

February 2021

# SAFETYZONE MAGAZINE



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to Increase CNC  
Productivity

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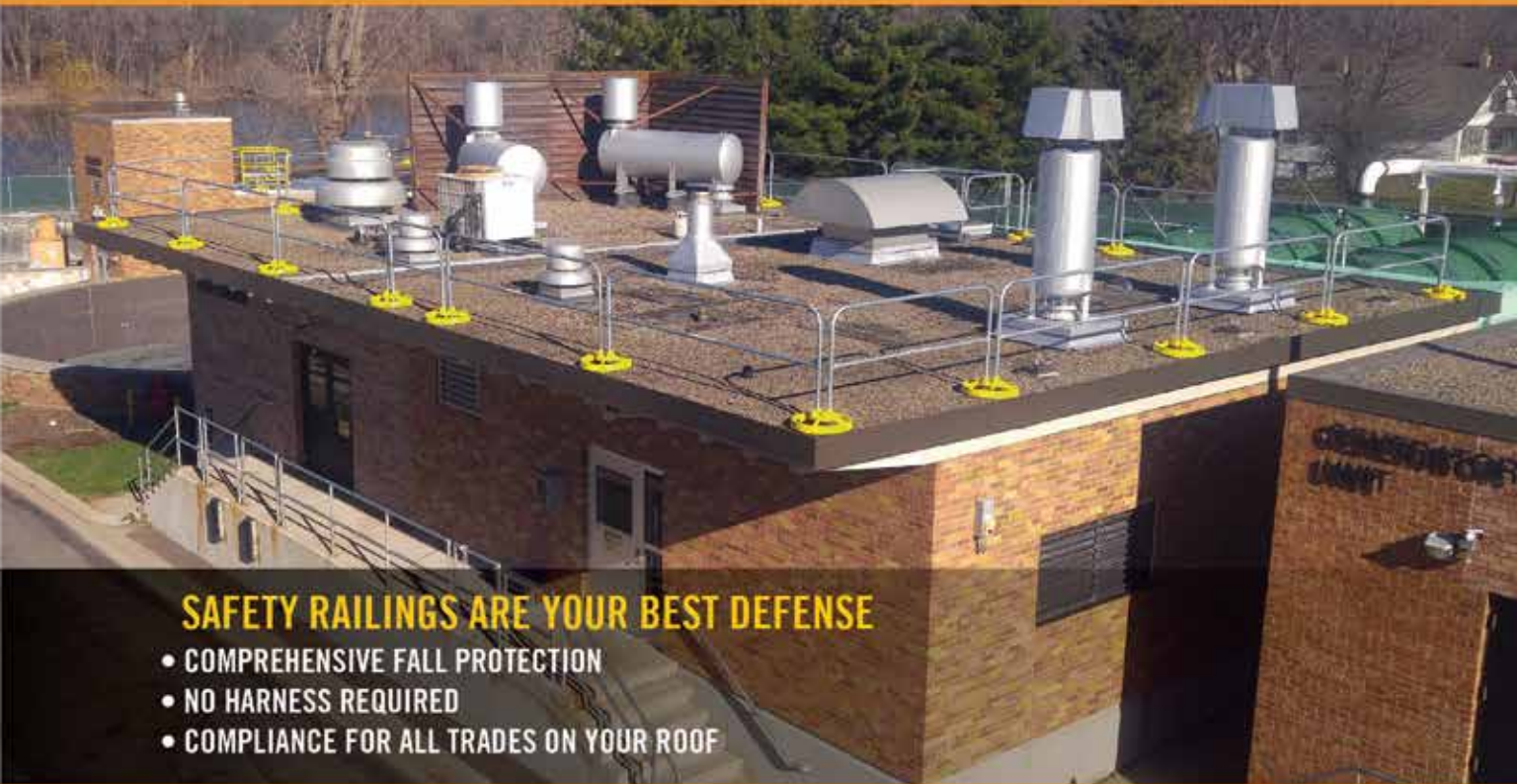
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## Identifying Quality Retention Knobs to Increase CNC Productivity

*Reliable domestic retention knobs utilizing superior U.S. steel can enhance set-up rigidity, which improves tool life and cycle times*

Contract machine shops and OEMs rely on CNC milling machines to produce very precise components in industries such as medical, aerospace, automotive, motorcycle, and gun manufacturing. However, consistently achieving precisely machined components requires a quality retention knob, particularly in high-speed, high-volume applications.

