

Title	Set up and start up an extrusion blow moulding machine to run advanced or complex moulds		
Level	4	Credits	5

Purpose	People credited with this unit standard are able to: remove, fit and set an advanced or complex extrusion blow mould; demonstrate knowledge of automatic transfer and ejection of extrusion blow mouldings; and set up and start up the extrusion blow moulding machine.
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Classification	Plastics Processing Technology > Extrusion Blow Moulding
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Available grade	Achieved
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Explanatory notes

- 1 Legislation relevant to this unit standard includes but is not limited to the Health and Safety at Work Act 2015.
- 2 Definitions

Advanced extrusion blow moulds may have the following features – offset neck, needle blow, single or multiple cavity, handled container, changeable inserts.

Complex extrusion blow moulds may have the following features – internal thread, unscrewing blow pins, single or multi-cavity, moving parts and components, guide shafts, wear plates, fall and rise plates, needle blow or spear unit.

Optimise – achieve the maximum output a machine can maintain while remaining stable and producing product to a consistent quality specification.

Parison control systems include parison programming, accumulator diehead, parison expanding, parison sealing.

Workplace procedures – procedures used by the organisation carrying out the work and applicable to the tasks being carried out. Examples are – standard operating procedures, site safety procedures, equipment operating procedures, codes of practice, quality management practices and standards, procedures to comply with legislative and local body requirements.
- 3 All evidence requirements must be performed in accordance with workplace procedures.

Outcomes and evidence requirements

Outcome 1

Remove, fit and set an advanced or complex extrusion blow mould.

Range may include – advanced mould, complex mould;
evidence is required for one mould.

Evidence requirements

- 1.1 The extrusion blow moulding machine is prepared for a mould change.
- 1.2 Mould and associated tooling are prepared for removal and fitting.

Range includes – extrusion die and pin.
- 1.3 Mould and associated changes are carried out.
- 1.4 Parison control systems are set to job specification.
- 1.5 Machine is set to job specification.

Outcome 2

Demonstrate knowledge of automatic transfer and ejection of extrusion blow mouldings.

Evidence requirements

- 2.1 Transfer systems for oriented mouldings through finishing stations to ejection are described.

Range finishing stations may include – deflashing, post-mould cooling, machining, leak detection, packaging.

Outcome 3

Set up and start up the extrusion blow moulding machine.

Evidence requirements

- 3.1 Machine is set to job specification.
- 3.2 The machine is put into production, monitored to maintain job specification, and adjusted to optimise the process and product.
- 3.3 Running adjustments are made and recorded.

Planned review date	31 December 2021
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Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	28 April 1993	31 December 2014
Revision	2	13 February 1997	31 December 2014
Review	3	23 January 1998	31 December 2014
Review	4	24 August 2006	31 December 2014
Review	5	21 March 2013	31 December 2019
Review	6	15 September 2016	N/A

Consent and Moderation Requirements (CMR) reference	0013
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.

Please note

Providers must be granted consent to assess against standards (accredited) by NZQA, before they can report credits from assessment against unit standards or deliver courses of study leading to that assessment.

Industry Training Organisations must be granted consent to assess against standards by NZQA before they can register credits from assessment against unit standards.

Providers and Industry Training Organisations, which have been granted consent and which are assessing against unit standards must engage with the moderation system that applies to those standards.

Requirements for consent to assess and an outline of the moderation system that applies to this standard are outlined in the Consent and Moderation Requirements (CMRs). The CMR also includes useful information about special requirements for organisations wishing to develop education and training programmes, such as minimum qualifications for tutors and assessors, and special resource requirements.

Comments on this unit standard

Please contact Competenz qualifications@competenz.org.nz if you wish to suggest changes to the content of this unit standard.