

ORACLE

Journal of the Institute of Sheet Metal Engineering



**AGM and
Gold Medal Dinner**

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Skills Competition

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**MMMA set for
MACH 2018**

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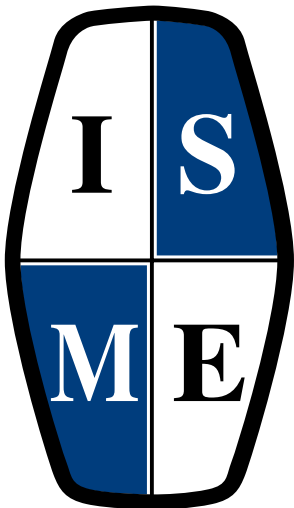
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The Oracle, mouthpiece of the Institute, speaks for and to the world of Sheet Metal Forming & Pressworking by way of featuring News, Views and Topics around the Industry

From the Secretary

Dear ISME Members,

Welcome to the Autumn edition of the ISME Oracle. In this edition we cover the AGM and Gold Medal Dinner where members and guests had the privilege of hearing from Mark White about his work introducing lightweight components into JLR's Body in White and another successful ISME Skills Competition held at Coventry Motor Museum.

We have also contacted some ISME Members to tell us a little about their work and found what a diverse and interesting membership we have ranging from industrial magazine editors, through cavalry helmet makers to producers of parts for heritage vehicles.

We also welcome new member Andy Connell of Sowerby Bridge.

A works visit is planned in November (see Martin Robey article for details) and we will be at the Birmingham Thinktank again next February for another "Meet the Experts" day.

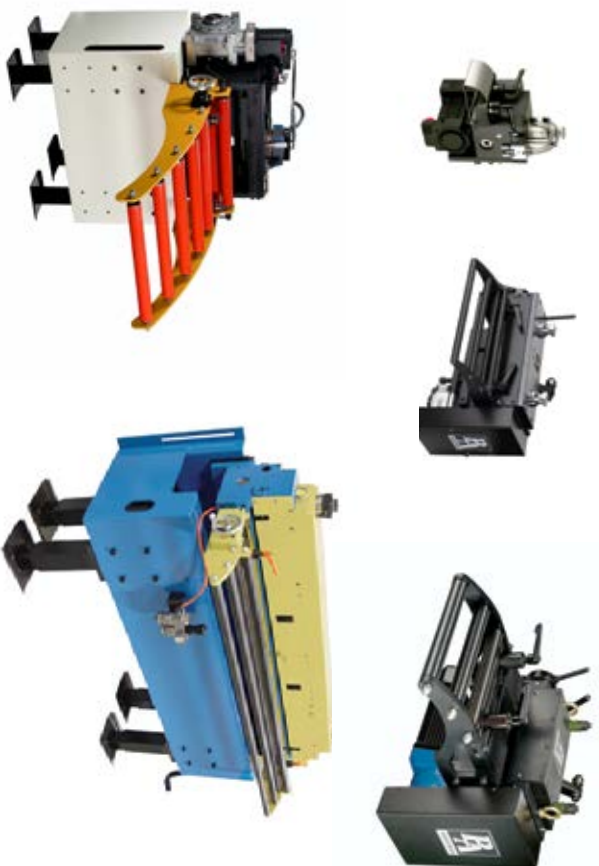
The feedback from members and companies is that business levels are good for machine suppliers and metalworkers and it is pleasing note the increasing level of apprentices being employed and the specialised training being set up to provide relevant, high quality training.

Bill Pinfold - ISME Hon Secretary



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AGM & Gold Medal Dinner 2017

The 72nd Annual General Meeting held on Thursday 11th May 2017 at Aston Wood Golf Club, Blake Street, Little Aston, Sutton Coldfield

The AGM formalities were opened by Chairman Steve Morley who welcomed members and guests.

There were no changes to the ISME Council.

Copies of the Annual Accounts for 2016 were handed out to members for discussion purposes.

