



Australian Government

FWPSAW3219 Replace stellite tips

Release: 1

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Modification History

Release	Comment
1	Replaces equivalent unit FPISAW3219B Replace stellite tips, which was first released with FPI11 Forest and Forest Products Training Package Version 2.2. This is the first release of this unit in the new standards format.

Application

This unit of competency describes the outcomes required to remove worn stellite tips from saw blades and to weld, anneal, clean and prepare replacement tips for grinding and return to service. Work is completed in a forest products factory setting.

The unit applies to Sawdoctor, Saw Repairer.

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

Pre-requisite Unit

Nil

Unit Sector

Sawmilling and Processing

Elements and Performance Criteria

<i>Elements describe the essential outcomes.</i>	<i>Performance criteria describe the performance needed to demonstrate achievement of the element. Where bold italicised text is used, further information is detailed in the range of conditions.</i>
1. Prepare for replacement	1.1 Review work order and where required check with appropriate personnel. 1.2 Select appropriate repair, maintenance and personal protective equipment and check operational effectiveness in line with manufacturer's recommendations. 1.3 Plan replacement process in line with work order.
2. Prepare tips	2.1 Follow organisational safety procedures throughout all maintenance

	and repair processes. 2.2 Clean saw of foreign matter and check for defects. 2.3 Measure tips requiring replacement and compare, check and mark against tolerances. 2.4 Clean saw and tip surfaces to provide good contact surface for brazing or silver soldering.
3. Replace tips	3.1 Set up saw in brazing jig in line with manufacturer's instructions. 3.2 Select brazing material and suitable technique for application and heat control. 3.3 Check tolerances, select replacement tip to meet application specifications and weld into position. 3.4 Trial weld one tip and adjust to confirm weld pressure, current temperature and annealing settings against specifications. 3.5 Segregate and dispose of tips with sub-standard welds in line with environmental protection practices. 3.6 Set manual or automatic feeds in line with number of tips to be welded. 3.7 Complete tip replacement regularly, checking and adjusting annealing process and temperatures to ensure specified range. 3.8 Repair damaged tips and dispose of irreparable tips in line with environmental protection requirements. 3.9 Remove surplus brazing material from saw surfaces and check tip tolerances against specifications. 3.10 Identify routine processing and equipment faults and resolve or report to appropriate personnel.

Foundation Skills

This section describes those core and employment skills that are essential to performance and are not explicit in the performance criteria.

Numeracy skills to:	- complete routine calculations to: - measure amounts of brazing materials - select temperatures for annealing process - estimate tolerances.
Oral communication skills to:	- ask open and close probe questions and actively listen to clarify contents of work order - make accurate verbal reports on processing and equipment faults.

Reading skills to:	• interpret: • workplace health and safety procedures • work orders • manufacturers' maintenance recommendations.
Writing skills to:	• complete accurate basic records for processing and equipment faults.
Planning and organising skills to:	• efficiently and logically sequence stages of preparation and repair work using work order to guide activities.
Problem-solving skills to:	• assess tip condition and rectify faults through correct welding process • identify and dispose of tips with sub-standard welds • recognise faulty equipment and resolve by reporting or rectifying.
Technology skills to:	• select and use appropriate repair, maintenance and personal protective equipment for welding stellite tips • efficiently and safely replace stellite tips.

Range of Conditions

Not Applicable

Unit Mapping Information

FPISAW3219B Replace stellite tips

Links

Companion Volume implementation guides are found in VETNet -

<https://vetnet.education.gov.au/Pages/TrainingDocs.aspx?q=0d96fe23-5747-4c01-9d6f-3509f8d3d47>