

Title	Saw wood panels using a panel saw system		
Level	3	Credits	10

Purpose	People credited with this unit standard are able to: demonstrate knowledge of the fundamentals of panel trimming; prepare to operate a panel saw system; operate and maintain a panel saw system; monitor and control the performance of a panel saw system; and explain and complete maintenance and documentation requirements.
----------------	---

Classification	Wood Manufacturing - Generic Skills > Wood Panel Manufacturing Skills
-----------------------	---

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 may include actions such as communication to management, communication to on-site technical support 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.
Panel saw system refers to the infeed table, transport system, cutting area, and the outfeed pack assembly.
Preventative maintenance refers to the care and servicing of equipment and machinery. This may include periodic checks and inspections, testing, measurements, adjustments, or parts replacement as required in accordance with worksite policies and procedures for the purpose of preventing faults or failures and to maintain production requirements.
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 industry sector.

3 Range

Wood panels may include but are not limited to – plywood, medium density fibreboard (MDF), particleboard, strandboard, fibre-faced strandboard, laminated veneer lumber (LVL);
evidence is required for one type of wood panel.

4 Assessment information

All activities and evidence must meet workplace procedures and accepted industry practice.

Outcomes and performance criteria

Outcome 1

Demonstrate knowledge of the fundamentals of panel trimming.

Performance criteria

1.1 The purpose of panel trimming in the wood panel manufacturing process is described.

1.2 The operation of a panel saw system is described.

1.3 The functions of the different types of saws are described.

Range may include but are not limited to – scribing saw, rotary profiling saw, hog saw, cross-cut.

1.4 Cutting defects are recognised from given samples.

Range defects may include but are not limited to – out of square, edge damage, corner damage, burn marks, saw marking.

1.5 Hazards associated with panel sawing are identified, and the role of protective equipment and safety features is explained.

Range hazards may include but are not limited to – dust, flying particles, moving panels, dust explosions, fire, confined space, moving equipment;
safety features may include but are not limited to – personal protective equipment, hold cards, lockouts, stop buttons, guards.

1.6 The consequences of non-conformance with quality and safety standards are described.

Range may include but are not limited to – out of square, edge damage.

Outcome 2

Prepare to operate a panel saw system.

Performance criteria

- 2.1 Panel saw system is set up in accordance with the sawing schedule.
- 2.2 Start-up checks are completed.
- 2.3 Input panel checks are completed to ensure panels meet product quality specification and production run expectations.

Outcome 3

Operate and maintain a panel saw system.

Performance criteria

- 3.1 Panel saw is started, operated, and shut down.
- 3.2 Production requirements are achieved by setting and adjusting operating parameters.
 - Range operating parameters may include but are not limited to – feed speed, saw speed, dimension, stacking alignment;
production requirements may include but are not limited to – product quality, production rate.
- 3.3 Operating faults in the sawing, extraction, and transport systems are identified and corrective action is taken.
 - Range may include but is not limited to saws – blunt, bent, or broken saws, out of square, edge damage, corner damage, edge burn, lubrication failure;
extraction system – blockages, holed ducting;
transport system – product misalignment, seized bearings, seized wheels.
- 3.4 Equipment faults and malfunctions are identified, and corrective action is taken.
- 3.5 Downgraded products are identified and removed.

Outcome 4

Monitor and control the performance of a panel saw system.

Performance criteria

- 4.1 Process requirements, plant performance, and forming quality are maintained by monitoring and interpreting feedback information and adjusting control parameters.

- 4.2 Output product quality is checked.
- Range length, width, thickness, squareness, and straightness of cut requirements and production rate.
- 4.3 Out-of-specification product is identified and processed.
- 4.4 Waste material is processed.

Outcome 5

Explain and complete maintenance and documentation requirements.

Performance criteria

- 5.1 Preventative maintenance and cleaning requirements are explained and applied.
- 5.2 Production, maintenance, and quality records are explained and completed.

Planned review date	31 December 2024
----------------------------	------------------

Status information and last date for assessment for superseded versions

Process	Version	Date	Last Date for Assessment
Registration	1	25 January 1995	31 December 2012
Review	2	24 November 1995	31 December 2012
Revision	3	12 February 1998	31 December 2012
Review	4	25 March 1999	31 December 2012
Review	5	26 June 2003	31 December 2012
Review	6	29 March 2005	31 December 2012
Rollover and Revision	7	23 February 2007	31 December 2013
Review	8	19 April 2012	N/A
Review	9	23 April 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.