

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD



*“ DAWN OF A NEW ERA ”*

*PRECISION GRINDING, TURNING, MILLING, GENERAL MACHINING AND MANUFACTURING*

*SUPPLIERS OF GUIDE ROLLERS, GUIDES, SHEAR BLADES AND TACKLE SPARES FOR ALL STEEL MILLS*

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## FOUNDING MEMBERS



**Rinaldo Natale Bellora**  
**\*20/12/1922 - +27/09/1998**



**Luigi Giordana**  
**\*11/10/1918 - +07/07/2001**

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## INTRODUCTION

## HISTORY

B.C.F. Precision Grinding Works (Pty) Ltd. was established in July 1966 by the late Rinaldo Natale Bellora and the late Luigi Giordana. Rinaldo was an artisan from Italy who worked at the world famous Graziano Lathes in Tortona a Company where they manufactured Graziano lathes. After immigrating to South Africa in 1952, he worked for H. R. Lasch (Pty) Ltd, in Germiston, machining parts for the overhead Lasch cranes. Luigi, also an artisan from Italy had worked for the Italian Air Force and Fiat Automobile manufacturers in Torino as a grinder.

Grinding jobs for customers such as Nordberg Ltd. and E.C. Lenning Ltd enabled B.C.F. Precision Grinding Works (Pty) Ltd. to steadily expand and in 1967 they found a niche in the market to service a steel mill called Union Steel Corporation Ltd. in Vereeniging. By 1979 guide rollers, shear blades and various tackle for Vaal Works and Klipworks were being reconditioned.



# **B.C.F. PRECISION GRINDING WORKS (PTY) LTD**

In December 1979 Walter Bellora followed in his father's footsteps and learnt the ropes of servicing the steel mills. B.C.F. Precision Grinding Works (Pty) Ltd. then began to manufacture guide rollers, shear blades, guides, shafts and various tackle for the steel mills, always trying to find new ways of improving the various items.

Since then, B.C.F. Precision Grinding Works (Pty) Ltd. has grown from strength to strength and is still growing every part of the business. Working with the best precision grinding, milling and turning machines. Manufacturing of guide rollers, guides, blades and various tackle for the steel mills, makes the range of work in the industry almost endless.

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## Commitment

B.C.F. Precision Grinding Works (Pty) Ltd. is committed to the industry and specifically to the products of the steel mills for ArcelorMittal S.A Ltd. (Newcastle, Pretoria and Vereeniging). The quality and delivery is of a very high standard and B.C.F. Precision Grinding Works (Pty) Ltd. takes pride in being one of the better sub-contractors of ArcelorMittal products for Newcastle, Pretoria and Vereeniging. The employees of B.C.F. Precision Grinding Works (Pty) Ltd. must be highly praised for their efforts and positive attitude towards their work, many of them already 2nd generation coming through the business.

To date B.C.F. Precision Grinding Works (Pty) Ltd. manufacture in excess of 820 different articles, of which over 16860 items have been delivered in one calendar year.

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## SPECIAL SHAFTS



**OIL QUENCH**



**HEAT TREATMENT**



**SHAFT HEAT TREATED**



**KARK FORGINGS**



**FORGING PRE MACHINED**



**SHAFTS STRESS RELIEVED**



**KARK SHAFTS**



**KARK SHAFTS**



**KARK SHAFTS**



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## SPECIAL SPARES



**KARK SPARES**



**KARK SPACER**



**KARK LOCK NUT**



**KARK LOCK NUT**



**KARK CLAMPING RING**



**KARK CLAMPING RING**



**KARK SUPPORT RING**



**KARK SUPPORT RING**



**KARK SPACING DISC**



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## GUIDE ROLLERS



**RAW MATERIAL**



**BLANKS**



**ROLL BEARING INSERTS**



**KIESERLING ROLLERS**



**GUIDE ROLLER STORE**



**GUIDE ROLLER STORE**



**SPECIAL GUIDE ROLLERS**



**GUIDE ROLLER STORE**



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## SHEAR BLADES



**RAW MATERIAL**



**ROUGHING STAGE**



**BLADES FOR RECONDITIONING**



**V BLADES, FLYING SHEAR**



**GROUND BLADES**



**FINISHED PRODUCT**

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## GENERAL SPARES



**STORES**



**GUIDE BOXES**



**GUIDE BOXES**



**FILLETING RINGS**



**PRESSURE RINGS**



**INNER RINGS**



**LOCKING RINGS**



**GUIDES**



**SHAFTS**



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## GENERAL SPARES

For all your  
Precision Grinding  
Turning  
Milling  
Horizontal and Vertical Boring  
CNC Turning  
NC Milling and Polishing  
General machining  
Reconditioning



