



Australian Government

ICPCBF307 Produce double-faced web

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 safely operate, adjust, monitor and shut down equipment and machinery used to produce double-faced web for corrugated board manufacture.

It applies to performing tasks such as monitoring machinery operations, dealing with routine problems and reporting production and machinery faults.

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

Unit Sector

Converting, Binding and Finishing

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. Inspect and adjust quality	1.1 Inspection and/or testing of sample is organised 1.2 Sample is visually inspected and/or tested according to enterprise procedures 1.3 Results are interpreted to determine adjustment requirements 1.4 Adjustments are carried out according to product and machine specifications
2. Maintain operation of reel transportation system	2.1 Reel stand is monitored and adjusted to ensure efficient continuous operation 2.2 Web control system is monitored and adjusted to ensure correct tension and accurate continuous positioning of the web and

ELEMENT	PERFORMANCE CRITERIA
	efficient operation 2.3 Substrate is added to the process according to job specifications
3. Maintain double-facing process	3.1 Starch delivery system is monitored and adjusted to suit corrugating process and according to job specifications 3.2 Heat delivery system is monitored and adjusted to suit corrugating process and according to job specifications 3.3 Speed of machine is optimised according to running conditions 3.4 Appropriate quantity of paper is run
4. Maintain in-line process(es)	4.1 Waxing units are monitored and adjusted to suit corrugating process and according to job specifications 4.2 Coating units are monitored and adjusted to suit corrugating process and according to job specifications 4.3 Tape dispensing units are monitored and adjusted to suit corrugating process and according to job specifications 4.4 Slitters are monitored and adjusted according to job specifications 4.5 Cut-off knife is monitored and adjusted according to job specifications
5. Synchronise machine operation	5.1 Machine downtime is minimised during flute, grade or deckle changes 5.2 Quality of board is maintained according to enterprise procedures or client acceptance standard 5.3 Machine speed is optimised and waste minimised
6. Maintain production process	6.1 Production process is operated in association with fellow workers and according to enterprise procedures and planned daily schedule 6.2 Production is maintained according to Work Health and Safety (WHS) requirements, manufacturer's specifications and enterprise procedures 6.3 Manual and/or automatic control is used according to job specifications 6.4 Performance is monitored and verified using the process control system according to enterprise procedures 6.5 Starch performance is monitored and adjusted throughout production run

ELEMENT	PERFORMANCE CRITERIA
	6.6 Production difficulties are anticipated and preventive action is taken to prevent occurrence by timely intervention 6.7 Process adjustments to eliminate problems are reported according to enterprise procedures 6.8 Faulty performance of equipment is identified and reported according to enterprise procedures 6.9 Waste is sorted according to enterprise procedures 6.10 Quality checks of product are undertaken on a regular basis and adjustments made as required
7. Identify and rectify problems	7.1 Problems in corrugator operation are identified and reported according to enterprise procedures 7.2 Adjustments or corrections are carried out according to specified procedures and are consistent with operator's skill level 7.3 Corrugator operation is checked to ensure correct operation
8. Conduct shutdown of production process	8.1 Correct shutdown sequence is followed according to manufacturer's specifications and enterprise procedures 8.2 Shutdown is conducted in association with fellow workers and in compliance with WHS requirements 8.3 Solid and liquid waste is removed from operating area and recycled or disposed of, where required, according to regulatory requirements and enterprise procedures 8.4 All product is removed from operating area 8.5 Machine faults requiring repair are identified and reported to designated person according to enterprise procedures 8.6 Repair/adjustment is verified prior to resumption of operations
9. Clean and wash up corrugator at end of run	9.1 In-line wax, coating and tape dispensing units are cleaned ready for next run 9.2 Starch delivery system is washed ready for next run, and liquid waste is disposed of according to regulatory requirements and enterprise procedures 9.3 Reel feed and transportation systems are disengaged and cleaned ready for next run 9.4 Production records or other documentation are accurately completed where required by enterprise procedures

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	1.4, 2.3, 3.1, 3.2, 4.1-4.5, 6.2, 6.3, 8.1	Recognises and evaluates text to establish job requirements from information contained in procedures or systems
Writing	6.7, 6.8, 8.5, 9.4	Uses clear language to record problems and document other information according to enterprise requirements
Oral Communication	6.1, 6.7, 6.8, 7.1, 8.2, 8.5	- Speaks clearly using appropriate vocabulary, tone and pace to report faults and discrepancies - Participates effectively in spoken interactions to confirm or clarify requirements
Navigate the world of work	1.2, 5.2, 6.1, 6.2, 6.4, 6.7-6.9, 7.1, 7.2, 8.1, 8.3, 8.5, 9.1-9.4	Recognises and follows all procedures for operation and maintenance of equipment, incorporating regulatory requirements, enterprise procedures or client standards
Interact with others	6.1, 6.7, 6.8, 7.1, 8.2, 8.5	- Cooperates with others as part of familiar routine activities, and contributes to specific activities requiring joint responsibility and accountability - Understands what to communicate, with whom and how, in routine work situations
Get the work done	1.1-1.4, 2.1-2.3, 3.1-3.4, 4.1-4.5, 5.1-5.3, 6.2-6.6, 6.9, 6.10, 7.1-7.3, 8.1-8.6, 9.4	- Determines priorities and sequences steps involved in clearly defined, familiar tasks - Plans, identifies and assembles resources required to complete tasks - Recognises and anticipates an increasing range of familiar problems, their symptoms and causes, actively looking for early warning signs and implementing contingency plans - Follows routine procedures for using digital technology by reading data from electronic monitoring and control systems

Unit Mapping Information

Code and title current version	Code and title previous version	Comments	Equivalence status

Code and title current version	Code and title previous version	Comments	Equivalence status
ICPCBF307 Produce double-faced web	ICPCF3107C Produce double-faced web	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>

Assessment Requirements for ICPCBF307 Produce double-faced web

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Performance Evidence

Evidence of the ability to:

- correctly and safely perform at least TWO runs on the double backer machine to produce TWO different types/classes of product, according to manufacturer's and job specifications and enterprise procedures
- monitor operations and adjust equipment and machinery as required to ensure production quality
- accurately complete relevant enterprise production records/reports when producing double-faced web.

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:

- identify significant work health and safety risks to workers operating machinery and undertaking this activity
- identify measures employed to prevent injury and/or illness in the case of the risks identified previously
- identify principle support systems on line to the corrugating machine
- explain how support systems are used to effectively control and monitor the corrugator
- identify sections of the double backer with the highest potential for operational problems during the run
- describe product faults commonly found during production runs, and how they can be corrected
- describe how settings for the following factors are monitored and adjusted during the run: in-feed, web alignment control, adhesive application, double backer, steam delivery, heating of web and speed

- identify product factors monitored visually/manually by staff operating end stages of the corrugator machine
- outline adjustments to make in response to problems found by staff operating end stages of the corrugator machine
- identify functions that must be attended to during wash-up and shutdown of the machine if it will be idle for two or more days
- identify key information contained in machine manuals, safety and other documentation relevant to producing double-faced web, and where they are kept.

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 Converting, Binding and Finishing field of work and include access to and use of special purpose tools, equipment (including in-line double back corrugating equipment) and materials used to produce double-faced web.

Assessors must satisfy NVR/AQTF assessor requirements.

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