

EDM TODAY

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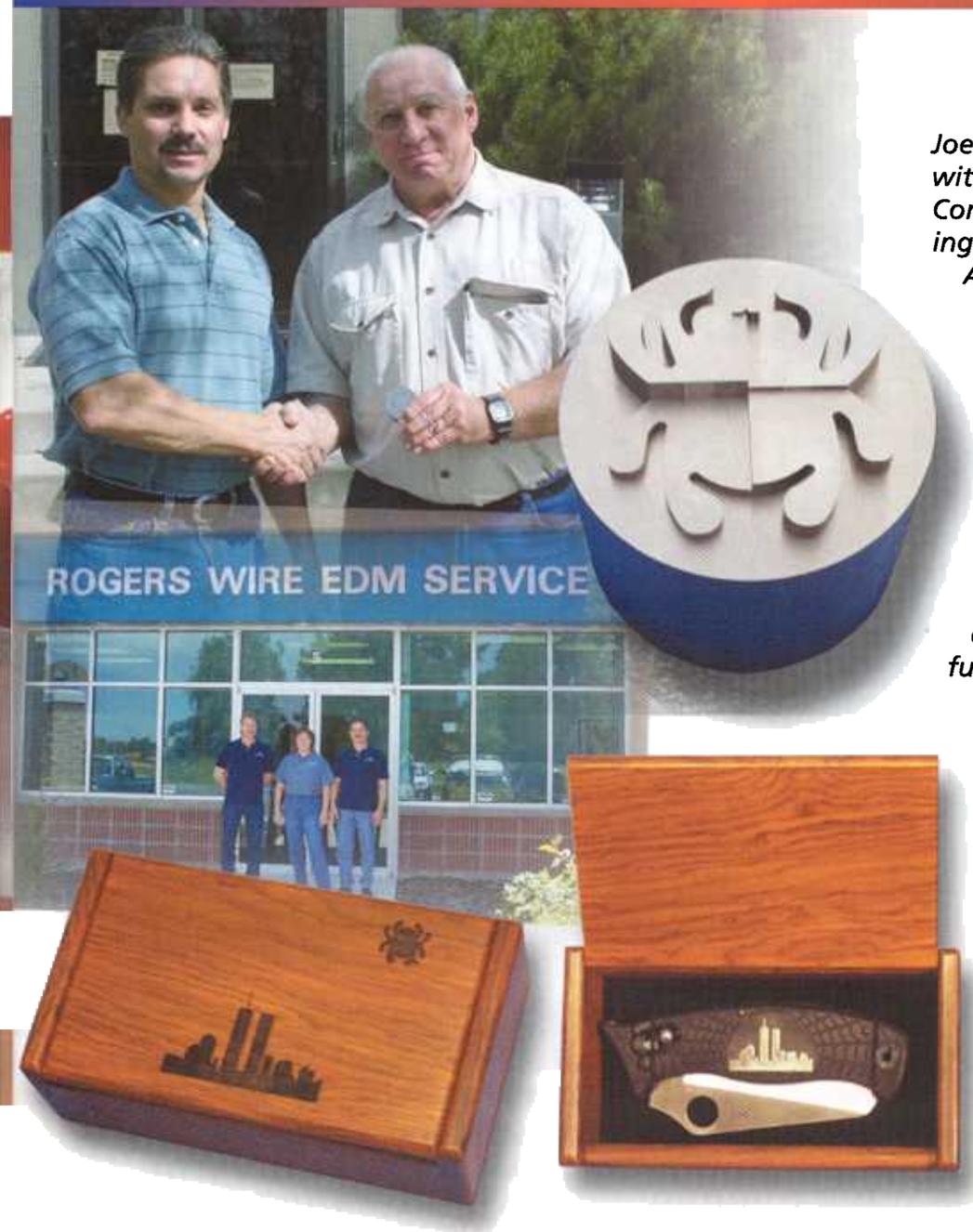
Remembering Our Fallen **HEROES**



September 11 2001, produced many heroes, but the bravest of the brave were the men and women that were running into the burning buildings, while all others were leaving. Those brave heroes include the Fire, Rescue, EMT, Paramedic, and Law Enforcement professionals, which have become known as the SAS (Save And Serve) group. A large number of those SAS heroes sacrificed their own lives that day, in order to save the lives of others.

