



Australian Government

Department of Education, Employment and Workplace Relations

ICPCF2104C Set up single-faced web

Revision Number: 1

ICPCF2104C Set up single-faced web

Modification History

Not applicable.

Unit Descriptor

Unit descriptor	This unit describes the performance outcomes, skills and knowledge required to set up a single-faced web for corrugated board manufacture.
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Application of the Unit

Application of the unit	This unit requires the individual to set up the reel in-feed, splicer, pre-conditioner, pre-heater, single facer, curing, coating and/or waxing sections of a corrugator.
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Licensing/Regulatory Information

Not applicable.

Pre-Requisites

Prerequisite units		

Employability Skills Information

Employability skills	This unit contains employability skills.
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Elements and Performance Criteria Pre-Content

Elements describe the essential outcomes of a unit of competency.	Performance criteria describe the performance needed to demonstrate achievement of the element. Where bold italicised text is used, further information is detailed in the required skills and knowledge section and the range statement. Assessment of performance is to be consistent with the evidence guide.
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Elements and Performance Criteria

ELEMENT	PERFORMANCE CRITERIA
1. Prepare for set up	1.1. Job specifications are read and interpreted from job documentation or process control system 1.2. Set-up is carried out correctly and in minimum time 1.3. Paper/board quantity requirements are estimated, ordered and checked
2. Set up reel transportation system	2.1. Unwind reel is set up and adjusted according to job specifications 2.2. Webbing procedures are carried out according to machinery requirements 2.3. Web control system is set up and adjusted according to job specifications 2.4. Reels are spliced/joined according to job specifications
3. Set up machine for single facing	3.1. Steam delivery system is set up and adjusted to suit corrugating process and according to job specifications 3.2. Corrugating rolls and pressure roll are set to correct pressure 3.3. Starch delivery system is set up and adjusted to suit corrugating process and according to job specifications 3.4. Heat delivery system is set up and adjusted to suit corrugating process and according to job specifications
4. Set up in-line units	4.1. Wax units are set up and adjusted to suit corrugating process and according to job specifications 4.2. Coating units are set up and adjusted to suit corrugating process and according to job specifications 4.3. Slitters are set up and adjusted according to job specifications 4.4. Cut-off knife is set up and adjusted according to job specifications
5. Inspect and adjust quality	5.1. Inspection and/or testing of sample is organised 5.2. Sample is visually inspected and/or tested according to enterprise procedures 5.3. Results are interpreted to determine adjustment requirements 5.4. Adjustment changes are carried out according to

ELEMENT	PERFORMANCE CRITERIA
	product and <i>machine</i> specifications

Required Skills and Knowledge

REQUIRED SKILLS AND KNOWLEDGE

This section describes the skills and knowledge required for this unit.

Required skills

- communication by checking and confirming all details required for the job against job specifications
- problem solving by selecting and checking a sample from the machine to ensure it conforms to the required quality standards
- planning and organising by preparing the job before setting up the sewing machine; planning the job to meet the required timeframe
- teamwork by maintaining the production process in association with others
- use of technology by setting roll pressures, adjusting steam delivery system and calibrating the equipment

Required knowledge

- significant risks that are posed to workers in this activity
- measures that are employed to prevent injury and/or illness in the case of the above identified risks
- identifying the different types/categories of rolled paperboard accurately
- end products commonly made from each of the rolled paperboard types
- principal components of a typical, single-face corrugated board adhesive
- determining satisfactory performance of this adhesive
- main tools and/or equipment items necessary for the efficient handling of paperboard rolls in the corrugation in-feed section
- setting up the machine checks
- correct settings
- product factors that are monitored automatically during production
- achieving the monitoring function
- machine manuals, safety and other documentation that are relevant to this task and where they are kept and information that is included in these documents

Evidence Guide

EVIDENCE GUIDE

The Evidence Guide provides advice on assessment and must be read in conjunction with the performance criteria, required skills and knowledge, range statement and the Assessment Guidelines for the Training Package.

Overview of assessment

Critical aspects for assessment and evidence required to demonstrate competency in this unit

Evidence of the following is essential:

- set up the reel in-feed, splicer, pre-conditioner, pre-heater, single facer, curing, coating and/or waxing sections of a corrugator
- set up the reel in-feed, splicer, pre-conditioner, pre-heater, single facer, curing, coating and/or waxing sections of a corrugator for at least TWO different product runs, according to manufacturer's and job specifications, enterprise procedures and the listed Performance Criteria
- evidence for assessment may be gathered from assessment of the unit of competency alone or through an integrated assessment activity.

Context of and specific resources for assessment

Assessment must ensure:

- assessment may take place on the job, off the job or a combination of these. Off the job assessment must be undertaken in a closely simulated workplace environment
- in-line corrugating machinery.

Method of assessment

A range of assessment methods should be used to assess practical skills and knowledge. The following examples are appropriate for this unit:

- direct questioning combined with review of portfolios of evidence and third party workplace reports of on-the-job performance by the candidate.

Guidance information for assessment

Holistic assessment with other units relevant to the industry sector, workplace and job role is recommended, for example:

- ICPCF220C Produce basic converted or finished product
- ICPCF231C Set up machine for basic flat-bed cutting
- ICPCF235C Set up machine for basic rotary cutting
- ICPCF281C Set up machine for basic laminating
- ICPCF3105C Produce single-faced web

EVIDENCE GUIDE

	• ICPSU201C Prepare, load and unload reels and cores on and off machine.
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Range Statement**RANGE STATEMENT**

The range statement relates to the unit of competency as a whole. It allows for different work environments and situations that may affect performance. Bold italicised wording, if used in the performance criteria, is detailed below. Essential operating conditions that may be present with training and assessment (depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts) may also be included.

<i>Machines</i> may include:	• range of corrugating machines with manual, semi-automated and fully automated process control systems.
<i>In-line processes</i> may include:	• range of wax and coating systems operations, slitters and cutters. Note that slitting and cutting may be separately assessable as flat-bed or rotary cutting.
<i>Substrate types</i> may include:	• range of substrates within the major categories of board or paper.
<i>Substrate handling</i> may include:	• wide reel handling systems.

Unit Sector(s)

Unit sector	
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Competency field

Competency field	Converting, Binding and Finishing
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Co-requisite units

Co-requisite units		