

QUALITY CONTROL: AN INTEGRAL PART OF THE KILN DRYING PROCESS

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Quality Control Overview

Key Performance Indicators

Moisture Content to Spec

- Percent of wood within target spec
- Recorded from inline meter at planer
- Recorded daily
- Compare to baseline on a daily and weekly basis

Kiln Defect Free

- Percent of kiln defects from the economy grade check performed by QC
- Calculated to the overall volume ran for the shift

Steam Pressure to Spec

- Recorded by kiln personnel at end of shift
- Reported as a daily and weekly average against a target (100 lbs)

Stacker Quality (Sawmill)

- Recorded by lift driver for each unit at sawmill outfeed
- Look at sticker placement, missing boards, missing stickers, etc.
- Reported as a daily and weekly average against a target of 100 percent

Kiln Operator Checks

Kiln Operator Checks "Loading Quality"

- Performed by kiln personnel
- Graded on quality of loading
- Immediate feedback to drivers

Kiln Operator Checks "Rough Dry Checks"

- Perform dry board check of Accudry units
- Designate units for "redry"
- All dry board counts for Accudry units are recorded along with Accudry reading for that position for moisture tracking purposes

Accudry Units at Planer

- The Accudry units are checked at the planer using inline moisture meter for dry board percentage, MC over max target spec and over dry below max target spec and over dry below max target spec
- Results are recorded for each Accudry unit

Kiln Wets

- Inline meter is set to mark wood over max target spec
- Allowed 10% per finished unit (stamped as S-green dry size)
- Volume over 10% is pulled into a unit and sold as "kiln wets"

Independent QC Checks

"Wets at Stacker"

Performed by QC and planer supervisor

Record wets

Results kept in database

Used to verify inline moisture meter

"Wets at Grade Checks"

Performed by QC during grade checks

Record "wet", "kiln wets," and "over dry"

Results kept in database

Compare to stacker wet check and inline moisture meter

Moisture Tracking

Excel database

Track each charge

Compare Accudry units, Accudry readings, rough dry checks and planer inline readings

Report for each charge and kiln

Kiln Meetings

Weekly Kiln Meeting

Attended by kiln operators, QC, planer supervisor, planer superintendent, and mill manager

Cover a basic agenda

Kiln Improvement Ideas

Ideas on improving kiln performance discussed

Testing is planned and performed

Plans of action are formalized after testing is complete