

Title	Produce printed and die cut board at a printer rotary die cutter for fibreboard packaging		
Level	4	Credits	25

Purpose	People credited with this unit standard are able to: check documentation and confirm that the components and equipment required for the job are available; make ready the printer rotary die cutter to produce printed and die cut board; operate the printer rotary die cutter to make printed and die cut board to meet job requirements; and confirm job is completed and undertake post production tasks.
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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

- 1 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.
- 2 Assessment must be undertaken at a printer rotary die cutter with at least two colour stations and configured with at least a hopper feeder and automatic stacking machinery.
- 3 Competence in this unit standard is to be demonstrated in the production and stacking of two die cut jobs of complex shape, each with a new die, of differing die cutting specifications. Each job must require the printing of three colours in not more than two passes with requirements for registration and trapping and alignment. Complex shape would typically be a box with a lid and internal dividers or a machine erectable case.
- 4 Printing and die cutting must be carried out in a single pass.

5 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.

6 Recommended skills and knowledge:

Unit 27788, *Produce die cut board at a rotary die cutter for fibreboard packaging*.

Outcomes and performance criteria

Outcome 1

Check documentation and confirm that the components and equipment required for the job are available.

Performance criteria

- 1.1 Job documentation is checked to ensure that all specifications for the process being undertaken are complete and any discrepancies are reported in accordance with workplace practices.
- 1.2 Components required for the job are checked against job documentation and their availability is confirmed.
- 1.3 Availability of equipment, as determined by the job documentation, is confirmed.

Outcome 2

Make ready the printer rotary die cutter to produce printed and die cut board.

Performance criteria

- 2.1 Machine crew and other staff are clearly advised of the make ready and production tasks they are responsible for, ensuring that no avoidable delays occur.
- 2.2 Production difficulties are anticipated and preventive action is taken to prevent their occurrence.
- 2.3 Systems are set up and adjusted in accordance with workplace practices to meet job requirements.

Range feeder, delivery, sheet pick-up and transportation, transfer, accumulation.

- 2.4 Rotary cutting devices are set up and adjusted in accordance with workplace practices to meet job requirements.
- 2.5 Cutting pressures are set up and adjusted in accordance with workplace practices.
- 2.6 Machine lays are set to correct position to ensure registration is achieved.
- 2.7 Pre-printed board is loaded ensuring its orientation is in accordance with workplace practices.
- 2.8 Sample run is conducted and any adjustments are carried out in accordance with workplace practices and job requirements.

Outcome 3

Operate the printer rotary die cutter to make printed and die cut board to meet job requirements.

Performance criteria

- 3.1 Production running speed is maintained ensuring that required quality and production standards are met.
- 3.2 Checks for faults are carried out during production running in accordance with workplace practices and action is immediately taken to identify and rectify any faults ensuring fault-free production running is successfully resumed.
- 3.3 Proactive measures are followed in accordance with workplace practices to reduce the likelihood of faults occurring during production.
- 3.4 Print position and registration of all print is in accordance with workplace practices.
- 3.5 Colours are confirmed as meeting the job requirements and viscosity adjustments are made during the production run to rectify any incorrect colour caused by viscosity.
- 3.6 Die to sheet registration and stacking accuracy are maintained during production in accordance with workplace practices.
- 3.7 Waste disposal requirements are in accordance with workplace practices.

Outcome 4

Confirm job is completed and undertake post production tasks in accordance with workplace practices.

Performance criteria

- 4.1 Quantity printed and other job requirements are checked against job documentation before removing job from machine and any discrepancies in quantity are rectified.
- 4.2 Correct shut-down sequence is followed.
- 4.3 Job documentation is completed and any amendments and variations are noted for future reference.
- 4.4 Other post production tasks are carried out as required by the job documentation.

Replacement information	This unit standard was replaced by skill standard 40354. This unit standard replaced unit standard 10127 and unit standard 10128.
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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	0005
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.