Title	Edge-finish particle board		
Level	4	Credits	5

Purpose	People credited with this unit standard are able to: explain fundamentals of edge-finishing particle board; operate and maintain edge-finishing equipment; and monitor and control the performance of edge-finishing equipment.

Classification	Wood Fibre Manufacturing > Composite Wood Panel Manufacturing

Available grade	Achieved

Explanatory notes

1   Range:
     Equipment may include but are not limited to – edge sealer, tenoner;
     evidence of one is required.

2   This unit standard is intended for work-based assessment. While all evidence requirements must be met, some range statements within this unit standard are indicative and dependent on enterprise and worksite specific equipment, procedures, and practices.

3   The following apply to the performance of all outcomes of this unit standard:
     a   All work practices must meet recognised codes of practice, and documented worksite health and safety and environmental procedures (where these exceed code) for personal, product and worksite health and safety. They must also meet the obligations required under current legislation, including the Health and Safety in Employment Act 1992, the Resource Management Act 1991, and their subsequent amendments of these Acts.
     b   All work practices must meet documented worksite quality management procedures. This includes the recording (by electronic or non-electronic means) of activities, events, and decisions.
     c   All communications must be made in accordance with worksite procedures for content, recipient, timing and method.

4   Definition
     Worksite policies and procedures refer to documented policies and to documented or other directions provided to staff. These must conform to legislation, and include, but are not limited to, ways of managing health and safety, environmental considerations, quality, and production, and must conform to legislation. Examples include standard operating procedures, company health and safety plans, on-site briefings, and supervisor's instructions.

Outcomes and evidence requirements

Outcome 1

Explain fundamentals of edge-finishing particle board in accordance with worksite policies and procedures.

Evidence requirements

1.1   The purpose of edge-finishing particle board is described.

1.2   Operating principles of edge-finishing equipment are described.

1.3   The operating parameters and capability of edge-finishing equipment are explained.

1.4   Operating components and process controls of edge-finishing equipment are identified and their purpose is explained.

Range   edge-sealer components may include but are not limited to – sealant supply system, applicator;
tenoner components may include but are not limited to – tooling, drive system, rollers, guides.

1.5   Hazards associated with edge-finishing particle board are identified and the role of protective equipment and safety features is explained.

Range   hazards may include but are not limited to – noise, dust, moving equipment;
safety features may include but are not limited to – personal protective equipment, safety isolation procedures, lockouts, emergency stops, guards, heat handling.

1.6   The consequences of non-conformance with worksite standards are described.

Outcome 2

Operate and maintain edge-finishing equipment in accordance with worksite policies and procedures.

Evidence requirements

2.1   Equipment is set up, started up, operated, and shut down.

2.2   Supply of consumables is established and maintained.

Range   consumables may include but are not limited to – tongues, sealant.

2.3 Setting and adjustment of operating parameters enables production requirements to be achieved.

Range operating parameters for edge-sealer may include but are not limited to – pressures, temperatures, flows, application rate; operating parameters for tenoner may include but are not limited to – pressures, guide setting, saw tooth size, groove dimensions; production requirements may include but are not limited to – product quality, production rate.

2.4 Equipment faults and malfunctions are identified and corrective action is taken.

Range equipment faults and malfunctions – electrical, mechanical, hydraulic, pneumatic, instrumentation.

2.5 Preventative maintenance and cleaning requirements are explained and applied.

Outcome 3

Monitor and control the performance of edge-finishing equipment.

Evidence requirements

3.1 Inspection of output product, and adjustment of control parameters, enable process requirements, plant performance, and product quality to be maintained.

3.2 Output product meets the requirements for tongue tolerance, groove tolerance, sealant coverage, and sealant thickness.

3.3 Production rate is maintained.

3.4 Production, maintenance and quality records are completed.

Planned review date	31 December 2016

Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	25 March 1999	31 December 2011
Review	2	29 March 2005	31 December 2011
Rollover and Revision	3	23 February 2007	31 December 2012
Review	4	20 October 2011	N/A

Consent and Moderation Requirements (CMR) reference	0173

This CMR can be accessed at http://www.nzqa.govt.nz/framework/search/index.do.

Please note

Providers must be granted consent to assess against standards (accredited) by NZQA, before they can report credits from assessment against unit standards or deliver courses of study leading to that assessment.

Industry Training Organisations must be granted consent to assess against standards by NZQA before they can register credits from assessment against unit standards.

Providers and Industry Training Organisations, which have been granted consent and which are assessing against unit standards must engage with the moderation system that applies to those standards.

Requirements for consent to assess and an outline of the moderation system that applies to this standard are outlined in the Consent and Moderation Requirements (CMR). The CMR also includes useful information about special requirements for organisations wishing to develop education and training programmes, such as minimum qualifications for tutors and assessors, and special resource requirements.

Comments on this unit standard

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