



Australian Government

Department of Education, Employment and Workplace Relations

ICPCF3107C Produce double-faced web

Revision Number: 1

ICPCF3107C Produce double-faced web

Modification History

Not applicable.

Unit Descriptor

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

Application of the unit	This unit requires the individual to perform runs on the double backer machine, maintain production, identify and rectify problems and faults, and correctly shut down the machine.
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Licensing/Regulatory Information

Not applicable.

Pre-Requisites

Not applicable.

Employability Skills Information

Employability skills	This unit contains employability skills.	

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. Inspect and adjust quality	1.1. Inspection and/or testing of sample is organised 1.2. Sample is visually inspected and/or tested according to enterprise procedures 1.3. Results are interpreted to determine adjustment requirements 1.4. Adjustment changes are carried out according to product and machine specifications
2. Maintain operation of reel transportation system	2.1. Reel stand is monitored and adjusted to ensure efficient continuous operation 2.2. Web control system is monitored and adjusted to ensure correct tension and accurate continuous positioning of the web and efficient operation 2.3. Substrate is added to the process according to job specifications
3. Maintain double facing process	3.1. Starch delivery system is monitored and adjusted to suit corrugating process and according to job specifications 3.2. Heat delivery system is monitored and adjusted to suit corrugating process and according to job specifications 3.3. Heat delivery system is monitored and adjusted to suit corrugating process and according to job specifications 3.4. Speed of machine is optimised according to running conditions 3.5. Appropriate quantity of paper is run
4. Maintain in-line process(es)	4.1. Waxing units are monitored and adjusted to suit corrugating process and according to job specifications 4.2. Coating units are monitored and adjusted to suit corrugating process and according to job specifications 4.3. Tape dispensing units are monitored and adjusted to suit corrugating process and according to job specifications 4.4. Slitters are monitored and adjusted according to job specifications 4.5. Cut-off knife is monitored and adjusted according to job specifications
5. Synchronise machine	5.1. Machine down-time is minimised during flute, grade

ELEMENT	PERFORMANCE CRITERIA
operation	or deckle changes 5.2. Quality of board is maintained according to enterprise procedures or client acceptance standard 5.3. Machine speed is optimised and waste minimised
6. Maintain production process	6.1. Production process is operated in association with fellow workers and according to enterprise procedures and planned daily schedule 6.2. Production is maintained according to OHS requirements, manufacturer's specifications and enterprise procedures 6.3. Manual and/or automatic control is used according to job specifications 6.4. Performance is monitored and verified using the process control system according to enterprise procedures 6.5. Starch performance is monitored and adjusted throughout production run 6.6. Production difficulties are anticipated and preventive action is taken to prevent occurrence by timely intervention 6.7. Process adjustments to eliminate problems are reported according to enterprise procedures 6.8. Faulty performance of equipment is identified and reported according to enterprise procedures 6.9. Waste is sorted according to enterprise procedures 6.10. Quality checks of product are undertaken on a regular basis and adjustments made as required
7. Identify and rectify problems	7.1. Problems in corrugator operation are identified and reported according to enterprise procedures 7.2. Adjustments or corrections are carried out according to specified procedures and are consistent with operator's skill level 7.3. Corrugator operation is checked to ensure correct operation
8. Conduct shutdown of production process	8.1. Correct shutdown sequence is followed according to manufacturer's specifications and enterprise procedures 8.2. Shutdown is conducted in association with fellow workers and in compliance with OHS requirements 8.3. Solid and liquid waste is removed from operating area and recycled or disposed of, where required,

ELEMENT	PERFORMANCE CRITERIA
	according to regulatory requirements and enterprise procedures 8.4. All product is removed from operating area 8.5. Machine faults requiring repair are identified and reported to designated person according to enterprise procedures 8.6. Repair/adjustment is verified prior to resumption of operations
9. Clean and wash up corrugator at end of run	9.1. <i>In-line</i> wax, coating and tape dispensing units are cleaned ready for next run 9.2. Starch delivery system is washed up ready for next run, and liquid waste is disposed of according to regulatory requirements and enterprise procedures 9.3. Reel feed and transportation systems are disengaged and cleaned ready for next run 9.4. Production records or other documentation are accurately completed where required by enterprise procedures

Required Skills and Knowledge

REQUIRED SKILLS AND KNOWLEDGE

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

Required skills

- OHS in relation to operating machinery such as safely switching off machinery before cleaning is started
- communication skills when reading and interpreting job requirements from job documentation or production control system
- planning and organising by shutting down equipment in the correct sequence
- teamwork when maintaining production processes in association with colleagues
- using technology by producing double-faced web on the corrugator
- problem solving by selecting and checking a sample from the machine to ensure it conforms to the required quality standards

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
- principle support systems on line to the corrugating machine
- effective control and monitoring of the corrugator by the operator
- sections of the double backer that have the higher potential for operational problems during the run
- product faults that are commonly found to arise during production runs and how can they be corrected
- settings monitoring and adjustment made during the run, for the following factors: : in-feed, web alignment control, adhesive application, double backer, steam delivery, heating of web and speed
- product factors that can be monitored visually/manually by staff operating end stages of the corrugator machine
- adjustments made in response to problems found by staff operating end stages of the corrugator machine
- functions that must be attended to for the wash-up and shutdown of the single facer for an idle period of at least two days
- 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:

- perform runs on the double backer machine, maintain production, identify and rectify problems and faults, and correctly shut down the machine
- perform at least TWO runs on the double backer to produce TWO different types/classes of product, 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. Assessment off the job must be undertaken in a closely simulated workplace environment
- in-line double backer corrugating equipment.

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:

- ICPCF2106C Set up double-faced web
- ICPCF220C Produce basic converted or finished product
- ICPCF231C Set up machine for basic flat-bed cutting
- ICPCF235C Set up machine for basic rotary cutting
- ICPSU201C Prepare, load and unload reels and cores on and off machine.

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>Substrate handling</i> may include:	wide reel handling 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.

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		

Co-requisite units		