

Overview

This standard covers a range of basic mechanical assembly competences that will prepare you for entry into the engineering or manufacturing sector, creating a progression between education and employment, or that will provide a basis for the development of additional skills and occupational competences in the working environment.

You will be expected to prepare for the assembly activities by obtaining all the necessary job instructions, components, tools, equipment and any documentation that may be required.

In carrying out the assembly operations, you will be required to work to instructions in order to produce the required assembly. The assembly activities will include making all necessary checks and adjustments, to ensure the components are correctly orientated, positioned and aligned, that moving parts have the correct working clearances, all fasteners are tightened to the correct torque, and that the assembled parts are checked for completeness and function as per the specification. On completion of the assembly activities, you will be expected to return all tools and equipment to the correct location, and to leave the work area in a safe and tidy condition.

Your responsibilities will require you to comply with health and safety requirements and organisational policy and procedures for the assembly activities undertaken. You will need to report any difficulties or problems that may arise with the assembly activities, and to carry out any agreed actions. You will work under a high level of supervision, whilst taking responsibility for your own actions and for the quality and accuracy of the work that you carry out.

Your underpinning knowledge will provide an understanding of your work, and will enable you to apply appropriate assembly techniques safely. You will understand the assembly process, and its application, and will know about the mechanical equipment being assembled, the components, tools and consumables used, to the required depth to provide a sound basis for carrying out the activities to the required specification.

You will understand the safety precautions required when carrying out the assembly activities, and when using assembly tools and equipment. You will be required to demonstrate safe working practices throughout, and will understand the responsibility you owe to yourself and others in the workplace.

Specific Unit Requirements

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Assembling mechanical components

At least one of the assemblies produced must combine different assembly operations and assembly techniques, and must include a mix of fixed and moving component parts, as identified in scope 3.

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Assembling mechanical components

Performance criteria

- You must be able to:*
- P1 work safely at all times, complying with health and safety legislation, regulations and other relevant guidelines
 - P2 obtain and prepare the appropriate components, tools and equipment
 - P3 use the appropriate methods and techniques to assemble the components in their correct positions
 - P4 secure the components, using the specified connectors and securing devices
 - P5 check the completed assembly to ensure that all operations have been completed, and that the finished assembly meets the required specification
 - P6 report any difficulties or problems that may arise with the assembly activities, and carry out any agreed actions
 - P7 leave the work area in a safe and tidy condition on completion of the assembly activities

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Assembling mechanical components

Knowledge and understanding

You need to know and understand:

- K1 the health and safety requirements, and safe working practices and procedures required for the assembly activities undertaken
- K2 the importance of wearing appropriate protective clothing and equipment (PPE), and keeping the work area safe and tidy
- K3 the hazards associated with the assembly activities (such as use of power tools, trailing leads or air hoses, damaged or badly maintained tools and equipment, lifting and handling heavy items), and how they can be minimised
- K4 the procedure for obtaining the required drawings, job instructions and other related specifications
- K5 how to use and extract information from engineering drawings and related specifications (to include BS or ISO standard symbols and abbreviations, imperial and metric systems of measurement, workpiece reference points and system of tolerancing)
- K6 how to prepare the components in readiness for the assembly activities (such as visually checking for defects, cleaning the components, removing burrs and sharp edges)
- K7 the assembly/joining methods, techniques and procedures to be used, and the importance of adhering to these procedures
- K8 how the components are to be aligned, adjusted and positioned prior to securing, and the tools and equipment to be used
- K9 the various mechanical fastening devices that are used (such as nuts, bolts, machine screws, cap screws, clips, pins, locking and retaining devices)
- K10 the importance of using the specified components and joining devices for the assembly, and why you must not use substitutes
- K11 where appropriate, the application of sealants and adhesives within the assembly activities, and the precautions that must be taken when working with them
- K12 how to conduct any necessary checks to ensure the accuracy, position, security, function and completeness of the assembly (such as checking for correct operation where the assembly has moving parts, checking the torque figures to which critical fastenings have been tightened, checking the end float on shafts, checking operating clearance on actuating mechanisms)
- K13 how to detect assembly defects (such as ineffective joining techniques, foreign objects, component damage), and what to do to rectify them
- K14 the methods and equipment used to transport, lift and handle components and assemblies
- K15 the importance of ensuring that all tools are in a safe and usable condition, and are used correctly, within their permitted operating range

