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Introduction

The purpose of this report is to present some facts and figures concerning the salvage and repair of dry kiln stickers; the approximate number of stickers used in our daily operation; the cost of repaired stickers to the cost of new stickers purchased from another company.

In our operation, the salvage of stickers to be repaired is done by the stickerman as they fill the sticker pockets on the automatic stackers. These pieces that can be repaired are bundled and put on the stacker platform. They are then transferred to the sticker repair building by means of lift truck.

We use approximately 55,000 stickers in the two-shift operation per day. So let it be a fact that out of these 55,000 stickers, there are many broken ones to be repaired. We have repaired as many as 700 stickers per day. Our normal operation is to repair 400 to 500 per day. This means approximately five stickers per kiln load are damaged either by stacking, transporting or unstacking.

The defective stickers are repaired by means of a scarfing saw, flue and staples. The overhead scarfing saw is a 10" carbon tip with a 3 h. p. motor. The sticker to be scarfed is placed in a clamp operated by a small air cylinder which holds it in place to give a 4-1/2" scarf joint. This saw is a manual operation using a foot pedal.

The pieces are cut 33-1/2", 70-1/2", and 52" lengths. They are then stored in proper length racks. The length of the finished sticker is 99-1/2". This length is acquired by a combination of the shorter lengths being glued and stapled.

On the glue table one end is placed in a 99-1/2" jig - the other scarf joint has glue applied by a small rubber-tired wheel which turns in a glue pot. It is then placed in the jig and stapled with five staples to hold scarf joints together firmly while glue line cures. After gluing the finished sticker it is placed in a rack holding approximately 500 stickers. When the temperature is above 60° the repaired stickers will cure satisfactorily when stored in a steam-heated oven overnight and then put in storage for future use.

Monsanto resin glue with a catalyst hardner is used with a mixture of two to one.

The staple gun is a paslode air gun using 3/4" galvanized staples with 80 pounds of pressure.

During the past year, the average cost per repaired sticker is 15¢, with the initial cost of 36¢ per new sticker. I believe this sticker repair operation is an economical process and recommend it to others who have a similar problem.