

# PATIENCE & NICHOLSON (NZ) LTD

# DRILL PRESS

March 2011

## CHRISTCHURCH UPDATE

Following the terrible earthquake in Christchurch on the 22nd February, customers and suppliers throughout NZ and from all around the world have contacted us to see if our employees were okay and if the factory was affected.

I am very pleased to advise that Kaiapoi missed the worst of it this time. Our team are all safe and well, and our factory was operating as usual the following morning.

Thank you for all of your enquiries, the concern that you shared was very humbling and sincerely appreciated.

Kevin Donovan  
General Manager

## P&N HSS CARBIDE BURS



- For shaping or forming metal
- 6mm shank
- Made from solid carbide (K30) Shank = S45C Steel
- The double cut bur allows for rapid stock removal in harder materials
- The chisel tooth pattern not only minimises tool chatter but reduces the chip to a granular shape, in most materials
- For use in air and electric die grinders
- Available in cylinder, ball nose, flame and tree shape
- Great point of sale packaging

**NEW**

**P&N**

## LEAN MANUFACTURING AT P&N

Many of you will have heard the term "lean manufacturing" and many of you will be supplying businesses that are involved in the concept in some way. In 2007 P&N embarked on the lean manufacturing journey, our Operations Manager Rick Smith had been talking about the concept for a while and probably just like many of you I heard the title and thought it was all about cost cutting. While reduced costs have been a benefit it's certainly not the whole story. So what is lean manufacturing? In simple terms, a lean organisation is one where at every level there is an understanding of how to identify waste and a continuous process of eliminating it. One of the first things that we did was create a value stream map of a number of our processes. This exercise is used to identify which activities actually add value to the product. Things like waiting, rework, searching for tools, transport etc do not add value from the customers' point of view and are considered waste.

A lot of our activity to date has been around workplace organisation through a "5S" program. This involves removing unnecessary items from the workplace by **Sorting, Setting** things in order, **Shining, Standardising** and then **Sustaining** the new systems that have been put in place.

- The whole factory has had a good clean out. There were a lot of unneeded items after 45 years in the same building!
- We have spent a lot of time making shadow boards and setting up tooling trolleys so operators have the tools at hand to enable them to efficiently do their job.
- We have introduced cleaning rosters to improve the cleanliness of the workplace.
- We are working towards writing Standard Operating Procedures for every operation in the factory and offices.
- 5S check-sheets and inspections have been introduced to ensure that the gains made are held and we don't slip back.

5S is the foundation of a lean organisation and enables a company to get quick gains in efficiency and morale as the workplace improves but it is really only the beginning of the lean process.

This is just a snapshot of how we have applied lean principles to our business. Our guess is that as a supplier the more you know about lean manufacturing the more you can help your clients achieve their goals. There is plenty of information about it on the internet and some very good local consultants so it may be worth spending a bit of time to learn about being lean.

FREE PHONE 0800 553 236

FREE FAX 0800 708 677

www.pandn.co.nz

# KINCROME FILE SETS



Kincrome has released a range of 3 great new File Sets. The blades are manufactured from Carbon Steel that has been hardened and tempered to ensure durability and performance. All the Files feature soft ergonomic handles for easy grip and have a hanging hole for storage. Blades are laser engraved with the cut type for easy file identification.

The range consists of two 3 Piece Sets; an 8" (200mm) Bastard Cut set and a 10" (250mm) 2nd Cut Set. Both sets feature a Round, a 1/2 Round and a flat file in each. A larger 10" 5 Piece Set is available that contains a Flat, Square and Round Bastard Cut and a Flat and Round 2nd Cut file. All sets include a convenient Canvas Wallet to store your files and protect them from damage.

- The Kincrome File Sets are available now.
- KK6308 Kincrome File Set 8" - 3 Piece Bastard Cut
  - KK6310 Kincrome File Set 10" - 3 Piece 2nd Cut
  - KK6315 Kincrome File Set 10" - 5 Piece Bastard/2nd Cut



## A NOTE FROM SALES

I trust you all had a relaxing break and 2011 has started off well for you.

You will notice over the next few months, a number of new products being introduced under the P&N brand, including Carbide Burs, Rotary Rasps, HSS Countersinks, HSS Deburring tools and HSS Step drills. The initial response to these new products and packaging has been very pleasing and offers a quality product under a quality brand at an affordable price.

Your local Territory Manager will have a number of new samples for you to look at and I would welcome any feedback you have.

On a more sombre note, the devastation in Christchurch is hard to comprehend. We all will know someone in that region who has been affected by the latest earthquake and our thoughts go out to all our customers and their families and also the P&N team at Kaiapoi and their families as well.

Greg Stevens  
NZ Sales Manager

# STAFF PROFILE



Darryn Nix is a valuable member of the customer services team. Darryn's role as one of four customer services representatives sees him tackling your 0800 553 236 line calls and queries. Darryn is an avid motor racing fan and Ford supporter, he enjoys fishing, snooker and renovating his home.

## HOW TO TIPS - CARBIDE BURS

Commonly referred to as rotary burs or rotary files these versatile tools come in a wide variety of shapes and sizes. They can be used for a multitude of tasks including; weld preparation and finish dressing of welds, deburring, scale removal, chamfering, die work, basic metal shaping and many others.

The carbide material that they are made from is very hard and also quite brittle so there are some key points to consider if you want to get the best performance and tool life:

- Carbide burs are typically designed for use in a high speed die grinder and will not work properly if run at low speed. A standard pistol grip drill or drill press will not run fast enough and can cause the bur to chip.
- Don't apply excessive pressure, let the bur do the work, if you apply enough pressure to slow the die grinder it can damage and/or wear out the cutting edge of the bur.
- The two main types are double cut burs for general steel and work with harder materials and aluminium cut with deeper flutes to eliminate bur loading in softer materials.
- A liquid wax or synthetic lubricant is recommended when using aluminium cut burs to stop material binding to the bur
- It is best to start at lower speeds and increase until you achieve the desired finish.
- It is preferable to clamp burs into a collet not a chuck, make sure you have the right size collet in your die grinder and insert the bur as far as possible before tightening.
- Always wear eye protection - carbide burs often produce a very fine chip.

RECOMMENDED SPEED (R.P.M)		
Bur Diameter	Double Cut	Aluminium Cut
1/16	50,000	-
1/8	35,000	-
3/16	25,000	-
1/4	22,000	46,000
3/8	18,000	31,000
1/2	16,000	23,000
5/8	15,000	18,000
3/4	14,000	15,000
1"	12,000	-

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