

Title	Change a die and rotate or replace die blankets at a rotary die cutter for fibreboard packaging		
Level	3	Credits	5

Purpose	People credited with this unit standard are able to: remove the die on completion of a production run; use job documentation to select the die for a new production run; mount the new die on the die cylinder; and rotate or replace the die blankets.
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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

- 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.
- It is recommended that rotation or replacement of die blankets is assessed under conditions where third party assistance is provided during the manual rotation of the cylinder.
- 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.

Outcomes and performance criteria

Outcome 1

Remove the die on completion of a production run in accordance with workplace practices.

Performance criteria

1.1 At the termination of the preceding production run, the machine is reset.

Range resettings may include but are not limited to – machine 'zeroing', opening machine, releasing impression, releasing brake.

1.2 Die is unbolted and removed.

Outcome 2

Use job documentation to select a die for a new production run in accordance with workplace practices.

Performance criteria

2.1 Die is selected and confirmed against job documentation to ensure job requirements are met.

2.2 Die is checked for damage and any damage is reported.

Outcome 3

Mount the new die on the die cylinder in accordance with workplace practices.

Performance criteria

3.1 Machine is set to meet job requirements.

Range procedures may include but are not limited to – machinery being 'zeroed', centring die cylinder, releasing impression, engaging brake.

3.2 Die and stripping componentry are securely mounted.

3.3 Machine is confirmed as being 'zeroed' prior to commencing production running.

Outcome 4

Rotate or replace the die blankets.

Performance criteria

- 4.1 Knowledge of, and procedures for, rotating or replacing die blankets are explained in terms of workplace practices.
- Range indicative faults, sequential steps, effects of excessive pressure, trimming or skimming.
- 4.2 Die blankets are rotated or replaced ensuring that there are no gaps between the blanket segments and that no damage is caused to the die blankets.
- 4.3 Rotation or replacement is achieved in accordance with workplace practices within the time allowed.

Replacement information	<p>This unit standard, and unit standard 27788 were replaced by skill standard 40336.</p> <p>This unit standard replaced unit standard 10122 and unit standard 10455.</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	0005
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.