
Overview

This standard is for print finishers who produce dies and stripping tools.

You must show that you can:

- 1 Produce die formes
- 2 Produce stripping tools

This involves:

- 1 identifying the job requirements;
- 2 identifying faults and taking action to deal with them;
- 3 unloading and stacking the finished product.
- 4 producing die formes;
- 5 checking that work meets the required standard;
- 6 taking appropriate action when it does not;
- 7 producing stripping tools;
- 8 checking that work meets the required standard;
- 9 taking appropriate action when work does not meet the standard.

**Performance
criteria**

Produce die formes

- You must be able to:
- P1 check that you have all the details required for the job
 - P2 check that you have enough materials of the right type for the job
 - P3 select the correct rule(s) for the job
 - P4 check that your work area is safe and ready for production
 - P5 locate rules securely in position with acceptable inter image consistency
 - P6 position nicks accurately for the nature of the image and the press requirements
 - P7 accurately identify and correct faults which it is your job to remedy
 - P8 accurately identify and promptly report faults which it is not your job to correct
 - P9 check that your work meets your company's quality standards
 - P10 produce die forme in time to meet the production schedule
 - P11 position and secure appropriate ejection material to the die board
 - P12 follow the correct procedure for the removal of waste

Produce stripping tools

- You must be able to:
- P13 check that you have all the details required for the job
 - P14 check that you have enough materials of the right type for the job
 - P15 check that your work area is safe and ready for production
 - P16 promptly report to your manager, if the material provided is not correct or sufficient
 - P17 produce stripping tools in time to meet production schedule
 - P18 check that your work matches the required standards
 - P19 make adjustments when standard are not met
 - P20 report promptly to your manager, if the standards cannot be met
 - P21 position stripping pins and devices accurately to strip waste at optimum running speed of machine
 - P22 check that the areas to be stripped will optimise machine speed and sheet stability with minimum subsequent hand work
 - P23 prepare the machine so that waste does not catch when passing through apertures
 - P24 follow the correct procedure for the removal of waste

Knowledge and understanding

Produce die formes

You need to know and understand:

- K1 what details you need for the job
- K2 the principles of making die formes
- K3 your company's quality standards
- K4 the risks associated with making die formes and how to avoid them
- K5 the range, use and limitations of materials and rules
- K6 the relationship between rules and board thickness
- K7 the principles of bridge positioning
- K8 the different carton styles and closures used by your company
- K9 the relationship between nicking and stripping
- K10 the relationship between rubber types and adhesives
- K11 what types of ejection materials there are
- K12 the principles of ejection
- K13 how to control rule accuracy and consistency
- K14 the common faults which can occur when producing die forms, what causes them, how to avoid them and which faults can be corrected
- K15 how to recognise when you should correct faults yourself and when you should ask for help
- K16 the procedures for the removal of waste

Produce stripping tools

You need to know and understand:

- K17 the job requirements and your company's quality standards
- K18 how to obtain material and how it is allocated to you
- K19 the types of board
- K20 the types of ejector pins and how they are classified
- K21 the types of stripping tools
- K22 the principles of automatic machine stripping and the function of stripping tools
- K23 the types of stripping tool upper, female and lower
- K24 the effects of stripping on sheet stability and press speed
- K25 the relationship between stripping and nicking
- K26 the relationship between the cost of tooling, the nature of the job and the length of the run
- K27 the commonly occurring faults which can affect efficient tool performance,

what causes them and how to prevent them

K28 how to transfer the die forme image to the stripping board

K29 how to cut the female stripping board

K30 the procedures for the removal of waste

Additional information

Scope / range: You must show that you can produce die formes consistently, over a period of time.

You must show that:

1 you can use the following rule types:

1.1 cutting

1.2 creasing

1.3 scoring

1.4 perforating

2 you can determine rule thickness according to:

2.1 height

2.2 profile

2.3 ejection material type

3 you produce die formes for the following carton styles and closures:

3.1 tube

3.2 tray

3.3 tuck

3.4 glue

3.5 lock

PROCTN403 (SQA Unit Code – H7T9 04)
Produce dies and tooling



Developed by	Proskills
Version number	1
Date approved	October 2013
Indicative review date	April 2018
Validity	Current
Status	Original
Originating organisation	Proskills
Original URN	403
Relevant occupations	Printers; Screen printers; Printing machine minders and assistants; Bookbinders and print finishers; Graphic designers
Suite	Carton Manufacture
Key words	Print; printing; mechanised print finishing and binding; finishing; binding; newspaper; periodical; machine; litho; web offset; flexo; screen print; gravure; pad print; carton manufacture; fibreboard
