

Sept 13th, 2017

M_{ETRO} D_{ETROIT} M_{ETAL} W_{ORKERS}

Monthly Newsletter

Very light crowd out on what was a beautiful September evening..., not sure why, it's not like the weather was bad... Come one, come all, the rooms on the right , just down the hall.

Th Vice President waited as long as he could, giving extra time for a few stragglers, before bringing down the hammer and calling for the start of the meeting.

First order of business was a discussion about the use of backing /packing material in the opposite side of the vise jaws when clamping up a small part. Kevin has been helping a young apprentice at work and the topic recently came up. Using an identical part, a piece of rough stock, set of joe blocks or anything appropriate to help keep the jaws parallel is just good



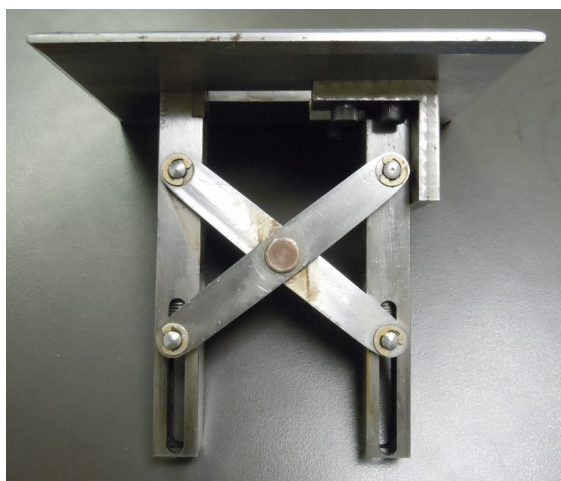
machining practice. A quick video appearance by Tom Lipton shed some clarification on just how far, or not so far, out a vice jaw can get when clamping up a small part on one end of the vice. The angle can be relatively small, but there, when this easy preventative measure is skipped. Bottom line - you need to know your machine, your vices, the part and the machining operation being performed in order to make an informed call on if, how and when to use a packing set up.

One other thing that was mentioned in the video was the, definitely more prone to this issue, jaws in your typical horizontal bandsaw, the ones with the pivot points to aid in setting up to cut angles. Although a good candidate for packing to keep the vise jaws in alignment, Ken Hunt noted that you can quickly and easily drill / tap a 1/2"-13 hole to act as an adjustable stop (adjust the size of the bolt to suit your particular saw... See Photo. This one pictured is more in



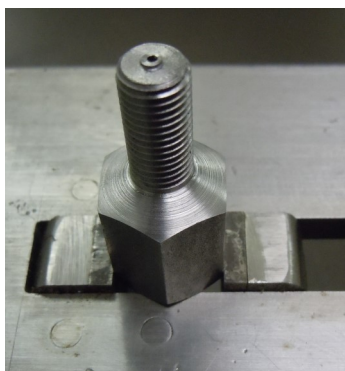
line with Brian Block type equipment, check out his YouTube Channel—search on YouTube : [bcbloc02](#)). This set up aids in the alignment and decreasing the time required for set up. Great suggestion Ken, thanks!

Get a Grip!



Brian Lawson brought in the coolest set of auxiliary vise jaws, see photos, that can be used to grip onto something thin while using your existing jaws as the gription force. Very neat and a great little project for anyone to try and

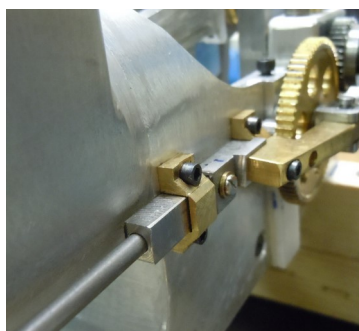
tackle. The set up fits in the regular jaws of your vise and when you apply clamping pressure with the vise jaw, it is translated to the small jaws shown in the above picture gripping the smallest of items, thin sheets of metal etc.... Thanks Brian!



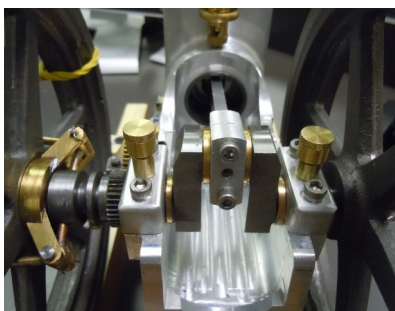
It's a HIT! Update:



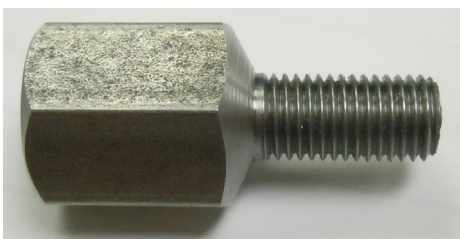
Louis has been working away at the farm boy hit and miss engine over the last few weeks. Those in attendance got to see the changes up close



and personal, the valves, valvetrain and mechanism responsible for the MISS cycle is ready to go. Louis noted that this type of engine is designed to only control the exhaust valve, if you look closely you can see that there is only one rocker arm (controlling the exhaust). The intake cycle happens only when the miss mechanism disengages and releases the exhaust valve, allowing for the valve to seal, creating negative pressure and pulling in a fuel charge for combustion, speeding up the RPMs, activating the governor and starting the miss cycle all over again...Very interesting! Nice work Louis, looking forward to more updates and info on how these engines work.



The Prez phoned in (he must have been on air force one, enroute to FLA or Texas...) and sent in a sample / video from a recent project, a testing device (fitting) that was machined on a hard-ding lathe with a turret tailstock. The video was quick, but full length for the actual operation which was a multistep, two pass process which turned out very nice. Never limited by pre-CNC technology, with a bit of prep and some thinking you can make short order of most jobs if you put your mind to work too. Nice work Kurt.



The Frankenmill

The Frankenmill, otherwise known as the RT VMA, a unique combination of a Clausing horizontal mill and a Bridgeport M-Head, was presented and “nearly” garnered a standing ovation, well maybe not quite but most thought it was a neat



packaging of some common machine tool features. There were a few comments, shots really, about only one of the team members in the photo having sweat stained clothing. Someone always must be the brains of the operation I guess...

Karl Gross was kind enough to share a few photos of some estate items that had a few of us looking, he's able to email them out, if you're interested drop him a note at KarlW144@aol.com

Mark your calendars, hold the date, tie a string around your finger... we've, I say that like I had something to do with it last time, been invited back to the EAA (Experimental Aircraft Association) to share some info and pass along knowledge, that's where you guys come in, at a session on November 2nd. More details to follow.

Make MDMW Great Again

It's election season already, elections for cabinet positions within the MDMW board are up for grabs at the November meeting. Get out and vote, throw your name in the hat for a position and give it a go! Debate moderator, Lester Bolt, will be brought in to ensure fair coverage for all candidates...

Video of the week, nothing to do with metal working (on the surface) but everything to do with sticking it out, to the end, finishing the race so to speak... and anyone who's been up against a challenge, machining or otherwise can appreciate that spirit! Thanks for the link Don! Search Chrissy Wellington Kona 2008 or this address (<https://youtu.be/qtslGL9Qat8>)

Next meeting is Oct 11th, see you ALL there.