

PAVING NEWS

A Caterpillar publication serving the global paving industry



Smooth Sailing

Preparing for the America's Cup



Small Part, Big Payoff

Extending mill bit life has significant impact on production



My Kind of Technology



Lieven Van Broekhoven
Worldwide Sales and Marketing Manager

I love technological advances, especially when the technology is so integrated with the product that I don't have to go to school to learn about it. I want technology that simply helps me do a better job or be more efficient without adding complexity.

This issue of Paving News has several outstanding examples of how Caterpillar uses technology to make products more reliable and more productive. The CAN-bus electrical system now used on most Cat® Screeds is basically invisible to the paver and screed operators. Yet, the CAN-bus cleans up all the electrical routing and simplifies on-board communications. It's unbelievable, but wiring on Cat Screeds has been reduced by more than 50% because of the new technology. And, the components on the screed and the tractor share information better.

For example, Cat Grade and Slope Control for asphalt pavers is designed to take advantage of the CAN-bus system. Because the electrical interface between the screed electronic

control module and the grade controls is better, screed control is more reliable and more responsive. Plus, the new technology provides a better platform for three-dimensional paving if that's the direction you want to go.

I would also like to mention the story about the manufacturing technology being used on Cat cold planer cutter bits. We've always had a great rotor design and a reputation for ease of maintenance. The latest focus on the manufacturing process for the cutter bits incorporates state-of-the-art powdered metal technology. The result is bits that can provide up to 50% more service life than other bits. From the crew's standpoint, nothing changes. They have nothing new to learn. The equipment operates the same way. Cutter maintenance is still done the same way, just less frequently, so the cold planer gets the tonnes in the trucks in less time.

Caterpillar makes the transition to the new technology effortless. That's the kind of technology that I want to buy. ■



Feature Articles

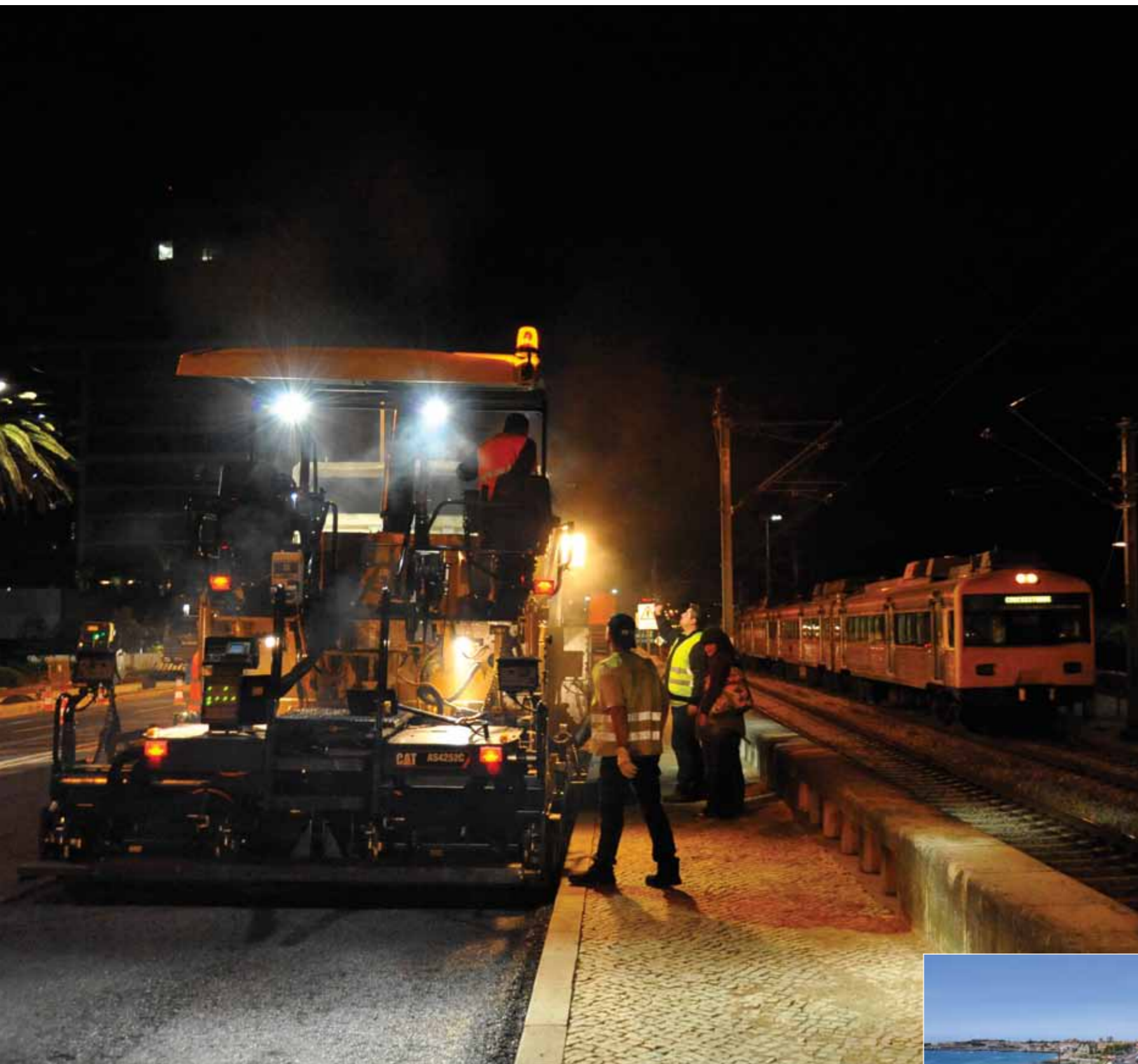
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Smooth Sailing