Suppliers of  
Guide Rollers  
Mill Guides  
Various cropping blades  
Tackle for all types of steel mills



Sub-contractors for  
Heat treatment  
Chroming  
Metal spraying including  
Tungsten Carbide and  
Chrome Carbide





# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## HEALTH AND SAFETY

**WELCOME TO**



**PRECISION GRINDING  
WORKS (PTY) LTD.**

**VISITORS TO SIGN IN BEFORE ENTERING FACTORY.  
SAFETY INDUCTION IS COMPULSORY.  
VISITORS WILL BE ESCORTED AT ALL TIMES.**



**UNAUTHORISED  
ENTRY STRICTLY  
FORBIDDEN**



**MOVING  
MACHINERY**



**SAFETY SHOES  
COMPULSORY  
IN WORK SHOP**



**TRESPASSERS  
WILL BE  
PROSECUTED**

**WE **TRUST** THAT YOU WILL PARTNER US AND  
COMPLY WITH **OUR HEALTH & SAFETY VALUES****



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## HEALTH AND SAFETY



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## HEALTH & SAFETY

## AUDIT ASSESSMENT REPORT

### Vendor Assessment Report



BCF Precision Grinding Works (Pty) Ltd

Registration number: 1966/000632/07

Physical address: 46 Ilana Street, Delville Ext 1, Germiston  
Tel: 011 827 4823  
Fax: 011 824 3313  
e-mail: BCF@TELKOMSA.NET

Vendor Number  
1150626 and 1161374

Report number: V1392

Date of report: 2012.03.28  
Date of assessment: 2012.03.28  
Faxed to:  
OR  
Received by: Signature:

Copy to:  
Vendor  
Vendor File  
Requestor

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# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## 1. Purpose

The purpose of the assessment was to determine if BCF Precision Grinding Works Pty Ltd has implemented the necessary Quality, Safety Management and Environmental system that complies with the minimum standards to be a vendor to ArcelorMittal Steel South Africa Limited.

The Vendor Specialist conducts assessments in accordance with ArcelorMittal Steel South Africa Limited and the Vendor Management's strategy, which assesses the vendor's involvement in implementing and maintaining Quality, Environmental and Safety Management systems.

Please note that this was not a complete audit, therefore it was not possible to cover all aspects of the vendor's activities and consequently it does not mean that no other shortcomings exist.

## 2. Vendor's scope of supply

BCF Precision Grinding Works (Pty) Ltd was established in July 1966, and provide the following services:

- Precision Grinding
- Turning
- Milling
- CNC
- General Machining

BCF Precision Grinding Works (Pty) Ltd are suppliers of the following products:

- Guide Rollers
- Guides
- Shear Blades
- Tackle Spares for Steel Mills

They are currently a supplier to ArcelorMittal SA, Newcastle and Vereeniging Plants.

## 3. Requirements

ArcelorMittal Steel South Africa Limited strives to conduct business with vendors who have implemented the following three management systems or equivalent:

- 3.1 Quality Management System (ISO 9001:2008)
- 3.2 Environmental Management System (ISO 14001:2004)
- 3.3 Safety Management System (OSHAS 18001:2007)

Failure to comply with these requirements could affect the organisation's future applications for work with ArcelorMittal Steel South Africa Limited.

## 3.1 Quality Management System (ISO 9001:2008)

BCF Precision Grinding Works (Pty) Ltd has documented and implemented activities of a Quality Management System that complies with ISO 9001:2008 standards.

