



Australian Government

Department of Education, Employment and Workplace Relations

PMBPROD394B Produce composites using resin transfer moulding

Revision Number: 1

PMBPROD394B Produce composites using resin transfer moulding

Modification History

Not applicable.

Unit Descriptor

Unit descriptor

This competency covers the operation and adjustment of resin transfer moulding processes and the solving of problems.

Application of the Unit

Application of this unit

This competency is typically performed by advanced operators applying knowledge of materials, product purpose and processes to the operation of resin transfer moulding equipment for the production of composites. It also requires using a range of well developed skills requiring some discretion and judgment to recognize and resolve a range of problems.

The operator will:

- start up resin transfer moulding equipment
- check materials for conformity to job requirements
- make appropriate adjustments to correct materials, equipment or process variations
- solve resin transfer moulding equipment, material and process problems, seeking guidance where necessary or appropriate
-

Licensing/Regulatory Information

Not applicable.

Pre-Requisites

Prerequisites

This unit has the prerequisite of *PMBPROD294B Operate resin transfer moulding equipment*.

Employability Skills Information

Employability Skills

This unit contains employability skills.

Elements and Performance Criteria Pre-Content

ELEMENT	PERFORMANCE CRITERIA
Elements describe the essential outcomes of a unit of competency	Performance criteria describe the required performance needed to demonstrate achievement of the element. Assessment of performance is to be consistent with the evidence guide.

Elements and Performance Criteria

ELEMENT ELEMENT	PERFORMANCE CRITERIA Performance criteria describe the required performance needed to demonstrate achievement of the element. Assessment of performance is to be consistent with the evidence guide.
1. Plan own work requirements.	1.1 Identify the most appropriate equipment to be used for production and upstream and downstream operations from production plan or request. 1.2 Identify and check materials required including additives. 1.3 Implement measures to control identified hazards in line with procedures and duty of care. 1.4 Identify requirements for materials, quality, production and equipment checks.
2. Start up resin transfer moulding process to procedures.	2.1 Identify process settings required for the product. 2.2 Adjust control panel (eg, cycle time, heating, cooling) as required for factors such as temperature, material. 2.3 Check materials, resins, fibres, cores are correct. 2.4 Take appropriate action for non-conforming materials. 2.5 Set up date, batch and materials markings to specifications, as required. 2.6 Complete pre-start checks. 2.7 Start up process.
3. Operate and make adjustments as required to the resin transfer moulding process to procedures.	3.1 Operate resin transfer moulding process, noting key variables. 3.2 Monitor controls/displays/terminals for production/process data. 3.3 Monitor product/process quality, thickness and integrity to procedures. 3.4 Take samples as required and identify product out of specification. 3.5 Make adjustments to remedy faults and nonconformity to standard, as required. 3.6 Establish a stable resin transfer moulding process. 3.7 Adjust process to minimise scrap and waste. 3.8 Clean, adjust and lubricate equipment as required.
4. Shut down machine to procedures.	4.1 Determine type of shutdown. 4.2 Select appropriate purging method.

ELEMENT ELEMENT	PERFORMANCE CRITERIA Performance criteria describe the required performance needed to demonstrate achievement of the element. Assessment of performance is to be consistent with the evidence guide.
	4.3 Purge efficiently and adequately as required. 4.4 Leave machine in appropriate condition and with appropriate locks, tags or notices. 4.5 Complete relevant documentation. 4.6 Ensure area is clean and clear after the shutdown, in readiness for the next start-up.
5. Anticipate and solve problems.	5.1 Recognise a problem or anticipate potential problems. 5.2 Determine problems needing priority action. 5.3 Refer problems outside area of responsibility to appropriate person, with possible causes. 5.4 Seek information and assistance as required to solve problems. 5.5 Solve problems within area of responsibility. 5.6 Follow through items initiated until final resolution has occurred.

Required Skills and Knowledge

This describes the essential skills and knowledge and their level required for this unit.

Application of knowledge of the materials, equipment and process sufficient to recognise material and equipment conditions which may lead to out of specification production.

Knowledge of organization procedures, quality and safety requirements at each production stage and relevant regulatory requirements; and the ability to implement them within appropriate time constraints and work standards.

Application of the knowledge of managing risks using the hierarchy of controls applied to the resin transfer moulding process. Application of approved hazard control and safety procedures and the use of PPE in relation to handling materials, equipment operation and cleanup.

Knowledge as a basis for problem solving process and material problems, including:

- characteristics of materials and behaviour in relation to heat, pressure, flow rate and time
- function and operating principles of resin transfer moulding equipment, machine components and ancillary equipment, including the mechanical, hydraulic, pneumatic, electrical and electronic principles which affect machine operations
- impact of machine speed, temperature, pressure, time during cycles on product quality and production output
- impact of variations in raw material and equipment operation in relation to the final product
- changes to materials at various stages of production
- waste management and significance of non-conforming materials
- polymer properties and their interactions with process conditions
- relationships between polymer properties and process conditions
- changes to polymer properties to better suit process requirements
- product problems related to polymer properties
- product problems related to process conditions
- adjustments to process conditions to meet polymer and product requirements.

