



Australian Government

ICPPRN214 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 1.0.

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 Delivery systems are monitored and adjusted to ensure efficient and continuous operation and ensure no damage to finished product 1.2 Substrate is added to and removed from process according to job instructions
2. Maintain basic flexographic printing process	2.1 Flexographic plate and plate cylinder or sleeve condition is monitored and adjusted to ensure quality of printed product meets the approved proof standard 2.2 Flexographic impression roller condition is monitored to ensure quality of printed product meets the approved proof standard

ELEMENT	PERFORMANCE CRITERIA
	2.3 Flexographic inking system and doctor blade are monitored and adjusted to ensure quality of printed product meets the approved proof standard 2.4 Drying systems are monitored and adjusted to ensure quality of printed product meets the approved proof standard 2.5 Basic in-line printing/converting/binding/finishing process(es) are monitored and adjusted to ensure quality of printed product meets the approved proof standard
3. Maintain routine production process	3.1 Production process is operated in association with fellow workers and according to enterprise procedures and planned daily schedule 3.2 Production is maintained according to work health and safety (WHS) requirements, manufacturer's specifications and enterprise procedures 3.3 Manual and/or automatic control is used according to job specifications 3.4 Performance is monitored and verified using the process control system according to enterprise procedures 3.5 Ink performance, colour, register and position of print are monitored and adjusted throughout production run 3.6 Production difficulties are anticipated and preventive action is taken to prevent occurrence by timely intervention 3.7 Faulty performance of equipment is identified and reported according to enterprise procedures 3.8 Waste is sorted according to enterprise procedures
4. Identify and rectify faults	4.1 Problem in flexographic machine operation is identified and reported according to enterprise procedures 4.2 Adjustments or corrections are carried out according to specified procedures and consistent with operator's skill level 4.3 Flexographic machine operation is checked to ensure efficient operation 4.4 Machine faults requiring repair are identified and reported to designated person according to enterprise procedures
5. Conduct shutdown of production process	5.1 Correct shutdown sequence is followed according to manufacturer's specifications and enterprise procedures 5.2 Shutdown is conducted in association with fellow workers and in compliance with WHS requirements

ELEMENT	PERFORMANCE CRITERIA
	5.3 Reels and cores are removed from press if web-fed 5.4 Unused ink is drained back into containers and correctly labelled and stored according to manufacturer's/supplier's specifications and enterprise procedures 5.5 Solid and liquid waste is removed from operating area and recycled or disposed of, where required, according to regulatory requirements and enterprise procedures 5.6 Product is removed from operating area
6. Clean and wash printing machine	6.1 Cylinders or sleeves, plate and roller surfaces are cleaned ready for next run 6.2 Inking rollers and doctor blades or chamber blade systems are cleaned with correct solvents according to WHS guidelines 6.3 Ink pumps, tanks and hoses are cleaned correctly 6.4 Impression rollers/central impression and press rollers are cleaned 6.5 In-line printing/converting/binding/finishing units are cleaned ready for next run 6.6 Reel or sheet-feed transportation and delivery systems are disengaged and cleaned ready for next run 6.7 Press is lubricated and protected according to duration of shutdown 6.8 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	3.2, 3.3, 4.2, 5.1, 5.4	Recognises and interprets text to establish job requirements from information contained within relevant procedures and specifications
Writing	3.7, 4.1, 4.4, 6.8	Enters routine data associated with production processes and enterprise procedures
Oral	3.1-3.3, 3.7, 4.1, 4.2,	Speaks clearly using appropriate vocabulary, tone and

Communication	4.4, 5.1, 5.2, 5.4	pace to report faults and discrepancies
Numeracy	1.2,	Interprets and analyses a range of mathematical information used in familiar and routine tasks
Navigate the world of work	2.1-2.5, 3.1-3.4, 3.7, 3.8, 4.1-4.4, 5.1, 5.2, 5.4, 5.5, 6.1-6.8	- Recognises and follows explicit and implicit protocols and meets expectations associated with own role - Recognises and follows all procedures for cleaning and maintenance of equipment incorporating regulatory requirements and enterprise procedures
Interact with others	3.1-3.3, 3.7, 4.1, 4.2, 4.4, 5.1, 5.2, 5.4	- 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	1.1-1.5, 2.1-2.5, 3.1, 3.4-3.8, 4.1-4.4, 5.1-5.6, 6.1-6.7	- Determines priorities and sequences steps involved in clearly defined, familiar 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

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
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Unit Mapping Information

Code and title current version	Code and title previous version	Comments	Equivalence status
ICPPRN214 Produce basic flexographic printed product	ICPPR214C Produce basic flexographic printed product	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 ICPPRN214 Produce basic flexographic printed product

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Performance Evidence

Evidence of the ability to:

- accurately produce TWO basic flexographic printing jobs (if possible including at least ONE in-line process) according to job specifications, enterprise procedures and work health and safety (WHS) requirements
- correctly shut down and clean flexographic press and, if possible, rectify any production problems with minimum downtime.

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:

- outline process for transportation and delivery
- describe process for determining the substrate printing side

For reel systems only

- outline WHS concerns when loading and handling heavy reels
- describe effect on the print of excessive tension on the unwinding reel
- describe process for correct web splicing and implications if web is not spliced correctly

For sheet systems only

- outline WHS concerns when operating sheet transportation and delivery systems
- identify reasons for fanning sheets before loading into the press
- describe the process for setting, and the check to be made to the double sheet detector during the print run, and components that can be adjusted to ensure correct delivery
- describe effect excessive suction can have on slow-down wheels

- state how often product quality should be assessed, and what action taken if print fills in when printing
- describe effect of dirt under the doctor blade on the print and the motion of doctor blade oscillation
- describe action taken if ink in duct is foaming
- name signs of wear in the plate image area
- outline WHS concerns for the in-line component of the press and how often in-line components of the job should be examined
- describe the process of monitoring to ensure quality
- outline precautions to ensure the rewound product is consistent, acceptable quality and how to identify if printed material is not of an acceptable standard
- outline marking of product deemed unacceptable by the operator
- describe the process of consultation needed when there is a problem with the print that cannot be fixed by the operator
- identify location of information concerning correct operation of the machine
- outline dangers from solvents and solutions used to clean the inking system, plate and press
- describe methods used to ensure proper storage of plates following printing
- list parts of the machine that should be thoroughly cleaned following the print run and components to be inspected for wear following the print run
- identify records important for following or repeat prints
- identify machine manuals and safety documentation relevant to this task, where they are kept, and information included in these documents.

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 must satisfy NVR/AQTF assessor requirements.

Links

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