



Australian Government

ICPPRN2140 Produce basic flexographic printed product

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 4.0.

Application

This unit describes the skills and knowledge required to safely operate either a reel- or sheet-fed flexographic print, ensuring efficient production flow and quality standards.

It applies to individuals working in the printing and graphic arts industry who perform a range of mainly routine tasks, work under direct supervision and use limited practical skills and knowledge in a defined context.

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. Maintain operation of delivery systems	1.1 Monitor and adjust delivery systems according to work health and safety (WHS) requirements 1.2 Add substrate to and remove substrate from the process according to job specifications
2. Maintain basic flexographic printing process	2.1 Check and adjust flexographic plate and plate cylinder or sleeve condition according to proof quality requirements 2.2 Check flexographic impression roller condition 2.3 Review and adjust flexographic inking system, doctor blade and drying systems 2.4 Monitor and adjust basic in-line process(es)

ELEMENT	PERFORMANCE CRITERIA
3. Maintain routine production process	3.1 Use machine controls as required 3.2 Review and verify performance using the process control system 3.3 Monitor and adjust ink performance, colour, register and position 3.4 Report process adjustments to eliminate problems according to enterprise procedures
4. Identify and rectify faults	4.1 Identify and report problems in machine operation according to enterprise procedures 4.2 Carry out adjustments or corrections according to specified procedures, and within scope of own role 4.3 Verify repairs and adjustments as required prior to resumption of operations
5. Conduct shutdown of production process	6.1 Follow shutdown sequence according to manufacturer specifications and enterprise procedures 6.2 Label and store unused ink and embellishment equipment according to manufacturer specifications and enterprise procedures 6.3 Remove solid and liquid waste from operating area and recycle and dispose of, as required, according to regulatory requirements and enterprise procedures 6.4 Clean and disengage all required parts of machinery used in printing process according to manufacturer specifications and enterprise procedures 6.5 Complete required production records and enterprise documentation

Foundation Skills

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

Skill	Description
Writing	Enters routine data associated with production processes and enterprise procedures
Numeracy	Interprets and analyses a range of mathematical information used in familiar and routine tasks

Self-management	- Identifies and follows explicit and implicit protocols and meets expectations associated with own role - Identifies and follows all procedures for cleaning and maintenance of equipment incorporating regulatory requirements and enterprise procedures
Teamwork	- Cooperates with others as part of familiar routine activities, and contributes to specific activities requiring joint responsibility and accountability - Identifies what to communicate, with whom and how, in routine work situations
Planning and organising	Determines priorities and sequences steps involved in clearly defined, familiar tasks
Problem solving	Identifies and anticipates an increasing range of familiar problems, their symptoms and causes, actively looking for early warning signs and implementing contingency plans
Technology	Follows routine procedures for using digital technology by reading data from electronic monitoring and control systems

Range of Conditions

This section specifies different work environments and conditions that may affect performance. Essential operating conditions that may be present (depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts) are included.

Delivery systems must include either:	- reel or - sheet
Monitoring and adjusting must include either:	- reel stand and rewind sections - web control system - sheeting action - set off / marking prevention system or - feeder and delivery system - sheet pick-up and transportation system - transfer system

Unit Mapping Information

Supersedes and is equivalent to ICPPRN214 Produce basic flexographic printed product.

Links

Companion Volume Implementation Guide is found on VETNet -

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

Assessment Requirements for ICPPRN2140 Produce basic flexographic printed product

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Performance Evidence

The candidate must demonstrate the ability to complete the tasks outlined in the elements, performance criteria and foundation skills of this unit, including evidence of the ability to:

- produce two basic flexographic printing products.

In the course of the above the candidate must:

- operate production process in association with fellow workers and according to enterprise procedures and planned daily schedule
- follow work health and safety (WHS) requirements, manufacturer specifications and enterprise procedures
- anticipate production difficulties and take preventive action to prevent occurrence.

Knowledge Evidence

The candidate must be able to demonstrate knowledge to complete the tasks outlined in the elements, performance criteria and foundation skills of this unit, including knowledge of:

- WHS risks and requirements for:
 - loading and handling heavy reels
 - operating sheet transportation and delivery systems
 - maintaining and examining the in-line components of the press
 - handling solvents and solutions
 - cleaning the inking system and its components
- transportation and delivery processes
- reel system process for determining substrate printing side
- effect on the print of excessive tension on the unwinding reel
- web splicing process and impact of incorrect splicing
- purpose of fanning sheets before loading into press
- sheet system setting process, the checks made during the print run, and adjustable components to ensure delivery as required
- effect of excessive suction on slow-down wheels

- required frequency of product quality assessments, and the action taken if print fills in when printing
- effect of dirt under the doctor blade on the print and the motion of doctor blade oscillation
- steps taken if ink in duct is foaming
- signs of wear in the plate image area
- frequency of examinations of in-line components of the job
- quality monitoring process
- quality criteria for printed material and the precautions required to ensure the rewound product is consistent and meets criteria
- marking of product deemed unacceptable by the operator
- required consultation process when a print problem cannot be fixed by the operator
- methods used to ensure required storage of plates following printing
- machine parts requiring thorough cleaning following the print run and components to be inspected for wear following the print run
- required records for following or repeat prints
- manufacturer manuals, enterprise procedures and work health and safety documentation, including their location and purpose.

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 printing field of work and include access to:

- special purpose tools, equipment and materials
- a reel or sheet-fed flexographic press.

Assessors of this unit must satisfy the requirements for assessors in applicable vocational education and training legislation, frameworks and/or standards.

Links

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