We recently heard about a company that had a close association with the SAS group, and we learned how they are honoring the fallen heroes. That company is

Spyderco Inc., a specialty knife manufacturer located in Golden, Colorado. Since the early '80s, Spyderco has been designing and producing knives to specifically meet the needs of the SAS group. When Spyderco heard that the cleanup crews at ground zero were having difficulty cutting tough materials such as fiberglass, they immediately donated a shipment of 300 Rescue model knives to assist them. Each knife was engraved "In Memory of America's Finest 9-11-01". This small gesture was appreciated by the workers, however, the Spyderco Company wanted to do much more.



Joe Rogers, on the left, is shown here with Sal Glessler, Spyderco Knife Company's President. Joe is presenting Sal with a special piece of EDM Art that he Wire-cut for him, in honor of their close cooperation on the WTC knife project. The artwork is a slip-fit segmented replica of the Spyderco logo.

A front view of Rogers Wire EDM Service is pictured here, with (left to right), Joe Rogers, his wife Chrisette, who is the company accountant, and their full time EDM specialist, Jess Clark.

The limited edition "Rescue Model" WTC knife is shown in its specially designed presentation case. The WTC view and the Spyderco logo are milled into the case, while the knife is held in place on a cushioned surface. The case makes a perfect setting to display and protect a fitting remembrance of the true heroes that gave their lives on 9/11 — A day that we will never forget.

Since the SAS group had been a supporter of the Spyderco Company for 20+ years, Spyderco decided that it was pay-back time. After much discussion within the company, they decided to create a very special item that would commemorate the 9/11 heroes, yet could be sold to generate funds to assist the 403 families of the men and women that gave their lives. There is no greater sacrifice than to give up one's own life, while saving another's.

Spyderco's Decision — A Limited Edition Knife

After much discussion, Spyderco decided to create a very special, rescue style knife that would contain actual steel from the World Trade Center, in a unique way. With a great deal of help and support from many people, a section of a steel I-beam was obtained from the remains of the

WTC. It was cut from the east side of Tower #1, while being videotaped by a NYPD crew, in order to verify its authenticity.

Different possibilities of using the steel were discussed, such as being forged into the blade, two steel bars in the handle, etc. However, it was decided not to melt the steel, but to create an item from the raw steel, that was representative of the World Trade Center, and would not require an explanation. The final decision was to use the steel to create a series of insets, depicting the New York Skyline as it was before 9/11, silhouetted before the sun. Each knife would have an inset imbedded into the handle, and no words would be necessary! The number of commemorative knives produced would be limited to 2,819, the number of lives that were lost that day. Each knife would be individually numbered and delivered in a custom presentation box, along with a letter of authenticity from the owners of Spyderco.



Joe Rogers in front of their newest Wire EDM, which was the machine that was used to produce all the New York skyline insets, for the 2,819 WTC Commemorative knives.

A view of the workshop at Rogers Wire EDM Service on a typical day. Their workload consists of a wide variety of jobs, with Tool & Die work being the prime source, along with some mold work.



None of the 2,819 knives will be discounted or given away.

One hundred percent of the profit derived from the project will be donated directly from Spyderco to the New York Police and Fire, Widows & Childrens Benefit Fund, in memory of the Firefighters, Law Enforcement, and Medical personnel lost on that unforgettable day.

Anyone that would like to join this endeavor in helping the Benefit Fund, while securing a unique piece of history for themselves, can find the complete information at the end of this article.

Producing The WTC Inset by Wire EDM

Rogers Wire EDM Service was the company Spyderco selected to machine

the raw steel into 2,819 New York skyline replicas, to be embedded into the handles of the commemorative knives. We contacted Joe Rogers, the company's President, for some background information on his company, and how he got started with Wire EDM.

Joe explained that his father had worked as a Mfg. Engineer in Chicago, and he became very interested in what his father did. As a result, Joe attended Vocational school, working in the machine shop and studying quality control. The shop was equipped with traditional and CNC machine shop equipment. He enjoyed the work and became proficient on all the equipment, especially CNC programming.

