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| <b>Title</b> | <b>Press wet pulp and paper webs in the pulp or paper manufacturing industry</b> |                |           |
| <b>Level</b> | <b>4</b>   | <b>Credits</b> | <b>10</b> |

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| <b>Purpose</b> | People credited with this unit standard are able to: demonstrate knowledge of web pressing; operate the press section; and monitor and control the performance of the press section. |
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| <b>Classification</b> | Wood Fibre Manufacturing > Pulp and Paper Manufacturing Skills |
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| <b>Available grade</b> | Achieved |
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## Guidance Information

### 1 Legislation and references

Legislation, regulations and/or industry standards relevant to this unit standard include but are not limited to the:

- Hazardous Substances and New Organisms Act 1996;
- Health and Safety at Work Act 2015;
- Resource Management Act 1991;
- Health and Safety at Work (Major Hazard Facilities) Regulations 2016.

### 2 Definitions

*Operating parameters* refer to the boundary conditions in which the operations are carried out in web pressing.

*Operating procedures* refer to the process(es) that are worked through, e.g. standard operating procedure (SOP) in web pressing.

*Worksite documentation* refers to organisation policies and procedures that are documented in memo, electronic, or manual format and available in the workplace, and are consistent with manufacturer's requirements. They may include but are not limited to – standard operating procedures, site specific procedures, site safety procedures, equipment operating procedures, quality assurance procedures, product quality specifications, references, approved codes of practice, housekeeping standards, environmental considerations, sustainability, on-site briefings, supervisor's instructions, and procedures to comply with legislative and local body requirements relevant to the pulp and paper industry.

### 3 Assessment information

Evidence presented for assessment against this unit standard must be consistent with safe working practices and be in accordance with applicable service information, worksite documentation and legislative requirements. This includes the knowledge and use of suitable tools and equipment.

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## Outcomes and performance criteria

### Outcome 1

Demonstrate knowledge of web pressing.

#### Performance criteria

- 1.1 Principles of the operation of the press section are explained.
- Range principles of the operation may include but are not limited to – action of the drive, draw control, roll types, felt runs, felt conditioning, loads, nip pressures, vacuum, Wahlstrom theory, water removal, controlled crown rolls, doctor blades, surface characteristics, temperature.
- 1.2 Operating components and process controls for the press section are described and their purpose and operation are explained.
- Range operating components may include but are not limited to – press rolls, felt guiding system, felt cleaning system, hydraulic system, distributed control system.
- 1.3 Hazards associated with pressing are identified, and actions to be taken to minimise, or eliminate the hazards are described.
- Range hazards may include but are not limited to – moving felt rolls, pressure, hydraulic oil.
- 1.4 Consequences of non-conformance of web pressing with worksite operating procedures are described.
- 1.5 Roles and responsibilities of the press section operator are described.

### Outcome 2

Operate the press section.

#### Performance criteria

- 2.1 Safe work practices associated with operating the press section are identified and used.
- Range practices may include but are not limited to – isolation procedures, lock-out or tag-out, emergency stops, machine guarding, wearing appropriate safety equipment.
- 2.2 Press section is set up, started up, operated, and shut down.
- Range set up may include but is not limited to – loads, pressures, rolls, felt tensions, felt guiding, showers, sheet tension, doctor blades.

2.3 Output web is checked to meet the specified requirements.

Range may include but is not limited to – moisture profile, absence of defects, thickness, sheet tension.

2.4 Essential care and housekeeping requirements are carried out.

**Outcome 3**

Monitor and control the performance of the press section.

**Performance criteria**

3.1 Performance of the press section is monitored and parameters are controlled in accordance with operating parameters.

Range control parameters may include but are not limited to – loads, pressures, felt tension, felt guiding, showers, sheet tension; performance parameters – grammage, moisture content.

3.2 Operating and equipment faults and malfunctions are identified and relevant corrective actions are taken.

Range operating faults and malfunctions – felt condition, guidance failure, sheet tension.

3.3 Production, maintenance, and quality records are completed.

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| <b>Planned review date</b> | 31 December 2028 |
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**Status information and last date for assessment for superseded versions**

| Process      | Version | Date             | Last Date for Assessment |
|--------------|---------|------------------|--------------------------|
| Registration | 1       | 22 February 1995 | 31 December 2024         |
| Revision     | 2       | 27 January 1997  | 31 December 2024         |
| Review       | 3       | 25 February 1999 | 31 December 2024         |
| Review       | 4       | 18 December 2006 | 31 December 2024         |
| Review       | 5       | 24 October 2014  | 31 December 2025         |
| Review       | 6       | 30 November 2023 | N/A                      |

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| <b>Consent and Moderation Requirements (CMR) reference</b> | 0173 |
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This CMR can be accessed at <http://www.nzqa.govt.nz/framework/search/index.do>.

### **Comments on this unit standard**

Please contact Hanga-Aro-Rau Manufacturing, Engineering and Logistics Workforce Development Council [qualifications@hangaarorau.nz](mailto:qualifications@hangaarorau.nz) if you wish to suggest changes to the content of this unit standard.