

BRP-Spruce Pine pushes the envelope to win industry recognition and honors

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tube water jacket design. “When we looked at this part, I knew it would be a difficult part, and I didn’t really want to sign off on it,” said Willie Anglin, senior process engineer. “But now, five years later, it is running better than many of our other blocks. The truth is, I never thought we would see it run as well as we do.”

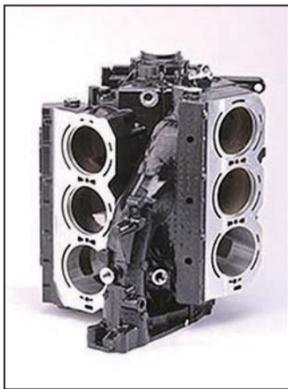
The two-stroke 300HP V-6 marine engine block called the G2 Snipe is cast in aluminum via the lost foam method. Nine foam tools are required to produce 15 individual foam patterns and the runner. The cast walls are as thin as 4mm for weight savings. Plus, rather than bolt a welded exhaust to the block, the engine designers wanted to incorporate those features into the single aluminum casting.

The one-piece design eliminated the need for multiple castings, weldments, and their assembly.

“The internal passages in this part are too delicate or too small to be made with sand cores,” said Curtis Taylor, plant manager. “Lost foam internal passages, complicated internal passages is our claim to fame. We hold tight tolerances, and we make parts where people need a lot of cooling passages or oil passages.”

This type of marine engine block is not so off base for BRP, which poured the first V-block two-stroke engine in production using lost foam. But succeeding at casting this part depended on process improvements at BRP that ultimately benefitted many other parts in production.

The first step in making the G2 Snipe is to make sub-assemblies of both the cylinder banks and the exhausts. Next, the cylinder banks are mated to the exhausts. However, before they can be joined, any glue squeeze or potential misalignment of the individual foam sections on the two mating surfaces must be dealt with.



Evinrude marine outboard engine. This entry pushed the envelope of what lost foam casting can do.

BRP uses a robot to smooth the mating surfaces and remove all obstacles to a robust glue joint between the cylinder bank and the exhaust.

“This part caused us to revisit our processes,” Taylor said. “The tolerances for everything that touches this part are tighter than everything else we produce at this plant. Everything is tighter because the product demands it.”

One of the improvements stemming from the G2 Snipe is BRP’s drying process.

“Historically, we used only heat to dry the parts, and the biggest improvement we saw was through dehumidifying the makeup air,” Anglin said. “We were able to decrease the relative humidity by roughly 90% for more effective drying.”

Dry foam patterns are important, because moisture takes energy out of the metal as it is poured, creating cold-metal type defects. Moisture can also turn to steam, which can cause voids. Achieving more efficient drying helped BRP improve its scrap rate by 40%.

For the G2 engine block, BRP also faced a challenge specific to larger lost foam cast parts.

“In a larger part like this, you are moving metal 25 inches through the part from a gate, and

it just makes it so much more difficult to get the metal back and the liquid to stay liquid in those internal passages,” Anglin said.

BRP has been successfully casting the G2 block for five years, but Taylor admits the first three years were challenging. Through continuous process developments, like improved drying, the foundry has been efficiently manufacturing the block for two years now.

Casting such a complicated part may seem like more trouble than it’s worth, but the cost savings from eliminating individual parts are considerable. Incorporating features into a single casting also helps achieve certain property and quality requirements.

“You also reduce the number of gas leaks you could potentially have in a part. That can be an issue when screws holding pieces together come apart,” Anglin pointed out. “You are going to save money, time, tooling costs, and will require fewer tools, fasteners, nuts and bolts—everything that goes into making multiple parts.”

The AFS/Casting Source Casting Competition is a chance to show the engineering and purchasing community what a metal casting can accomplish.

Beyond the company recognition and industry public relations gained through the honored castings, entries appear in trade magazines. The winners this year were showcased at Cast in North America at Metalcasting Congress in April 2020.

Free legal help available in Yancey

Pisgah Legal Services office in Burnsville is located 302 W. U.S. Hwy. 19E Bypass, Burnsville. Call 252-0406. For more info, see pisgahlegal.org.

The attorneys are working remotely and aren’t meeting with clients at the offices, but are still helping folks online and doing phone applications.