Paving job goes perfectly in preparation for America's Cup



The Portuguese village of Cascais has enough attractions, including magnificent views of the Atlantic Ocean, to make it a tourist destination. The historic hotels and winding roads that nearly touch the ocean also have been the backdrops of films, including a James Bond film. In addition, the city has a rich racing history, having hosted the Formula I Portuguese Grand Prix and numerous motorcycle events.

The attention was even greater this year with the arrival of one of the world's premier sailing races, the America's Cup, in August.

With a busy summer ahead, Cascais municipality realised it had to make improvements to Avenida Marginal, the waterfront thoroughfare that leads to the village and the main attractions.

The main issue with the road was its drainage.

"In times of heavy rainfall, stormwater tributaries accumulate, forming a river and making it dangerous to cars and pedestrian circulation," an engineer for the town of Cascais wrote in a report.

The importance of the street meant that the work

had to be completed before the America's Cup crowd arrived. Yet the seasonal tourists also meant the road had to remain open while the work took place.

Sanestradas, a respected paving contractor, was chosen for the job based on the time requirements and the need for high quality.

The project

Cascais municipality's project involved a 1km section of Avenida Marginal. Much of the road's surface was in good shape, with the exception of about 65m. That section of road had been damaged during a building construction project. The 65m would also be the location for a new drainage system, with rainfall channelled to it via curbs along the remainder of that 1km section.

Directing the water to those drains created another challenge. About 300m of the road was so level that water did not flow.

A simple solution would have been placing a new surface lift with a slightly steeper grade. Yet that choice was dismissed because of low curbs: an



AT A GLANCE

Company: Sanestradas
Owner and Managing Director: Daniel A. Gonçalves
Headquarters: São Domingos de Rana, Portugal
Founded: 1966
Services offered: Engineering; asphalt manufacturing; paving

▲ The importance of the Cascais street meant it had to remain open while the work was done.

average of only 100mm. Applying a new bituminous layer to create the grade would have simply caused rain to run over the curbs. The flooding would have continued.

Cascais municipal officials came up with a strategy. First, they proceeded with the new drainage system. The 65m of existing curb was removed, and the ditch floor area replaced with two 200mm layers of crushed, aggregate base of extensive granulometry. That base featured irrigation fluidised MC70 bitumen at an impregnation rate of 1kg/m².

A binder layer with a thickness of 11cm was placed on top, followed by the wear layer with an average thickness of 6cm.

The remainder of the road did not need new base layers or other improvements. Therefore, milling crews removed 6cm of material. The paving crew then placed an AC 14 Surf 35/50 (BB) wear layer over both the rebuilt and milled portions of the project.

Tight schedule

Crews were given just two weeks to complete the work, but the time was actually considerably less because work was only allowed at night. Crews began work at 8pm or 9pm and continued until about 7am the following morning. In addition, Avenida Marginal had to remain open to traffic with no limitations on

Fridays, Saturdays and Sundays to allow tourists to come and go unimpeded. That meant the two weeks was in actuality eight days.

Further complicating the project was the requirement to keep traffic circulating, though in a limited manner. This led to a process of milling one lane for two nights, then tandem paving and compacting for the next night. At that point, the lane was completed.

Milling

A Cat® PM102 Cold Planer removed the 6cm of asphalt in the required areas. The PM102, smaller than the Cat® PM200, was chosen because its size made it a better fit for



the narrow road. Yet the machine delivered the required productivity, too, as it had to mill a lane in only two nights.

The tight timeframe left no margin for error. Because of this, two service technicians from STET, the Cat dealer in Portugal, remained on the jobsite throughout the night in case they were needed. Fortunately, there were no problems.

Paving

When an entire lane was milled, tandem pavers went to work. Delivery trucks end-dumped the material into the pavers.

Sanestradas chose the new Cat AP555E with an AS4252C Screed. Working just a few metres ahead of it was the tried-and-tested Cat AP655D.

Pedro Santos, project chief for Sanestradas, was pleased with both pavers. One key reason: their productivity enabled the job to be completed in a short timeframe. “With the two pavers working in tandem we

succeeded in finishing the job much faster than expected, and with excellent smoothness results,” said Sr. Santos.

