

Title	Set up a timber planer for dress four sides		
Level	3	Credits	20

Purpose	People credited with this unit standard are able to: demonstrate knowledge of factors affecting the finished quality of machined timber; manage hazards associated with setting up a timber planer; clean and strip a planer; describe the process of setting up a planer for dress four sides; select and fit preset cutterheads for dress four sides; complete set-up and make adjustments for dress four sides; and check planer set-up for dress four sides.
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Classification	Solid Wood Manufacturing > Timber Machining
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Available grade	Achieved
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Guidance Information

- 1 Legislation
Health and Safety at Work Act 2015.
Resource Management Act 1991.
- 2 Definitions
Accepted industry practice refers to approved codes of practice and standardised procedures accepted by the wider wood manufacturing industry as examples of best practice.
Workplace procedures refer to documented policies and procedures set by the organisation carrying out the work, and to documented or other directions provided to staff, and applicable to the tasks being carried out. They may include but are not limited to – standard operating procedures, site specific procedures, site safety procedures, equipment operating procedures, quality assurance procedures, product quality specifications, references, approved codes of practice, housekeeping standards, environmental considerations, on-site briefings, supervisor’s instructions, and procedures to comply with legislative and local body requirements relevant to the wood manufacturing sector.
- 3 Assessment information
 - a For people already employed in the industry, the workplace referred to is their employer's. For other people, the workplace will be either a local workplace or a typical New Zealand workplace.
 - b All activities and evidence must meet workplace procedures, accepted industry practice, and manufacturers’ specifications.
- 4 Recommended unit standards for entry: Unit 678, *Feed and tail out planer, and monitor planer performance*; and Unit 689, *Set cutters into cutterheads*.

Outcomes and performance criteria

Outcome 1

Demonstrate knowledge of factors affecting the finished quality of machined timber.

Performance criteria

1.1 Factors affecting the finished quality of machined timber are explained.

Range machine factors may include but is not limited to – cutting speed, cutter pitch, feed speed, cutting angles and blunt knives; timber factors – moisture content, grade, density.

1.2 Factors determining feed speed are described.

Range end use, machine capability.

1.3 The relationship between wood type, wood density, timber grade, and moisture content on cutter wear are explained.

1.4 Planer setting methods that ensure least downgrade are explained.

Range minimum stock removal on bottom and fence side heads.

1.5 Machine defects are identified from given timber samples and their causes are explained.

Range may include but is not limited to – raised grain, burn marks, cutter chip marks (raised line), sniping, torn grain.

Outcome 2

Manage hazards associated with setting up a timber planer.

Performance criteria

2.1 Hazards associated with setting up a timber planer are identified and actions to be taken to manage the hazards are described.

Range hazards may include but are not limited to – tools left in the machine, components coming loose, guards not in place, loose clothing, inadvertent starting of the machine, noise; evidence of four is required.

2.2 Safe work practices associated with setting up a timber planer are identified and applied.

Range practices may include but are not limited to – isolation procedures, lock-outs, emergency stops, machine guarding, wearing appropriate safety equipment.

Outcome 3

Clean and strip a planer.

Performance criteria

3.1 Planer is prepared for set-up in accordance with product requirements.

Range may include but is not limited to - components cleaned, spindles oiled.

3.2 Machine is fully isolated.

3.3 Planer and work areas are cleaned of all foreign matter that could affect set-up operations.

3.4 Planer components are checked, and remedial action is taken if any worn or damaged parts are found.

Range components may include but is not limited to – feed rollers, chip breakers, fences, beds, pressures, plates, lubrication system, extraction system, hoods and guards; action – repair, replace, record, report.

3.5 Cutterheads or cutters are removed and stored.

Outcome 4

Describe the process of setting up a planer for dress four sides.

Performance criteria

4.1 A planer is described in terms of its manufacturer's data.

Range planer – any with which the trainee is familiar; includes but is not limited to - machine make, model, layout of cutterheads, spindle speed.

4.2 Sequential steps required to set-up the planer are described.

4.3 Reasons for using a systematic approach to setting up a planer are described.

Outcome 5

Select and fit preset cutterheads for dress four sides.

Performance criteria

- 5.1 Cutterheads that will produce required planed timber size are selected and are checked for defects and damage.
- 5.2 Cutterheads are fitted onto spindles and locked where required.
- 5.3 Outrigger bearings are fitted where required.

Outcome 6

Complete set-up and make adjustments for dress four sides.

Performance criteria

- 6.1 Cutterheads are adjusted to required size and locked where required.
- 6.2 Other machine components are adjusted to suit job specifications and are checked for conformance with safety requirements.

Range pressures, chip breakers, feed rollers, fences, guides, bed plates, adjustable fence plates.
- 6.3 Shavings hoods and safety guards are set.
- 6.4 Feed speed is set in relation to timber size, species, and product requirements.

Outcome 7

Check planer set-up for dress four sides.

Performance criteria

- 7.1 All setting up and other tools are removed from the planer and stored.
- 7.2 Test piece is run through the planer and measured to ensure conformance with product requirement.
- 7.3 Components are adjusted until output timber conforms to the specified size.

Range tested for width and thickness;
three sample test boards permitted.
- 7.4 Operation of any fitted branding or labelling equipment is checked, and the correct brand or label installed.
- 7.5 Tally meter is re-set.

Planned review date	31 December 2024
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Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	27 January 1994	31 December 2020
Review	2	24 October 1996	31 December 2020
Review	3	10 February 1999	31 December 2020
Review	4	18 December 2006	N/A
Review	5	25 June 2020	N/A

Consent and Moderation Requirements (CMR) reference	0013
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.

Comments on this unit standard

Please contact Competenz qualifications@competenz.org.nz if you wish to suggest changes to the content of this unit standard.