



Australian Government

Assessment Requirements for ICPCBF410 Set up machine for complex carton folding and gluing

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.

Performance Evidence

Evidence of the ability to:

- set up at least THREE crash lock, six-corner and specialty work carton jobs using different carton sizes and weights, which include use of multiple gluing units, according to manufacturer's and job specifications and enterprise procedures.

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:

Documentation

- identify information concerning folding requirements found in the job documentation or production control system, and how it is interpreted to ensure smooth workflow throughout the factory
- list factors to consider when planning a folding sample

Sheet transportation and delivery systems

- explain work health and safety (WHS) factors for setting folder transportation and delivery systems
- identify areas of the carton blank transportation system to monitor to ensure trouble-free operation
- list parts of the carton blank pick-up system to adjust to ensure accurate and continuous sheet handling
- identify areas of the delivery system to observe to maintain neat delivery of finished work and to prevent damage to the finished product
- explain checks required when substrate is removed from the machine

Machine setting for complex folding and gluing

- explain WHS factors for setting and/or adjusting the folding unit
- identify the largest/smallest size carton blank that can be processed on this machine
- describe ways the machine can be adapted to facilitate smaller/larger stock
- identify accuracy of a carton blank entering folding rollers
- describe causes of scratching/scuffing of substrate during transportation
- identify machine speed variations
- describe problems that can be expected if:
 - the machine is running too fast
 - the machine rollers are set too loose
 - there is too much roller pressure
 - the delivery system is not set correctly
- identify how correct roller pressure is determined for a given job
- describe how roller pressures checks are made
- describe required adjustments if the carton blank is out-of-square
- list reasons for the sheet being out-of-square
- describe adjustment required to eliminate smudging/scuffing on carton blanks
- describe adjustment required if the sheet will not leave the folding unit
- In-line processes
- list necessary steps to set up gluing units
- describe how a neat and clean gluing job is achieved
- identify adhesive used in the gluing unit and how length of the glue line is adjusted

Checking and adjustment

- identify causes of out-of-square folding and how they are rectified
- list segments of quality assurance inspected at sample run completion
- identify areas of the machine to adjust if carton blank is creasing
- identify areas of the machine to adjust if carton blank is not entering the machine
- explain items to check against client sample

Information sources

- identify machine manuals and safety documentation relevant to this task, where they are kept, and the information included in them.

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:

- Royal 40, Bobst Media or Bobst Domino machine, which includes multiple gluing units
- relevant materials and equipment.

Assessors must satisfy NVR/AQTF assessor requirements.

Links

Companion Volume implementation guides are found in VETNet -

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