

<b>Title</b>	<b>Set up and operate a decorator unit for single colour decorations on crepe tissue</b>		
<b>Level</b>	<b>3</b>	<b>Credits</b>	<b>10</b>

<b>Purpose</b>	People credited with this unit standard are able to: prepare polymer plates and cylinders on a decorator unit; pre-set the inking system; set doctor blades; demonstrate knowledge of factors affecting decorating standards; prepare for the production run; and decorate single colour work on crepe tissue and monitor and control decoration quality.
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<b>Classification</b>	Wood Fibre Manufacturing > Tissue Converting
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<b>Available grade</b>	Achieved
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### Guidance Information

- 1 Legislation, regulations and/or industry standards relevant to this unit standard include but are not limited to the:
  - Health and Safety at Work Act 2015
  - Resource Management Act 1991.

Any new, amended or replacement Acts, regulations, standards, codes of practice, guidelines, or authority requirements or conditions affecting this unit standard will take precedence for assessment purposes, pending review of this unit standard.

- 2 **Definition**  
*Worksite policies and procedures* refers to documented policies and to documented or other directions provided to staff. These 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.
- 3 **Assessment information**  
 Evidence presented for assessment against this unit standard must be consistent with safe working practices and be in accordance with applicable service information, worksite policies and procedures and legislative requirements. This includes the knowledge and use of worksite specific equipment, procedures, and practices.

This unit standard may be assessed in the workplace using naturally occurring evidence or in a simulated environment that demands performance equivalent to that required in the workplace. All activities and evidence must be in accordance with worksite policies and procedures.

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## Outcomes and performance criteria

### Outcome 1

Prepare polymer plates and cylinders on a decorator unit.

#### Performance criteria

- 1.1 Safe work practices associated with setting up and operating a decorating unit are demonstrated.
- Range practices may include but are not limited to – energy isolation procedures, lock outs, emergency stops, machine guarding, wearing of appropriate safety equipment.
- 1.2 Decorator unit components are positioned and secured on the decorator to meet the requirements of the job specifications.
- Range components include but are not limited to – polymer plates, sleeves, cylinders.
- 1.3 Faults on polymer plates and cylinders are identified.
- Range minimum evidence of four is required.

### Outcome 2

Pre-set the inking system.

#### Performance criteria

- 2.1 Operation of the inking system is explained.
- 2.2 Pumps are located and filled with the ink required by the job specifications.
- 2.3 Factors affecting the viscosity of ink are identified and explained.
- 2.4 Viscosity is checked and adjusted to meet the requirements of the job specifications.

### Outcome 3

Set doctor blades.

#### Performance criteria

- 3.1 The location and function of doctor blades are explained.

3.2 Doctor blades are fabricated and set in accordance with the requirements of the job specifications.

Range positions and pressures.

3.3 Ink chamber faults are rectified.

Range incorrect orientation and pressure of blades, leaking end seals, worn blades.

#### **Outcome 4**

Demonstrate knowledge of factors affecting decorating standards.

#### **Performance criteria**

4.1 Factors affecting the decorating speed for the job are explained.

Range factors may include but are not limited to – ink, tissue grams per square metre (GSM), register, drying system.

4.2 Characteristics of an acceptable image are explained.

Range colour consistency and registration maintained, correct tissue GSM, correct inks, standard maintained to approved sample.

#### **Outcome 5**

Prepare for the production run.

#### **Performance criteria**

5.1 Web tensions are tuned to the machine in order to meet the requirements of the job specifications.

Range draw, nip, bow.

5.2 Impression is checked for correct image transfer and adjusted to meet the requirements of the job specification.

5.3 Decorator unit is fine tuned to ensure the required production standard is achieved.

Range pressures, inking systems, tensions, registration, delivery.

#### **Outcome 6**

Decorate single colour work on crepe tissue and monitor and control decoration quality.

**Performance criteria**

6.1 Crepe tissue is decorated with single colour to meet the specifications of the job lay card or sample.

6.2 The decoration standards are monitored to enable variation against the approved sample to be identified.

Range may include but not limited to – colour variation, registration, picking, ghosting, set-off.

6.3 Problems encountered during decoration are rectified by making corrective actions or adjustments.

Range problems may include but are not limited to (a minimum of two) – dirty print, set-off, ghosting, over/under impression, smudging, show-through, ink contamination, bleeds, creasing, mis-register, trapping, doctor blade faults and blocking, strike-through.

6.4 Waste is minimised and recycled.

<b>Planned review date</b>	31 December 2028
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**Status information and last date for assessment for superseded versions**

Process	Version	Date	Last Date for Assessment
Registration	1	29 June 1999	31 December 2012
Revision	2	20 August 2002	31 December 2012
Review	3	23 November 2003	31 December 2012
Rollover and Revision	4	26 January 2007	31 December 2012
Review	5	21 July 2011	31 December 2026
Review	6	29 June 2023	N/A
Revision	7	28 August 2025	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 Hanga-Aro-Rau Manufacturing, Engineering and Logistics Workforce Development Council [qualifications@hangaarorau.nz](mailto:qualifications@hangaarorau.nz) if you wish to suggest changes to the content of this unit standard.