

PANEL GLUE-UP STEWARD

STEWARD
Jacob Miller
REPORTS TO
Shop lead, Eli Yoder

STATION
Glue-up bench
REVIEWED
Weekly · Q4 2026

MISSION

Turn straight, milled stock into flat, tight, well-matched panels that the next station never has to fix — using glue, clamps and time with care, and leaving the bench ready for whoever comes next.

OUTCOMES

01	FLAT, TIGHT PANELS	Every panel comes out of the clamps flat, with closed glue lines end to end and no starved or open joints.
02	MATCHED GRAIN AND COLOUR	Boards are arranged for grain direction, colour and figure before glue touches wood, so the panel reads as one piece.
03	STEADY FLOW TO THE NEXT STATION	The day’s cut list is glued, cured and staged on time, so sanding and assembly never wait on this bench.
04	CAREFUL USE OF MATERIALS	Glue is spread evenly, not wasted; clamps and cauls are kept clean, true and accounted for.
05	A SAFE, CLEAN BENCH	Squeeze-out is scraped before it cures, the floor is clear, and the station is reset at the end of every shift.

MEASURABLES

Boxed figures missed goal.

MEASURABLE	GOAL	AUG 21	AUG 28	SEP 4	SEP 11	SEP 18	SEP 25
01 Panels glued Count off the cut list, cured and staged	≥ 180 / wk	186	192	174	188	195	183
02 Flat on first check Within 1/32" over 24" out of the clamps	≥ 97%	98%	97%	95%	98%	99%	98%
03 Glue-line failures Open or starved joints found downstream	≤ 2 / wk	1	0	3	1	0	1
04 Grain and color rejects Panels sent back by QC for mismatch	≤ 3%	2.1%	1.6%	2.7%	3.4%	1.9%	1.5%
05 Clamp time kept Minimum 45 minutes before unclamping	100%	100%	100%	96%	100%	100%	100%
06 Glue used Pounds per 100 sq ft of panel	≤ 1.2 lb	1.1	1.2	1.3	1.1	1.0	1.1
07 Staged on time Panels ready by the 2 p.m. hand-off	5 of 5 days	5/5	5/5	4/5	5/5	5/5	5/5
08 Bench reset Clean, clamps racked, glue capped at close	5 of 5 days	5/5	4/5	5/5	5/5	5/5	5/5

OBSERVATIONS AND COMMENTS

STEWARD · DATE

SHOP LEAD · DATE



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