Caterpillar had a technician specialised in handling pavers on hand to ensure smooth integration of the new AP555E. He closely followed both the performance of the machine and the crew and offered suggestions for improvement.

Compaction

Three Cat compactors, the CB434D, PS300B and CB34, easily kept pace with the two pavers, and met density specifications.

The PS300B worked in breakdown mode, and was right behind the second paver, the AP555E. The longitudinal joint was done ‘hot’, and easily compacted, because the first paver worked only a few dozen metres ahead of the second.

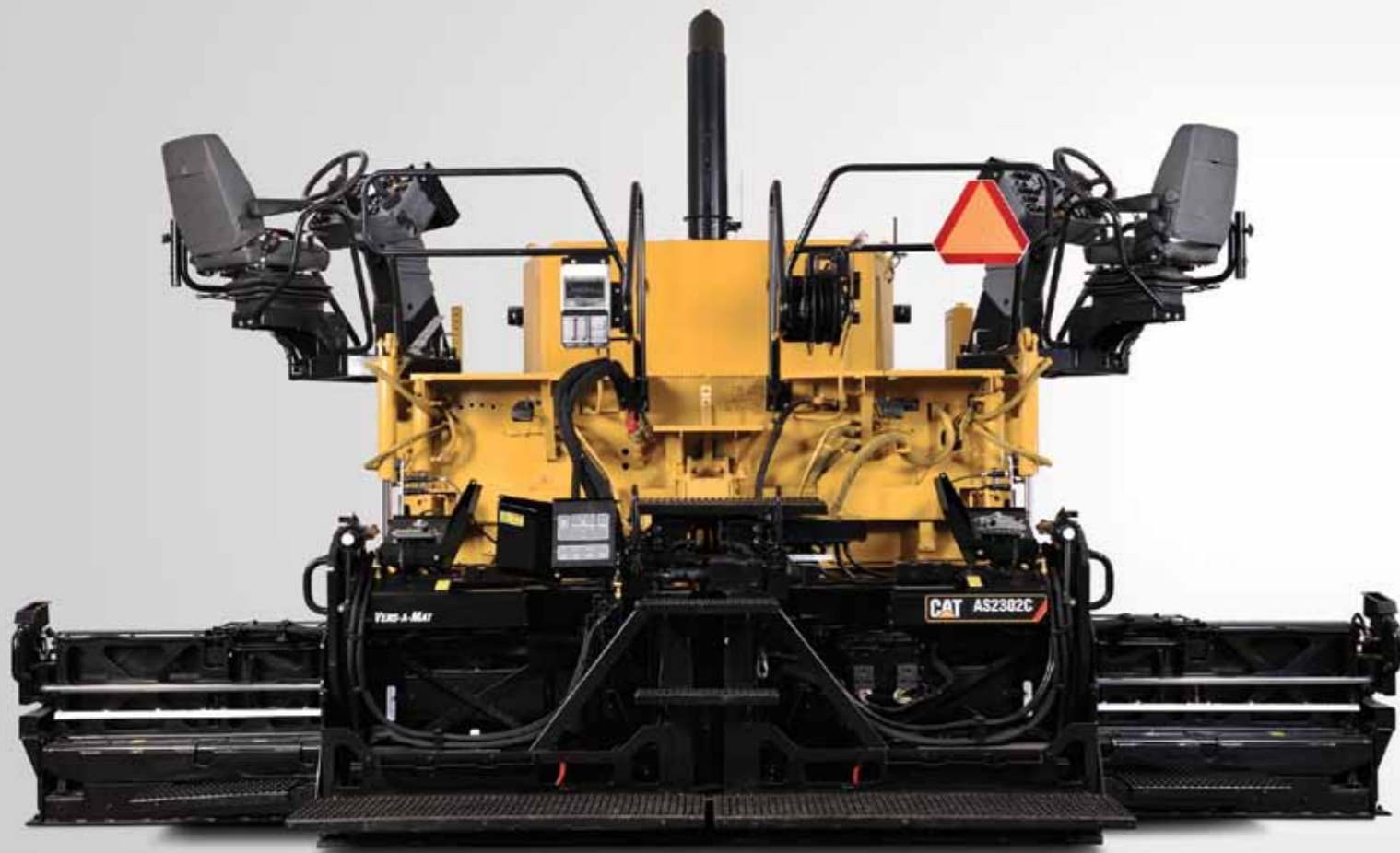
The compactors worked at a distance that enabled compaction and kept pace with the paving train. The

number of passes depended on the pace of the paver and the delivery trucks. The compactors treated the two freshly placed mats as if they were one and worked across the entire width of the lane.

Completion

Santos and other Sanestradas representatives were pleased with the performance of the Cat cold planers, pavers and compactors, and the Caterpillar dealer. Many officials from both Caterpillar and STET were on-site to ensure the highly complex project was a success.