Report Of Council

The Chairman presented his report on the past year:

Welcome to all members and guests to our 72nd AGM here at the Aston Wood Golf Club, I'm pleased to say that we can again combine this event with the award of our prestigious Gold Medal award.

2016 has been another busy year with a number of successful events arranged. The Skills Competition was hosted by Cosford Aerospace Museum. 29 trainees entered with the winner being Ben Lang of Babcock. We are grateful to our sponsors IMechE, Sertec Group, CBM, AP&T Group, Radshape, Bauromet, Midland Power Press Services and Babcock Marine for their support.

Another very successful "Meet the Experts Day" was held at the Thinktank Museum, Birmingham. Sertec, provided stands for the event supported by several ISME members and friends. This is an important ISME initiative to involve young people in engineering.

The Institute's journal, Oracle has been regularly produced by our Editor, Brian Chappelhow and many positive comments have been received about the quality and content of the magazine.

Advertising revenue has been maintained but Council are seeking ways to get the publication to a break even situation.

Membership has remained constant with new members recruited to replace retirements.

Finally, I would like to thank Josie and MPPS for the financial accounting that they do for the Institute.

The report of Council was proposed for acceptance by Mr. D. Glennon and seconded Dr. A. Foster

Retirement/ Election Of Officers

The Officers were prepared to stand again and there being no other nominations were re-elected unopposed. The following council members were due to retire by rotation and had indicated their willingness to stand for re election:- Dr. A. Foster, Prof. D. Mynors and Mrs. J. Stevenson who were unanimously re-elected. Barry Smith of H T Brigham Ltd. was nominated to join Council and was also unanimously elected.

The report of Council was proposed for acceptance by Mr. D. Glennon and seconded Dr. A. Foster.

Following the AGM, ISME Members and Guests moved for pre-dinner drinks prior to the Gold Medal Dinner.

The Gold Medal Dinner was attended by 54 Members and guests held in honour of Dr Mark White, former Chief Technical Specialist for Lightweight Structures for Jaguar Land Rover.

It was an excellent evening with good service from the Aston Wood Golf Club Staff.



Gold Medal presented to Dr Mark White - former Chief Engineer, Body Complete

The following citation was presented framed with the Gold Medal to Dr Mark White, Former Chief Eng. Body Complete.

Mark has worked for Jaguar for most of his career since graduating from Coventry University in 1983. Starting in Body Engineering back in 1987, in 2002 took responsibility for Jaguar and Land Rover Body in White Engineering. In 2004 he became Chief Technical Specialist, and in 2012, as part of Jaguar Land Rover expansion, Mark took responsibility for the newly formed Body Complete Business Unit, responsible for design and development of all JLR body structures, sheet metal, closures, roof systems and related mechanisms. Mark has led JLR's drive to reduce overall vehicle weight, and was awarded a Doctorate in Engineering by Brunel University in 2011. His career highlights include leading the development of all aluminium-intensive JLR body structures over the past 15 years and working with the supply base to develop new alloys and processes to improve performance and reduce the cost of lightweight technology. Mark retired from JLR in April 2016 but remains a self-confessed car fanatic, driving the great roads of the world, watching motor sport and doing as many track days as he can.


ISME Chairman Steve Morley closed the Dinner thanking all attending and looked forward to next year's event.



Roeland Vermoere & Chris Sharratt of Nidec Minster presented with their new ISME membership certificate

Companies Attending The Gold Medal Dinner





Member News - Andrew Sandford

Andy is a former Council Member and Chairman of ISME.

Earlier this year he took over the ownership of Engineering Capacity magazine, which covers contract and subcontract manufacturing - including pressworking and sheet metal work - for OEMs and higher tier manufacturers who want to buy those services.

He had previously been editor of the magazine for eight years and now combines that role with the commercial aspects of the magazine and website.

Any member who thinks they have a story they might like to cover are more than welcome to get in touch, and if anyone wants to consider advertising with them there will always be very favourable rates for ISME members.

