

## MITGI NEWS

### SHOP NEWS

The last 3 Months at MITGI have been good for us. We continue to stay busy here in the shop. We have been working on new tooling projects as well as keeping our shelves stocked with our product line as well as the product line we carry for our customers. In our R & D Department we have been working with 4 different companies on developing a variety of Bone Drills from the medical industry. Some of the drills are even tested on Cadavers before they are used in surgical procedures. Another part of our business that has shown improvement is our laser Marking Service. When our laser was originally purchased it was used mainly for Laser Marking the tools we produce here. Now we have customers sending their parts for us to Laser Mark. We also are working on increasing the size of our product line and have more of the popular sizes of our Micro End Mills coated and ready for same day shipping.

### END MILL NEWS

We are constantly doing R&D looking for ways to improve our tools & value for our customers. We are striving to make our products the best tools you can buy, at a reasonable price. In a recent case, we developed a different process that resulted in going from making 70 parts per tool, to producing up to 3000+ parts per tools for a customer! This process gave us about a 15% tool life advantage over a very prominent national tool manufacturer, giving our customer more productivity & higher margins in this ultra-competitive economy. We will be implementing this new, proprietary process on more & more products throughout 2009, while keeping our pricing & shop rate the same across the board. By doing this, we hope to add value and profitability as a quality tooling vendor to our customers, aiding them in being successful in this tough market place.

### AND THEN THE FIGHT STARTED!!!!

**After retiring, I went to the Social Security office to apply for Social Security. The woman behind the counter asked me for my driver's license to verify my age. I looked in my pockets and realized I had left my wallet at home. I told the woman that I was very sorry, but I would have to go home and come back later. The woman said, 'Unbutton your shirt.' So I opened my shirt revealing my curly silver hair. She said, 'That silver hair on your chest is proof enough for me' and she processed my Social Security application. When I got home, I excitedly told my wife about my experience at the Social Security office. She said, 'You should have dropped your pants. You might have gotten disability, too.'**  
**And then the fight started....**

### KIDS IN CHURCH

**A Sunday school teacher asked her children as they were on the way to church service,  
"And why is it necessary to be quiet in church?"**

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### Monthly Specials

Watch for our upcoming Monthly Specials. Every month we have one of our stock tools on sale. Listed below are the tools we will have on sale for the next 3 months.

April — Deburring Knives

May — Thread Mills



services,  
“And why is it necessary to be quiet in church?”  
One bright little girl replied,  
“Because people are sleeping.”

### Check out our newly updated website with online ordering available

We have recently updated our website. Take a look and see the new format along with an updated list of tools we have in stock. We also have 2009 pricing for all the tools we carry. We still have our specials page with our monthly stock tool we have on sale. New to the Website is an online ordering option we have added and also our bargain cave. The Bargain Cave will have over stock tools at a discounted price. The tools, which are different Form Tools, Mold Tools, End Mills, and Reamers just to mention a few, are over stock and have been discontinued by the original customer. Take a look and see if there is something that might fit your application. The Bargain Cave will have over stock items beginning sometime in May. Just click on the logo below to take a look at the updated Website.



### WHY MEN DON'T GIVE ADVICE!!!!!!

Dear Walter,

I hope you can help me here. The other day, I set off for work leaving my husband in the house watching the TV as usual. I hadn't driven more than a mile down the road when the engine conked out and the car shuddered to a halt. I walked back home to get my husband's help. When I got home I couldn't believe my eyes. He was in our bedroom with the neighbor's daughter. I am 41, my husband is 44, and the neighbor's daughter is 22.

We have been married for ten years. When I confronted him, he broke down and admitted that they had been having an affair for the past six months. I told him to stop or I would leave him. He was let go from his job six months ago and he says he has been feeling increasingly depressed and worthless. I love him very much, but ever since I gave him the ultimatum he has become increasingly distant. He won't go to counseling and I'm afraid I can't get through to him anymore.

Can you please help?

Sincerely,

Sheila

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Dear Sheila,

A car stalling after being driven a short distance can be caused by a variety of faults with the engine. Start by checking that there is no debris in the fuel line. If it is clear, check the vacuum pipes and hoses on the intake manifold and also check all grounding wires. If none of these approaches solves the problem, it could be that the fuel pump itself is faulty, causing low delivery pressure to the injectors.

I hope this helps,

Walter

### MILL & LATHE FORMULAS

Cutting Speed (surface feet/min)

$$\text{SFM} = 0.263 \times \text{DIA.} \times \text{RPM}$$

Revolutions Per Minute

$$\text{RPM} = 3.82 \times \text{SFM} \div \text{DIA.}$$

Feed Rate (in/min)

$$\text{IPM} = \text{FPT} \times \text{T} \times \text{RPM}$$

Feed Per Revolution

$$\text{FPR} = \text{IPM} \div \text{RPM}$$

Feed Per Tooth (in)

$$\text{FPT} = \text{IPM} \div (\text{RPM} \times \text{T})$$

Metal Removal Rate

$$\text{MRR} = \text{W} \times \text{d} \times \text{F}$$

Converting IPR to IPM

$$\text{IPM} = \text{IPR} \times \text{RPM}$$

Chipload

$$\text{IPM} \div (\text{RPM} \times \text{F})$$

Basic Pitch

$$\text{OD} - .75(\sin 60) \div \text{TPI}$$

Converting IPM to IPR

$$\text{IPR} = \text{IPM} \div \text{RPM}$$

Converting SFM to SMPM

$$\text{SMPM} = \text{SFM} \times .3048$$

Converting IPR to MMPR

$$\text{MMPR} = \text{IPR} \times 25.40$$

Distance over Time (in minutes)

$$\text{L} = \text{IPM} \times \text{TCm}$$

Time Cutting over Distance (Mill) (Minutes)

$$\text{TCm} = \text{L} \div \text{IPM}$$

Time Cutting over Distance (Mill) (seconds)

$$\text{TCs} = \text{L} \div \text{IPM} \times 60$$

Time Cutting over Distance (Lathe) (seconds)

$$\text{TCs} = \text{L} \div (\text{IPR} \times \text{RPM}) \times 60$$



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