



Australian Government

ICPPRN4130 Set up for complex flexographic printing

Release: 1

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Modification History

Release	Comments
Release 1	This version first released with ICP Printing and Graphic Arts Training Package Version 4.0.

Application

This unit describes the skills and knowledge required to set up machines for non-routine flexographic printing. It includes the ability to conduct a proof run and adjust settings to ensure production speeds are attained.

It applies to individuals working as print machinists in the printing and graphic arts industry. They prepare material, set up, monitor and operate equipment and machinery, apply solutions to a defined range of problems associated with the print medium, and analyse and evaluate information from a variety of sources. They may also provide leadership and guidance to others with some limited responsibility for the output of others.

No licensing, legislative or certification requirements apply to this unit at the time of publication.

Unit Sector

Printing

Elements and Performance Criteria

ELEMENT	PERFORMANCE CRITERIA
<i>Elements describe the essential outcomes.</i>	<i>Performance criteria describe the performance needed to demonstrate achievement of the element.</i>
1. Prepare for job	1.1 Identify job requirements 1.2 Set up required printing machinery according to manufacturer specifications and work health and safety (WHS) requirements 1.3 Confirm availability of all job components
2. Set up reel transportation and delivery system on web-fed machine	2.1 Reels are checked for treatment levels, coatings and printing side, and age of product 2.2 Secure unwind reels on reel shaft

ELEMENT	PERFORMANCE CRITERIA
	2.3 Position reels on unwind stand 2.4 Web press according to non-routine job specifications 2.5 Centre and set edge guide 2.6 Set tension according to substrate requirements
3. Select and prepare inks and solvents	3.1 Select inks and solvents according to end-user requirements and confirm they meet quality requirements 3.2 Prepare inks and solvents according to manufacturer specifications 3.3 Mix and prepare colour and volume of ink to match requirements of the printing process 3.4 Record ink formula and approved colour drawdowns 3.5 Label, handle and store inks and solvents according to manufacturer specifications and hazardous liquids storage regulations
4. Set up machine for complex flexographic printing	4.1 Install and mount required flexographic plate cylinders, sleeves and mounting sheets and make register adjustments as required 4.2 Gauge and pre-set plate cylinders to impression as required 4.2 Select rollers according to individual colour and plate reproduction requirements 4.4 Select ink metering system for each unit 4.5 Set up inking system and set roller nips and blades 4.6 Adjust viscosities according to job specifications 4.7 Select air volume and drier temperature curing units according to requirements for inks, substrate and solvents 4.8 Air volume is adjusted between colours to maximise drying and minimise air overspill
5. Set up in-line units for basic process(es)	5.1 Set up minor in-line units are set up for basic process(es) 5.2 Provide assistance in set-up of major in-line units
6. Conduct proof run	6.1 Set print impressions to minimum kiss impression 6.2 Set web tensions for unwind, between stations and rewind 6.3 Confirm drying meets substrate requirements 6.4 Adjust viscosities according to colour requirement at proof speed and check against colour matching system 6.5 Inspect and test proof as required according to enterprise

ELEMENT	PERFORMANCE CRITERIA
	procedures 6.6 Seek client approval and authority prior to the production run as required
7. Readjust settings to production speed	7.1 Interpret production speed print results and make adjustments to press, ink and substrate settings as required 7.2 Splice web at production speed and obtain samples for quality inspections according to enterprise procedures 7.3 Document press setting and store samples

Foundation Skills

This section describes language, literacy, numeracy and employment skills incorporated in the performance criteria that are required for competent performance.

Skill	Description
Writing	Completes records according to workplace requirements
Numeracy	Interprets and analyses a range of mathematical information used in familiar and routine tasks
Self-management	- Complies with enterprise procedures relevant to own role - Implements actions according to instructions, making adjustments if necessary
Teamwork	- Collaborates with others to complete tasks according to requirements - Follows accepted communication practices and protocols when seeking approval
Planning and organising	Takes responsibility for planning and organising own workload using analytical processes to decide on a course of action, and assembles resources required
Problem solving	Identifies and takes responsibility for addressing predictable, and some less predictable, problems in familiar work contexts
Technology	Reads data from electronic monitoring and control systems

Unit Mapping Information

Supersedes and is equivalent to ICPPRN413 Set up for complex flexographic printing.

Links

Companion Volume Implementation Guide is found on VETNet -

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