

# HEALTH MATE SAUNAS LUMBER DRYING



## • INITIAL DRY AT SORT YARD

- When the green raw materials first arrive at the factory, the lumber is first sorted by length, size, grade, & grain.
- **Initial drying** is then started at the sort yard before the lumber is processed.
- Typically, the lumber sits out in the yard for minimum two weeks to avoid any collapsing of wood.
- Collapsing causes defects in the surface which may distort the appearance of lumber.
- **Health Mate Saunas** use the best selected grade & grain for sauna panels.



## • AIR DRY BLANK SIZE LUMBER

- After initial drying, the lumber is then chopped and ripped to blank sizes for sauna panels.
- These blank sizes are then **Air Dried** piece by piece with sticking between each piece.
- Typically, the blanks are air dried for minimum two weeks to avoid any shrinkage.
- Shrinkage causes variances to the lumber size as this will ultimately result in inconsistent sauna panels.
- **Health Mate Saunas** eliminate any poorly dried lumber by sorting the best air dried blanks to be used for sauna production.



## • KILN DRY BEFORE MOLDING

- After air dry, the blanks are then placed in our highly innovative German Gann kilns.
- **Kiln dry** is the most important step before molding to reach the optimum moisture content needed for sauna use of minimum 12%.
- The lowest moisture content level that can be reached by air dry is no less than 20%.
- Wet lumber will cause mold, rot, & essentially will have a shorter life span.
- **Health Mate Saunas** dries our lumber to 6-8% to avoid any problems and thus provides the best equilibrium moisture content for use in sauna.