

GHP-SOP-02 Rev. No. 1	Standard Operating Procedure	Date: 7/25/06
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Knife Bond Check SOP

Purpose: To ensure proper glue bonds

Responsibility: Supervisors and Leads

Procedure:

1. Perform at least four knife bond checks per shift, per day
 - One from each spreader
 - Additional bond checks should be done, when product changes require adjustments to glue spreads
 - Red Oak, Ash and any other species susceptible to bleed through
 - 3-Ply (Hardwood Face and Back)
 - Line by line construction (Evaluating each glue line with 1-5 rating system)
 - Anytime problems occur, such as:
 - Long stand times
 - Questionable glue spreads
2. Use the 1-5 rating system (also on the check sheet) to evaluate bonds
 - 1 = No bond, falling apart
 - 2 = 0-20% wood pull (light fiber)
 - 3 = 25-50% wood pull (medium fiber)
 - 4 = 80% wood pull
 - 5 = 100% wood pull
3. Record on “*Knife Bond Check Sheet*” (GKB-IF-01) all information pertaining to the knife bond check.
4. Only those employees trained in knifing techniques will be allowed to knife panels
5. Turn check sheet in to the Quality Department at the end of each shift

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