

Title	Bond overlays to wood panel substrates using an overlay press		
Level	4	Credits	20

Purpose	People credited with this unit standard are able to: demonstrate knowledge of fundamentals of overlay bonding; coordinate caul plate change for overlay bonding; operate and maintain an overlay press to bond overlays to wood panel substrates; and monitor and control the performance of an overlay press.
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Classification	Solid Wood Manufacturing > Overlay Bonding
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Available grade	Achieved
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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.
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 sector.
- 3 Assessment information
All activities and evidence must be in accordance with workplace procedures and accepted industry practice.

Outcomes and performance criteria

Outcome 1

Demonstrate knowledge of the fundamentals of overlay bonding.

Performance criteria

- 1.1 The purpose of the overlay press in the bonding process is described.
- Range may include but is not limited to – heating, pressing, surface finish.
- 1.2 The operating parameters and capability of the overlay press are explained.
- Range may include but are not limited to – time in press, temperature, pressures.
- 1.3 Pressures, temperatures and cycle times used in overlay presses at the candidate's own workplace are identified.
- 1.4 The need for dust-free surfaces is explained.
- 1.5 Operating components and process controls of the overlay press are identified, and their purpose is explained.
- Range may include but are not limited to – platen, press compensation mats, caul plates, loading systems, unloading systems.
- 1.6 Hazards associated with overlay pressing are identified, and the role of protective equipment and safety features is explained.
- Range hazards may include but are not limited to – noise, moving plant, heat;
safety features may include but are not limited to – personal protective equipment, hold cards, lockouts, stop buttons, guards.
- 1.7 The consequences of non-conformance with workplace procedures when bonding using an overlay press in terms of production, safety, and quality are described.

Outcome 2

Coordinate caul plate change for overlay bonding.

Performance criteria

- 2.1 Production schedule is interpreted for detail of caul plate requirements.
- 2.2 Support staff are briefed on caul plate change process and timing.
- 2.3 Delivery of replacement caul plates to meet the production schedule requirements is completed.

- 2.4 Removal of caul plates and the installation of replacement caul plates is coordinated.
- 2.5 Press is prepared for next order.
- 2.6 Arrangements are made for the removed caul plates to be returned to storage.

Outcome 3

Operate and maintain an overlay press to bond overlays to wood panel substrates.

Performance criteria

- 3.1 Overlay press is set up, started, operated, and shut down.
- 3.2 Operating parameters are set and adjusted to enable achievement of production requirements.
 - Range operating parameters may include but are not limited to – press temperature, cycle times;
production requirements may include but are not limited to – product quality, production rate.
- 3.3 Operating faults and malfunctions are identified, and corrective action is taken.
 - Range operating faults and malfunctions may include but are not limited to – out-of-specification temperatures, pressures, time, caul plate damage, overlay surface damage.
- 3.4 Preventative maintenance and cleaning requirements are applied.
- 3.5 Waste material is processed.

Outcome 4

Monitor and control the performance of an overlay press.

Performance criteria

- 4.1 Feedback information from controls and checks is monitored and interpreted, and control parameters are adjusted to maintain process requirements, plant performance, and product quality.
- 4.2 Output product is checked to ensure it meets customer requirements.
- 4.3 Production rate is maintained.
- 4.4 Product and process inspection is carried out.
- 4.5 Production, maintenance, and quality records are completed.

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 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
Revision	5	25 September 2001	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	22 October 2020	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>.

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.