No spectators were more important than Cascais Municipality authorities, who also kept a close watch on the jobsite. They saw machines making quick work of the milling, paving and compaction and were pleased the road was completed in time for the America’s Cup, while serving all the tourists so crucial to the village’s economy. ■



They include:

- Great control for urban and commercial applications, minimising handwork.
- Heavy-duty frames that prevent flexing and enable material to easily flow out to extenders when increasing paving widths.
- Smooth, consistent results on mainline paving.
- Easy-to-operate, low-maintenance screed plates.
- Superior serviceability.

Customers have provided key input on how to further enhance the existing product line. Engineers have taken that input, as well as research gathered by experts in the field, and created four key improvements that are being phased into the entire screed line. They are:

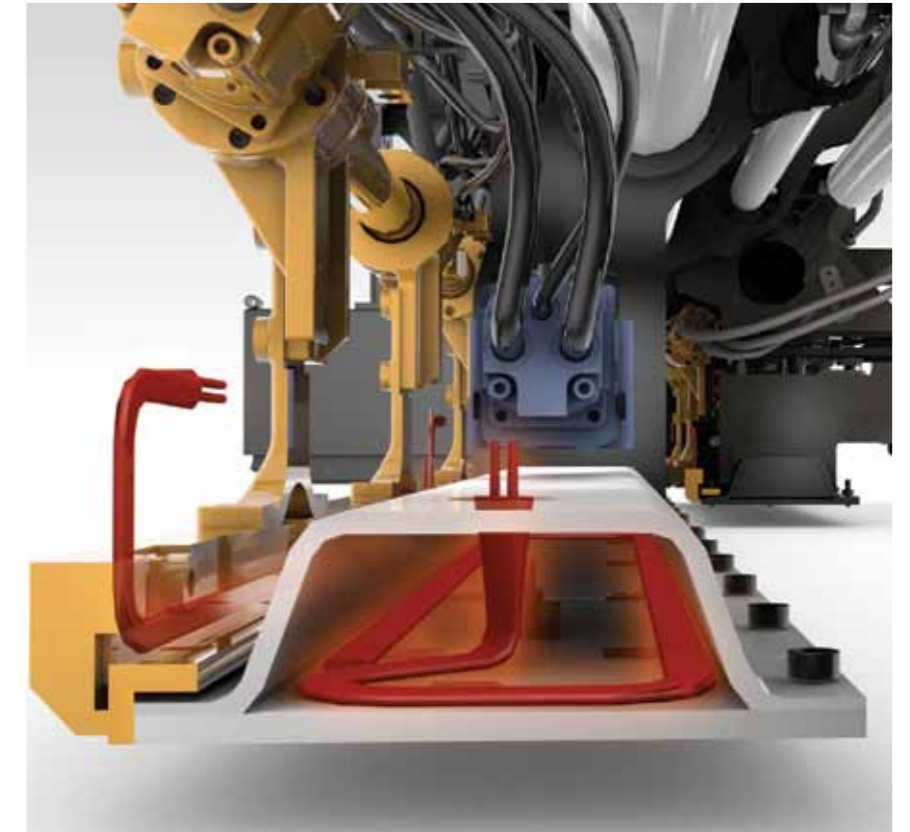
1. Utilisation of a CAN-bus system
2. Integration of an improved grade and slope system
3. Electric heat enhancements
4. A convenient toolbox

CAN-bus system

This is a key improvement that already has been implemented in many Cat screeds, and will be added to others soon. The CAN-bus system substantially reduces the amount of wiring running between the operator's controls and the components. In fact, some of the new screeds have seen a wiring reduction of over 50%.

How could so much wiring be eliminated? Previously, a wire ran from each control switch through the screed harnessing to the tractor control system. The information then was routed from the tractor back to the screed along a separate wire to the proper motor or controller to carry out the function. Now the screed handles these functions internally, and only communicates relevant information to the tractor over dedicated communication wires.

The reduction in wiring has two



▲ The electric screed system has been updated to extend the life of heating elements.

important customer benefits. First, the reduction lessens the possibility of a problem with wiring. Second, if a problem does occur, it's much easier to isolate. Technicians and even operators will find it much easier to troubleshoot.

The screed continues to respond quickly to commands. The CAN-bus system is simply an improved method for the various components to easily communicate with one another. These communication changes allow for product improvements without costly wiring changes.

Cat Grade and Slope option

The addition of this system into the new screeds means less reliance on the operator. Paving contractors will see better control of yield, and an associated cost-savings, as the screeds become more automated. The

automation provided by grade and slope also helps place smoother mats.

In addition, its implementation enables contractors to benefit from the quality improvements associated with 3-D paving techniques and the comprehensive, multi-layered information they provide.

Electric screed improvements

Paving contractors over the last few years have embraced the electric screed system and the consistent heat it supplies, from one end of the screed to the other. Caterpillar engineers have updated that electric system to extend the life of the heating elements.

