

To Our Customers
*The World Keeps
Spinning...*



Briefly Speaking

Improving
Fabrication
Capabilities In
Hetran



Hetran
Core
Products

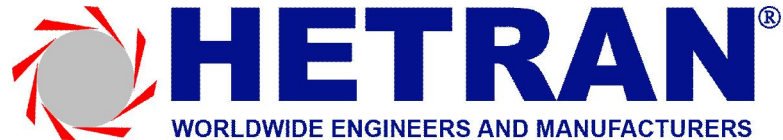
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January 2009

Quarterly
Bulletin

Corporate Headquarters:

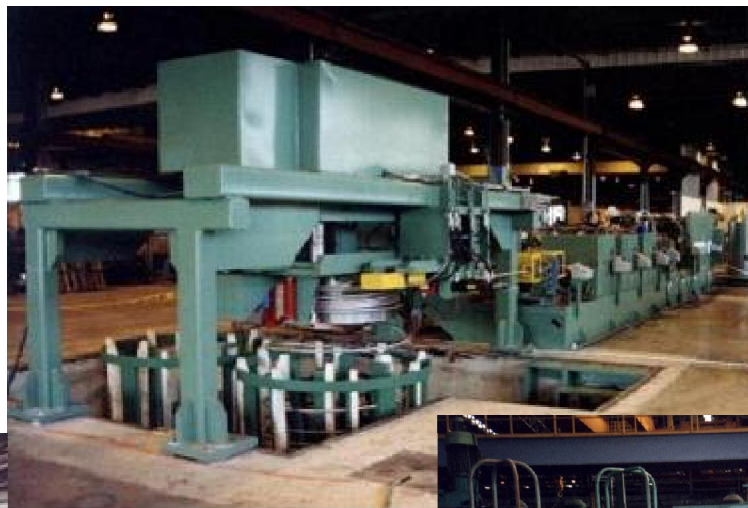
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Hetran Rotary Wire Shaver and Polishing Systems

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The Leading Technology for Peeling Super-Alloy, Titanium and Other
Specialty Metal Coils...

To Our Customers: The World Keeps Spinning...



During a recent staff meeting, we tried to think of a single country that has been unaffected by the financial tremors moving throughout the world economy. Our managers concluded there were none. Countries around the globe are too interconnected. Even Iceland, with its abundant geothermal resources and small population, was rattled. North or South Hemisphere, large or small, service, agriculture or manufacturing based, the status quo in business, government and the global society has been shaken.

Yet, the world keeps spinning. Plans and strategies are being recalibrated worldwide. Organizations are beginning to execute on current problems and opportunities. We are a resilient society.

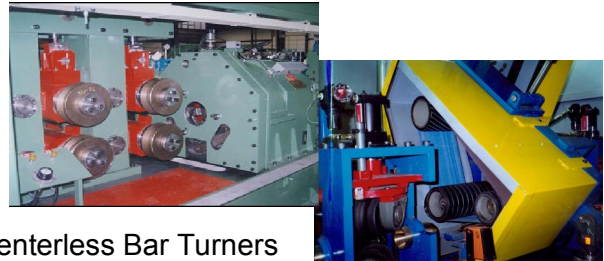
At Hetran we are pursuing many opportunities. A comprehensive review of our installation, commissioning and repair service capabilities is underway. In-house training will begin in January with the goal to improve customer satisfaction. Agents are being added in more countries to respond effectively to customers' needs. We are finalizing our new bar and tube packaging/wrapping lines to add yet another automated and in-line process to our finishing cells. Work on our totally new, compensating, large bar peeling head continues. We will have a special demonstration in our Orwigsburg, Pa. facility this coming spring to show how it significantly improves contact time and peeling productivity.

We would be pleased to meet with you to provide more information about our company and our products. Don't hesitate to contact us.

Helmut Oertmann, President



Hetran's Core Products ... Machines To Meet Your Processing Needs:



Centerless Bar Turners
(peelers)

Coil Shavers (rotary and die)

Coil-to-Bar (turn) Lines

Bar, Tube and Coil Belt Polishing Systems

Belt Polishing Systems for Super-Finishing Bars
Prior to Plating

Two-Roll Vertical Straighteners/Burnishers

High Speed, Dry Abrasive Saws

Horizontal Press Straighteners

Chamfering, Facing and Deburring Machines

Bar End Stamping, Engraving Systems

Bar and Coil End Turn Pointers

Handling Tables For All Types of Processing
Equipment

Custom Designed Bar and Coil Processing Lines

Integration of Eddy Current and Sonic, and
Related NDE Technologies

Cell Configurations For In-Line Continuous
Processing

Hetran also has strong working relationships with producers of related process equipment and regularly integrates these into projects: laser size measurement systems, precision centerless grinding machines, weighing equipment, coolant reclamation systems, turnings conveyors, coil-to-bar drawing lines and multi-roll bar straightening machines.