Please email him at
Editor@engineeringcapacity.com

If you want to get your own copy of the magazine and newsletter please subscribe on
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PROUD



Nobles and FloorStak teamwork is a winner at Liverpool FC

In order to comply with the UK Equality Acts 2006 and 2010, all football grounds have a duty to provide suitable facilities for disabled supporters. Liverpool FC awarded a contract this year to Nobles Construction for ground improvements which will ensure compliance.

FloorStak (a proprietary product of Regent Engineering Ltd) was approached by Nobles Director, John Watson, to design, manufacture and install 3 platforms in different areas of the grandstand, with a tight deadline for completion during the "closed season" window. Part of the design brief was that the platforms must be demountable in sections so that the spectator capacity allocated to disabled spectators could be adjusted to suit demand.

The programme involved increasing the number of wheelchair bays from 195 to more than 250 positions, adding more than 150 extra amenity and easy-access seats around the stadium, improving viewing positions for visiting disabled supporters, and creating new raised disabled bays in the Centenary Stand for disabled supporters.

Using a combination of standard FloorStak components and bespoke designed parts, the platforms were manufactured off-site then subsequently fully installed within the 3 week window allocated by the club.



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50 years' service for Master Craftsman John Davies MISME

John works as a Master Armourer at the oldest UK manufacturing company, Firmin and Sons Ltd in Birmingham. Firmin was established in 1655 and make ceremonial buttons and armour by hand and previous customers include Admiral Lord Nelson and the Duke of Wellington. They are currently the Official Armourers to the Queen's Household Division and John specialises in making the helmets and breast plates worn by these men.

John started at the company as an apprentice and has recently completed 50 years service which was marked by an award by his company which was featured on several BBC News bulletins in August. A short video of John making a helmet can be found on the BBC web site by searching for "Firmin and Sons". In it, he says he loves his job but every handmade helmet is a challenge.

John has been a Senior Judge at the ISME Skills Competition for many years and he donated a half size model helmet as a trophy for the Open Class to be awarded annually.



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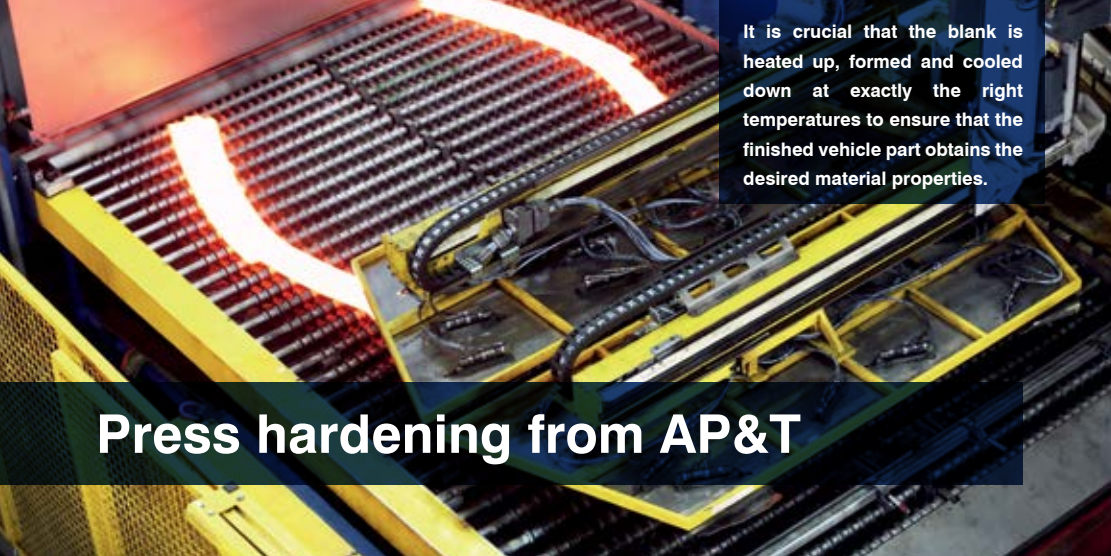
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It is crucial that the blank is heated up, formed and cooled down at exactly the right temperatures to ensure that the finished vehicle part obtains the desired material properties.