After working for a year in a Chicago machine shop, Joe decided to move to Colorado, where he started

working in a high production machine shop. Because of his CNC knowledge, he became the programmer and eventually the foreman of the CNC department. He was involved in programming, and the purchase of equipment and software. By chance, the company also had an Andrews Wire EDM, one of the first Wire EDMs in Denver. The Wire EDM became Joe's favorite, since it was clean, highly accurate, and no chips! After a careful accurate set-up, just turn it on and let the machine do its work. He was hooked!

Starting "Rogers Wire EDM Service"

Joe had a strong desire to start his own business, and there were very few Wire EDMs in that section of the country — and not a single Wire EDM

The graphic screen on the Robofil 510P Wire EDM, depicts the cut as it takes place. This screen shows the outline of the 2819 WTC insets that were Wire cut, 15 to a stack, from a section of a steel I beam that was salvaged from the wreckage of the WTC.



shop! He reasoned that there would be no competition, and at least for a while, he might have a niche. At the time, the local shops were sending their Wire EDM work back East to be done. By starting a local EDM shop, Joe thought it would be a big advantage, especially since he was already familiar with many of the other shops.

Financing the new venture however, was a problem, because Wire EDM was new to the area, and the local bankers did not understand it. This made them wary of a technology without a long, proven track record, especially since it would be a start-up company run by a first-time businessman. But Joe was persistent, and finally he secured a loan and started "Rogers Wire EDM Service" in June of '92 with a Charmilles Robofil 300.

With a new state-of-the-art Wire EDM and his experience, Joe was able to bring in most of the work that was being sent out-of-town. Today, they have three Wire EDMs and Joe works along with a full time operator. His Wife, who has an accounting degree, handles the finances.

Joe explained that for a few years the shop stayed busy with Plastic Injection Mold and Tool & Die work. However, about two years ago, almost all the mold work went overseas, and several of their customers closed down because of it. Today, Joe's shop concentrates on Tool & Die work, and a small amount of Mold work. Aerospace and Medical jobs are still active, and will probably stay in the U.S., since the work is often complex, and requires experience and talent to accomplish it.

The Commemorative Knife Project

By chance, Spyderco's shop is just 10 minutes away from Joe's shop, and Spyderco's President, Sal Glessner and an associate visited Joe with their idea for the knife project. They wanted to find out if Wire EDM could accomplish it. With them, they had their art work and a large chunk of the steel I beam from the remains of the WTC. The beam had been torch-cut and was bent and twisted out of shape. Sal Glessner explained that in order to finish the mold for the handle of the new knife, they would require sample parts of the WTC inset as soon as possible.

Since 100% of the project's profit would be passed on to

the victims' families, everyone involved in the project tried to keep their cost as low as possible. Joe started his end of the project immediately, by using Spyderco's artwork to write a program, and he cut several samples that were approved. With no immediate rush for production since the knife handle was still in progress, Joe planned to do the production of the insets during off hours and in between jobs, in order to keep his pricing to a minimum.

The inset was to be .030" thick, however, due to the intense heat the I beam had been subjected to during the fire, the first batch of insets twisted and pinched the wire during EDMing. In order to prevent this, the beam section was sent out for stress relieving. This solved the problem, and production of the insets started. Joe built a stacking fixture with 15 pieces to a stack, and soon was cutting the insets production style. As soon as the knife handles were in production, everything came together.

The Commemorative knife is a rescue style that a police officer or fire fighter would carry, since the blade, because of its design, can easily and quickly slice through a seat belt in order for a quick release from a vehicle. Or it can cut and saw through wall board or other materials that might hinder a rescue. It can be opened quickly with one hand, by using the thumb hole, and remains securely open due to the new Spyderco ball bearing lock.

This Is Your Opportunity To Help The Hero's Survivors

This is an excellent opportunity to help the families, and at the same time secure a piece of history for yourself. You can do this by calling the Spyderco Knife Company at 1-800-525-7770, extension 129, and talk with Pat Palmer to place your order. Your limited edition, WTC knife will be delivered to you in a custom presentation box with a letter of authenticity from the owners of Spyderco. The price for each knife (prepaid) is \$225.00 plus \$6.95 shipping and handling within the continental U.S. One hundred percent of the profit will be donated directly from Spyderco to the "New York Police and Fire, Widows and Childrens Benefit Fund", in memory of the true heroes that were lost on that unforgettable day.

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