- Documented Quality Management system does exist.
- Minutes of Management Review meetings are documented.
- Drawings and programmes for all machines are kept on file.
- Customer surveys are done.
- Job cards are signed off at each stage and inspected.
- Company organogram is available with clearly defined roles and responsibilities.
- Non-conformance reports are being issued. None received.
- Approved suppliers list maintained.
- Test certificates are issued by suppliers.
- A guide manual is available for calibration of measuring equipment used.

The following findings were made during the assessment:

- Internal audits to be done once system is fully developed and implemented.
- NCRs to be completed once feedback received from supplier.

## 3.2 Environmental Management System (ISO 14001:2004)

BCF Precision Grinding Works (Pty) Ltd has elements of an Environmental Management System.

The following positive activities to the implementation and maintenance of an Environmental Management System (ISO 14001:2004) were observed:

- Environmental policy is documented and available.
- There is a general procedure in place to address an EMS.
- Management review meetings are combined for entire SHEQ system.
- Scrap metal recycling is done.
- Oil is collected by an external company.
- Material Safety Data sheets are available.
- Drip trays are made use of.

The following findings were made during the assessment:

- Environmental Representative is not formally appointed as a consultant will be used to develop systems.
- Environmental audits are not done.
- Environmental system is not fully developed.



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## 3.3 Safety Management System (OSHAS 18001:2007)

BCF Precision Grinding Works (Pty) Ltd has documented and implemented activities of a Safety Management System that complies with OSHAS 18001:2007 standards

The following positive activities to the implementation and maintenance of a Safety Management System (OSHAS 18001:2007) were observed:

- SHE policy is in writing and prominently displayed.
- All employees informed and trained regarding the SHE policy.
- There is a copy of the OHS act available.
- Legal appointments have been done.
- Health and Safety Rep has been appointed even though there are less than 20 employees.
- Overhead crane training and CNC training is done. As well as in house training.
- Combined SHEQ Management Review minutes available.
- Health and safety committee meetings are held every three months.
- Health and Safety Rep monthly inspections are done monthly.
- Toolbox talks done at the factory.
- Personal Protective Equipment is recorded on a register.
- Incident investigation procedure is in place.
- Risk assessments done by consultant.
- Risk assessments are included in the management review minutes.
- HIRAs and safe work procedures are available.
- Task observations are completed.
- Equipment registers are maintained.
- First aid boxes are available, together with legally compliant inventory.
- Medical records of employees are kept on file.
- Lockout procedure is available.
- SHE audits are done very six months.
- Vehicles have a maintenance plan in place and checklists done on all five vehicles.

The following findings were made during the assessment:

- PPE must be signed for by employees on each issue of PPE.
- Behaviour based safety is not yet monitored.

## 4. Recommendations

Based on the work performed by the vendor specialist, it was established that BCF Precision Grinding Works (Pty) Ltd complies with the requested criteria in order to conduct business with ArcelorMittal South Africa Limited.

Quality, Safety- and Health system policies and procedures are developed and available.

Management has demonstrated positive commitment to the implementation of management systems and is well motivated to expand and improve on current systems.

BCF Precision Grinding Works (Pty) Ltd currently has been awarded a contract to supply ArcelorMittal SA and were audited initially in 2011. There has been a lot of progress towards the successful implementation and development of their SHEQ systems.

ArcelorMittal SA can continue to make use of the BCF Precision Grinding Works (Pty) Ltd as a supplier.

Audit conducted by

  
Devina Chetty  
Vendor Specialist  
Vendor Management  
Procurement and Logistics  
Centre of Excellence

12/04/2012  
Date

Approved by

  
Mias de Kock  
Manager  
Vendor Management  
Procurement and Logistics  
Centre of Excellence

18/4/2012  
Date

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD



**GUARD HOUSE**



**DESIGNATED SMOKING AREA**



**RECYCLING AREA**



**OIL CATCHMENT AREA**



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## QUALITY



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## QUALITY

Certified ISO 9001 : 2008    TUV Rheinland    Cert. Reg. No. 01 100 828275

The Directors, Management and all employees of B.C.F. Precision Grinding Works ( Pty ) Ltd. accept full responsibility for supplying products and services to their customers in accordance with the agreed specifications, delivery times, prices, quality and acknowledges that the customer satisfaction is essential for continued growth and long-term profitability.