Press hardening from AP&T

New system for process monitoring results in higher product quality

Higher and more consistent quality of the formed vehicle part, possibility for shorter cycle times and better control over the entire manufacturing process. This is what customers can expect from AP&T's new process monitoring system for press hardening – in-line process monitoring – which is now being introduced to the market.

Pyrometers and infrared cameras are used to measure the material's temperature with a high degree of precision both before and after pressing. The pyrometer registers the absolute temperature at a certain point, while the infrared cameras are used to read the heat distribution on the part's surface. All of this takes place without any of the equipment coming into physical contact with the material. It is crucial that the blank is heated up, formed and cooled down at exactly the right temperatures to ensure that the finished vehicle part obtains the desired material properties. The higher the degree of precision, the better and more consistent the result.

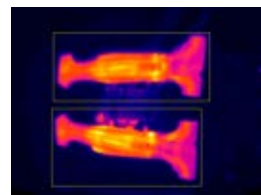
"Our monitoring equipment enables our customers to achieve an optimized and well-controlled process that gives the end product a higher level of quality," says AP&T Project

Leader, Technology Development Jörgen Theander.

In-line process monitoring was developed from the start to meet the demands placed both by the process and customers, and it satisfies the car manufacturers' standards, such as CQI-9.

"The system was produced in cooperation with our customers, and it is designed completely in line with our specifications. It has been tested during practical operation both externally and in our own press hardening line in Ulricehamn over a one-year period. The results have been excellent, and several of our customers have already decided to invest in the new system.

The press hardening technology enables sheet metal parts to be manufactured with low weight and high strength, which results in lighter, safer and more energy-efficient cars. AP&T is one of the world's leading suppliers of complete production solutions for press hardening.



AP&T's in-line process monitoring measures the material's temperature with a high degree of precision both before and after pressing.



MMMA Metalworking Village set to be best yet

The MMMA are very excited to announce that there will be over 550 square metres within the Metalworking Village for MACH 2018.

Visitors to Hall 20, Stand H20 – 327, will be interested to see a number of leading edge Technologies on display, featuring over 20 member companies. These will include technologies from:-

Press Form, Midland Power Press, Presscare, Bruderer UK, Roemheld UK, Schuler Presses, P J Hare, Worcester Presses, Decade Monitoring, Worlifts Ltd, I Mach, Crescent Machinery, Oerlikon, ASC UK, Cotswold Machinery, Group Rhodes, AP&T, Orthinghaus UK, AIDA, TMA Engineering, Industrial Clutch, Voith Turbo, MTL Engineering, Press Techniques, Ross UK.

With so many working exhibits on display, the MMMA, Metalworking Village looks set to be the best yet for attracting visitors.

More information available at www.mmma.org.uk



Report on CBM Health and Safety Group Meeting July 2017

Jenny Skeldon (HM Inspector of H&S) Manufacturing Sector gave an update on current policy.

During visits inspectors will pay particular

attention to exposure to asthmagens and carcinogens, metal working fluids and weld fumes and the methods in place to control and measure exposure.

The Priorities are:

- Controlling exposures to substances causing occupational lung disease
- Reducing the incidence of common work-related ill-health conditions, such as MSDs and work-related Stress
- Preventing serious incidents involving heavy loads, during maintenance activities and catastrophic events

Energy Savings Opportunity Scheme (ESOS) Phase 2

CBM CEO Geraldine Bolton gave an update on the Energy Savings Opportunity Scheme (ESOS) phase 2. The legislation means all qualifying organisations have to prepare mandatory energy audits. A qualifying company has at least one of their UK group members with 250 employees or more, turnover above 50m euros, or a balance sheet value above 43m euros. The scheme covers all power and fuel used by a company for industrial processes, building and transport. If your business will be affected, you must start now to put in a comprehensive programme of analysis and data collection for the months ahead to complete the audit.

