



Australian Government

PMBPROD311 Produce blow moulded products

Release: 1

PMBPROD311 Produce blow moulded products

Modification History

Release 1. Supersedes and is equivalent to PMBPROD311C Produce blow moulded products

Application

This unit of competency covers the skills and knowledge required to operate and adjust blow moulding processes to produce product.

This unit of competency applies to experienced operators who are required to start up and shut down blow moulding equipment, monitor equipment operation, establish a stable process, make adjustments to remedy faults and non-conformity and solve problems within area of responsibility.

This unit of competency applies to an experienced operator demonstrating theoretical and technical knowledge and well developed skills in situations that require some discretion and judgement. The experienced 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

PMBPROD211 Operate blow moulding equipment

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	Plan own work requirements	1.1	Identify the most appropriate equipment to be used for production process, upstream and downstream operations from production plan or request
		1.2	Identify and check materials required, including additives and regrind and their amounts or percentages
		1.3	Implement measures to control identified hazards in line with procedures and duty of care
		1.4	Identify requirements for materials, quality, production and equipment checks
2	Start up blow moulding equipment to procedures	2.1	Identify process settings required for product
		2.2	Set up and adjust blow moulding equipment for shot size, parison control, die gap, temperature, screw speed, cycle speed, slow close setting (or cushion) and timing
		2.3	Check safety gates and guards are located in their correct working positions and emergency stops are identified and checked as required
		2.4	Verify equipment, raw material and mould all match job requirement
		2.5	Set up date, batch and materials markings
		2.6	Complete other pre-start checks
		2.7	Start up equipment safely and 'dry run' to warm hydraulics and components to operating temperature before production, as required
3	Operate and make adjustments to the blow moulding process to procedures	3.1	Check condition of equipment and introduce raw materials as required
		3.2	Operate blow moulding equipment, noting key variable
		3.3	Monitor controls/displays/terminals for production and process data

- 3.4 Monitor product/process quality
 - 3.5 Make adjustments to remedy faults and nonconformity as required
 - 3.6 Establish a stable blow moulding process
 - 3.7 Collect and reprocess/discard scrap/trim and other materials
 - 3.8 Clean, adjust and lubricate equipment as required
 - 3.9 Complete logs and records as required
 - 3.10 Pause or stop equipment in an emergency, as required
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- 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:

- injection moulding machines which may be bottom blow, top blow, needle blow, tail to tail blow, parison pre-blow and pre-squeeze, parison

stretching and parison orientation type machines

- components of injection moulding machines, including material supply systems, plastification unit, dies/tools and injection units
- ancillary equipment that is integral to the process, including one or more of:
 - chillers
 - die heating equipment
 - hopper driers
 - mixing hoppers
 - dehumidifying driers
 - air compressors
 - dosing machines
 - blending and mixing equipment
 - conveyors.

Additional tools and equipment will be selected as required from:

- hand tools used in this 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
- rotational equipment or vibration
- 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

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
- intermittent faults.

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.

Unit Mapping Information

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Links

MSA Training Package Implementation Guides - <http://mskills.org.au/training-packages/info/>