customers with up to date functional machines to increase their productivity and improve the quality of their operation.

QUICKMILL'S SERVICE & PRODUCTION TEAM

MUCH MORE THAN A MACHINE

METAL CUTTING SOLUTIONS!

Quickmill's Tooling & Applications Group

Dave Piggott
VP, Technical Director

Roger Patterson
Tooling & Applications Specialist

Chason Thompson
Tooling & Applications Specialist

Value Added Services:

- Tooling Certificates
- Time Studies
- Tooling Set Up Kits
- Quicksqueeze Baffle Clamp Kits
- Quicksupport Tubesheet Support Kits
- Tooling and Applications Training
- Mastercam Parts Programming
- Tooling Recommendations
- Tooling and Fixture Design

QUICK TOOLING TIP

"INFORMATION IS THE KEY TO SUCCESS"

I can not stress enough the importance and the need for information gathering in the world of drilling and milling. The information gathering I am referring to, in this case is the technical date listed in the tooling manufacturers catalogs. As well as pre-recorded data collected from previous jobs which specify a certain speed and feed for a particular material and application.

Time and time again customers are stumped and questioning themselves on speeds, feeds, and the proper application for new tooling and or new materials. The number one thing every machinist and or machine operator should have on hand and available to them at all times is the tooling manufacturers catalogs. It is important you take the time to understand how to read and apply the information given in these catalogs. In doing so you will save time and money in both machining time and overall tooling costs.

Chason Thompson, Tooling and Applications Specialist.

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