This is where the CBM can manage the ESOS process for you. They have specialist technical expertise in the metal forming industry processes and many years of energy expertise.

Geraldine also reported on a retrospective demand for rates on the solar panels mounted on the CBM building's roof which would more than wipe out any revenue achieved from the panels.

HSE releases annual workplace fatality figures

The Health and Safety Executive (HSE) released in July its annual figures for work-related fatalities, as well as the number of people known to have died from the asbestos-related cancer, mesothelioma, in 2015.

The provisional annual data for work-related fatal accidents revealed that 137 workers were fatally injured between April 2016 and March 2017 (a rate of 0.43 per 100,000 workers), the second lowest year on record.

There has been a long-term downward trend in the number of fatal injuries to workers – they have halved over the last 20 years – although in recent years the trend shows signs of levelling.

The new figures show the rate of fatal injuries in several key industrial sectors:

- **30 fatal injuries to construction workers were recorded.** While this accounts for the largest share, this is the lowest number on record for the sector. However, over the last five years the number has fluctuated. The annual average for the past five years is 39. The annual average rate over the last five years in construction is around four times as high as the all industry rate.
- **27 fatal injuries to agricultural workers were recorded.** This sector continues to account for a large share of the annual fatality count. It has the highest rate of fatal injury of all the main industry sectors, around 18 times as high as the all industry rate.
- **14 fatal injuries to waste and recycling workers were recorded.** Despite being a relatively small sector in terms of employment, the annual average fatal injury rate over the last five years is around 15 times as high as the all industry rate.

The fatalities in the waste and recycling sector in 2016/17 include the single incident at Hawkeswood Metal Recycling Ltd in Birmingham on 7 July 2016 which resulted in five deaths.

The new figures also highlight the risks to older workers – around a quarter of fatal injuries in 2016/17 were to workers aged 60 or over, even though such workers made up only around 10% of the workforce.

There were also 92 members of the public fatally injured in accidents connected to work in 2016/17. Almost half of these occurred on railways with the remainder occurring across a number of sectors including public services, entertainment and recreation.

Mesothelioma, one of the few work related diseases where deaths can be counted directly, contracted through past exposure to asbestos killed 2,542 in Great Britain in 2015 compared to 2,519 in 2014. The current figures relating to asbestos-related cancer reflect widespread exposures before 1980. Annual deaths are therefore expected to start to reduce after this current decade.





Sales growth helps Worcester press on with new home and identity

Major demand from customers in automotive and white goods has helped a Black Country manufacturing specialist relocate, putting it on course for another record year.

Worcester Presses, which provides a range of mechanical and hydraulic presses and coil processing equipment for clients all over the UK, has completed a move from its traditional home in Stourbridge to a more modern facility on Peartree Lane in Dudley.

The new site features built-in offices, central stores, a large machine shop and a dedicated 6000 sq ft engineering area that is supporting the firm's desire to offer more turnkey solutions on the equipment it supplies.

It marks a new era in the company's 68-year history, as the relocation has paved the way for a new corporate identity and the appointment of Ivan Littlewood as Engineering Director. He will be in charge of the management and control of Worcester Presses' engineers, including

in-house manufacture, commissioning of new machines and servicing.

"2016 was a very good year for our business and that upward trend is continuing with the first eight months of 2017 delivering even more deals and the real possibility of achieving record breaking turnover," explained Charles Higgins, Director at Worcester Presses.

"Whilst some firms are understandably nervous about Brexit, we've seen nothing but growth since the vote, with this increase being driven by our traditional automotive customer base and emerging opportunities in white goods and the building trade."

He continued: "In particular, we are being asked to supply more turnkey machinery packages and that really drove our decision to move to the new factory in Dudley, which is better suited to adapting presses and coil handling equipment. Whilst only a few miles away, we have also seen a massive difference in transport times."