Toolbox

Sometimes an improvement has more to do with customer convenience and less to do with technology. That's

Cat® Screed Improvements Enhance Profitability

Technology, convenience built into new models

Many pieces of the paving equation must come together to create smooth mats. While all elements are crucial to the process, none are more important than the screed. In fact, a properly specified, selected and operated screed can be the difference between a satisfied customer and costly rework.

Even though Cat® screeds are already recognised as some of the most advanced in the industry, designers at Caterpillar Paving Products are fully aware of the need for continuous improvement. As improvements are made, rest assured key features and benefits of previous screed models won't be forgotten.



the case with the inclusion of a toolbox on new screeds.

Customers specifically requested the toolboxes. They are conveniently located so operators can store key jobsite tools right on the screed.

Helping you find new ways to

become more productive and profitable on your jobsites is the focus of Caterpillar's commitment to continuous improvement. See your Cat Dealer for information on the introduction of the screed improvements by model. ■

THE LATEST IN THE LINEUP

The Caterpillar AS3301C Asphalt Screed is the most recent to join the Caterpillar Paving Products line-up. It replaces the Extend-A-Mat 10-20B.

Like other Cat® screeds recently developed, or under development, around the world, the AS3301C will show improvements in four key areas: Wiring improvements thanks to a CAN-bus system, integration of an improved optional grade and slope system, electric heat enhancements, and the addition of a toolbox.

Other changes to the AS3301C include:

A spinner for the depth crank. The spinner makes the crank easier to turn,

conserving operator energy throughout the shift.

Recessed switches. Prevent un-intended actuation by the operator.

An improved ergonomically correct control panel. The arrangement of the panel was adjusted based on input from screed operators.

An integrated coily cord. The cord, located near the sonic feed sensor, previously ran from the sensor to the back corner of the paver. It was exposed to damage during normal paving practices or even during travel. The cord now is integrated into the screed's frame for



added protection.

A cupholder. The new screed includes a spot to hold a bottle of water or a coffee mug. The holder can be folded when the paver works in a confined area or when encountering obstructions.

A Year of Trade Shows

Caterpillar paving products have been well-represented at trade shows around the world in the last year. Caterpillar and Cat® Dealers continued to show their global commitment by participating in dozens of the events.

No matter what the location, customers can benefit from trade shows. The events provide:

- A chance to compare Cat machines, side-by-side, with competitive equipment.
- A close-up view of new products.
- Experts who can answer questions
- A chance to talk about other needs, such as product support

Talk to your Cat Dealer about upcoming trade shows in your area. ■



Ankara, Turkey



Verona, Italy



Jakarta, Indonesia

Bucharest, Romania



Zaragoza, Spain

Mumbai, India



Taking the Rental Road

French firm rents pavers and reclaimers, with or without operators



The benefits of renting are many, and one French company is turning those advantages into a burgeoning business.

ATPS, with headquarters in Paris, is built around purchasing pavers, and other road construction and maintenance machines, and renting them to contractors. It's a formula that has worked well. The company opened in 2000, and now owns 60 pavers, 12 spreaders and 12 trucks.

"The objective of ATPS is now to reach a fleet of 100 pavers and 60 operators to cope with the growing demand of customers all over France and Europe," said Patrick Pichardie, Founder and President of ATPS.

Pichardie's reference to operators is an important one.

ATPS doesn't just rent equipment it also will provide personnel to operate the machines. Those who arrive are experienced, well trained and capable of producing a top-quality result.

The outcome: Contractors handling large or complicated projects can count on the best machines and operators in the business. "We have great people, and when you give them the time, tools and support to meet challenging goals, they deliver," said Pichardie.

Equipment reflects customer commitment

The business has been built around experienced people and quality equipment. The pavers of choice are Caterpillar.

In particular, ATPS has utilised the Cat® AP555E. In fact, ATPS took delivery of the first AP555E sold in France.

The purchase of Caterpillar pavers was an extension of the relationship the business management team had built with Bitelli and its line of quality pavers. To this day, ATPS continues to utilise pavers manufactured by Bitelli, a company Caterpillar purchased in 2000.

The relationship between ATPS and the local Cat dealer, Bergerat Monnoyeur, is an extension of that bond. ATPS and the dealer work closely together, even after the sale is completed. A recent example is an agreement between ATPS and Bergerat Monnoyeur. The Cat dealer occasionally "rents" the paver back from ATPS and

uses it to demo to other customers. The result: Bergerat Monnoyeur is allowed to demo its paver, while ATPS has access to customers it had not previously reached.

More purchases ahead

ATPS will continue to acquire new equipment. Some purchases will be the result of the company's growth. In addition new machines will be needed to ensure the highest availability and top productivity for customers.