In milling machines, retention knobs are commonly used with tapered tool holders to engage drawbars that hold the tool holder firmly in the spindle. The tapered tool holder comes with threads designed to accept the retention knob, but any improper seating of V-flange toolholders costs manufacturers in lost productivity. It also causes run-out and vibration that reduces the precision of machining while reducing tool & spindle life. This is an extremely common problem in machining.

Beyond this, high-speed machining in excess of 20,000 RPMs is often utilized in aerospace, medical, and other industries when machining exotic alloys and harder metals like titanium. At the higher RPMs, the precise and secure seating of tapered toolholders in the spindle (with the help of the retention knob) is even more critical. So much so, that failing to pay attention to this single detail can lead to further decreased productivity, less precise machining, reduced tool life, and even damaged workpieces.



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That is why strong, well-manufactured retention knobs are so important. A superior product increases the rigidity of the set-up, which increases tool life and speeds cycle times (the measure of the time it takes to complete each part from start to finish.)

The problem is poorly designed retention knobs from overseas are often made of low-quality steel that may be prone to breaking during machining. Newer CNC milling machines exert significantly more drawbar pressure on retention knobs than in the past. As drawbar tension continues to increase in CNC machines, it puts so much pressure on the retention knob, that it may be more likely to break if not manufactured to the highest standard.

Retention knob failures may fail due to other reasons, including improper knob configuration, misaligned machines, metal fatigue, over-torqueing and exceeding the machine's capability. That is why it is essential to periodically inspect each retention knob for signs of excessive wear, damage, or corrosion. If found, the retention knob should be replaced.