The mechanical Chin Fong range of presses is still the core of the Worcester Presses' business, closely followed by its growing range of Tomac Coil Handling equipment, Yeh Chiun hydraulic presses and press transfer equipment.

Employing 12 people in Dudley, the company has seen a 35% increase in sales for its Yeh Chiun range of hydraulic presses, offering both C Frame and straight side presses to customers involved in the metal forming and stamping industry.

As part of its desire to expand its offering, the firm has also signed an agreement with a press transfer system specialist to supply complete automation packages in the UK, providing clients with a way of streamlining labour intensive manufacturing applications.

Russell Hartill, Sales Director at Worcester Presses, went on to add: "Since 2015, we've probably grown by about 25%. When we sat down and looked at what was behind that it was clear that our customers were demanding more configurations from their machines and the ability to customise presses so they can carry out more complex operations.

"This was a key driver in our relocation as we needed more space, a higher roof and a layout that wasn't restricted by the confines of our previous site that was built in the 1800s."

He concluded: "Our product offering has also been strengthened with a series of new agreements. Not only can we offer our existing equipment - mechanical presses, hydraulic presses, decoilers, straighteners and servo roll feeders - but we are also now in a position to supply a fully automated press transfer line, with complete after sales support."

Worcester Presses has recently taken on an apprentice to assist in the electrical division and have plans in place to increase the workforce between now and the end of 2018.

For further information, please visit www.worcesterpresses.co.uk or contact 01384 392266



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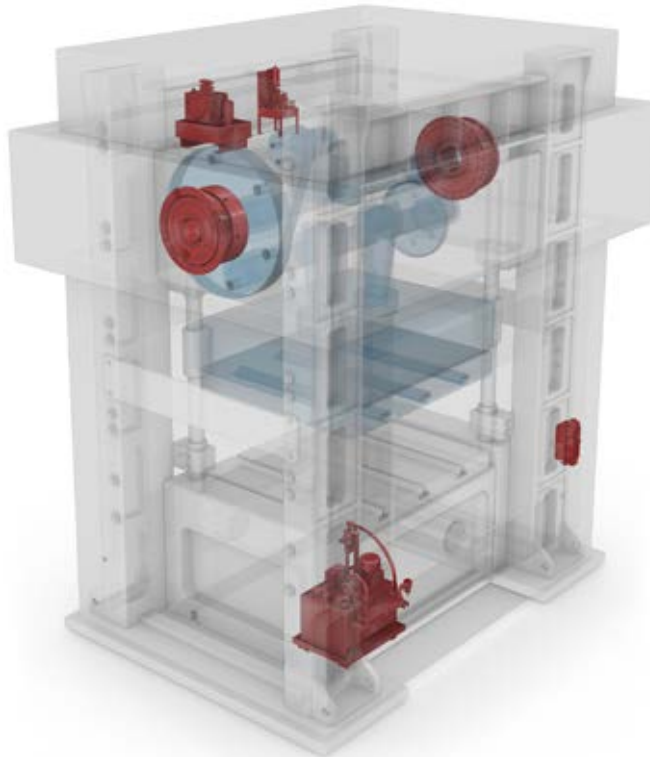
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Sheet Metal Skills Competition

ISME thank the Museum Staff especially, Karen Burgess, Clive Parker-Skelhon and the catering staff for the excellent lunch.

The Apprentices and Trainers were very impressed with the Museum exhibits layout and facilities.

This year's event bought in 25 apprentice competitors from 3 companies. This shows the need for young talent to make or maintain our metal commodities whether in aerospace, ship building, automotive, construction, catering or retail hardware.

With Competitors from, Babcock Marine Technology, Sertec and PAB Coventry we had a good mix of test pieces to judge.

The Categories were:

- Wall vent year 1
- Ducting year 2
- Hinged Clasp (category for toolmaking apprentices)
- Hinged Clasp Checking Fixtures (category for toolmaking apprentices)
- Open class exhibits.