The purchases also reflect yet another customer commitment: to consistently upgrade the rental fleet with new machines. Renting new models enables ATPS customers to benefit from all the latest technological



COMPANY BACKGROUND

Company: ATPS
Headquarters: Paris, France
Area served: Three branches in Toulon, Paris and Bordeaux cover the entire country of France and other parts of Europe
Company founded: July 2000
Fleet: 60 pavers, including Cat AP555Es and BB621s

developments incorporated in Cat pavers.

Of course the operators ATPS provides also can take advantage of those productivity benefits. They include the Mobil-trac System, a rubber running gear which provides the flotation and traction of a crawler, just like that of a traditional suspension, while delivering the mobility and ride quality of a wheel-type paver. ATPS also appreciates the paver's ventilation system, sonic sensors and levelling systems.

The new pavers help portray ATPS as a company that puts quality first, as well as a firm that is clearly dedicated to providing customers with the best equipment available.

Ready for any jobsite

The mix of pavers ensures customers who rent ATPS equipment can handle virtually any job. Some of the work includes renovation of city streets and roads, pathways, highways, golf cart paths, pathways made of stabilised sand, and hippodromes.

The ATPS fleet includes pavers for small roads, for stabilised sand applications and for medium size jobsites. The Cat AP555E pavers are utilised on large jobsites, highways and roundabouts.

Varying job sizes and durations also mean ATPS must have flexible rental terms. The company offers rental periods ranging from one day to a year. The business was started when

Pichardie saw contractors needed small pavers, but usually for a short time. He also realised they needed quality products, and sometimes operators. Those who needed the pavers also wanted machines that did not require maintenance.

Pichardie's early success led him to broaden his offerings by including larger pavers, as well as reaching an expanded geographic base.

On the job

Contractor COREAL is an example of an ATPS customer. COREAL works throughout France and employs 380, specialising in building construction, and rents pavers when needed, particularly when

developing access roads.

COREAL turned to ATPS when it recently built a warehouse, and needed a narrow paver of 2.5-3m to place the surface for the facility's access road. The operator described the paver as manoeuvrable and intuitive—a very important benefit for someone who is renting a paver.

Consistent with ATPS' best-practices approach, COREAL was provided with a perfect solution for project requirements. "Customers want reliable machines with experienced operators so they don't have to worry about anything other than having the job completed on time," said Pichardie. ■

WHEN IT'S RIGHT TO RENT

Purchasing equipment helps paving contractors build equity in their businesses. However, renting paving equipment may be a better option for one or more of the following reasons.

- 1. The perfect combination.** Renting allows contractors to select the correct machine for their specific requirements in terms of working width, weight restrictions on access, height or width, optional equipment of the digital sensor type or additional extensions, machine for stabilised or lightly coated sand, and many others.
- 2. Handling peak demands.** Rental can provide a solution for those who occasionally need to complete work more quickly than their equipment and teams can manage.
- 3. Testing.** Renting gives owners and operators a chance to evaluate how a machine performs on their jobsites. Can that roller achieve compaction in fewer passes? Does the paver really enhance mat smoothness? Rental helps provide those answers.
- 4. Estimating.** Pre-determined rental costs make it easier to put together current and future bids.
- 5. No capital investment.** Renting frees up business capital because a contractor only pays for a machine while it's needed. The capital saved can be applied to other business needs.
- 6. Cheaper costs.** Contractors who rent avoid numerous costs mainly for servicing, breakdowns and updating their machines at the same time as reducing their payroll and charges for carrying out parts inventories.
- 7. Makes storage unnecessary.** Transportation arrangements can be made so the machine is delivered to the jobsite—and returned to the Cat dealer from the same jobsite.
- 8. Provides access to the latest models.** Older equipment can be replaced by new without a large capital outlay. The new equipment, and associated improvements, might boost productivity on a particularly challenging or important job.
- 9. Flexibility.** It is easy to rent this equipment for a day, week, month or year, with or without an operator, thus allowing them to meet occasional needs.
- 10. Customer service.** Rental helps contractors handle all those "special requests" key customers make after the job starts.



^ The new pavers feature the latest technological improvements.



^ The pavers work well when placing asphalt for a new warehouse.

Contact your Cat Dealer for more information about benefitting from the rental of paving equipment.



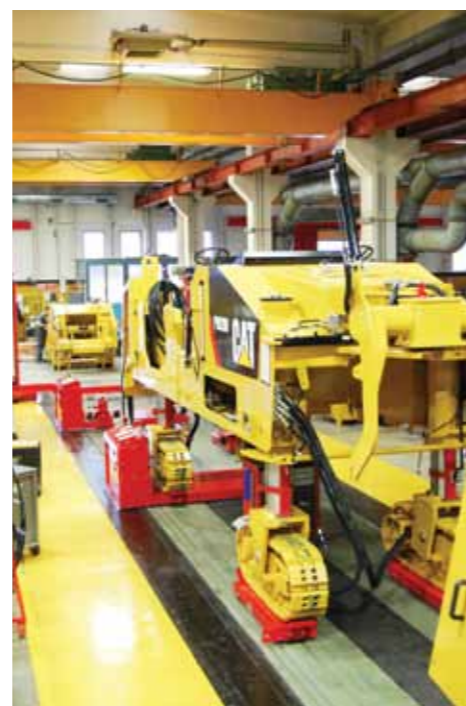
Significant Investments Made at Caterpillar Paving Products Plants

Improved Facilities Benefit Customers

Many of the facility improvements at Caterpillar Paving Products are taking place inside manufacturing facilities. But customers from the outside world will most appreciate the changes.

