



# Warping Causes & Solutions

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## CAUSES

1. Paper and board moisture content could be too low or too high.
2. Changes in the environmental conditions of the plant. During the winter months the plant is drier and humidity is lower. This could have a tendency to dry out the paper and board.

## Solutions

1. Carefully monitor paper and board purchased to be certain your suppliers deliver consistent quality.
2. Use jelly glue and dryflex products that are high in solids so you are not adding water which exacerbates the problem.
3. Plasticize the adhesive film with glycerin or corn syrup.
4. Pre-Dome board or paper before gluing.
5. Adjust adhesive application to reduce the amount being applied.
6. If paper or board is warped to begin with the adhesive will generally not help or improve warpage situation.