Title	**Feed and tail out finger jointer**		
Level	**3**	**Credits**	**6**

Purpose	People credited with this unit standard are able to: manage health and safety when feeding and tailing out a finger jointer; demonstrate knowledge of the operation and operating principles of a finger jointer; prepare to operate the finger jointer; feed shook or block into finger jointer monitor finger jointer operation; carry out out-feed operations; and record downtime, report machinery breakages, and isolate machinery.

Classification	Solid Wood Manufacturing > Finger Jointing

Available grade	Achieved

Guidance Information

1 Legislation
Health and Safety at Work Act 2015.
Resource Management Act 1991.

2 Definitions
Accepted industry practice refers to approved codes of practice and standardised procedures accepted by the wider wood manufacturing industry as examples of best practice.
Corrective action refers to actions such as communication to management, communication to on-site technical person, communication to off-site technical support person, cleaning, communication with maintenance staff, recalibration, or changes made to the operating system in accordance with workplace procedures.
Workplace procedures refer to documented policies and procedures set by the organisation carrying out the work, and to documented or other directions provided to staff, and applicable to the tasks being carried out. 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, on-site briefings, supervisor's instructions, and procedures to comply with legislative and local body requirements relevant to the wood manufacturing sector.

3 Assessment information
- a For assessment against this unit standard, finger jointer operators that have not been trained to adjust the machine, must be able to recognise problems and alert supervisor.
- b All activities and evidence must meet workplace procedures and accepted industry practice.

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Outcomes and performance criteria

Outcome 1

Manage health and safety when feeding and tailing out a finger jointer.

Performance criteria

1.1 Hazards associated with feeding and tailing out of the finger jointing machine are identified and actions to be taken to manage the hazards are described.

Range hazards may include but are not limited to – moving equipment, lifting, noise;
evidence of three different hazards is required.

1.2 Safe working practices associated with feeding and tailing out of the finger jointing machine are identified and applied.

Range practices may include but are not limited to – isolation procedures, lockouts, emergency stops, machine guarding, and wearing of appropriate safety equipment;
evidence of five is required.

Outcome 2

Demonstrate knowledge of the operation and operating principles of a finger jointer.

Performance criteria

2.1 Purpose and function of the finger jointer are explained.

2.2 Operating parameters and capability of the finger jointer are explained.

Range includes but is not limited to – maximum and minimum shook cross sections, maximum and minimum shook lengths, maximum and minimum output lengths, throughput speed.

2.3 Operating components of the finger jointer are explained.

Range may include but is not limited to – face-to-face or edge-to-edge joint profile, finger length, trim saws (if required), scoring saws (if required), glue applicator, cut off saw, press, turn down, crowder, automatic stacker (if required).

2.4 Basic machine maintenance requirements are explained.

Range maintenance requirements may include but are not limited to – housekeeping, lubrication, drives, conveyors, extraction systems.

2.5 Roles and responsibilities of the finger jointer operator are described.

2.6 Problems associated with incorrect stacking of packets are identified.

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Outcome 3

Prepare to operate the finger jointer.

Performance criteria

3.1 Start-up checks are completed.

3.2 Upstream and downstream processing stages are checked to ensure they are ready for production.

3.3 Raw materials are checked.

Range may include but is not limited to – moisture content, size, dressed vs undressed, grade, packet ID.

Outcome 4

Feed shook or block into finger jointer.

Performance criteria

4.1 Starting procedure for finger jointer and feed gear is carried out.

4.2 Foreign matter that could affect the cutters and saws is removed.

4.3 Feedstock is arranged to meet manufacturer and/or company specifications for length compatibility and out-of-specification shook is rejected.

Outcome 5

Monitor finger jointer operation.

Performance criteria

5.1 Any operating faults and malfunctions are identified, and corrective action taken.

Range operating faults and malfunctions may include but are not limited to – mechanical, electrical, pneumatic, hydraulic.

5.2 In-feed rate is maintained to meet the capability of the machine and production requirements.

5.3 Product quality is monitored, and any required adjustments are made.

Range may include but is not limited to – stepping, overlap, pinhole, open joint, short fingers, tear out, rip out, glue spread, out-of-specification shooks.

5.4 Finger jointer is operated to minimise mis-feeding.

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5.5 Safe work practices are followed to clear any jammed shook.

5.6 Input data is recorded, and production records are maintained.

Outcome 6

Carry out out-feed operations.

Performance criteria

6.1 Finger jointed product quality is monitored, and any defects are identified and diagnosed.

Range defects may include but are not limited to – stepping, pin holes, dry joints, bow, crook, tear out.

6.2 Reject material is identified and rectified or reworked.

6.3 Finger jointed products are stacked, packaged, and labelled.

6.4 Housekeeping standards are maintained.

6.5 Output data are recorded, and production identifications and records are maintained.

Outcome 7

Record downtime, report machinery breakages, and isolate machinery.

Performance criteria

7.1 Downtime data are recorded.

7.2 Machinery breakages are reported and recorded.

7.3 Isolation procedures are carried out.

Planned review date	31 December 2024

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Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	25 May 1995	31 December 2012
Review	2	10 February 1999	31 December 2012
Revision	3	14 March 2000	31 December 2012
Revision	4	15 December 2000	31 December 2012
Review	5	18 December 2006	31 December 2012
Rollover and Revision	6	15 April 2011	31 December 2014
Review	7	18 April 2013	31 December 2015
Review	8	20 March 2014	N/A
Review	9	25 June 2020	N/A

Consent and Moderation Requirements (CMR) reference	0013

This CMR can be accessed at http://www.nzqa.govt.nz/framework/search/index.do.

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.

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