Medicare covers health screenings for men over 50

If you are a man with Medicare coverage, talk with your doctor about getting screened for prostate cancer, colorectal cancer and cardiovascular disease. Medicare covers prostate screenings once every 12 months for men over 50 and the colorectal screening tests every 120 months, unless at high risk. Cardiovascular screenings can detect conditions that could lead to heart attack or stroke and are covered by Medicare every five years. For more info, call SHIIP counselor Vivian Hollifield at Yancey Extension Service at 682-6186.

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LEGAL NOTICE

LEGAL NOTICE IN THE GENERAL COURT OF JUSTICE, YANCEY COUNTY NORTH CAROLINA SUPERIOR COURT DIVISION

NOTICE TO CREDITORS
Having qualified as Executor of the Estate of Edward Dean Canipe of Yancey County, North Carolina, this is to notify all persons and corporations having claims against the Estate of said deceased to present them to the undersigned on or before the 20 day of October, 2020 or this notice will be pleaded in bar of their recovery. All persons indebted to said estate please make immediate payment.

This the 17 day of July, 2020.
Jeremy Canipe
39 Sunny Cove Road
Candler, NC 28715
Published July 22, 29, August 5, 12, 2020

LEGAL NOTICE IN THE GENERAL COURT OF JUSTICE, YANCEY COUNTY NORTH CAROLINA SUPERIOR COURT DIVISION

NOTICE TO CREDITORS
Having qualified as Executrix of the Estate of Marcia Elaine Houchard of Yancey County, North Carolina, this is to notify all persons and corporations having claims against the Estate of said deceased to present them to the undersigned on or before the 15th day of October, 2020 or this notice will be pleaded in bar of their recovery. All persons indebted to said estate please make immediate payment.

This the 15th day of July, 2020.
Kedren M. Cooper
551 Fox Creek Road
Mars Hill, NC 28753
Published July 15, 22, 29, August 5, 2020

LEGAL NOTICE IN THE GENERAL COURT OF JUSTICE, YANCEY COUNTY NORTH CAROLINA SUPERIOR COURT DIVISION

NOTICE TO CREDITORS
File No.: 20 E 142
Having qualified as Executor of the Estate of David Alan Kent of Yancey County, North Carolina, this is to notify all persons and corporations having claims against the Estate of said deceased to present them to the undersigned on or before the 29th day of September, 2020 or this notice will be pleaded in bar of their recovery. All persons indebted to said estate please make immediate payment.

This the 1st day of July, 2020.
Erin Davis
1200 Augusta Street
Charlottesville, VA 22903
Published July 1, 8, 15, 22, 2020

LEGAL NOTICE STATE OF NORTH CAROLINA COUNTY OF YANCEY

NOTICE TO CREDITORS
The undersigned, having qualified as ADMINISTRATOR of the ESTATE OF MATTHEW GLENN RIDDLE, deceased, late of YANCEY County, North Carolina, notifies all persons having claims against said estate to present them to the undersigned c/o Lisa M. Rothman at McGuire, Wood & Bisette, P.A., PO Box 3180, Asheville, NC 28802, on or before October 22, 2020, or this Notice will be pleaded in bar of their recovery. All persons indebted to said Estate will please make immediate payment to the undersigned.

This the 22nd day of July, 2020.
KATHLEEN R. RODBERG, ADMINISTRATOR
ESTATE OF MATTHEW GLENN RIDDLE
Published July 22, 29, August 5, 12, 2020

LEGAL NOTICE IN THE GENERAL COURT OF JUSTICE, YANCEY COUNTY NORTH CAROLINA SUPERIOR COURT DIVISION

NOTICE TO CREDITORS
Having qualified as Executor of the Estate of Rema Mae Holder Padgett Ogle of Yancey County, North Carolina, this is to notify all persons and corporations having claims against the Estate of said deceased to present them to the undersigned on or before the 8th day of October, 2020 or this notice will be pleaded in bar of their recovery. All persons indebted to said estate please make immediate payment.

This the 8th day of July, 2020.
Jeannette Petty
69 River Run Lane
Burnsville, NC 28714
Published July 8, 15, 22, 29, 2020

LEGAL NOTICE IN THE GENERAL COURT OF JUSTICE, YANCEY COUNTY NORTH CAROLINA SUPERIOR COURT DIVISION

NOTICE TO CREDITORS
Having qualified as Executor of the Estate of Emma Gibbs of Yancey County, North Carolina, this is to notify all persons and corporations having claims against the Estate of said deceased to present them to the undersigned on or before the 29th day of September, 2020 or this notice will be pleaded in bar of their recovery. All persons indebted to said estate please make immediate payment.

