

Title	Produce fault free board on a corrugator for fibreboard packaging		
Level	3	Credits	20

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; inspect and adjust quality; maintain operation of reel transportation system, corrugating process and production process; rectify faults without causing production delays; 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

- 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 must be undertaken at either a single facer or a double backer with platen.
- Competence in this unit standard is to be demonstrated in the production of two production runs producing two different types of product in accordance with workplace practices and to meet job requirements.
- 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.

Plant listed maximum speed refers to that determined by each workplace as appropriate for the board dimensions, board type, and run length in production.
Workplace practices refer to the documented procedures for the machine and/or workplace.

Substrate refers to a range of substrates within the major categories of board or paper.

5 Recommended skills and knowledge:

Unit 27812, *Set up, shut down, and wash up a corrugator station 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

Inspect and adjust quality in accordance with workplace practices.

Performance criteria

- 2.1 Inspection and/or testing of sample are carried out and results are interpreted to determine adjustment requirements.
- 2.2 Adjustments are carried out ensuring job requirements are met.

Outcome 3

Maintain operation of reel transportation system in accordance with workplace practices.

Performance criteria

- 3.1 Reel stand is monitored and adjusted to ensure efficient continuous operation.
- 3.2 Web control system is monitored and adjusted to ensure correct tension and accurate continuous positioning of the web and efficient operation.

3.3 Substrate is added to the process according to job specifications.

Outcome 4

Maintain corrugating process in accordance with workplace practices.

Performance criteria

- 4.1 Starch delivery system is monitored and adjusted to suit corrugating process and job requirements.
- 4.2 Heat delivery system is monitored and adjusted to suit corrugating process and job requirements.
- 4.3 Steam delivery system is monitored and adjusted to suit corrugating process and job requirements.
- 4.4 Corrugating roll and pressure rolls are monitored and adjusted to suit corrugating process and job requirements.
- 4.5 Appropriate quantity of paper is run with a minimum wastage.

Outcome 5

Maintain production process in accordance with workplace practices.

Performance criteria

- 5.1 Production process is undertaken and maintained in association with crew.
- 5.2 Manual and/or automatic control is used in accordance with job requirements.
- 5.3 Performance is monitored and verified using the process control system.
- 5.4 Starch performance is monitored and adjusted throughout the production run.
- 5.5 Quality checks are carried out on a regular basis and adjustments made as necessary.

Outcome 6

Rectify faults in accordance with workplace practices without causing production delays.

Range misalignments, wash-boarding, wet board, any form of de-lamination (extensive or localised), folded edges, leaning or deformed or damaged flutes, wrinkles, indentations or crushed or damaged board.

Performance criteria

- 6.1 Production difficulties are anticipated and preventive action is taken to prevent occurrence by timely intervention.

- 6.2 Faulty performance of equipment is identified and reported.
- 6.3 Adjustments or corrections are carried out.
- 6.4 All faults within the operator's control (other than for rectifying indentations) are rectified at plant listed maximum speed.
- 6.5 Waste disposal requirements are met.

Outcome 7

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

Performance criteria

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

Replacement information	This unit standard was replaced by skill standard 40342. This unit standard replaced unit standard 3776, unit standard 3780, unit standard 3784, unit standard 21619, and unit standard 21620.
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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>.