Suppliers whose products or services affect the quality, products and services of B.C.F. Precision Grinding Works (Pty) Ltd. are expected to provide assurance for the quality of their products and services.

Management undertakes to achieve a standard of excellence and integrity by ensuring that all employees are treated equally through involvement and participation.

All personnel at B.C.F. Precision Grinding Works ( Pty ) Ltd. will be committed to observing and abiding by the contents of this policy statement and ensuring that it is implemented, communicated and understood at all levels in the organisation. B.C.F. Precision Grinding Works ( Pty ) Ltd. is committed to the continuous improvement of its activities.

In order to realise this policy statement : the following quality objectives are pursued:

The adopted quality system must ensure that the products delivered and services rendered comply with the in-house standards, customer order requirements, customer drawing specifications and codes of good practice pertaining to all work and or contracts.

The adopted quality system must comply with the in-house requirements and other relevant specific quality system requirements which will be reviewed for continued suitability both internally (B.C.F. Precision Grinding Works (Pty) Ltd. and externally (Customers).

The adopted quality system must ensure that the quality and costing programme is continuously improved.



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

QUALITY

ISO 9001 : 2008



Management  
System  
ISO 9001:2008



www.tuv.com  
ID 9105075812

## CERTIFICATE

Standard ISO 9001:2008

Certificate Registr. No. 01 100 828275

TÜV Rheinland Inspection Services Certifies:

Certificate Holder: **B.C.F. Precision Grinding Works (Pty) Ltd**  
46 Ilana Street  
Delville Ext 1  
Germiston  
1401  
South Africa

Scope: Precision Grinding, Turning, Milling, CNC and General  
Suppliers of Guide Rollers, Guides, Shear Blades and Tackle  
Spares for the Steel Mills

An audit was performed, Report No. 828275. Proof has been  
furnished that the requirements according to ISO 9001:2008  
are fulfilled.

The due date for all future audits is 10 - 04 (dd.mm).

Validity: The certificate is valid from 2014-05-19 until 2017-05-18  
First Certification 2014

A handwritten signature in black ink, likely of a TÜV Rheinland representative.

South Africa, 2014-05-20

TÜV Rheinland Inspection Services (Pty) Ltd  
92 Koranna Avenue  
Doringboud  
Centurion  
0140  
Certification Body No. C09



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Precisely Right.

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

CAD /CAM PROGRAMMING - EDGE CAM



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

**BBBEE**



Certificate Number: RM / 102857



IRBA Registration  
no 374172

## BROAD BASED BLACK ECONOMIC EMPOWERMENT VERIFICATION CERTIFICATE

**Company Name:** BCF Precision Grinding Works (Pty) Ltd  
**Trading As:**  
**Registration Number:** 1966/000632/07  
**VAT Registration Number:** 4040101414  
**Physical Address:** 46 Ilana Street, Delville, Germiston,

---

**Scorecard Applied:** Qualifying Small Enterprise Scorecard

Element	Weighting Points	Actual Score
Employment Equity	25	17.79
Preferential Procurement	25	25.00
Enterprise Development	25	18.05
Socio-Economic Development	25	25.00

**Broad Based BEE Status Level** Level Two  
**BBBEE Procurement Recognition Level** 125%  
**Fronting Practices** None  
**Black Ownership** 0.00%  
**Black Women Ownership** 0.00%  
**Value Adding Supplier (Yes/No)** Yes  
**Enterprise Development (Yes/No)** No  
**Financial Year End** 28 Feb 2014

**Verification Date:** 15/08/2014  
**Expiry Date:** 14 August 2015



B-BBEE Approved Registered Auditor Full Name: Renn G Moore  
B-BBEE Approved Registered Auditor: Registration No: 374172  
B-BBEE Approved Registered Auditor  
RG Moore & Associates Incorporated





In our opinion, the B-BBEE Status reflected on this Certificate has been determined, in all material respects, in accordance with the Codes of Good Practice on Black Economic Empowerment gazetted on 9 February 2007 in terms of the Black-Economic Empowerment Act of South Africa. Our independent reasonable assurance report is available for inspection at the registered office of BCF Precision Grinding Works (Pty) Ltd together with the accompanying Scorecard and should be referred to for an understanding of our assurance engagement. This certificate has been determined, on the basis of information provided by management that may not be complete in all respects. We do not accept or assume responsibility to anyone other than BCF Precision Grinding Works (Pty) Ltd for our work, for this report, or for the conclusion that we have reached.

