

Title	Set up, shut down, and wash up a corrugator station for fibreboard packaging		
Level	3	Credits	10

Purpose	People credited with this unit standard will be able to: check documentation and confirm that the components and equipment required for the job are available; prepare equipment ready for set-up; set up reel transportation system on the corrugator station; set up corrugator station to produce web; inspect and adjust quality; shut down and wash up corrugator station, and clean up the work area.
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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.
- Assessment against this unit standard will be undertaken at either a single facer or a double backer and platen section of a corrugator.
- 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

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

Prepare equipment ready for set-up in accordance with workplace practices.

Performance criteria

- 2.1 Equipment is switched on following the sequence of switch-on routines and checks.
- 2.2 Station and any components are confirmed as being free from damage or deformation.
- 2.3 Gelled starch is cleaned from starch trays and components.

Outcome 3

Set up reel transportation system on the corrugator station in accordance with workplace practices.

Performance criteria

- 3.1 Unwind reel is set up and adjusted to meet job requirements.
- 3.2 Webbing procedures are carried out.
- 3.3 Web control system is set up and adjusted to meet job requirements.
- 3.4 Reels are spliced to meet job requirements.

Outcome 4

Set up corrugator station to produce web.

Performance criteria

- 4.1 Starch delivery system is set up and adjusted in accordance with workplace practices to suit corrugating process.
- 4.2 Rider roll is set to correct pressure to meet job requirements.
- 4.3 Heat delivery system is set up and adjusted in accordance with workplace practices to suit corrugating process and job requirements.

Outcome 5

Inspect and adjust quality in accordance with workplace practices.

Performance criteria

- 5.1 Inspection and/or testing of sample is carried out and results are interpreted to determine adjustment requirements.
- 5.2 Adjustment changes are carried out ensuring job requirements are met.

Outcome 6

Shut down and wash up corrugator station, and clean up the work area.

Performance criteria

- 6.1 Warm down and shut down procedures are carried out in accordance with workplace practices.
- 6.2 Starch, paper dust and foreign matter are cleared from the equipment.

Range starch trays, starch lines, starch filter systems, dams, spreader bars.
- 6.3 Starch tanks, where available on the equipment being used, are isolated to prevent back flushing.
- 6.4 Corrugator is hosed clean in accordance with workplace practices, and the machine area is cleaned.
- 6.5 Starch delivery system is washed up ready for next run, and liquid waste is disposed of in accordance with workplace practices.
- 6.6 Reel-feed and transportation systems are disengaged and cleaned ready for next run.
- 6.7 Machine faults requiring repair are identified and reported in accordance with workplace practices.
- 6.8 Filled starch trays are in the level operating position.

Replacement information	This unit standard was replaced by skill standard 40341. This unit standard replaced unit standard 21617 and unit standard 21618.
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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>.