



Australian Government

PMBPROD306 Prepare and start equipment for production

Release: 1

PMBPROD306 Prepare and start equipment for production

Modification History

Release 1. Supersedes and is equivalent to PMBPROD306B Prepare and start equipment for production

Application

This unit of competency covers the skills and knowledge required to prepare and start equipment for production. It applies to bringing a machine from 'power-off' to first-off product and making ready to hand over to the operator to continue the production run.

This unit of competency applies to advanced operators who are required to confirm production requirements, perform pre-start checks, check equipment set-up, start up and adjust operation, and hand over operating machine to operator.

This unit applies when start-up is performed as an activity by itself and the started plant is then handed over to an operator to operate. It does not apply when start-up is part of operation and is included in the relevant operate/produce unit of competency.

This unit of competency applies to an advanced operator demonstrating theoretical and technical knowledge and well developed skills in situations that require some discretion and judgement. The advanced operator may work alone or as a member of a team or group and will work in liaison with other shift team members, team leader and supervisor, as appropriate.

No licensing, legislative or certification requirements apply to this unit at the time of publication.

Pre-requisite Unit

Nil

Competency Field

Production

Unit Sector

Not applicable

Elements and Performance Criteria

Elements describe the essential outcomes.

Performance criteria describe the performance needed to demonstrate achievement of the element.

- | | | | |
|---|--------------------------|-----|--|
| 1 | Perform pre-start | 1.1 | Check all emergency stops, guards and controls |
|---|--------------------------|-----|--|

	checks	1.2	Identify requirements for materials, quality and production run
		1.3	Check and adjust equipment as required
		1.4	Check that the equipment has been set-up correctly
2	Carry out pre-start operations to procedures	2.1	Restore all power to the machine and ancillary equipment
		2.2	Start up the ancillary equipment and set the temperature and other controllers as required
		2.3	Check all machine settings as required
		2.4	Select and load the correct raw material
		2.5	Charge, purge and clean machine as required
3	Start machine and hand over to operator	3.1	Start and check machine
		3.2	Adjust machine as required to bring to operational speed/ condition
		3.3	Check and run machine until a quality product is obtained
		3.4	Make adjustments to machine and extra equipment in line to produce an acceptable product
		3.5	Make any adjustments required to ensure the machine and its upstream and downstream extra equipment in line are in balance
		3.6	Give the operator all necessary instructions and hand over the machine
		3.7	Shut down machine as required
4	Anticipate and solve problems	4.1	Recognise a problem or a potential problem
		4.2	Determine problems needing priority action
		4.3	Refer problems outside area of responsibility to

appropriate person, with possible causes

- 4.4 Seek information and assistance as required to solve problems
- 4.5 Solve problems within area of responsibility
- 4.6 Follow through items initiated until final resolution has occurred

Foundation Skills

This section describes those required skills (language, literacy and numeracy) that are essential to performance.

Foundation skills essential to performance are explicit in the performance criteria of this unit of competency.

Range of Conditions

This field allows for different work environments and conditions that may affect performance. Essential operating conditions that may be present (depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts) are included.

Regulatory framework The latest version of all legislation, regulations, industry codes of practice and Australian/international standards, or the version specified by the local regulatory authority, must be used.

Applicable legislation, regulations, standards and codes of practice include:

- health, safety and environmental (HSE) legislation, regulations and codes of practice relevant to the workplace, manual handling and hazardous materials
- Australian/international standards relevant to the materials being used and products being made
- any relevant licence and certification requirements.

All operations to which this unit applies are subject to stringent HSE requirements, which may be imposed through state/territory or federal legislation, and these must not be compromised at any time. Where there is an apparent conflict between performance criteria and such requirements the legislative requirements take precedence.

Procedures All operations must be performed in accordance with relevant procedures.

Procedures are written, verbal, visual, computer-based or in some other form, and include one or any combination of:

- emergency procedures
- work instructions
- standard operating procedures (SOPs)
- safe work method statements (SWMS)
- formulas/recipes
- batch sheets
- temporary instructions
- any similar instructions provided for the smooth running of the plant.

Tools and equipment

Tools and equipment include:

- production plant/equipment
- machine control systems
- safety interlocks and systems
- measuring instruments
- ancillary equipment that is integral to the process.

Additional tools and equipment will be selected as required from:

- hand tools used in the process
- hoists/lifting equipment not requiring any special permits or licences
- manual handling aids, such as hand carts and trolleys
- relevant personal protective equipment (PPE).

Hazards

Hazards must be identified and controlled. Identifying hazards requires consideration of:

- weight, shape, volume of materials to be handled
- hazardous products and materials
- sharp edges, protrusions or obstructions
- slippery surfaces, spills or leaks
- smoke, dust, vapours or other atmospheric hazards
- high temperatures
- electricity
- gas
- gases and liquids under pressure
- structural hazards

- equipment failures
- machinery, equipment and product mass
- other hazards that might arise.

Problems Routine and non-routine problems must be resolved.

Non-routine problems must be resolved by applying operational knowledge to develop new solutions, either individually or in collaboration with relevant experts, to:

- determine problems needing action
- determine possible fault causes
- develop solutions to problems which do not have a known solution
- follow through items initiated until final resolution has occurred
- report problems outside area of responsibility to designated person.

Non-routine problems are unexpected problems or variations of previous problems and include one or more of:

- unstable process variables
- sub-optimal operation
- variations in feed rates
- variations in quality
- emergency situations.

Operational knowledge includes one or more of:

- procedures
- training
- technical information, such as journals and engineering specifications
- remembered experience
- relevant knowledge obtained from appropriate people.

Routine problems are predictable and have known solutions and include one or more of:

- processing problems
- equipment malfunctions
- materials problems.

