



## **Dieboard Product Storage and Handling Guidelines**

Engineered wood products are natural materials that are subject to dimensional change depending on variations in temperature and humidity during manufacturing, storage, and use. The veneers, processes and environment for rotary/ flat dieboards and other specialty hardwood plywood are carefully handled and stored under controlled conditions to minimize change in size and shape. After manufacturing, the dieboards are inspected to insure they meet or exceed IADD (International Association of Diecutters and Diemakers) Industry Standards, or other applicable standards, capped with protective cardboard and stretch wrapped. The purpose of the caps and stretch wrap is not only to secure and protect the rotary dieboard package from damage, but also slow the exchange of moisture between the environment and the wood in the dieboard/ panel. Movement in a wood product due to variations in temperature and relative humidity is nearly impossible to eliminate, but following recommended handling and storage guidelines will minimize the change.

## **Storage and Handling Recommendations for Dieboards, and Specialty Hardwood Plywood Products**

- Store in an area where the temperature and relative humidity are controlled within a range of 55-80°F / 30-60% relative humidity. Target 65°F and 40-45% relative humidity.
- Do not store dieboards/ panels where HVAC or fan will blow directly on the product. Keep the movement of outside air into the storage area minimized as much as possible.
- Keep the dieboards/ panels in their original packaging materials as long as possible. Do not unwrap at arrival and store exposed to the air. Cover exposed dieboards/ panels with plastic sheeting.
- Dieboards/ panels should not be stored directly on the floor as concrete or other flooring can act as a conductor to moisture. Keep the dieboards/ panels on their original pallets or at least 4" off the floor, or lay a material on the floor that will provide a moisture barrier.
- Do not store any dieboards or specialty plywood on an uneven surface.
- Keep rotary dieboards stored vertically as opposed to horizontally and/ or stacked.
- Keep flat dieboards/ panels on their original shipping pallet, strapping in place for as long as possible, or cover with plastic sheeting and evenly distribute weight to the top of the load.
- Dieboards and specialty plywood should be used within 6 months of purchase. Manage inventory accordingly.

Proper storage and handling of dieboards and specialty hardwood plywood has a significant effect on the performance of the material in the user's process and product. To keep products within industry tolerance and to realize the best possible performance/ results, following recommended storage and handling guidelines is required on behalf of the customer.

09/28/15