

Title	Produce specialty board for fibreboard packaging		
Level	4	Credits	5

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; set up machine for production of specialty board; apply starch to bond together the medium papers; corrugate the bonded mediums and bond with the top liner paper; produce fault free specialty board over extended periods; 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 Definitions

Extended periods are defined as periods of at least one hour's duration, and including several paper changes.

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.

Plant listed maximum speed refer to the speed that is determined by each workplace as appropriate for specific production conditions taking into account paper grades, flutes, run length, and chop length.

Specialty board refers to dual arch or twin cushion.

Workplace practices refer to the documented procedures for the machine and/or workplace.

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

Set up machine for production of specialty board in accordance with workplace practices.

Performance criteria

- 2.1 Machine is positioned and secured.
- 2.2 Machine is switched on in the required sequence and checks are carried out.
- 2.3 Liner and medium papers are threaded and pulled through the machine to ensure accurate feeding.

Outcome 3

Apply starch to bond together the medium papers.

Performance criteria

- 3.1 Starch is applied in accordance with workplace practices.
 - Range even and continuous coverage, quantity, corrugator rollers free from starch.
- 3.2 Starch is spread on the medium paper in accordance with workplace practices.
- 3.3 Bonding is achieved ensuring alignment is maintained.

Outcome 4

Corrugate the bonded mediums and bond with the top liner paper.

Performance criteria

- 4.1 Adhesive is applied to the flute tips.
- 4.2 Bonding of the medium papers to the top liner paper is achieved without splits, tear-offs or wrinkles at the pressure roller or pressure belt.
- 4.3 Web is checked for faults and any faults found are rectified or reported in accordance with workplace practices.

Outcome 5

Produce fault free specialty board over extended periods in accordance with workplace practices.

Performance criteria

- 5.1 Splices are made during the production run.
- 5.2 Specialty board is produced at a speed to ensure the double backer does not reduce below plant listed maximum speed, except when splices are being made at the medium or top liner papers.
- 5.3 Specialty board web is free of faults in any extended period.

Outcome 6

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

Performance criteria

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

Replacement information	This unit standard replaced unit standard 3783.
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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>.