This the 1st day of July, 2020.
Jeffery Ray Gibbs
1211 Pine Swamp Road
Burnsville, NC 28714
Published July 1, 8, 15, 22, 2020

8 July 2020

I never cried out from the pain

I cry out, everyday from the pain. Everyday, today, everyday since 10/73. I never talked.

So much punishment for doing “the most right thing” 19 Dec 1965. Something only sacrifice can equal.

My Vietnam story of 18 & 19 Dec 1965 is good enough for the Pulitzer Prize in true journalism. The cover-up of Execution of Prisoners of War by the United States Government.

In the attempts to discredit me a lot of lies have been told. In 1977 – 78 – 79 there were so many fabrications that it took 14 pages in the New York Times to tell them.

A few years ago I began talking again. I talked to a lady that said, she could help me. Turns out she was an investigator for the SPCA.

I was putting the SPCA out of business in St. Petersburg, FL by giving away 1000 dollar dogs for the price of a shot record. You, all, saw me on TV as the lies were told. The SPCA tried to do me like they did the circus. Both, the judge and the SPCA colluding together. I went to court 9 times without an attorney and long story short their lawyers ran from the courtroom. I could sue for 5 million and win the money for what they did to me.

On 14 Dec 02 leaving Adult Education Classes for the Christmas holidays, while on a bicycle I was struck by a hit and run car in St. Petersburg. Turns out after identifying him 2 days later, a prominent attorney, the police would not allow me to report the crime under threat of arrest if I continued to insist. He broke my right little finger and permanently damaged the 3rd finger. A Peter A. Meros and his secretary fine upstanding citizens. There is also much pain when I write.

I am still saying the same thing I was talking about in 1975. Thousands of lies to keep quiet what could have been honored by a cover story of fake news. Lies of our great fathers. An entire country treating war crimes of murder of POW with silence.

In Vietnam to stay alive after LZ Tonto I became the most volunteer for hazardous duty. For 5 months I was the bait to draw out the enemy.

I was poisoned twice, hospitalized twice, near death. Americans did this to me to cover-up murder, torture, execution, push-out.

After returning to the U.S., still in uniform I was given the wrong parachute, twice. The first, I was a Jump Master and taped out 5 jumpers from a UH-1. I jumped from the skids, a night equipment drop. On the way down I passed-up those 5. On land while those 5 still in the air I broke my M-14 in half and an aluminum pack frame in 6 places. I walked off the drop zone. The second; a sky-dive from outside a fixed-wing aircraft. I fell almost 3200 feet with a very small amount of parachute. My commando MC-1 parachute was taken from me and I was re-issued this old style T-10, (modified). Only a professional parachute landing fall saved my life. 31 days hospitalized. Disabled for life.

I was shot by my C.O. Cpt. Roy Martin 18 Dec 1965 once in each boot. I exposed myself to attempt to reveal my location to stop my own unit from firing on my position. I had volunteered to infiltrate 3 Reinforced regiments of Viet Cong and North Vietnamese Regulars. I recovered William Nells Swanson, a kid left on the battlefield. I recovered weapons, ammo, equip. and a “top secret” Russian Aiming Device that was most likely responsible for shooting-down our gunship Slick and filled my bird with holes. I believe I killed 10 men. Back in the U.S. on duty in uniform I was shot by two men under orders from a Lt. Samuel Mitchell to shoot me. They did. I looked into their eyes and into their minds as in face to face combat and moved at a divine time saving myself from a gut shot. Struck in the upper left leg by a 44 – 40 cal. bullet. I had just started talking about LZ Tonto asking for my medals.

If there is any decency left in America I would appreciate accepting some of it as I am in sore need of comfort.

Well, anyway, don’t make me go on forever because I will never stop. I have revealed much fear and horrifying anguish close to my heart. However, those lies spewed by the establishment that I was despondent are just that – lies to discredit me. Fabrications to dishonor me.

My life improves. All those whom share my story, share the pain as I release the long fear into the readers of this publication. My life improves. Others, are now helping me to carry the burden.

Honor and Courage
James Holland