Latest Machine Builds



An 8" (200mm) turner for titanium that is nearly complete. The machine base, including the turning head, is in the background.



The 200mm turner machine base, with major components, ready for fastening to the base. (Spindle not in turning head housing.)

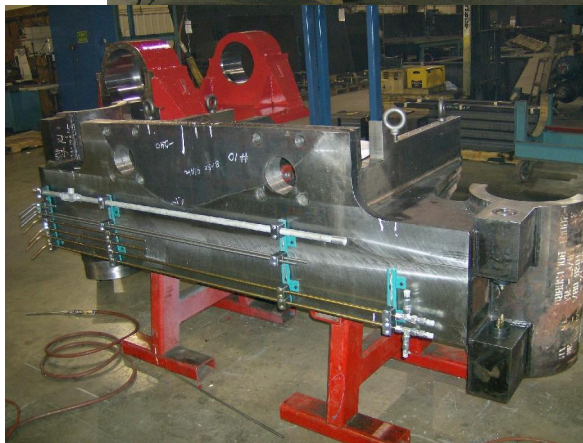


A two-roll vertical straightener, for processing carbon and alloy steels up to 8" (200mm)



A view of the top roll and housing

A guide holder and door assembly, ready to mount onto the straightener.



Customers are cordially invited to see the numerous Hetran large bar turning machines, two-roll straighteners and wire shaving machines which are being fabricated. Do not hesitate to contact your local agent, sales representative, or our Corporate office, to coordinate a visit and, if needed, to request assistance in obtaining a visa.

Feature Story



Hetran Rotary Wire Shaving and Polishing Systems

Hetran produces both rotary shaving ("peeling") and die shaving ("back-die", or "broaching") machines for shaving rod and wire. Both type shavers have wide application in the metals' industries. This article explains why the Hetran rotary shaving system is the preferred shaving technology for many applications

Hetran rotary wire shavers were first introduced in 1971. Today, more than 75 Hetran rotary shavers are being used worldwide in the metals industries. At least 90% of these rotary coil shaving installations include in-line Hetran planetary polishers. Diameters typically being processed range between 2 and 38 mm (.080" to 1.496").



It is significant to note that the vast majority of titanium alloy coils being shaved today are processed on Hetran rotary shaving machines.

There are many reasons why Hetran rotary wire shaving and polishing systems are the leading preference for shaving super alloy, titanium and many other specialty and exotic metals:

1. Feed rates and cutting tool surface speeds are infinitely variable on rotary shavers therefore tool life can be optimized.

Die shaving technology requires a consistently higher surface speed than any die shaving tool will tolerate when processing most super-alloys, titanium and many other specialty metals. Rapid tool wear and failure causes poor size control and can damage the material being processed.

Because tool surface speeds can be varied, rotary shaving is the only productive method for shaving these difficult to machine materials.



A rotary coil shaving and polishing system for high strength stainless and super alloys up to 1.250" (32 mm)

2. Coil breakage caused by tensile stress can be eliminated.

Low ductility metals (e.g., silicon and magnetic irons, many engine valve steels, certain red metal alloys) often cannot withstand the tensile force required to pull the coil through the die shaving tool and coil breakage routinely occurs. Far less tensile force is needed to pull the coil through the rotating cutting tools and coil breakage can be eliminated by varying the rotating cutting tools and line speeds.

3. Rotary shaving will accommodate a significant depth of cut and excessive out-of-roundness of the starting material more so than will die shaving.

Attempts to die shave large volumes of material from the diameter or from the surface of rod that is excessively out of section will cause coil breakage, stretching, and erratic mechanical properties in the coil. Longitudinal surface marks from tool erosion will occur, and size control and roundness will be compromised.

For example, if 0.3 mm or more is to be removed from the diameter of 10 to 15 mm stainless wire rod, or if the starting material has excessive over or under-fill from hot rolling, rotary shaving is the more productive shaving alternative.

4. Rotary shaving has a negligible surface work hardening affect and does not increase the mechanical properties of the finished coil.

Die shaving typically increases tensile strength and surface hardness of the material being processed and can limit its use, depending upon the hardness or tensile specification for the material, or the down-stream processing requirements.

