

<b>Title</b>	<b>Demonstrate knowledge of the alignment of bandsaw and circular rip saw centres</b>		
<b>Level</b>	<b>3</b>	<b>Credits</b>	<b>5</b>

<b>Purpose</b>	People credited with this unit standard are able to demonstrate knowledge of the alignment of: bandsaw headrig; bandsaw centres; and circular rip saw centres.
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<b>Classification</b>	Solid Wood Manufacturing > Saw Doctoring
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<b>Available grade</b>	Achieved
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### Guidance Information

- 1 Reference  
Williston, E. M. *Saws: Design, Selection, Operation, Maintenance* (San Francisco: Miller Freeman, 1989). ISBN-10: 0879300736, ISBN-13: 978-0879300739.
- 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.  
*Carriage* consists of a headblock, slides, and knees.  
*Roll case* is a series of free feed rollers before or after the saw centre.  
*Roller* means the same as a *roll*, and *feed roller* means the same as a *feed roll*.  
*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  
All activities and evidence must be in accordance with workplace procedures and accepted industry practice, and the reference text listed above.

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### Outcomes and performance criteria

#### Outcome 1

Demonstrate knowledge of the alignment of bandsaw headrig.

**Performance criteria**

- 1.1 Procedure for checking, levelling, and aligning the carriage track is explained.
- 1.2 Procedure for aligning components is explained.
- Range may include but is not limited to – bottom bandwheel to track, top bandwheel to bottom bandwheel (crossline), double pressure guides to top bandwheel, carriage knees and slides to saw, knees to slide.
- 1.3 Reasons for and amount of lead required are explained.
- 1.4 Procedure for checking alignment of top and bottom bandwheels is explained.
- 1.5 Position of wheels and guides is described for double pressure, single pressure, and no pressure systems.

**Outcome 2**

Demonstrate knowledge of the alignment of bandsaw centres.

Range line bar resaw or centre cut resaw.

**Performance criteria**

- 2.1 Procedure for checking alignment of top and bottom bandwheels is explained.
- Range procedures – rotating saw backwards, plumb line; alignment – aligned, cross-lined, out of plumb or stepped.
- 2.2 Procedure for aligning guides is explained.
- 2.3 The relationship between fence, feed rollers, and the bandsaw for alignment of bandsaw centre is described.

**Outcome 3**

Demonstrate knowledge of the alignment of circular rip saw centres.

**Performance criteria**

- 3.1 Process for the alignment of circular rip saws is explained.
- 3.2 Relative positions of components are identified.
- Range arbor in relation to feed rollers, in-feed and out-feed roll cases in relation to arbor and feed rollers, guides in relation to arbor.

<b>Planned review date</b>	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	10 February 1999	31 December 2012
Review	2	18 December 2006	31 December 2012
Rollover and Revision	3	15 April 2011	N/A
Review	4	24 September 2020	N/A

<b>Consent and Moderation Requirements (CMR) reference</b>	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](mailto:qualifications@competenz.org.nz) if you wish to suggest changes to the content of this unit standard.