“While many of our competitors choose to blatantly ‘advertise’ their investments in facilities, Cat® Paving is quietly, behind the scenes, making the aggressive investment necessary to continue our leadership position in the worldwide paving equipment industry,” said Jim McReynolds, Global Paving President.

The improvements to Caterpillar Paving Products plants in Rantigny, France; Minerbio, Italy; Xuzhou, China; and Minneapolis, USA, have been made to provide increased volumes, better quality and timeliness that customers require, McReynolds said.



Among the changes to the facilities:

- **Improved materials receiving areas**, including the utilisation of modern technology for scanning, tracking and inventorying all incoming materials. The receiving areas also have a direct line to the distribution warehouse. “It’s enabled us to speed up our assembly processes and meet our delivery dates,” said Joshua Meyer, Region Manager with Caterpillar Paving Products for Europe, Africa and the Middle East.
- **Only providing what is needed, when it’s needed.** “We now deliver only the components for a specific machine to a station,” said Giacomo Minchio, Manager of the Minerbio and Rantigny facilities. “It improves space utilisation, and makes the assembly process more efficient. It’s an improvement that helps avoid waste. When we avoid waste, we help our customers with cost.”
- **A major workflow reorganisation.** “We’ve reconfigured the lines and the flow,” Meyer said. “The increased efficiency means the products are built faster, and also improves quality because there are fewer starts and stops along the way.”
- **A reconfiguration of work stations.** The amount of work to be completed at each station is better balanced. Making sure there are quality checks and the right amount of work at each station, and the proper tooling, is part of the improvement plan.
- **The use of ‘island’ offices.** Process engineers and managers are now located directly on the line. “They’re essentially in an all-glass bubble on the assembly line,” Minchio said. “They’re closely observing the process. If issues arise, they’re immediately available to provide solutions and advance production.”
- **More comprehensive pre-delivery inspections.** The new process includes more inspections for each machine. They’re extremely comprehensive, and done at



Reorganised workflow and work stations have improved quality and lessened the manufacturing time at Caterpillar Paving Products facilities, including this plant in Minerbio, Italy.

various points during the process. Machines also are randomly chosen for additional audits. Steps also are being taken to eliminate any trouble spots in the production line.

“To summarise, we are improving our facilities to better meet the demands of the various global markets we serve,” said Lieven Van Broekhoven, Worldwide Sales and Marketing Manager. “There has been considerable consolidation in the global paving industry in the past few years, and we are positioning ourselves to remain the best partner for

our paving customers in the markets where we are currently the leader, and to become a stronger contender in those geographical areas where we see potential for growth well beyond our current position.

“The improvements in our facilities are the result of our recent phenomenal global growth and the experience we have gained from that. Our production, logistics, purchasing and marketing teams all contributed to the concepts and implementation of the improvements mentioned. We call this Cat@work.” ■



Mill Bit Life a Big Factor in Cost-per-Tonne

Many contractors consider power a key indicator of cold planer productivity, and rightly so. Power certainly is an important contributor to overall performance.

Those same contractors may not be as likely to consider the impact of mill bit life when factoring productivity. Yet the useful life of those bits has an enormous impact, on both production and costs.

First, long-lasting mill bits maximise machine uptime. During the course of a year, mill bits with extended life can deliver hundreds of hours in increased productivity.

An under-rated yet key benefit is that extended bit life enables replacement at the time of the crew leader's choosing. That means new bits often can be installed between jobs or at the end of the workday when operators, haul truck drivers and labourers are off the clock.

This added efficiency provides significant cost-savings, and should be considered at the time of purchase. Bits with lower initial purchase prices can prove to be surprisingly expensive when cost-per-tonne is measured.

That bottom-line cost is why Caterpillar puts an enormous emphasis on extending bit life. Three key factors help extend life:



1. Bit design.
2. Manufacturing techniques.
3. Exclusive Cat Conical Tool Holders.

Bit design

Caterpillar Paving Products offers a variety of mill bits, with varied features, to precisely match the materials at your jobsites. Properly matched bits not only offer productivity on the jobsite, but function efficiently to extend life.

Among the life-saving design features of Cat® mill bits:

- Tapered bodies that move abrasive material away from the holder.
- Wear-reducing washers.
- High carbide content for longer wear life.

Manufacturing techniques

The manufacturing process and materials used also have an impact on mill bit life. Caterpillar Paving Products offer Master Grade carbide bits, which can provide up to 50% more life than standard bits. The focus of the manufacturing process, from the selection of materials to final heat treatment, is to produce mill bits that last.