We continue to praise the skills of the Apprentices for their workmanship and quality. Dimensional accuracy of the test pieces this year were to a very high standard with marking very close in all categories. The Open Class entries as normal gave the Judges a challenge to identify skills and originality.

ISME also judge their written technical document that accompanies the component they have made. We believe that the written word is an essential part in the planning of how they go about producing their exhibit. Like all events in today's environment we are indebted to our event sponsors;

- Bruderer
- Institution of Mechanical Engineers (ImechE)
- Sertec Group holdings
- Confederation of British Metalforming (CBM)
- AP&T Group
- Radshape
- Bauromat
- Babcock Marine
- Midland Power Press Services

Without their support there would not be a competition.



**View gallery and this
year's winners overleaf**

This Year's Award Winners

While Judging took place the Contestants, Trainers & Guests enjoyed the very interesting Museum.

As previously mentioned the ISME judges thought the quality standard was exceptionally high with the following awards given;

- Wall Vent Test Piece Winner (Frank Cooper Award) Lewis Blakemore Sertec
- Wall Vent Test Piece Written Winner, Amy Hayes Babcock
- Ducting Test Piece Winner, Sam Joyce Babcock
- Ducting Written Winner (Ted Rosmarin Award) Alexander Johnson Babcock
- Clasp Test Piece Make Winner Cameron Wallace PAB
- Clasp Test Piece Written Winner Austin Forletta Sertec
- Clasp Checking Fixture, Winner Matthew Murchington Sertec
- John Davies Award Open Class winner, Stephen Livick Babcock
- Open Class Written Award Winner, Alexander Johnson Babcock
- ISME Trophy Overall Winner, Alexander Johnson Babcock

Thanks must go to the Company trainers, colleges and training schools for the time effort and support they give to the students and apprentices. Without their commitment there would not be a competition. This also applies to the support of the ISME judges who provide their time free of charge. We are currently planning to hold the 2018 event again in June which appears to be better for the College and training providers' time table. If you are interested in the next competition please contact; Adrian Nicklin ISME Event Officer adriannicklin@btinternet.com, Mobile 07774 260126



Martin Robey - Profile

Martin Robey Engineering Limited, has for many years been acknowledged as the major player in the manufacture and supply of parts for the Classic Jaguar and Jensen marques. Since 1978 a manufacturing facility has developed that is diverse, flexible and efficient.

The Company has facilities to manufacture a wide range of components from small brackets and deep drawn pressing to complete body shells for the Jaguar E-Type and Jensen Interceptor.

Martin founded the Company in 1978 while working as a Time Served Sheet Metal Engineer. He started to manufacture a Front Wheel Arch repair for MK.II Saloons as a joint venture with a friend. Being one of the first high quality repair panels made available at that time, demand soon took off in what was the early beginnings of the Classic Car Movement.

At the same time, an S Type Saloon was brought to Martin for restoration and when finished, so good was the workmanship that it brought in other orders for similar work. The parts were showed to an existing Classic car parts dealer and orders were placed from then on, leading to gradual expansion with certain leaps and bounds and many milestones along the way.

Whilst low volume large Body Panels are still made by hand using the traditional skills of the Sheet Metal Worker and Panel Beater, manufacturing is now assisted with the latest technology being incorporated such as Cad Cam designing to run CNC Machines, eliminating many labour intensive tasks. A wide variety of Plant and Equipment is on Site to cover most aspects of manufacturing from Folding, Forming, Spot, Mig, Tig Welding, large Double action Power Presses and a 5 Axis Laser Profiling Machine. But it is ultimately down to the skilled sheet metal engineers, body builders and restoration Engineers to make the service offered by the company so special. Importantly, Martin continues to provide a



traditional Apprenticeship Scheme to maintain craftsmanship in a technological world.

The manufacturing did not stop at Body Parts; soon fixtures, fittings, engine frames, heater boxes and hood frames came into production. Today, over 5,000 individual parts are made by the business for non current Jaguars.

In 1981 the Company began supplying parts via mail order to retail customers, leading to further expansion. This mail order facility soon became a 'stand alone' Parts Department, leading to the formation of Martin Robey Sales Limited, a separate entity to the engineering business.