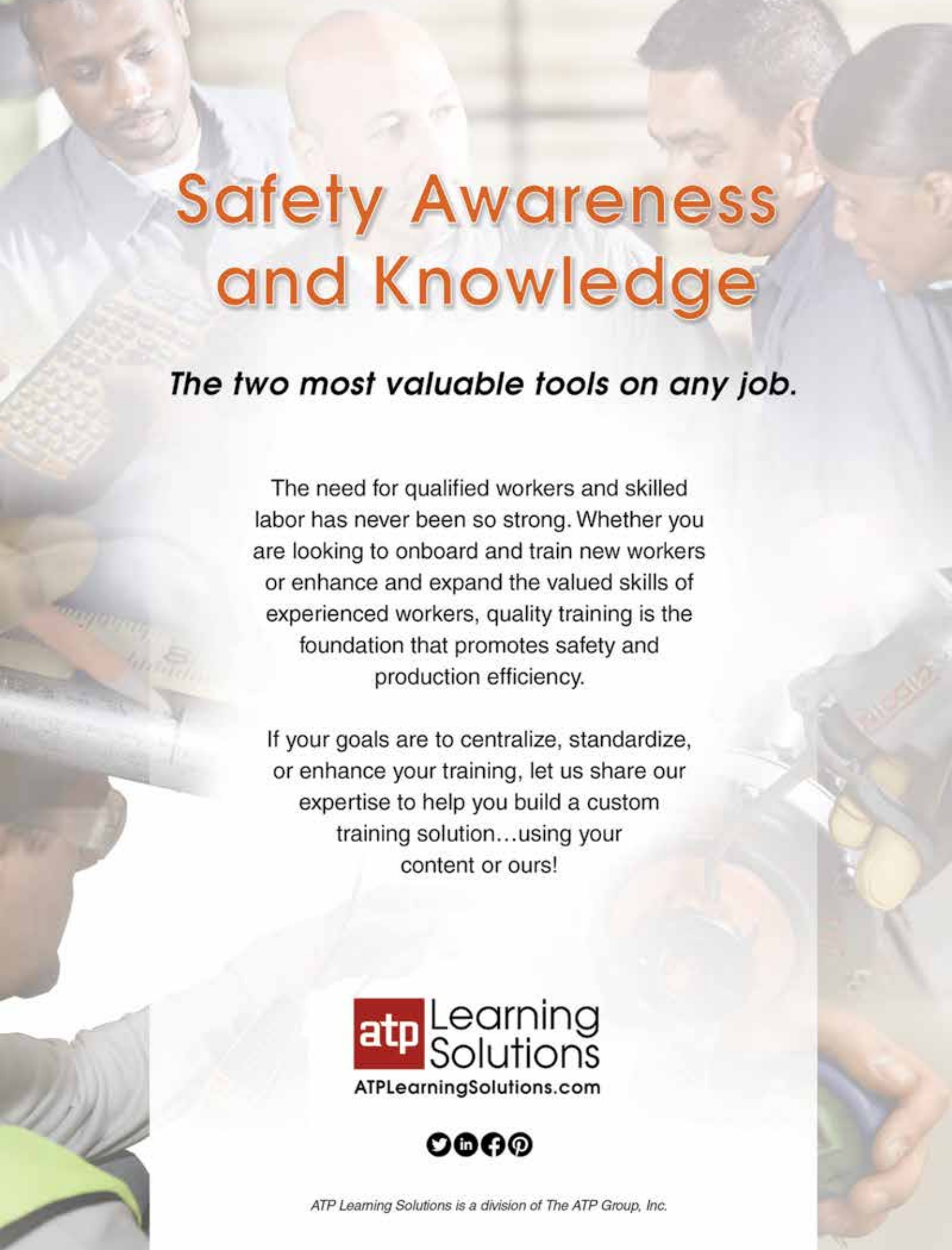
"We deal with a lot of aerospace companies, some with high-speed CNC applications with harder metals or alloys," says Bob Selleck, Manager at SAG Supply, a Long Island, NY-based provider of high-quality industrial tools, machinery and accessories. "For that, you need a reliable retention knob that will last without breaking or moving. It needs to hold everything tightly in place with precision."

Although retention knobs often look very similar, they are not interchangeable. The materials, coatings applied, and the quality of manufacturing can be important differentiators. Another consideration is where the item is manufactured, given that some overseas imports have a reputation for lower quality.

"Some [retention knob] imports do not always fit snugly or precisely in the flange and may wobble or move a little bit under high-speed applications," adds Selleck.

The most reliable retention knobs are those made with superior U.S. steel and coated with black oxide, to prevent corrosion. In addition, the retention knobs should be subjected to the most rigorous quality control standards, including frequent inspection by the manufacturer.

As an example, Selleck points to Ohio-based T.J. Davies, a manufacturer of high-quality retention knobs that utilizes certified 86L20 and 9310 steel drawn in the United States. He adds that SAG Supply carries TJ Davies retention knobs for their reliability at higher RPMs during CNC machining.



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86L20, a low alloy nickel, chromium, molybdenum case hardening steel, has high hardenability without temper brittleness, along with good external and internal strength, and high wear-resistance. However, if a CNC operator desires and even higher quality steel, they can choose a retention knob made of 9310, a low alloy steel composed mostly of nickel and chromium. This alloy also has high hardenability, core hardness and fatigue strength, which makes it an excellent steel for use in heavy-duty machinery.

"We have found the domestic TJ Davies retention knobs to be of higher quality and more reliable than imports," says Selleck. "They do not break; they last longer even at higher speeds with harder metals. We have carried them for over 10 years, and I have never heard of a problem or complaint."