1. Preparing powders. A hardening material, such as tungsten carbide, is combined with a cobalt bonding material. These materials are milled, mixed, dried and transformed into a powder for pressing.
2. Shaping. State-of-the-art pressing machines turn the powder into a



^ Tapered bodies and wear-reducing washers help extend the life of Cat mill bits.

3. Sintering. This high-temperature process fuses the bonding material and solidifies the hard metal product. Sintering is so intense that the size of the bit shrinks by 20% during the complex process, leaving behind a compact, hardened bit.
4. Surfaces/tolerances. The bits are so hard that diamond tools must be used to polish and hone them during the last stage of the process.

Exclusive Cat Conical tool holders

The holders themselves are built for extended life, and a tapered fit to maintain tightness. Conical tool holders extend bit life by:

- Improving rotation for even wear.
- Holding bits away from the rotor mandrel. This isolates the bits, keeps material away from the drum, and extends drum life, too.
- Breaking away if they strike

an immovable object, such as a manhole. The break-away feature helps prevent damage to more expensive components of the rotor drive system.

If you're evaluating mill bit options solely on initial price, you're missing three important elements of the equation: mill bit life, the productivity increases/savings that result from longer change intervals and the negative impact of more frequent downtime on your production schedule. To learn more, talk with our milling and paving experts. ■

TIPS FOR EXTENDING BIT LIFE

1. Choose the right bit for the right job
2. Make sure your water system is functioning properly to keep bits cool and clean
3. Adjust your conveyor speed to ensure proper material cleanout and reduce abrasion



Long-lasting mill bits maximize machine uptime. >



SUPPORT THAT WORKS AS HARD AS A CAT®.

NATIONAL COVERAGE

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Cobbs Wood Ind. Estate, Brunswick Road,
Ashford, Kent TN23 1EN

Boldon - Tel 0191 5377735 Fax 0191 4107890
Unit 3, Brooklands Way, Boldon Business Park Boldon
Tyne & Wear NE35 9LZ

Bristol - Tel 0117 980 2180 Fax 0117 980 2181
Unit 5B, Severnside Trading Estate, St Andrews Road
Avonmouth, Bristol BS11 9EB

Cannock - Tel 01543 461461 Fax 01543 461700
Service 01543 461516
Watling Street, Cannock, Staffordshire WS11 8LL

Cardiff - Tel 01443 223456 Fax 01443 236300
Forest View Business Park, Llantrisant
Pontyclun CF72 8LX

Chesterfield - Tel 01246 541541 Fax 01246 541555
Parts 01246 541571
Britannia Road, Chesterfield, Derbyshire S40 2TZ

Cork - Tel +353 21 4502252 Fax +353 21 4502945
Tivoli, Co.Cork, Ireland

Dublin - Tel +353 1 2574000 Fax +353 1 4592482
Unit 525, Greenogue Business Park, Rathcoole,
Co. Dublin.Ireland

Edinburgh - Tel 0131 440 7080 Fax 0131 440 7081
Pentland Industrial Estate, Loanhead, Edinburgh EH20 9QH

Glasgow - Tel 01698 713713 Fax 01698 711712
Whistleberry Road, Hamilton ML3 0EG

Halstead - Tel 01787 272000 Fax 01787 474968
19 Fourth Avenue, Bluebridge Ind. Estate
Halstead, Essex C09 2SY

Leeds - Tel 01132 534221 Fax 01132 531452
Gelder Road, Gildersome, Morley, Leeds LS27 7JS

Leicester - Tel 01455 826026 Fax 01455 826028
Peckleton Lane, Desford, Leicester LE9 9JT

Lisburn - Tel +44 2892 661221 Fax +44 2892 661355
Blaris Industrial Estate, Altona Road, Lisburn BT27 5QB
Northern Ireland

Muir of Ord - Tel 01463 870575 Fax 01463 870620
Muir of Ord Industrial Estate, Great North Road IV6 7UA

Nanpean - Tel 01726 823322 Fax 01726 821333
Drinnick Road, Nanpean, St Austell, Cornwall PL26 7TU

Perth - Tel 01738 623181 Fax 01738 637254
Ruthenfield Place Inveralmond Industrial Estate,
Perth PH1 3XU

Peterborough - Tel 01733 334664 Fax 01733 334674
2 Sturrock way, Off Bretton Way, Peterborough
Cams PE3 8YF

Poole - Tel 01202 330789 Fax 01202 330790
21 Witney Road, Poole, Dorset BH17 0GL

Slough - Tel 01753 505070 Fax 01753 505071
558 Ipswich Road, Slough Trading Est, Slough SL1 4EP

Winsford - Tel 01606 594311 Fax 01606 595101
Service 01606 595141
Winsford Industrial Estate, Cheshire CW7 3QE

For more information, please contact your local Finning branch.