Bill Pinfold and Adrian Nicklin recently visited Martin at his fascinating factory and he has kindly offered to host a works visit for ISME members – details below.

ISME Works Visit Martin Robey Engineering Ltd.

10.30am Thursday 9 November 2017

Martin Robey will host a visit for ISME Members to view his press shop, sheet metal fabrication department and historic vehicle restoration shops at his Nuneaton factory.

He will give a short talk on how he became involved with supplying and manufacturing parts for historic Jaguar and Jensen cars.

Full details will be circulated shortly and will appear on the ISME website. Alternatively, contact Adrian Nicklin on adriannicklin@btinternet.com.



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Member News

Prestigious Award for ISME Member

ISME Member John Yarnall has been made a Fellow of the Institute of Metals, Minerals and Mining.

John, a Consultant Surface Engineer of Rugeley, Staffs was given the award in recognition for his contribution in a senior technical management role to the coatings industry.



MISME honoured by the Queen

Congratulations to ISME Company Member KMF's Managing Director Gareth Higgins who has been awarded an MBE in the Queen's Birthday Honours list. Gareth, who has helped to steer KMF through 25 years of growth, is honoured for services to apprenticeships.

New ISME Member

We are pleased to welcome Andrew Connell of Sowerby Bridge to ISME membership.

Andrew currently works for C3S Projects Ltd as a Projects Manager in the Modular Buildings Division, though the majority of his experience is in metal fabrications, lean manufacturing and production scheduling as well as managerial roles in manufacturing environments.

We welcome Andrew to ISME, we are sure his membership will be of benefit to him.



ISME Fellow sets up new business

47 year old Dave Gilbert is a Sheet Metal Worker born and bred from the Black Country who has been involved in sheet metal work since the age of 16. Having worked for a number of companies (and been a Director or shareholder in four of them!), he has now set up his own business DG Fabs Ltd.

Based in Bilston, the business benefits from the best skills and equipment including in house CNC AMADA Punching, Plasma, Press-Braking and Shearing.

DG Fabs also provides an entire range of fabrication services, such as welding (MIG/TIG/spot/stud), assembly and finishing.

Dave has vast 'hands on' experience and besides running his business he is in demand to participate in various Welding and Sheet Metal Fabrication knowledge forums, both in the UK and the United States.

And if all that wasn't enough, Dave is Author of 'The Complete Fabricator' which is an essential read for anyone in the fabrication industry.

For more information ring Dave Gilbert on 07904 531905 or visit his new website on www.dgfabs.com.



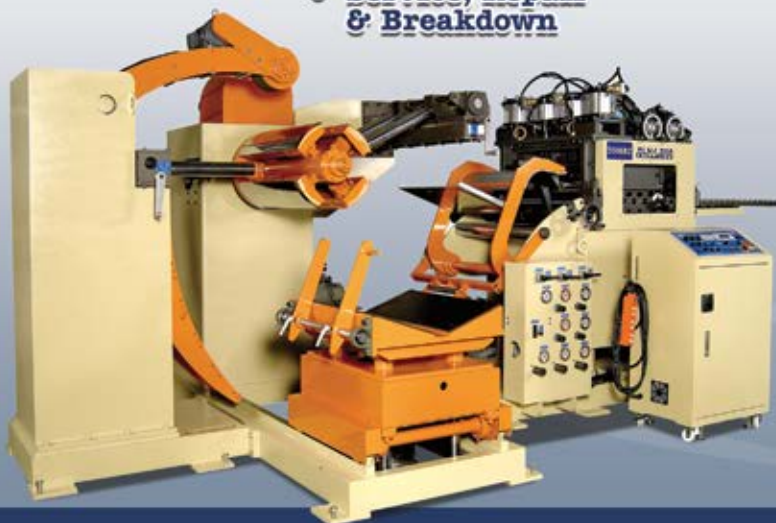


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