



Australian Government

**Assessment Requirements for ICPPRN314
Produce complex flexographic printed
product**

Release: 1

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Modification History

| Release | Comments |
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| Release 1 | This version first released with ICP Printing and Graphic Arts Training Package Version 1.0. |

Performance Evidence

Evidence of the ability to:

- operate a reel-fed flexographic press ensuring an efficient THREE or more colour production flow that maintains product quality standards. Any production problems are anticipated and rectified with minimum downtime. The machine is correctly shut down and cleaned according to work health and safety (WHS) guidelines
- demonstrate use of control, monitoring and data entry systems
- monitor production output and make necessary adjustments to maintain print quality on a flexographic machine while producing a complex print on TWO occasions (if possible using different substrates, and if possible including at least TWO in-line processes) according to job specifications and enterprise procedures.

Note: If a specific volume or frequency is not stated, then evidence must be provided at least once.

Knowledge Evidence

To complete the unit requirements safely and effectively, the individual must:

Reel transportation and web control

- explain what causes the reel to wander
- explain what causes web to break at the unwind unit
- describe the difference between a 'flying paster' and 'zero speed' type reel-stand
- explain what print fault results from the reel being run out of centre
- identify possible faults in the unwind section that could cause a web break

Reel delivery for rewinding and sheeting

- identify WHS risks associated with rewinding and sheeting
- identify the safety feature in the delivery system that helps if the web jams up
- explain why the sheet cut-off might wander

- describe the effect of poorly adjusted nip rollers when rewinding and sheeting

Printing and drying units

- explain what happens if the plate lifts on the leading edge during a print run
- explain how a build-up of ink on the impression cylinder affects the printed product
- explain what causes ink to foam in the ink tray
- explain the effect of too much reducer in the ink
- list actions that reduce wear of the doctor blade
- explain why it is necessary that all solvents be removed from the final ink film
- describe the link between driers and set off and marking
- explain what causes UV ink to dry
- explain what causes substrate to distort
- list the effect in the chillers if the drying temperature was too low
- explain the effect of incorrect drying temperature on the finished product
- discuss why it is advisable not to eat or drink near the machine when using UV inks

In-line processes

- explain why it is necessary to frequently examine in-line components of the job
- describe how consistency of the punching unit is checked
- explain the outcome of excessive pressure on the slitters

Maintaining production process

- describe safety features within the organisation that aid in maintaining effective production
- identify who is legally responsible if removal of machine guards and/or disconnection of micro switches occurs
- describe the effect of inadequate communication within the work team
- explain ramifications if machine guards are removed and/or micro switches are disconnected on a machine
- explain what other measurements besides optimum solid ink density can be measured to assess print quality
- determine the accurate method of checking register during a production run
- describe why it is necessary to take immediate action when anticipating production problems
- explain actions to eliminate further processing of unacceptable printed product
- determine result to the substrate if relative humidity is increased in the press room
- explain the procedure to care for a newly delivered substrate to the press room
- describe why waste should be sorted and the advantage of keeping reusable waste

Client liaison

- identify what industry standards that can be applied to enhance client communication
- describe necessary procedures clients should follow to OK a printed product

Flexographic machine operating problems

- explain when it is necessary to call service personnel to correct a machine problem
- describe enterprise procedures in place to report any machine operating problems

Shutdown procedures

- explain what happens if correct shutdown procedures are not followed
- explain why it is necessary that correct shutdown procedures are conducted with fellow workers
- list advantages of proper labelling and storage of excess inks and materials
- identify why printed product needs to be clearly labelled prior to removal from the press room
- determine what further operations are required for printed reels once they are removed from the printing machine
- explain how the printed job should be stored after removal from the printing machine
- detail cleaning and washing the printing unit
- explain what WHS concerns should be observed when handling ink
- identify safety precautions for cleaning the printing cylinders
- explain why it is necessary to thoroughly clean and wash the printing unit prior to the next print run
- explain why anilox cells should be thoroughly cleaned
- describe how plates can be stored to minimise damage

Cleaning feed, transportation, delivery and in-line sections

- explain work health and safety (WHS) precautions for cleaning these sections of the machine
- explain why it is necessary to maintain a clean substrate handling section of the machine

Completing production records

- identify what completed records are used in the final analysis of the job
- explain benefits of comprehensive records when considering production of future jobs
- identify machine manuals, safety and other documentation relevant to this task, where are they kept and information contained.

Assessment Conditions

Gather evidence to demonstrate consistent performance in conditions that are safe and replicate the workplace. Noise levels, production flow, interruptions and time variances must be typical of those experienced in the printing field of work and include access to:

- special purpose tools, equipment and materials
- a range of standard inks and substrates
- a variety of stack, in-line and central impression flexographic printing machines.

Assessors must satisfy NVR/AQTF assessor requirements.

Links

Companion Volume implementation guides are found in VETNet -

<https://vetnet.education.gov.au/Pages/TrainingDocs.aspx?q=a74b7a0f-a253-47e3-8be0-5d426e24131d>