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- K16 problems with the assembly operations, and the importance of informing appropriate people of non-conformances
- K17 when to act on your own initiative and when to seek help and advice from others
- K18 the importance of leaving the work area in a safe and clean condition on completion of the assembly activities (such as removing and storing power leads, returning hand tools and equipment to the designated location, cleaning the work area, and removing and disposing of waste)

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Additional Information

Scope/range related to performance criteria

You must be able to:

1. Carry out **all** of the following during the assembly activities:
 - 1.1 adhere to procedures or systems in place for risk assessment, COSHH, personal protective equipment (PPE) and other relevant safety regulations
 - 1.2 follow job instructions, assembly drawings and procedures
 - 1.3 ensure that all power tool cables, extension leads or air supply hoses are in a safe and serviceable condition
 - 1.4 use lifting and slinging equipment, in accordance with health and safety guidelines and procedures (where appropriate)
 - 1.5 ensure that components used are free from foreign objects, dirt or other contamination
 - 1.6 apply safe and appropriate assembly techniques and procedures at all times
 - 1.7 return all tools and equipment to the correct location on completion of the assembly activities

2. Produce assemblies, using **four** of the following methods and techniques:
 - 2.1 assembling of components by expansion/contraction
 - 2.2 applying sealants/adhesives
 - 2.3 fitting (such as filing, scraping, lapping or polishing)
 - 2.4 electrical bonding of components
 - 2.5 securing by using mechanical fasteners/threaded devices
 - 2.6 assembling of products by pressure
 - 2.7 setting and adjusting
 - 2.8 applying bolt locking methods
 - 2.9 aligning components
 - 2.10 drilling
 - 2.11 shimming and packing
 - 2.12 riveting
 - 2.13 pinning
 - 2.14 reaming
 - 2.15 blue-bedding of components
 - 2.16 torque setting
 - 2.17 balancing components

3. Assemble products to meet the required specification, using **six** of the

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following types of component:

- 3.1 assembly structure (framework, support, casings, panels)
 - 3.2 pre-machined components
 - 3.3 shafts
 - 3.4 levers/linkages
 - 3.5 springs
 - 3.6 fabricated components
 - 3.7 chains
 - 3.8 keys
 - 3.9 belts
 - 3.10 bearings
 - 3.11 couplings
 - 3.12 pulleys
 - 3.13 gaskets
 - 3.14 seals
 - 3.15 sprockets
 - 3.16 gears
 - 3.17 pipework/hoses
 - 3.18 bushes
 - 3.19 cams and followers
 - 3.20 other specific components
4. Secure the components, using **two** of the following categories of fastening devices:
- 4.1 threaded fasteners (such as nuts, bolts, machine screws, cap screws)
 - 4.2 locking and retaining devices (such as tab washers, locking nuts, wire locks, special purpose types)
 - 4.3 pins (such as parallel/dowels, hollow/roll, tapered, split)
 - 4.4 spring clips (such as external circlips, internal circlips, special clips)
 - 4.5 rivets (such as countersunk, roundhead, blind, special purpose types)
5. Assemble products, using **two** of the following assembly aids and equipment:
- 5.1 workholding devices
 - 5.2 shims and packing
 - 5.3 lifting and moving equipment
 - 5.4 rollers or wedges
 - 5.5 specialised assembly tools/equipment
 - 5.6 supporting equipment
 - 5.7 jigs and fixtures
6. Carry out the required quality checks, to include **four** of the following, using appropriate equipment:

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- 6.1 positional accuracy
 - 6.2 alignment
 - 6.3 freedom of movement
 - 6.4 function
 - 6.5 component security
 - 6.6 bearing/shaft end float
 - 6.7 completeness
 - 6.8 operating/working clearances
 - 6.9 dimensions
 - 6.10 freedom from damage or foreign objects
 - 6.11 orientation
7. Produce mechanical assemblies which comply with **all** of the following:
- 7.1 all components are correctly assembled and aligned, in accordance with the specification
 - 7.2 moving parts are correctly adjusted and have appropriate clearances
 - 7.3 where appropriate, assemblies meet geometric tolerances (such as square, straight, angles free from twists)
 - 7.4 all fastenings have appropriate washers and are tightened to the required torque
 - 7.5 where appropriate, bolt locking methods are applied

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Assembling mechanical components

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