

40336 Produce die cut board using a rotary die cutter for fibreboard packaging

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| Kaupae Level | 3 |
| Whiwhinga Credit | 25 |
| Whāinga Purpose | <p>This skill standard is intended for people who are already working in the fibreboard packaging industry and want to progress into an operator role. They will be able to make ready and operate a rotary die cutter, change a die, rotate or replace die blankets at the end of a production run, and complete post-production tasks for fibreboard packaging.</p> <p>This skill standard aligns with the New Zealand Certificate in Fibreboard Packaging (Level 3) with strands in Case Converting, Case Corrugating, and Carton Converting [Ref: 1819].</p> |
| Whakaakoranga me mātua oti Pre-requisites | Unit standard 340, <i>Demonstrate knowledge of safe working practices in the print industry</i> , or demonstrate equivalent knowledge and skills. |

Hua o te ako me Paearu aromatawai | Learning outcomes and assessment criteria

| Hua o te ako Learning outcomes | Paearu aromatawai Assessment criteria |
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| 1. Confirm job requirements for fibreboard packaging. | a. Check job documentation to ensure that all specifications for the process being undertaken are met and report any discrepancies. |
| | b. Check required job components against the job documentation and confirm their availability. |
| | c. Confirm equipment is available, as determined by the job documentation. |
| 2. Make ready a rotary die cutting machine to produce die cut board. | a. Set up die to sheet registration within specified tolerance on a rotary die cutting machine. |
| | b. Complete make ready process on rotary die cutter to meet job requirements. |

| Hua o te ako Learning outcomes | Paearu aromatawai Assessment criteria |
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| 3. Operate a rotary die cutting machine to produce die cut board. | <ul style="list-style-type: none"> a. Maintain production running speed and ensure quality and production standards are met. b. Check for faults during production run and identify and rectify any faults to ensure fault free production is successfully resumed. c. Maintain die to sheet registration and stacking accuracy during production to meet job requirements. d. Follow waste disposal requirements including correct ejection of trimming. |
| 4. Carry out post-production tasks for fibreboard packaging. | <ul style="list-style-type: none"> a. Check quantity and other job requirements against job documentation and rectify any discrepancies in quantity before removing job from machine. b. Follow correct shut-down sequence for rotary die cutter. c. Complete job documentation and note any amendments and variations for future reference. d. Carry out other post-production tasks as required by job documentation. |
| 5. Remove die on rotary die cutting machine. | <ul style="list-style-type: none"> a. Reset machine at the end of preceding production run. b. Unbolt and remove die on rotary die cutting machine. c. Store die and obtain inspection approval for next production run. |

| Hua o te ako Learning outcomes | Paearu aromatawai Assessment criteria |
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| 6. Mount die on the die cylinder of rotary die cutting machine. | a. Select die for new production run and confirm against job documentation to ensure job requirements are met. |
| | b. Check die for damage and report any damage. |
| | c. Set machine to meet job requirements and ensure uniform cutting across rotary die cutting machine. |
| | d. Mount die and stripping componentry securely. |
| | e. Confirm machine is 'zeroed' prior to commencement of production run. |
| 7. Rotate or replace the die blankets on rotary die cutting machine. | a. Rotate or replace die blankets ensuring there is no gap between blanket segment and no damage to die blankets. |
| | b. Complete rotation or replacement of die blankets within allowable timeframe. |

Pārongo aromatawai me te taumata paearu | Assessment information and grade criteria

Assessment specifications:

- It is recommended that rotation or replacement of die blankets is assessed under conditions where third party assistance is provided during the manual rotation of the cylinder.
- Evidence presented for assessment against this skill standard must be consistent with safe working practices and be in accordance with applicable service information, workplace procedures and legislative requirements.
- It is recommended people hold credits for skill standard 40320, *Explain rotary die cutting machinery and identify die cutting faults in fibreboard packaging*, before being assessed against this skill standard.

Definitions:

Die blanket is also referred to as die mat.

Job documentation refers to the documentation that is used in the workplace that contains the instructions and requirements for a particular production job. This may include but is not limited to – workplace orders, production orders, workplace specifications, samples, lay cards.

Job requirements refer to specific requirements for the fibreboard packaging job at hand. These requirements may or may not be covered in the job documentation and may include special instructions, quality requirements expected by the customer, and/or production standards as set down by the fibreboard packaging workplace and/or organisation.

Workplace procedures refer to organisation policies and procedures that are documented in memo, electronic, or manual format and available in the workplace. 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, manufacturer’s requirements, 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 fibreboard packaging industry.

Ngā momo whiwhinga | Grades available

Achieved

Ihirangi waitohu | Indicative content

Make ready

- Minimisation of machine downtime through communicating jobs and responsibilities to machine crew, anticipation of production difficulties and taking preventative action to avoid delays.
- Confirmation of job requirements including run length, print specifications, take off requirements, number of ups in die cutting.

Die change

- Machine reset such as machine ‘zeroing’, opening machine, releasing impression, releasing brake.
- Adjustment of machine settings after die change such as machinery being ‘zeroed’, centering die cylinder, releasing impression, engaging brake.
- Knowledge and procedures relating to rotation or replacement of die blankets such as indicative faults, sequential steps, effects of excessive pressure, trimming or skimming.

Rauemi | Resources

Legislation relevant to this skill standard includes but is not limited to:

- Health and Safety at Work Act 2015.

Any new, amended or replacement Acts, regulations, standards, codes of practice, guidelines, or authority requirements or conditions affecting this skill standard will take precedence for assessment purposes, pending review of this skill standard. Legislation can be accessed at:

<https://www.legislation.govt.nz>.

Pārongo Whakaū Kounga | Quality assurance information

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| Ngā rōpū whakatau-paerewa Standard Setting Body | Hanga-Aro-Rau Workforce Manufacturing, Engineering and Logistics Development Council |
| Whakaritenga Rārangi Paetae Aromatawai DASS classification | Manufacturing > Fibreboard Packaging > Fibreboard Packaging Production |
| Ko te tohutoro ki ngā Whakaritenga i te Whakamanatanga me te Whakaōritenga CMR | 0013 |

| Hātepe Process | Putanga Version | Rā whakaputa Review Date | Rā whakamutunga mō te aromatawai Last date for assessment |
|------------------------------------------------------|---------------------------------------------------------------------------|-----------------------------------|--------------------------------------------------------------------|
| Rēhitatanga Registration | 1 | 28 November 2024 | N/A |
| Kōrero whakakapinga Replacement information | This skill standard replaced unit standard 27788 and unit standard 27792. | | |
| Rā arotake Planned review date | 31 December 2029 | | |

Please contact Hanga-Aro-Rau Manufacturing, Engineering and Logistics Workforce Development Council at qualifications@hangaarorau.nz if you wish to suggest changes to the content of this skill standard.