Cenfed B-BBEE Verification Agency (Pty) Ltd • Le Marle Estate • 2 Station Road • Nigel • Tel: (011) 814 2752/3 • Fax: 086 513 0744  
www.cenfedbee.co.za • admin@cenfedbee.co.za • Company Registration No. 2012/164259/07

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## POLICIES

- HUMAN RIGHTS POLICY
- SOUND BUSINESS CODE AND GOOD PRACTICE POLICY
- CODE OF ETHICS POLICY
- ACCESS TO INFORMATION POLICY
- BBBEE POLICY
- RISK MANAGEMENT POLICY
- HEALTH AND SAFETY POLICY
- QUALITY POLICY
- ENVIRONMENTAL POLICY
- WORK PLACE CODE OF CONDUCT POLICY
- ANTI-FRAUD CORUPTION AND BRIBERY POLICY
- INTOXICATING DRUGS AND ALCOHOL POLICY
- CRANES AND HOISTS POLICY



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## TYPE OF MACHINES

- LATHES : CNC, PARALLEL, COPY, TURRET, UNIVERSAL, TOOLROOM
- GRINDERS : EXTERNAL, INTERNAL, INTERNAL CNC, SURFACE, CRANKSHAFT, CYLINDRICAL
- MILLING : CNC, NC-BED TYPE, UNIVERSAL, DOUBLE HEAD, SLOT, HORIZONTAL, MACHINING CENTRE
- BORING MILL : HORIZONTAL, VERTICAL
- DRILLS : PEDESTAL, H / D RADIAL ARM
- SAWS : AUTOMATIC, POWER, BAND, VERTICAL, HORIZONTAL
- HONING : SPEED HONE, HORIZONTAL
- MISCELLANEOUS : WIRE CUTTING, SHAPING MACHINE, ABRASIVE CUT OFF, 200 TON PRESS, WELDERS MIG / TIG, VERTICAL PLANER, DIAMOND TOOL GRINDER, SLOTTER, SPARK ERODER.

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## MACHINING FACILITIES

up to and including machining sizes

- **LATHES PARALLEL** : O/D 1000mm X L 3000mm
- **LATHES CNC** : O/D 950mm x L 3200mm
- **LATHE COPY** : O/D 400mm x L 2000mm
- **GRINDERS EXTERNAL** : O/D 680mm x L 2500mm
- **GRINDERS INTERNAL** : I/D 650mm x L 550mm
- **GRINDER INTERNAL CNC** : I/D 250 mm x L 250 mm
- **GRINDERS SURFACE** : L 2000mm x W 500mm x H 1000mm
- **MILLING** : L 3000mm x W 750mm x H 2000mm
- **MILLING CNC** : L 3200mm x W 970mm x H 950mm
- **MILLING DOUBLE HEAD** : L 500mm x W 400mm x H 400mm
- **HORIZONTAL BORING MILL** : L 2000mm x W 2000mm x H 1500mm
- **VERTICAL BORING MILL** : O/D 1600mm x H 1000mm
- **WIRE CUTTING** : L 1000mm x W 600 x H 300mm
- **DRILLS RADIAL** : L 1000mm x H 1200mm
- **DRILLS PEDESTAL** : Stroke Height 1000mm
- **SAWS POWER** : O/D 420mm
- **SAWS BAND** : O/D 500mm
- **HONING** : Diameter 1.143mm x L 80mm
- **SPARK ERODER** : Stroke Height 300mm
- **SLOTTER** : Stroke Height 1000mm

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## MACHINE GALLERY AT B.C.F.





# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

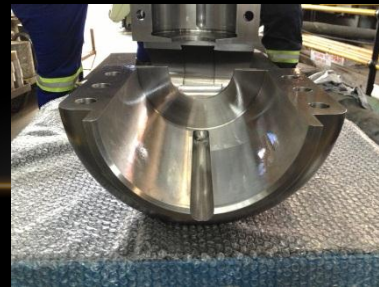
## MACHINE GALLERY AT B.C.F.