Competence also includes the ability to :

- plan own work, including predicting consequences and identifying improvements
- maintain output and product quality using appropriate instruments, controls, test information and readings
- identify and describe own role and role of others involved directly in the process
- identify factors which may affect product quality or production output and appropriate remedies
- identify when assistance is required to solve problems.

Knowledge and ability to identify and take appropriate action on the range of possible causes of product faults.

Language, literacy and numeracy requirements

This unit requires the ability to read and interpret typical product specifications, job sheets, material labels, and machine control panels such as those displaying PLC information, if fitted.

Writing is required to the level of completing workplace forms, quality assurance records and production reports.

Numeracy is required to the level of determining required weights/volumes of materials in a resin mix for different circumstances (say using a data sheet), number of layers of impregnated matrix required to yield the required product laminate thickness, and similar activities.

Evidence Guide

The Evidence Guide provides advice on assessment and must be read in conjunction with the performance criteria, required skills and knowledge, the range statement and the assessment guidelines for this training package.

Overview of assessment

A holistic approach should be taken to the assessment.

Assessors must be satisfied that the person can consistently perform the unit as a whole, as defined by the Elements, Performance Criteria and skills and knowledge.

Where the assessee does not currently possess evidence of competency in *PMBPROD294B Operate resin transfer moulding equipment*, it may be co-assessed with this unit.

Critical aspects for assessment and evidence required to demonstrate competency in this unit

It is essential that competence is demonstrated in the knowledge and skills defined in this unit. These may include the ability to:

- identify critical materials properties and composites moulding process characteristics in relation to the process requirements and the end product
- identify and take appropriate action on problems and potential problems.

Consistent performance should be demonstrated. For example, look to see that:

- the process runs smoothly , with the minimum need for intervention
- all safety procedures are always followed.

Assessment method and context

Assessment will occur on an industrial resin transfer moulding equipment and will be undertaken in a work-like environment.

Competence in this unit may be assessed:

- using appropriate resin transfer moulding equipment requiring demonstration of start-up, operation and shutdown procedures
- in a situation allowing for the generation of evidence of the ability to recognise, anticipate and respond to problems
 - by using a suitable simulation and/or a range of case studies/scenarios
 - through a combination of these techniques.

In all cases it is expected that practical assessment will be combined with targeted questioning to assess the underpinning knowledge and theoretical assessment will be combined with appropriate practical/simulation or similar assessment. Assessors need to be aware of any cultural issues that may affect responses to questions.

Assessment processes and techniques must be culturally appropriate and appropriate to the oracy, language and literacy capacity of the assessee and the work being performed.

Specific resources for assessment

This section should be read in conjunction with the Range Statement for this unit of competency. Resources required include suitable access to an operating plant or equipment that allows for appropriate and realistic simulation. A bank of case studies/scenarios and questions will also be required to the extent that they form part of the assessment method. Questioning may take place either in the workplace, or in an adjacent, quiet facility such as an office or lunchroom. No other special resources are required. Access must be provided to appropriate learning and/or assessment support when required. Where applicable, physical resources should include equipment modified for people with disabilities.

Range Statement

RANGE STATEMENT

The range statement relates to the unit of competency as a whole. It allows for different work environments and situations that may affect performance. Add any essential operating conditions that may be present with training and assessment depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts. Where reference is made to industry codes of practice and/or Australian/international standards, the latest version must be used.

Context

This competency applies to all resin transfer moulding within the plastics and rubber industries. It includes the operation of all relevant additional equipment integral to the composites forming process.

Procedures

All operations are performed in accordance with procedures.

Procedures include all relevant workplace procedures, work instructions, temporary instructions and relevant industry and government codes and standards.

Tools and equipment

This competency includes use of equipment and tools such as:

- resin transfer moulding equipment such as moulds, resin pumps and fittings
- components of resin transfer moulding equipment such as closures, couplings, hoses, breathers, bleeders
- controller, such as PLC if fitted
- relevant personal protective equipment (PPE)
- hand tools used in the production process
- material loading equipment used for loading of raw materials.

Hazards

Typical hazards include:

- hazardous vapours and materials
- fibres, airborne and handled
- humidity, air temperatures, radiant heat, hot moulds
- stationary and moving machinery, parts and components
- manual handling hazards.

Problems

'Anticipate and solve problems' means resolve a wide range of routine and non-routine problems, using product and process knowledge to develop solutions to problems which do not have a known solution/s recorded in the procedures.

Typical process and product problems may include:

- resin, over or undersupplied to mould
- release agents performance
- contamination
- temperature variations, affecting resin cure-rate
- blemishes
- missing detail
- warped moulds or dies
- worn or damaged mould parts or fittings
- variations in materials and/or contamination of materials
- processing problems.

Appropriate action for problems outside of area of responsibility may be reporting to an appropriate person.

Appropriate action for problems within of area of responsibility includes asking questions and seeking assistance from appropriate persons/sources.

Variables

Key variables to be monitored include:

- operating temperatures
- cycle time
- output rate
- surface finish and condition
- product weight
- product integrity and general conformance to specification/sample.
-

Unit Sector(s)

Not applicable.