

Title	Cut and crease cartons to a minimum of six up and autostrip for fibreboard packaging		
Level	4	Credits	40

Purpose	People credited with this unit standard are able to: follow safety requirements for the machinery being operated; check documentation and confirm requirements for the job are available; make ready the stripping unit for production running; cut and crease cartons to a minimum of six up and autostrip cartons; finish job and carry out post-press tasks; and carry out maintenance on the machinery and equipment being operated; in accordance with workplace practices.
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Classification	Fibreboard Packaging > Fibreboard Packaging Production
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Available grade	Achieved
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Prerequisites	Unit 340, <i>Demonstrate knowledge of safe working practices in the print industry</i> , or demonstrate equivalent knowledge and skills.
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Guidance Information

- Candidates must follow any applicable and recognised codes of practice, and documented workplace health, safety, and environmental procedures for personal, product, workplace health, safety, and environmental matters, and the obligations required under current law including the Health and Safety in Employment Act 1992 and its subsequent amendments.
- 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 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 workplace.
Workplace practices refer to the documented procedures for the machine and/or workplace.

Outcomes and performance criteria

Outcome 1

Follow safety requirements for the machinery being operated in accordance with workplace practices.

Performance criteria

- 1.1 Machine start-up, shutdown, and emergency procedures in the workplace are explained and followed.
- 1.2 Risk awareness and hazard control measures, as circulated by the company, are described and followed.
- 1.3 Potential and actual hazards in the workplace are identified and reported.

Outcome 2

Check documentation and confirm requirements for the job are available in accordance with workplace practices.

Performance criteria

- 2.1 Job documentation is checked to ensure that all specifications for the process being undertaken are complete, and any discrepancies are reported.
- 2.2 Substrate specifications are checked against the job documentation, and availability of required quantity is confirmed.
- 2.3 Equipment requirements, as determined by the job documentation, are confirmed as available.
- 2.4 Make-ready material suitable for the substrate is selected to meet the job requirements.
 - Range may include but is not limited to – adhesive, counters, rubber, cork, hardener, creasing matrix, knifeline/dieline.
- 2.5 Cutting forme is checked for condition to ensure that the job requirements are met.
- 2.6 Printed substrate is checked for printing faults, and any faults are reported or rectified.
 - Range includes but is not limited to – print against knifeline/dieline, print and gloss-free gluing areas, print registration, bleed, position, set-off, catch-up, hickies, lamination, warp in board, mis-registration.

- 2.7 Lead-in or break-away knives are checked against sheet size and any faults are rectified in accordance with workplace practices.

Outcome 3

Make ready the cutting and creasing unit for production running in accordance with workplace practices.

Performance criteria

- 3.1 Cutting forme nicking requirements are confirmed, and cutting forme is nicked to meet the requirements of further processes.
- 3.2 Cutting forme is rubbered up to meet the requirements of the cutting and creasing process.
- 3.3 Cutting forme is positioned and locked up to meet machine specifications, and clean cutting plate is secured in the machine.
- 3.4 Sheet detectors and lay positions are set to suit the printed sheet.
- 3.5 Position is confirmed from a pull (proof).
- 3.6 Feeder and delivery positions are set to meet the job requirements.
- 3.7 Patch sheet is prepared, avoiding excessive local or overall pressure and ensuring that damage to cutting forme is prevented.
- 3.8 Final make-ready is undertaken in preparation for run.
- 3.9 Counting system is set to meet the job requirements.

Outcome 4

Make ready the stripping unit for production running in accordance with workplace practices.

Performance criteria

- 4.1 Materials required for stripping unit are identified to meet the job requirements.
- Range may include but is not limited to – stripping board, bars, pins.
- 4.2 Stripping unit is made ready.
- Range may include but is not limited to – bars, stripping boards, position, top and/or bottom frame, pins, front waste stripping, grip edge.
- 4.3 The need for single or double action pins is recognised, and the importance of correct placing of the pins to meet the job requirements is described.
- 4.4 Faults found while undertaking make ready of the stripping unit are rectified.

Outcome 5

Cut and crease cartons to a minimum of six up and autostrip cartons in accordance with workplace practices.

Performance criteria

- 5.1 Substrate is loaded into machine and positioned in accordance with job requirements.
- 5.2 Machine is run to allow final adjustments to be made to ensure the job requirements are met.
- 5.3 Job is run maintaining operating speed consistent with the required quality and production standards.
 - Range operating speed – minimum of 60% of the rated speed of the machine as specified in the machine operating manual.
- 5.4 Production of required quantity is confirmed before lifting job from machine.

Outcome 6

Finish job and carry out post-press tasks in accordance with workplace practices.

Performance criteria

- 6.1 Job documentation is completed.
- 6.2 Pressure is recorded on the patch sheet and the patch sheet is filed.
- 6.3 Forme is checked for damaged rules and any faults are repaired or reported.
- 6.4 Forme and stripping unit are stored.
- 6.5 Plate is cleaned and stored.
- 6.6 Machine is cleaned.
- 6.7 Waste control procedures are followed.
 - Range recyclable waste, non-recyclable waste, security waste.

Outcome 7

Carry out maintenance on the machinery and equipment being operated, in accordance with workplace practices.

Performance criteria

- 7.1 Machinery and equipment is inspected, adjusted, and maintained to ensure efficient operation.
- 7.2 Adjustments and/or maintenance unable to be carried out are reported.

Replacement information	This unit standard was replaced by skill standard 40349.
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This unit standard is expiring. Assessment against the standard must take place by the last date for assessment set out below.

Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	21 August 1997	31 December 2014
Revision	2	16 March 1999	31 December 2014
Review	3	28 February 2001	31 December 2014
Review	4	18 December 2006	31 December 2016
Review	5	19 September 2013	31 December 2027
Review	6	28 November 2024	31 December 2027

Consent and Moderation Requirements (CMR) reference	0005
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.