5. Rotary shaving is practical for a much greater range of sizes than is possible with die shaving.

Rotary shaving is readily done between 2 and 37 mm (0.080" to 1.460"). (Hetran built a rotary coil shaver capable of 50 mm.)

Die shaving technology has inherent design and cost limitations which limit the practical size range capability to 5 to 20 mm diameter (0.196" to 0.787").



An automatic compensating head on a rotary wire shaver for diameters up to 1.496" (38 mm)

6. Hetran rotary wire shaving machines are readily expanded into manufacturing cells that contain multiple processing steps, in-line.

These additional manufacturing processes can readily be added due to the fact that feeds and speeds can be varied to meet multiple process needs. Planetary polishers typically are added to provide the capability to produce a wide range of surface finishes from mirror smooth to those that are rougher and ideal for drawing. Eddy current, line marking, pre-coating and drawing capabilities can readily be added in-line. Take-up equipment can be added to dead cast coils down onto carriers for quick removal.



This recently completed rotary wire shaver is a manufacturing cell with multiple processes in-line, including peeling, polishing, rotary and encircling coil eddy current testing, line marking, dead-casting of the peeled and polished coils, and the option to straighten and saw-cut the coil to exact length bars.

7. Hetran rotary shaving and polishing systems provide the capability for acidless processing of coils for drawing.

This is an increasingly important environmental and capital investment consideration. Black coils can be rotary shaved and polished then be taken directly into drawing without the need for process annealing or acid cleaning.

8. Hetran rotary shaving and polishing systems can produce exceptional precision and mirror-like surface finishes.

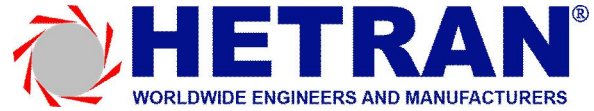
This precision capability can be enhanced by in-line high resolution laser size measurement devices and Hetran automatic compensation turning heads. Diameter tolerances as small as ± 0.0002 " (± 0.005 mm) can be attained on super alloys and titanium via Hetran rotary shaving and polishing. This tight range of diameter tolerances and highly reflective surface finishes cannot be achieved by die shaving.

A coil shaving and polishing system for brass, bronze and copper based alloys.

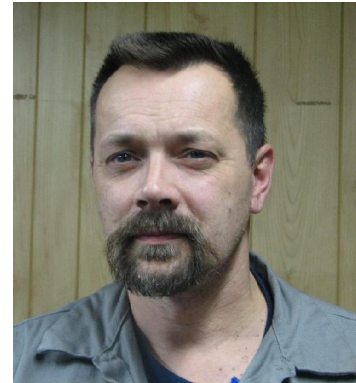


Briefly Speaking

Did You Know ... about Hetran's investments in new machine tools and fabrication equipment?



This new Haas model 1600 CNC Machining Center is a fully automated, CNC controlled, large, 5 axis machine that was commissioned in November, 2008. It has a size capability roughly 36" x 36" x 36" (914 mm) and can accommodate diameters up to 32" (812 mm). This new unit has a probing system and linear scales for optimum repeatability.



Bruce Bensinger
Orwigsburg Plant Manager

"These capital investments will improve our quality and our cost competitiveness. The additional capacity to make larger critical components, in-house, will also help us reduce lead times for building new machines and for fabricating spare parts."

These investments are aimed at increasing capacity, reducing lead times, quality control, and the capability to machine larger components.

Other capital improvements are planned. Hetran has completed the financial arrangements to install a large CNC turn and grind machine with 68" (1725 mm) center to center capacity.

The advantage of this technology is that larger parts can be machined in a single set-up.

New CNC controlled water-jet cutting equipment that can produce parts without a heat affected zone also is being evaluated.

This Tos boring mill will be retrofitted with new CNC controls this spring. The operator, Ed Shuller, is machining a housing for a BT4 turner, currently being fabricated in the Orwigsburg facility



Paul Graburick, machinist, at left, and Bill Ney, Machining Coordinator, review a part being worked on the new Haas CNC. The new Haas CNC is ideal for machining large components and also precision turning head components like head plates, finger boxes and spindles.

Going Forward

The April, 2009 issue of the Hetran Quarterly Bulletin will include a feature article on Hetran two-roll vertical black bar straighteners and bright bar burnisher/straighteners.

The article will highlight several of the newest, large bar capacity machines currently being fabricated in the Orwigsburg facility.

How To Reach Us



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