Long-term reliability also depends on utilizing a superior coating to prevent corrosion. For this reason, each retention knob is coated with black oxide. In this process, the top layer of the ferrous material is treated with chemical that convert the surface to prevent rust. Black oxide also increases abrasion resistance while providing a decorative finish.

"I have never seen one of the black oxide coated retention knobs rust, and we sell a lot of them," says Selleck.

If a retention knob ever needs to be replaced, it also helps to have quick shipping from a domestic supplier rather than dealing with lengthy overseas shipping and logistics. Manufacturers like TJ Davies can ship items same day with no minimum order and will drop-ship to end users on behalf of distributors.

"When I need retention knobs, I do not want to wait for overseas shipping," says Selleck. "When I order domestically, I usually get what I need within two days."

Because contract machine shops and OEMs require utmost CNC precision and productivity at all times, utilizing reliable retention knobs made with superior U.S. steel, coated with black oxide, can actually become a competitive manufacturing and production advantage.

For more information: call 440-248-5510; Fax 440-248-5546; email [sales@tjdavies.com](mailto:sales@tjdavies.com); visit [www.tjdavies.com](http://www.tjdavies.com); or write to T.J. Davies Co. Inc., 16995 W Park Cir Dr, Chagrin Falls, OH 44023.

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# The Concrete Safety Solution

Often overlooked as a dangerous job, concrete truck drivers risk their lives at every assignment. With blind spots, difficult drop-off sites, and multiple personnel in the surrounding area; there is a multitude of obstacles and worriment to overcome.

However, truckers should rest assured that there is technology out there that is specifically designed to assist with these hurdles. Safety Vision, LLC is dedicated to creating mobile surveillance systems that mitigate hindrances in the industry; and with their complete concrete mixer solution, the support needed is embedded in the truck.

## **Observer 4401™ HVR**

<http://www.safetyvision.com/products/observer-4401-hvr>

Serving as the foundation of the solution, the Observer 4401 Hybrid Video Recorder (HVR) collects and retains all the vehicle's information, including the metadata and video footage. Equipped with two SD card slots, it can hold up to 512 GB of video, which is a substantial amount and vital to enforcing the most effective and safe operations.



By reviewing the array of recorded video, businesses can learn which practices need improvement, as well as which ones are favorable. These insights can then be shared with the truckers in order to improve their overall operational awareness. Moreover, businesses are empowered to turn these recordings into first-hand training videos for all established and new employees. This ensures that all personnel are knowledgeable and up to date about how to best follow their practices.

## **SV-EXTCAM HD**

<http://www.safetyvision.com/products/sv-extcam-hd>

By placing multiple cameras on the truck's exterior, the entire surrounding area is captured; making it easier for drivers to focus on the given task at hand. When the cameras act as the second pair of eyes for the vehicle, the trucker can devote their attention to their route and/or dropping off the concrete.



Additionally, exterior cameras provide protection against false claims. When the incident is captured on video, the "he said/she said" aspect is diminished, since all evidence is observed by the cameras.

## **CP4™ Monitor**

<http://www.safetyvision.com/products/cp4>

The CP4 monitor completes the solution, which allows the driver to see through the camera's lens in real-time. With multiple split screen views, the monitor is able to play 9 cameras at once: whether they be

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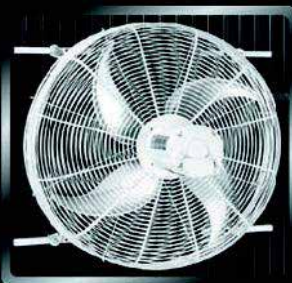
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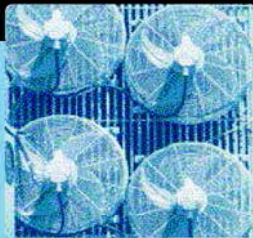
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placed internally or externally. This product truly allows the driver to focus on the task by managing distractions: they no longer have to attempt to maintain complete visibility on the road, their surroundings, and the drop-off; they have a second pair of eyes right there with them.