Unit Mapping Information

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Links

Companion Volume implementation guides are found in VETNet -

<https://vetnet.gov.au/Pages/TrainingDocs.aspx?q=932aacef-7947-4c80-acc6-593719fe4090>

Assessment Requirements for PMBPROD306 Prepare and start equipment for production

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Performance Evidence

Evidence required to demonstrate competence in this unit must be relevant to and satisfy the requirements of the elements and performance criteria and demonstrate the ability to:

- read and interpret procedures, job specifications, instruments/control panels, material labels and safety data sheets (SDS)
- set up and adjust machine control system to produce product to specification, including one or more of:
 - basic controls
 - open loop
 - closed loop
 - shot size and correction capacity
 - speed/cycle time
 - screw position
 - equipment/process pressure
 - clamp pressure
 - time
 - screw speed
 - screw back pressure
 - screw back time
 - melt decompress position
 - sprue break
- start up process and monitor key variables, including:
 - equipment condition
 - set up variables
 - product measurements
 - product integrity and general conformance to specification
- make adjustments to process to:
 - remedy faults and nonconformity
 - establish a stable process
 - establish balance with upstream and downstream processes
- give instructions to the operator and handover over the machine
- safely shut down equipment in normal and abnormal circumstances

- identify hazards and apply relevant hazard controls
- apply safety procedures
- apply housekeeping procedures
- apply waste management procedures
- recognise early warning signs of equipment/processes needing attention or with potential problems
- distinguish between causes of problems, including:
 - operational problems
 - instrument failure/malfunction
 - electrical failure/malfunction
 - mechanical failure/malfunction
 - wrong readings
 - equipment design deficiencies
 - polymer properties
 - process variables
- recognise and prioritise problems requiring action
- resolve non-routine problems
- communicate effectively with team/work group and supervisors
- complete workplace records
- do basic arithmetical manipulations, including additions, subtractions, divisions, fractions and percentages.

Knowledge Evidence

Must provide evidence that demonstrates knowledge relevant to their job sufficient to operate independently and to solve routine and non-routine problems, including knowledge of:

- function and operating principles of machine and components
- products, materials and material characteristics
- behaviour of materials in relation to key process variables
- quality requirements at each production stage
- function of and readings from measuring instruments, including one or more of:
 - levelling
 - thermocouples
 - pyrometers
 - transducers
 - thermometers
 - pressure gauges
 - vacuum gauges
 - flow meters
- purpose and operation of safety interlocks and systems, including one or more of:
 - limit switches

- normally open/normally closed
- overstroke control systems
- hydraulic temperature control
- material temperature control
- machine guards
- nozzle purge guard
- mould protection systems
- ejection limit switches
- impact of machine operating parameters on product quality and production output
- factors which may affect product quality or production output and appropriate remedies
- polymer properties and their interactions with process conditions
- impact of variations in raw materials and equipment operation in relation to final product
- routine and non-routine problems that may arise, the range of possible causes and appropriate actions
- organisation procedures relevant to the work environment/job role
- hierarchy of control
- hazards that may arise in the job/work environment and:
 - their possible causes
 - potential consequences
 - appropriate risk controls.

Assessment Conditions

- The unit should be assessed holistically and the judgement of competence shall be based on a holistic assessment of the evidence.
- The collection of performance evidence is best done from a report and/or folio of evidence drawn from:
 - a single project which provides sufficient evidence of the requirements of all the elements and performance criteria
 - multiple smaller projects which together provide sufficient evidence of the requirements of all the elements and performance criteria.
- A third-party report, or similar, may be needed to testify to the work done by the individual, particularly when the project has been done as part of a project team.
- Assessment should use a real project in an operational workplace. Where this is not possible or where personal safety or environmental damage are limiting factors assessment must occur using a sufficiently rigorous simulated environment that reflects realistic operational workplace conditions. This must cover all aspects of workplace performance, including environment, task skills, task management skills, contingency management skills and job role environment skills.
- Assessment in a simulated environment should use evidence collected from demonstration of skills and one or more of:
 - walk-throughs
 - pilot plant operation

- industry-based case studies/scenarios
- ‘what ifs’.
- Knowledge evidence may be collected concurrently with performance evidence or through an independent process, such as workbooks, written assessments or interviews.
- Assessment processes and techniques must be appropriate to the language, literacy and numeracy requirements of the work being performed and the needs of the candidate.
- Conditions for assessment must include access to all tools, equipment, materials and documentation required, including relevant workplace procedures, product and manufacturing specifications associated with this unit.
- The regulatory framework will be reflected in workplace policies and procedures and is not required to be independently assessed.
- Foundation skills are integral to competent performance of the unit and should not be assessed separately.
- Assessors must satisfy the assessor competency requirements that are in place at the time of the assessment as set by the VET regulator.
- In addition the assessor or anyone acting in subject matter expert role in assessment shall demonstrate both technical competency and currency. If the assessor cannot demonstrate technical competency and currency they shall assess with a subject matter expert who does meet these requirements.
- Technical competence can be demonstrated through one or more of:
 - relevant VET or other qualification/Statement of Attainment
 - appropriate workplace experience undertaking the type of work being assessed under routine and non-routine conditions
 - appropriate workplace experience supervising/evaluating the type of work being assessed under routine and non-routine conditions
- Currency can be demonstrated through one or more of:
 - being currently employed undertaking the type of work being assessed
 - being employed by the organisation undertaking the type of work being assessed and having maintained currency in accordance with that organisation’s policies and procedures
 - having consulted/had contact with an organisation undertaking the type of work being assessed within the last twelve months, the consultation/contact being related to assessment
 - conducting on the job training/assessments of the type of work being assessed
 - being an active member of a relevant professional body and participating in activities relevant to the assessment of this type of work.

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