



Australian Government

Assessment Requirements for ICPPRN4130 Set up for complex flexographic printing

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.

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:

- set up a flexographic printing machine for a complex job on two occasions according to manufacturer and job specifications and enterprise procedures.

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:

- enterprise procedures, manufacturer specifications and work health and safety (WHS) risks and requirements for:
 - mounting and proofing flexographic plates
 - installing printing cylinders or sleeves
 - webbing up the machine and setting up the machine and delivery system
 - slitting on the machine
 - preparing and handling inks and additives
- production problems arising from not reading or understanding job specifications
- features, functions, and common faults for photopolymer plates, including:
 - advantages of thinness in processing printing
 - faults on new plates
 - types of solvents required
 - plate mounting procedures
- key features, functions, procedures, and common faults of web-fed machines and their transportation and delivery systems
- flexographic printing procedures, key features and adjustment parameters for common issues
- inks used in the printing process, their key qualities, functions, and common issues
- labelling and storage procedures of inks and additives, and ink shelf lives

- the PIV unit, its function and adjustment procedures
- the purpose or function of:
 - plasticisers and additives in flexographic inks
 - air blast in sheet delivery
 - using water treatment additives in a central impression drum and chill roller coolant system
- the procedure for:
 - determining reel position
 - graduating drying speeds of each progressive colour
- the issues arising from the following errors, and their causes:
 - incorrect unwind and rewind tension
 - excessive lay-on roller or slitter pressure
 - using an over-reduced ink
 - excessive final drying temperatures when printing polypropylene film
 - excessive print area tension and print pressure
 - excessive use of slow solvents
 - telescopic roll
 - picking when printing multi-coloured work
 - lateral streaks in uneven printing
- checks and precautions required:
 - for minimising waste when preparing ink
 - on plates, cylinders and gears, including before and after installation
 - for ink viscosity while using ink pumps
- the advantages of:
 - centring all machine controls
 - gauging up and dry register prior to printing a job
- benefits of optical mounting and cushion mounts
- cold seals, procedures for forming them and common issues
- method through which substrate is pulled into the machine
- special end-use requirements
- Zahn cups, their function and measurements, and issues that may arise in their use
- the angle chamber blades should be set at
- anilox rollers, their function, features, setup procedures and common issues that may arise
- jobs printed using a hexagonal cell configuration
- factors affecting drying rate of liquid and aqueous inks
- UV lamps, their operating range and precautions required
- hole punching procedures, their functions and key precautions
- instruments for identifying retained solvent trapped in print
- manufacturer manuals, enterprise procedure 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
- flexographic press.

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 Guide is found on VETNet -

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