



Australian Government

Department of Education, Employment and Workplace Relations

PMAOPS405A Operate complex control systems

Release: 1

PMAOPS405B Operate complex control systems

Modification History

Not applicable.

Unit Descriptor

Unit descriptor	This unit covers the operation of a complex control panel. These controllers use a large number of control loops and a broad range of control algorithms. The panel will control entire plant areas and multiple products/ process streams. It will typically be located off plant in a control room and will require managing multiple complex tasks.
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Application of the Unit

Application of the unit	In a typical scenario an operations technician uses a complex process control system to operate and monitor an entire plant area consisting of several plant units/systems. This control system would typically be an advanced control system and may include operation of simpler control systems as part of its operation. This panel technician/central control room operator has an overall responsibility for the operation of all units of equipment within the entire plant area and may include optimization of the area using the control system. As such they often also take a lead role as part of the operating team. Competencies required by this role other than panel competencies as such are not covered by this unit. The operations technician would: • monitor and operate equipment in the entire plant area • solve process problems related to the plant area • liaise with other plant areas as necessary • use the advanced control features of the control system Generally the operations technician would be part of a team during start up, shut down and normal operating conditions and would be expected to be capable of demonstrating competence in all parts of this unit. He/she would be taking a leading role in liaising and cooperating with other members of the team. Typically the panel operator will liaise with other 'outside operators', however this unit does not preclude the situation where the panel operator may also undertake 'outside' functions.
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Licensing/Regulatory Information

Not applicable.

Pre-Requisites

Prerequisite units	
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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.

Elements and Performance Criteria

ELEMENT	PERFORMANCE CRITERIA
1. Use operator interface.	1.1. Use keyboards, track ball and monitor and/or stand alone controllers to access control system/panel 1.2. Monitor the process using the operator interfaces 1.3. Select appropriate controller modes 1.4. Access historical data and information 1.5. Acknowledge messages and alarms 1.6. Access advanced control features as appropriate
2. Access control information.	2.1. Obtain relevant data and information from the control system by applying systems knowledge 2.2. Identify the status of individual pieces of equipment from the control panel and use information to identify potential faults 2.3. Minimise fluctuations and variations in process through the interpretation of existing trends and control schematics 2.4. Determine the overall operating effectiveness of the plant area related to the required targets for the area 2.5. Record process variations/irregularities to procedures.
3. Control process variations and monitor operations.	3.1. Use historical data to assist the identification of problems 3.2. Process available information to identify potential faults 3.3. Undertake required set point/output changes to meet plant area and process requirements 3.4. Adjust production in response to test results and control panel information 3.5. Monitor key process and environmental variables and take appropriate action 3.6. Adjust controller settings in accordance with procedures 3.7. Use advanced control features as appropriate 3.8. Optimise entire plant area in accordance with guidelines 3.9. Undertake calibration operations as appropriate 3.10. Coordinate with stakeholders external to the plant area as appropriate 3.11. Record adjustments and variations to specifications/schedules

ELEMENT	PERFORMANCE CRITERIA
	3.12. Communicate to appropriate personnel as required.
4. Facilitate planned and unplanned process start-ups and shut-downs.	4.1. Select and apply procedures to planned startup and shutdown processes 4.2. Select and apply procedures to unplanned shutdown processes 4.3. Implement all required emergency responses 4.4. Communicate necessary information to all personnel affected by events 4.5. Log all required information.
5. Respond to alarms or out of specification conditions.	5.1. Identify system(s) affected by the alarm or condition 5.2. Interpret alarms and prioritise actions to be taken 5.3. Respond to the alarm or incident by following procedures 5.4. Deal with any out of specification material in accordance with procedures 5.5. Communicate the problem/solution to appropriate personnel 5.6. Record the information as required 5.7. Provide details of the alarm and action taken to the next shift at change over 5.8. Follow the incident up see that appropriate action has been taken.
6. Control hazards.	6.1. Identify hazards in the production/processing work area 6.2. Assess the risks arising from those hazards 6.3. Implement measures to control risks in line with procedures and duty of care
7. Resolve other problems within scope of responsibility.	7.1. Identify possible problems in equipment, control systems or process 7.2. Determine problems needing action 7.3. Determine possible fault causes 7.4. Rectify problem using appropriate solution within area of responsibility 7.5. Follow initiated items through until final resolution has occurred 7.6. Report problems outside area of responsibility to designated person.

Required Skills and Knowledge

REQUIRED SKILLS AND KNOWLEDGE

This describes the essential skills and knowledge and their level, required for this unit.

Required skills

Competence includes the ability to distinguish between causes of problems/alarms/fault indications such as:

- instrument failure/malfunction
- electrical failure/malfunction
- mechanical failure/malfunction
- equipment design deficiencies
- product parameters (temperature, flows, pressure and levels)
- process control system malfunction
- power/utility failures
- software problems
- multitasking.

An ability to communicate with other work groups and personnel during the operation and monitoring of this panel is considered to be an essential element of this unit of competency.

