

## 40354 Produce printed and die cut board using a rotary die cutter for fibreboard packaging

<b>Kaupae   Level</b>	4
<b>Whiwhinga   Credit</b>	25
<b>Whāinga   Purpose</b>	<p>This skill standard is intended for people who already have experience working in the fibreboard packaging industry and will be able to work independently as a competent skilled operator. They will be able to make ready and operate an inline rotary die cutter to make printed and die cut board, and carry out post-production tasks.</p> <p>This skill standard aligns with the New Zealand Certificate in Fibreboard Packaging (Level 4) with strands in Case Converting, Case Corrugating, and Carton Converting [Ref: 1820].</p>
<b>Whakaakoranga me mātua oti   Pre-requisites</b>	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

<b>Hua o te ako   Learning outcomes</b>	<b>Paearu aromatawai   Assessment criteria</b>
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.

Hua o te ako   Learning outcomes	Paearu aromatawai   Assessment criteria
2. Make ready an inline rotary die cutting machine to produce printed and die cut board.	<ul style="list-style-type: none"> <li>a. Set up die to sheet registration within specified tolerance on a rotary die cutting machine.</li> <li>b. Set up and adjust systems on rotary die cutter to meet job requirements.</li> <li>c. Set up and adjust rotary cutting devices to meet job requirements.</li> <li>d. Set up and adjust cutting pressures.</li> <li>e. Set machine lays to correct position and ensure registration is achieved.</li> <li>f. Load board and ensure its orientation meets workplace requirements.</li> <li>g. Conduct sample run and carry out any adjustments to meet job requirements.</li> </ul>
3. Operate a printer rotary die cutting machine to produce printed and die cut board.	<ul style="list-style-type: none"> <li>a. Maintain production running speed and ensure quality and production standards are met.</li> <li>b. Check for faults during production run, and identify and rectify any faults to ensure fault free production is successfully resumed.</li> <li>c. Follow proactive measures to prevent faults occurring during production.</li> <li>d. Carry out checks to ensure correct print position and registration is achieved.</li> <li>e. Confirm colours meet the job requirements and adjust viscosity during production run to rectify any incorrect colour caused by viscosity.</li> <li>f. Maintain die to sheet registration and stacking accuracy during production to meet job requirements.</li> <li>g. Follow waste disposal requirements including correct ejection of trimming.</li> </ul>

Hua o te ako   Learning outcomes	Paearu aromatawai   Assessment criteria
4. Carry out post-production tasks for fibreboard packaging.	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.

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

Assessment specifications:

Assessment must be undertaken at an inline rotary die cutter with at least two colour stations and configured with at least a hopper feeder and automatic stacking machinery.

Competence in this skill standard is demonstrated through:

- The production and stacking of two die cut jobs of complex shape, each with a new die, of differing die cutting specifications.
- Each job must require the printing of three colours in not more than two passes with requirements for registration, trapping and alignment.
- A complex shape would typically be a box with a lid and internal dividers or a machine erectable case.
- Printing and die cutting must be carried out in a single pass.

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 40336, *Produce die cut board using a rotary die cutter for fibreboard packaging*, before being assessed against this skill standard.

Definitions:

*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.
- Set up systems including feeder, delivery, sheet pick-up and transportation, transfer, accumulation.

**Post-production**

- Post-production tasks as required by job documentation.

**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

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

<b>Hātepe   Process</b>	<b>Putanga   Version</b>	<b>Rā whakaputa   Review Date</b>	<b>Rā whakamutunga mō te aromatawai   Last date for assessment</b>
<b>Rēhitatanga   Registration</b>	1	28 November 2024	N/A
<b>Kōrero whakakapinga   Replacement information</b>	This skill standard replaced unit standard 27789		
<b>Rā arotake   Planned review date</b>	31 December 2029		

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