



Australian Government

ICPPRN513 Set up for specialised 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 1.0.

Application

This unit describes the skills and knowledge required to set up machines for specialised flexographic printing.

It applies to individuals required to set up for specialised colour jobs and who have a good knowledge of substrates and press settings.

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. Confirm non-routine job specifications	1.1 Job requirements are read and interpreted from job documentation or production control system 1.2 Set up is planned and carried out correctly in minimum time, with minimum wastage 1.3 Availability of all job related components is checked 1.4 Proofed job is checked for conformance with job specifications
2. Select and prepare inks and solvents for non-routine job	2.1 Inks and solvents are selected according to job specifications and end-user requirements 2.2 Quality and suitability of inks and solvents are checked and appropriate action is taken 2.3 Inks and solvents are prepared according to work health and

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	<p>safety (WHS) requirements, and manufacturer's/supplier's instructions with suitable precautions to minimise waste</p> <p>2.4 Correct colour and weight/volume of ink are mixed and viscosities checked and modified according to press requirements and non-routine job specifications</p> <p>2.5 Ink formula and approved colour draw downs are appropriately recorded</p> <p>2.6 Inks and solvents are appropriately labelled, handled and stored according to manufacturer's/supplier's instructions and relevant hazardous liquids storage regulations</p>
3. Set up machine for specialised flexographic printing	<p>3.1 Flexographic plate cylinders are installed and register adjustments centred</p> <p>OR</p> <p>3.2 Sleeves are installed in press and register adjustments made</p> <p>OR</p> <p>3.3 Plate mounting sheets are mounted on cylinders in press, and register adjustments made</p> <p>3.4 Plate cylinders are gauged up or pre-set to impression</p> <p>3.5 Anilox rollers are selected to suit individual colour and plate reproduction requirements for each unit</p> <p>3.6 Appropriate ink metering system is selected for each unit</p> <p>3.7 Inking system is set up and roller nips/blades are set correctly</p> <p>3.8 Ink circulation is maintained at correct level</p> <p>3.9 Viscosities are adjusted according to job specifications</p> <p>3.10 Air volume and drier temperatures are selected to suit inks, substrate, solvents, and according to job specifications</p> <p>3.11 Air volume is adjusted between colours to maximise drying and minimise air overspill</p>
4. Conduct proof run	<p>4.1 Material to be used for proof is organised correctly</p> <p>4.2 Press is set up and operated according to WHS guidelines</p> <p>4.3 Print impressions are set to minimum kiss impression</p> <p>4.4 Web tensions are correctly set at unwind, between stations and rewind</p> <p>4.5 Print is checked for register</p> <p>4.6 Drying is checked as sufficient to key ink to the substrate</p>

ELEMENT	PERFORMANCE CRITERIA
	4.7 Viscosities are adjusted to obtain the correct colour at proof speed
5. Organise proof inspection and/or testing	5.1 Proof is visually inspected and/or tested or laboratory testing is organised according to enterprise procedures 5.2 Production does not commence without client approval or authority where appropriate
6. Troubleshoot machinery and material problems	6.1 Corrective or preventive action is recommended and implemented where appropriate 6.2 Changes are communicated to relevant personnel in a logical and easily understood manner 6.3 Changes are monitored to confirm improvement to production efficiency

Foundation Skills

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

Skill	Performance Criteria	Description
Reading	1.1, 1.4, 2.1-2.4, 2.6, 3.9, 3.10	<ul style="list-style-type: none"> Recognises and interprets text to establish job requirements from information contained within relevant instructions, procedures and specifications
Writing	2.5, 2.6, 5.2	<ul style="list-style-type: none"> Completes workplace records and labels accurately and according to requirements Considers context and audience when composing texts
Oral Communication	5.2, 6.2	<ul style="list-style-type: none"> Participates effectively in spoken interactions using appropriate vocabulary, questioning and listening techniques to gain approvals or provide information
Numeracy	2.4, 3.8-3.11	<ul style="list-style-type: none"> Interprets and analyses a range of mathematical information used in familiar and routine tasks
Navigate the world of work	2.3, 2.6, 4.2, 5.1, 5.2	<ul style="list-style-type: none"> Complies with legislative requirements and follows organisational policies and procedures relevant to own role Recognises boundaries of own role responsibilities
Interact with others	5.2, 6.2	<ul style="list-style-type: none"> Collaborates with others to complete tasks according to requirements Follows accepted communication practices and

		protocols when seeking approval
Get the work done	1.2-1.4, 2.1-2.6, 3.1-3.11, 4.1-4.7, 5.1, 6.1, 6.3	<ul style="list-style-type: none"> Plans, evaluates, identifies and assembles resources required to complete tasks Determines priorities and sequences steps involved in complex tasks Takes responsibility for addressing predictable and unpredictable problems in familiar work contexts Evaluates effectiveness of decisions to identify opportunities for improvement Reads data from electronic monitoring and control systems

Unit Mapping Information

Code and title current version	Code and title previous version	Comments	Equivalence status
ICPPRN513 Set up for specialised flexographic printing	ICPPR513A Set up for specialised flexographic printing	Updated to meet Standards for Training Packages	Equivalent unit

Links

Companion Volume implementation guides are found in VETNet -

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