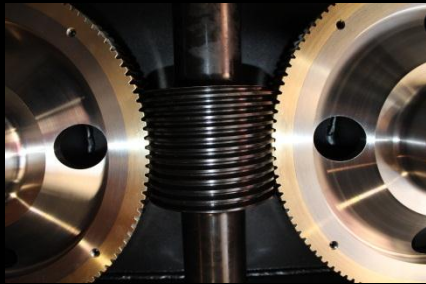
# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## JOB DONE GALLERY



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## JOB DONE GALLERY





# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## STAFF EMPLOYEES AND TRAINING FACILITIES



STAFF & EMPLOYEES



TRAINING FACILITY



TRAINING FACILITY



EMPLOYEES



WALL OF EMPLOYEES ACHIEVEMENTS AND COMPANY POLICIES



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD


## AWARDS AND MEMBERSHIP



# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## *Certificate* **of membership**

*BCF Precision Grinding Works (Pty) Ltd*

  
Chief Executive Officer: SEIFSA

is a member of the  
**South African Engineers' and Founders' Association**  
(Member Number 497)

federated to  
**Steel and Engineering Industries Federation of Southern Africa (SEIFSA)**

Duration of membership: 27 July 1978 to 30 June 2015



Steel and Engineering Industries Federation of Southern Africa  
**OUR PASSION, YOUR SUCCESS**





# B.C.F. PRECISION GRINDING WORKS (PTY) LTD



East Rand

## THE CHAMBER OF COMMERCE AND INDUSTRY - EAST RAND

### EVALUATION CRITERIA

SECURITY, MARKETING, AFTER SALES SERVICE  
PROFESSIONALISM, HUMAN RESOURCES  
PRIORITIES, TRANSPARENCY, COMPLIANCE  
WITH LEGAL REQUIREMENTS,  
FIRST IMPRESSIONS.

THIS IS TO CERTIFY THAT

**BCF**

*Precision Grinding Works (Pty) Ltd*

HAS ACHIEVED A

**Silver**

**FLEUR-DE-LIS  
BUSINESS AWARD**

IN THE CATEGORY

SMALL TO MEDIUM SIZED COMPANIES

L.A. van Der Walt

CEO

Chamber of Commerce

PRESIDENT



Date of Affiliation  
24/06/2014



Renewal Date  
24/06/2015



East Rand

Chamber of  
Commerce &  
Industry

CERTIFICATE OF MEMBERSHIP

*This is to certify that*

**BCF**

*Precision Grinding Works (Pty) Ltd*

*Has been awarded*

**Membership**

L.A. Van Der Walt

CEO

Chamber of Commerce

PRESIDENT



Date of Affiliation  
24/06/2014



Renewal Date  
24/06/2015





# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

## REVIEWS



**METALWORKING NEWS**  
VOLUME 11.1  
March 2012

**we have a dream**  
*to provide turning operations and all machining services*

**D'ANDREA**  
MULTITRADE DISTRIBUTORS  
TOTAL TOOLING SOLUTIONS

**D'ANDREA®**  
TECHNOLOGY FOR MORE PRECISION

*Easy to install  
Contained costs  
Easy connection  
High performances  
Reduced dimensions and weights.*

## 46 Years of engineering craftsmanship



Wesley and Walter Bellora

Industry in Italy is characterised by a large number of small, family-owned companies, almost all of them located in the northern part of the country, where industry in Italy is concentrated.

The Italian engineering industry has not escaped this scenario and the picture still holds true today. However industry in Italy has not just relied on the family businesses alone. Some big, internationally recognisable names have emerged, names that don't leave you guessing, especially in the engineering field.

With a strong emphasis on artisans and craftsmanship these Italian companies built an enviable reputation, passing the skills on to the next generation. The history of engineering will reveal that Italian artisans have made a name for themselves worldwide and are held in the highest regard. World War II left Italy in disarray and many of these artisans looked internationally to create a new life.

South Africa was to benefit with a number of these immigrants choosing to venture south of the equator.

Two such gentlemen were the late Rinaldo Bellora and the late Luigi Giordana. Rinaldo learnt his trade at Graziano Tortona Srl where they manufactured the world renowned Graziano lathes. After immigrating to South Africa in 1952, Rinaldo worked for H. R. Lasch (Pty) Ltd, in Germiston, Gauteng machining parts for the overhead Lasch cranes.