Utilizing the monitor not only enhances visibility for the surrounding area, but also establishes a better view of the drop-off area. Drivers can rest assured that they are completing it in an optimal and efficient manner because their drop-off is on the screen in front of them. Safety is guaranteed.

While concrete truckers face many difficulties while on the road or at drop-off sites, Safety Vision's complete concrete surveillance solution offers that helping hand needed to ensure safety on the job. By using the system, truckers gain confidence in every facet of their job by depending on their surveillance system for security.

*Written by Alicia Delgado, the Marketing Manager for Safety Vision, LLC.*

To learn more, please go to <http://www.safetyvision.com>

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# New Partnership to Strengthen JLG Electrification Capabilities

*JLG and Oshkosh partner with Microvast on development of battery technologies*

JLG Industries, Inc., an Oshkosh Corporation company [NYSE:OSK] and leading global manufacturer of mobile elevating work platforms (MEWPs) and telehandlers, is pleased to announce a planned investment by parent company Oshkosh Corporation in Microvast, a global provider of next-generation battery technologies for commercial and specialty electric vehicles. This new partnership, in combination with the company's existing electrification supply chain partners, will continue to strengthen and advance the development of industry-leading electrified solutions across the JLG® product line, including boom lifts, scissor lifts, low-level access lifts, vertical access lifts, stock and order picker lifts, towable lifts and telehandlers.

According to Frank Nerenhausen, Oshkosh Executive Vice President and President of JLG Industries, this relationship enhances the Company's product development and technology roadmap. "JLG is focused on electrification and the delivery of sustainable technologies that are environmentally friendly without a compromise to performance. We believe advancing battery technology is crucial to striking this balance."

JLG has been at the forefront of the industry's movement toward electrification, having offered electric products since the mid-1990s when the Company launched its first electric boom lift. Recent electric product introductions include the industry's first all-electric scissor lift — the AE 1932 DaVinci™ model. "Our new DaVinci all-electric lift represents the future of electrification — every component is optimized to deliver premium performance and value to the customer," says Nerenhausen.

