

<b>Title</b>	<b>Demonstrate knowledge of rotary die cutting machinery and die cutting faults for fibreboard packaging</b>		
<b>Level</b>	<b>2</b>	<b>Credits</b>	<b>5</b>

<b>Purpose</b>	People credited with this unit standard are able to: demonstrate knowledge of rotary die cutting machinery used in the workplace; and identify rotary die cutting faults, and describe their causes and the actions required to rectify them.
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<b>Classification</b>	Fibreboard Packaging > Fibreboard Packaging Production
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<b>Available grade</b>	Achieved
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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.
- Definition  
*Workplace practices* refer to the documented procedures for the machine and/or workplace.

### Outcomes and performance criteria

#### Outcome 1

Demonstrate knowledge of rotary die cutting machinery used in the workplace.

#### Performance criteria

- 1.1 Main components of rotary die cutting machinery are identified, and their functions are described in terms of workplace practices.  
  
Range      die cylinder, anvil or die blanket cylinder, pin stripper, dicar equalisers.
- 1.2 Workplace practices are explained in terms of zeroing, centring, changing impression pressures, and releasing and reapplying the drum lock.  
  
Range      importance of correct set up, faults resulting from incorrect settings.

- 1.3 The relationship between anvil wear, circumference, and speed is explained in terms of the potential faults that result from changes between these factors.
- 1.4 Die rubbering requirements are described in terms of workplace practices.
- Range durometer, width, height, style, position.
- 1.5 Different types of rules are described in terms of those used in the workplace.
- Range cutting, creasing, perforating.
- 1.6 Requirements for handling and storing dies are explained in terms of workplace practices.

## Outcome 2

Identify rotary die cutting faults, and describe their causes and the actions required to rectify them.

### Performance criteria

- 2.1 Rotary die cutting faults are identified from photographs or diagrams or physical samples.
- Range may include but is not limited to – variations in blank size; board fractured, cracked or damaged at creasing; board bends at non specified locations during creasing; board not cut to specification; board not creased to specification; board fails to bend accurately along crease locations; intermittent cutting; waste or scrap ejection not to specification; uneven cutting and/or creasing; die to board variation; evidence is required for six faults.
- 2.2 A minimum of two causes and one corrective action for each cause are described for each fault identified in performance criterion 2.1.
- Range the causes and corrective actions described are those most often experienced in the workplace.

<b>Replacement information</b>	<p>This unit standard was replaced by skill standard 40320.</p> <p>This unit standard replaced unit standard 10121 and unit standard 10124.</p>
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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	20 September 2012	31 December 2027
Review	2	28 November 2024	31 December 2027

**Consent and Moderation Requirements (CMR) reference**

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