

# TIPS FOR

# FINGER JOINTING

## *What is finger jointing?*

Finger jointing is a woodworking joint made by cutting a set of corresponding rectangular cuts in two pieces of wood, which are then glued to interlock them.

### SELECT THE RIGHT GLUE

**THIS WILL DEPEND ON YOUR:**

1. End use conditions--interior vs. exterior
2. Performance conditions

### MONITOR TEMPERATURES



Both wood and glue temperatures should be above 35°F.

**Cold wood** will cool **warm glue** very quickly.

### TYPES OF WOOD

We do **NOT** recommend mixing different species!\*

\*The difference in expansion and contraction will weaken a finger joint, causing failure in testing and service.

### TIGHTNESS OF JOINT

Critical for quality work and good end-use performance



You should not be able to press a dry joint together by hand



A glued and machine pressed joint should be tight (no gaps)



To troubleshoot, cut a cross section 1/16" thick of glued joint and examine for fit



### GLUE APPLICATION

- Application **MUST** be uniform and on ALL fingers.
- There must be some squeeze out when joint is pressed.
- Check application 4-5 times/hour and clean or adjust equipment for proper coverage.

### SQUEEZE PRESSURE

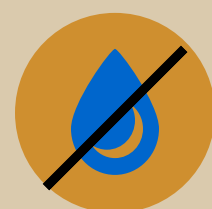
- Time depends on length of stock and quantity of joints.
- Clamp must have ample pressure to prevent movement during pressing.
- Press anvil must be slightly smaller than the wood cross section to deliver maximum pressure.
- Ensure even pressure by centering line force of the anvil and fulcrum outside the center line of the stock.

### HANDLING



Prevent bond disruption by allowing stock to build up before off loading by hand.

### STORAGE TIME & TEMP



Store glued joints in a warm, dry place for **2-3 days**