

Title	Identify materials, establish operating parameters, and solve bonding problems in overlay bonding operations		
Level	5	Credits	15

Purpose	People credited with this unit standard are able to: identify materials and establish overlay press operating parameters; and solve bonding problems in overlay bonding operations.
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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.
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

Identify materials and establish overlay press operating parameters.

Performance criteria

- 1.1 Substrate type and characteristics are identified to achieve customer requirements for end product characteristics.
- Range type may include but is not limited to – medium density fibreboard, high density fibreboard, particleboard, hardboard, strandboard; characteristics may include but are not limited to – moisture content, water resistance, impact resistance, thickness, overall density, surface density, amount of permissible cup and bow, internal bond, dimensions, surface characteristics, modulus of rupture, modulus of elasticity.
- 1.2 Resin-impregnated paper is identified in terms of resin type, resin content, and characteristics to achieve customer requirements for end product characteristics.
- Range resin type may include but is not limited to – melamine, urea and phenol formaldehyde, diallylphthalate; resin content may include but is not limited to – volatile content, wear resistance, scratch resistance; characteristics may include but are not limited to – shelf life, storage requirements, impact resistance, stain resistance, thickness, density, colour.
- 1.3 Manufacturing conditions are set to match customer requirements and end product characteristics to achieve board stability.
- 1.4 Methods of achieving customer requirements for surface texture and finish are selected to meet pressing equipment and resin type.
- Range may include but are not limited to – caul plates, embosser, paper texture, multiple overlays, resin type, caul mats.
- 1.5 Press operating parameters are established to correspond to identified materials and customer requirements.
- Range may include but are not limited to – press closure time, pressure, pressure cycle, press temperature, time in press.

Outcome 2

Solve bonding problems in overlay bonding operations.

Performance criteria

- 2.1 Causes of problems and potential solutions are identified using available data.

Range problems may include but are not limited to – bowing, scratches, dents, torn paper, incorrect paper positioning on substrate, double paper, panels sticking to press, temperature variation over panel, surface defects, foreign matter, delamination, dust contamination, incorrect colour, incorrect gloss level, blowing.

2.2 Best solution is evaluated and selected.

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
Review	5	29 March 2005	31 December 2012
Rollover and Revision	6	23 February 2007	31 December 2013
Review	7	19 April 2012	N/A
Review	8	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.