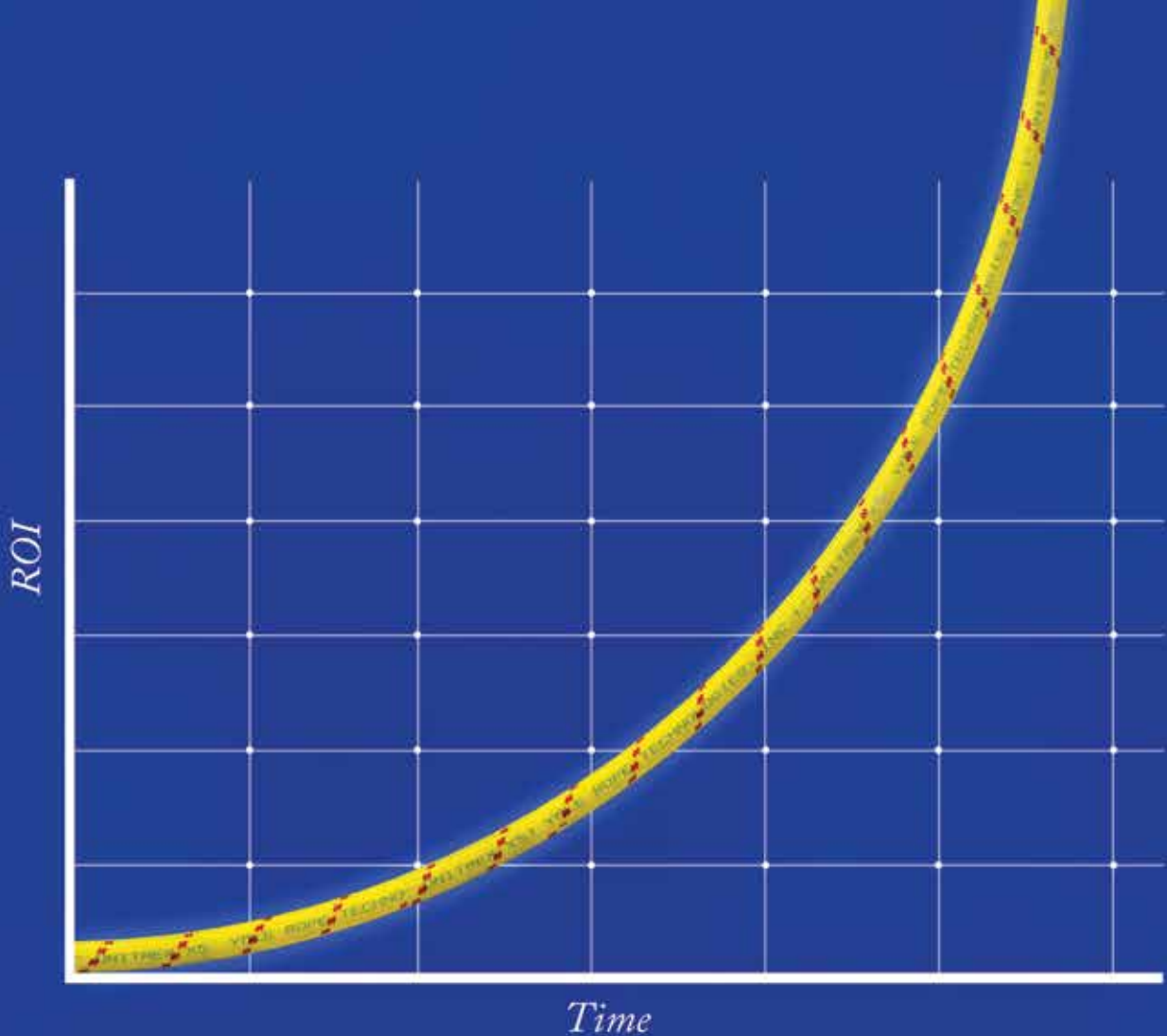
"Our strategic investment in Microvast is an excellent addition to Oshkosh's electrification focus and established partnerships," said John C. Pfeifer, Oshkosh Corporation President and Chief Operating Officer. "These partnerships, combined with Oshkosh's highly-capable product development team, support our expanding leadership with technology-enabled products across the markets we serve."

Oshkosh agreed to make a \$25 million private investment in public equity, or PIPE, in Microvast, who announced a merger with Tuscan Holdings Corp. on February 1, 2021. Oshkosh and Microvast also entered into a joint development agreement highlighting future battery collaboration and integration. To learn more about Oshkosh's core innovation areas, visit [www.oshkoshcorp.com/brands-innovations](http://www.oshkoshcorp.com/brands-innovations).

For more information about JLG, visit [www.jlg.com](http://www.jlg.com).

#### *About JLG Industries, Inc.*

*JLG Industries, Inc. is a world-leading designer, manufacturer and marketer of access equipment. The Company's diverse product portfolio includes leading brands such as JLG® aerial work platforms; JLG and SkyTrak® telehandlers; and an array of complementary accessories that increase the versatility and efficiency of these products. JLG is an Oshkosh Corporation company*



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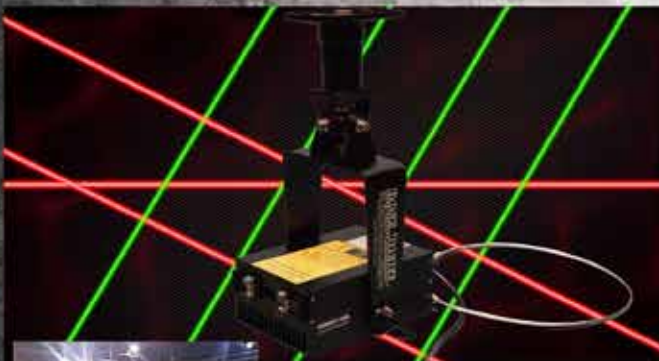


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