Luigi had worked for the Italian Air Force and Fiat Automobile as a grinder before joining up with his friend Rinaldo in South Africa. Luigi then worked for Paramount Gears (pty) Ltd, and on 27 January 1966 B.C.F. Precision Grinding Works (Pty) Ltd, (BCF) was established.

Grinding jobs for customers such as Nordberg and E.C. Lenning enabled BCF to steadily expand and in 1969 they found a niche in the market to service the wear parts and recondition spares or replacement parts for the steel mill Union Steel Corporation Ltd, which was based in Vereeniging.

By 1979 rollers, shear blades and various other components and wear parts for Vaa Works and Kilgworks were being reconditioned by the company.

Although the company had focussed on grinding type applications in the beginning the mix of disciplines offered has changed considerably. Precision grinding is still very much part of the company requirements, however cnc turning, milling and



An overhead view of the machine shop

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD



The mix of components that BCF manufactures as replacement parts or spares has increased considerably over the years. These include many different sizes and shapes of guide rollers, shear blades and shafts and today total 722 items. These are either manufactured from forgings or are machined from solid bars or blanks. BCF holds stock inventories of up to nine month lead times and up to 15 000 components can be manufactured by the company in one year



general machining is what accounts for the majority of the work carried out by BCF.

These disciplines are complimented by horizontal and vertical boring mills, polishing, wire cutting, spark erosion and the slotting of keyways.

As is customary in Italy second and third generation family members would join the company started by the father. This has been no different at BCF. Walter, Rinaldo's son, began working for the company in 1980 after completing his national service commitments.

"I had no formal training in any aspects of the business," recalls Walter. "I was employed to look after the administration and the servicing of clients, which were mainly the steel mills, as well as trying to increase the order intake. Being young and enthusiastic and very naïve no job was too complicated for Dad's company. Little did I know that from time to time I was being set-up and the optical illusion drawings handed over to me for quoting were not possible to machine. I soon learnt and have never stopped learning since."

"During this stage I would spend time on the shopfloor learning the basics of machining and how to operate the conventional machines that we had at the time. While they were still alive both my dad and Luigi continued to operate the machines daily. In fact both my dad and Luigi were still working for the company when they passed away at the age of 76 years and 83 years respectively."

"It was as early as 1980, a couple of months after I joined the business that I realised how important artisans were to BCF. I took a decision with my father's permission to embark on surrounding ourselves with

young talented artisans."

"Chris van der Walt, Petrus Mphela and a few years later Carlos de Almeida joined BCF.

Today these three artisans alone have a combined 89 years of service between them."

"The decision to surround ourselves with young artisans in 1980 has definitely been the most important business decision I have ever made. Carlos has since trained new young employees into impeccable artisans with strong basic founding skills."

"That quality is important for BCF and its clients. Carlos is also in charge of the production. 60% of our employees and staff have over 25 years service and even on their side second generation family members have joined the company," said Walter.

Limited by time taken on the conventional machines and coupled with an increase in volume and components required by clients, BCF invested in their first NC machine on the 5 January 1989. More have followed since and today the company has 13 CNC machines comprising lathes and machining centres. The newest machine is a Litz MV 1400 A which was installed just over a year ago. It came equipped with a fourth axis.

All machines are run via the EdgeCAM machining programme.

Besides most of the conventional lathes and grinders other machines that the company has includes a Chmer Wire EDM CW1060 HS, a Chmer spark eroder CM H322, a Rockford vertical slotter, Coccen band saw SH-7550S and other inspection and measuring engineering equipment.




Shear blades recently manufactured by BCF




Shafts in the process of being manufactured by BCF


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Other machines that the company has includes a Chmer Wire EDM CW1060 HS

The company can turn components with a maximum outside diameter of 1000 mm up to 3 000 mm in length on their lathes, and milling machine specifications are up to: length 3 000 mm x width 750 mm x height 2 000 mm. External grinding parameters are: outside diameters of 680 mm x length 2 500 mm; internal grinding: outside diameter swing 750mm X inside diameter 600 mm x length 550 mm and tool room surface grinding: length 3 000 mm x width 500 mm x height 1 000 mm.



