



Australian Government

Assessment Requirements for ICPPRN313

Set up for basic flexographic printing

Release: 2

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Modification History

Release	Comments
Release 2	This version released with ICP Printing and Graphic Arts Training Package Version 2.0. Version created to amend outdated application section.
Release 1	This version first released with ICP Printing and Graphic Arts Training Package Version 1.0.

Performance Evidence

Evidence of the ability to:

- demonstrate all safety devices on the machine
- demonstrate use of control, monitoring and data entry systems
- set up a press on TWO occasions for basic flexographic printing (if possible including at least ONE in-line process), according to manufacturer's specifications and enterprise procedures. The individual will also conduct a proof run and adjust settings to ensure production speeds are attained.

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:

Job requirements

- describe what to do if vital information is missing from the job ticket
- ensure all required materials are available prior to set up

Flexographic printing plates and cylinders or sleeves OR plate mounting sheets

- identify precautions to avoid damaging plates and cylinders

For reel systems only

Reel in-feed

- explain work health and safety (WHS) factors to consider when operating the reel in-feed and delivery system
- explain how to correctly select printing side of the material
- describe the effect of low web tension on the print
- name types of web splices that could be used appropriately for the job

Reel delivery system

- describe effect of excessive web tension at the rewind of the machine
- discuss how to minimise three risks associated with the rewind

For sheet systems only

Sheet in-feed

- explain WHS factors to consider when operating the sheet in-feed and delivery system
- describe why the sheet is normally set up in the middle of the machine
- describe effect side-lay selection has on the job
- describe how appropriate front lays should be selected
- describe what determines position of the sheet before it is transported to the printing unit
- explain how a register check is carried out
- discuss why a two-sheet cut is used on most feeders
- discuss how the machine recognises if a sheet is missing or late

Sheet delivery system

- describe why application of spray powder is sometimes advisable
- discuss effects of too much spray powder
- show how slowdown devices may be used in delivery
- identify effect of excessive jogging on the stack

Selection and preparation of inks and additives

- name major environmental and WHS concerns with regard to inks and additives
- describe how ink suitability is matched to a particular job
- describe implications if ink is too viscous
- describe how an ink that is slightly light can be modified to meet the job needs
- identify methods to check ink for correct colour
- name the person who passes the colour prior to running the job

Machine set-up

- discuss all WHS factors to consider when setting up the machine
- show how machine specifications are determined, relating to a specific job

- discuss steps to ensure the inking system is adjusted correctly
- describe why inking system ink level is maintained at a certain level
- list necessary precautions when handling doctor/chamber blades
- identify optimum make-ready-speed for the job
- explain basic in-line processes
- list steps to incorporate the in-line processes into the make-ready
- describe how equipment used in in-line processing is protected against damage during set-up
- list precautions to take if uv drying is utilised to dry the ink film

Proofing and adjustment

- identify methods to minimise waste during make-ready
- list procedures required to have the print approved
- describe quality control measurements to apply to the proof to test against known standards
- outline how to check on initial print prior to running
- describe how setting adjustments are determined
- identify processes to plot success of the machine adjustment
- describe how final results are recorded for future reference

Relevant test procedures

- identify and describe tests for scuffing and coefficient of friction
- show circumstances in which these tests should be applied

Leaching

- discuss leaching

Information sources

- identify machine manuals, safety and other documentation relevant to this task and where are they kept, and information contained.

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 range of standard inks and substrates
- a variety of stack, in-line and central impression flexographic printing machines.

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

Links

Companion Volume implementation guides are found in VETNet -

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