Required knowledge

The knowledge referred to in the Evidence Guide for this unit includes:

- advanced control features
- interactions between control loops
- interactions between plant units within the entire plant
- the architecture and location of the process/production equipment
- specific plant process operations
- interactions between plant items/processes
- product specifications and tolerances
- systems operating parameters
- system integrity limits
- process control philosophies and strategies
- emergency shutdown procedures
- process specific physics, chemistry and mathematics
- relevant chemistry of the process to the level of writing chemical equations and identifying and manipulating factors controlling rate of reaction and yield (or equivalent physics for a physical process/biochemistry for a biochemical process) - chemistry to include both intended products and interfering reactions (eg salts, hydrates)
- basic science of upstream and downstream processes
- interactions between plant area and other value stream members
- impact of external factors, eg variations in weather, feed etc

REQUIRED SKILLS AND KNOWLEDGE

- complex process drawings, eg P&ID, PFD, cause and effect
- basis of control for the plant/s
- instrumentation and control systems including feed forward, feed back and open control
- instrumentation and control system components (eg relevant primary sensing devices, final control elements, transducers/transmitters)
- control loops (including PID control, set points, controlled variable, indicated variable)
- interaction between multiple control loops (including cascade control)
- impacts of changing controller settings and the limits within which changes can be made
- effective communication techniques
- organisation procedures
- UPS and its applications and use.

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, the Range Statement and the Assessment Guidelines for the Training Package.

Overview of assessment

Assessment of this unit should include demonstrated competence on actual plant and equipment in a work environment. The unit will be assessed in as holistic a manner as is practical and may be integrated with the assessment of other relevant units of competency. Assessment will occur over a range of situations, which will include disruptions to normal, smooth operation.

Simulation may be required to allow for assessment of parts of this unit. Simulation should be based on the actual plant and will include walk-throughs of the relevant competency components. Simulations may also include the use of case studies/scenarios, role plays and 3D virtual reality interactive systems. In the case of evacuation training or of training for competencies practiced in life threatening situations, simulation may be used for the bulk of the training.

This unit of competency requires an application of the knowledge contained in the use of the process control system and its integral equipment, to the level needed to maintain control and recognise and resolve problems. This can be assessed through questioning and the use of what-if scenarios both on the plant (during demonstration of normal operations and walk throughs of abnormal operations) and off the plant.

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

Competence must be demonstrated in the ability to recognise and analyse potential situations requiring action and then in implementing appropriate responses. The emphasis should be on the ability to stay out of trouble rather than on recovery from a disaster.

Consistent performance should be demonstrated. In particular look to see that:

- early warning signs of equipment/processes needing attention or with potential problems are recognised
- the range of possible causes can be identified and

EVIDENCE GUIDE	
	analysed and the most likely cause determined • appropriate action is taken to ensure a timely return to full performance • obvious problems in related plant areas are recognised and an appropriate contribution made to their solution. These aspects may be best assessed using a range of scenarios/case studies/what-ifs as the stimulus with a walk-through forming part of the response. These assessment activities should include a range of problems, including new, unusual and improbable situations, which may have been generated from the past incident history of the plant, incidents on similar plants around the world, hazard analysis activities and similar sources.
Context of and specific resources for assessment	Assessment will require access to a process control system over an extended period of time, or a suitable method of gathering evidence of operating ability over a range of situations. A bank of scenarios/case studies/what-ifs will be required as will a bank of questions which will be used to probe the reasoning behind the observable actions.
Method of assessment	In all plants it may be appropriate to assess this unit concurrently with relevant teamwork, communication and leadership units.
Guidance information for assessment	Assessment processes and techniques must be culturally appropriate and appropriate to the oracy, language and literacy capacity of the assessee and the work being performed.

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 italicized wording, if used in the Performance Criteria, is detailed below. Add any 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.

Codes of practice/ standards	Where reference is made to industry codes of practice, and/or Australian/international standards, the latest version must be used.
Context	This unit of competency includes all such items of equipment and unit operations which form part of the control system. For your control room this may include (select relevant items): • process control systems (eg Distributed Control Systems) • use of multiple control systems • personal computers • printers • fire and gas detection/protection systems • emergency shutdown systems • communications systems. Typical problems for your plant may include: • operating without advanced control features • loss of power/utilities • analysing failure modes • variation/loss of feed • unstable control of pressure, temperature level and flows • control equipment failure • process plant trips • change in atmospheric conditions (rain, temperature, wind, lightning) • emergency situations.
Alarms or abnormal conditions	Alarms or other abnormal conditions includes: • emergency, including emergency shut down • partial or complete controller failure.
Other problems	Other problems includes: • problem solving control functions
Appropriate action	Appropriate action includes: • determining problems needing action

RANGE STATEMENT	
	• determining possible fault causes • rectifying problem using appropriate solution within area of responsibility • following through items initiated until final resolution has occurred • reporting problems outside area of responsibility to designated person.
Procedures	Procedures may be written, verbal, computer-based or in some other form. They include: • all work instructions • standard operating procedures • formulas/recipes • batch sheets • temporary instructions • any similar instructions provided for the smooth running of the plant. For the purposes of this Training Package, 'procedures' also includes good operating practice as may be defined by industry codes of practice (eg Responsible Care) and government regulations.
Health, safety and environment (HSE)	All operations to which this unit applies are subject to stringent health, safety and environment requirements, which may be imposed through State or Federal legislation, and these must not be compromised at any time. Where there is an apparent conflict between Performance Criteria and HSE requirements, the HSE requirements take precedence.

Unit Sector(s)

Unit sector	Operational/technical
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Competency field

Competency field	
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Co-requisite units

Co-requisite units		
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