The company also has a Chmer spark eroder CM H322



The company can turn components with a maximum outside diameter of 1000 mm up to 3 000 mm in length on their lathes

Horizontal boring mil encompasses: length 2 000 mm x width 2 000 mm x height 1 500 mm. Vertical boring mill outside diameter 1 600 mm x height 1 000 mm and the slotting machine specifications are: outside diameter 2000 mm x 1000 mm height.

The mix of components that BCF manufactures as replacement parts or spares has increased considerably over the years. These include many different sizes and shapes of guide rollers, shear blades and shafts and today total 722 items. These are either manufactured from forgings or are machined from solid bars or blanks. BCF holds stock inventories of up to nine month lead times and up to 15 000 components can be manufactured by the company in one year.

"The majority of the components are for the steel mills but we are not limited to this type of machining," explained Walter. "We do have long standing contracts with most of the mills but we have broadened our base of clients over the years and are looking to increase the numbers."

One of the more interesting components that BCF has recently started manufacturing is locking rings and special shafts. "Made in stainless steel the rings are import replacement components. The rings are manufactured to very tight tolerances and we are pleased to say that our rings are outperforming the imported component," enthused Walter.

## Third generation

Keeping it in the family, Walter's wife Linda joined the company 22 years ago to manage the book keeping side of the business. But now a third generation Bellora is fully entrenched in the business. Walter and Linda's son Wesley joined in 2008 after completing training at Hotel School and a couple of years in the commercial field.

"When Wesley decided to join the family business I wasn't sure where he would fit into our mould and thought back to when I joined BCF that, the same type of scenario probably entered my father's mind 33 years ago. However with the clients we are currently dealing with we needed to implement a number of safety and quality procedures. I needed help on these admin aspects and this is where Wesley has been a great help. If you don't have these controls in place you are likely to lose the business. Besides that, we embraced the fact that our employees have been very loyal to the company and we needed to provide a safe environment that is conducive to productive and enjoyable working conditions."

With a strong emphasis on artisans and craftsmanship these Italian companies built an enviable reputation, passing the skills on to the next generation

"Wesley however thrives on the work he does on the machines, an obvious gift from his grandfather's genes. He has exceeded all our expectations in this sector at BCF. Like all our valued artisans and employees Wesley has already become an invaluable asset to the family business."

"We have also attained a level 2 BEE compliance certificate, thanks to Wesley's dedication."

Currently the manufacturing facility of BCF occupies just over 1 000 m<sup>2</sup> under roof and two further buildings, each in the region of 480 m<sup>2</sup>, house a vast amount of materials that have not been machined. Included in the one is a training room and a specific health and safety office.

"Our goal is to make our customers comfortable with our artisans ability to not only make precision quality components for them, but to realise the importance of looking after people as a whole so that they may become efficient, to improve the standards of our industry in South Africa and to become even more competitive" Walter concluded.

For further details contact B.C.F. Precision Grinding Works on TEL: 011 827 4823 or email bcf@telkomsa.net ■



The Rockford vertical slotter is capable of machining components with an outside diameter 2000 mm and a 1000 mm height

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## THE FUTURE AT B.C.F.

Third generation - Wesley Bellora joined the company in August 2008 he has a hands on approach to learning, programing, machining and managing the various facets of the company. Wesley together with management and the employees has taken the company to a higher level in technology and administration. Achieving the compliancy level and certification for the company's Quality Management System ISO 9001 : 2008 ID Number 9105075812 together with TUV Rheinland , Certificate Registration Number : 01 100 828275. This achievement is a step in a positive and future direction for the company. B.C.F. Precision Grinding Works (Pty) Ltd. will strive to employ its engineering expertise and continue to provide the quality to new and refurbished range of products, thereby benefitting the industry and our clients by optimising the plant, equipment and employees. To create through our endeavours total satisfaction, peace of mind and wealth for all stakeholders. Wesley is fully responsible for the technology innovations at B.C.F. Precision Grinding Works (Pty) Ltd.

# B.C.F. PRECISION GRINDING WORKS (PTY) LTD

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