Modification history

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| Release | Comments |
| Release 1 | This version released with FBP Food, Beverage and Pharmaceutical Training Package Version 1.0 |

| FBPOPR2019 | Fill and close product in cans |
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| Application | This unit of competency describes the skills and knowledge required to set up, operate, adjust and shut down a primary packaging process that fills product into cans and hermetically seals containers using a closer or seamer.  This unit applies to individuals who work under general supervision and exercise limited autonomy in a food processing packing environment. It typically applies to the production worker responsible for applying basic operating principles to the operation and monitoring of a filling and closing process and associated equipment.  All work must be carried out to comply with workplace procedures, in accordance with State/Territory work health and safety, and food safety regulations, legislation and standards that apply to the workplace.  No occupational licensing, legislative or certification requirements apply to this unit at the time of publication. |
| Prerequisite Unit | Nil |
| Unit Sector | Operational (OPR) |

| Elements | Performance Criteria |
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| Elements describe the essential outcomes. | Performance criteria describe the performance needed to demonstrate achievement of the element. |
| 1. Prepare for work in processing area | 1.1 Read or listen to work instructions from supervisor and clarify where needed  1.2 Identify work health and safety hazards and tell supervisor  1.3 Wear appropriate personal protective equipment and ensure correct fit  1.4 Confirm that materials and packaging components and consumables are available to meet operating and food safety requirements  1.5 Identify and confirm workplace cleaning and maintenance requirements |
| 2. Prepare the filling and closing process for operation | 2.1 Fit and adjust machine components and related attachments according to work health and safety and operating requirements  2.2 Enter operating parameters to meet safety and production requirements  2.3 Carry out pre-start checks, adjusting equipment performance according to operator instructions |
| 3. Operate and monitor the filling process | 3.1 Start, operate and monitor the process for variation in operating conditions according to work health and safety and operating procedures  3.2 Monitor the process to confirm that filled and closed containers meet specifications  3.3 Identify, rectify and report out-of-specification equipment, product and process outcomes according to workplace requirements  3.4 Follow and apply workplace cleaning and environmental procedures |
| 4. Monitor closure and seaming stage | 4.1 Monitor the closing stage to confirm that closures and seams meet specifications  4.2 Identify and report out-of-specification process outcomes according to workplace procedures |
| 5. Shut down the filling and closing process | 5.1 Identify the appropriate shutdown procedure and implement safely according to operating procedures  5.2 Report maintenance requirements according to workplace procedures  5.3 Maintain workplace records according to workplace procedures |

| Foundation Skills  This section describes those language, literacy, numeracy and employment skills that are essential for performance in this unit of competency but are not explicit in the performance criteria. | |
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| Skill | Description |
| Reading | * Interpret workplace and standard operating procedures relevant to job role * Interpret production requirements |
| Writing | * Record operating, routine maintenance and shutdown information on paper-based and electronic media |
| Numeracy | * Monitor and interpret production and process control indicators and data * Monitor supply and flow of materials to and from the process |
| Navigate the world of work | * Apply workplace procedures to own role and responsibilities * Identify skills, knowledge and experience required for performing own role in the workplace * Ask questions to clarify understanding or seek further information |
| Interact with others | * Communicate and report operational and safety information to relevant personnel * Use modes of communication suitable to purpose to confirm understanding when conducting operational start-up and shutdown procedures |
| Get the work done | * Access and interpret process control panels and system * Maintain a clean and hazard-free work area * Identify out-of-specification standards and maintain quality specifications * Confirm equipment status and condition * Interpret process and equipment information to monitor process and respond to abnormal performance and variations |

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| Unit Mapping Information | | | |
| Code and title current version | Code and title previous version | Comments | Equivalence status |
| FBPOPR2019 Fill and close product in cans | FDFOP2019A Fill and close product in cans | Updated to meet Standards for Training Packages | Equivalent unit |

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| Links | Companion Volumes, including Implementation Guides, are available at VETNet:  https://vetnet.education.gov.au/Pages/TrainingDocs.aspx?q=78b15323-cd38-483e-aad7-1159b570a5c4 |

| TITLE | Assessment requirements for FBPOPR2019 Fill and close product in cans |
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| Performance Evidence | |
| An individual demonstrating competency in this unit must satisfy all of the elements and performance criteria of this unit.  There must be evidence that the individual has filled and closed product in cans on at least one occasion, including:   * accessing workplace information to identify processing requirements * selecting, fitting and using PPE * confirming supply of necessary materials and services for filling and closing product in cans * preparing/conditioning product for filling in cans * conducting pre-start checks, including: * inspecting equipment condition to identify any signs of wear * selecting appropriate settings and/or related parameters to suit filling requirements * cancelling isolation or lock-outs as required * confirming that equipment is clean and correctly configured for filling and seaming requirements * positioning sensors and controls correctly * ensuring any scheduled maintenance has been completed * confirming that all safety guards are in place and operational * starting, operating, monitoring and adjusting the filling process and equipment to achieve required outcomes, including monitoring control points, and conducting inspections, as required, to confirm process remains within specification, including: * fill temperatures * headspace * vacuum * visual appearance of the product * line speed/throughput * monitoring supply and flow of materials to and from the process * starting, monitoring and adjusting the closer to confirm alignment and formation of the seam * monitoring control points and conducting inspections related to the seaming/closing process, and confirming that coding is correct * taking corrective action in response to out-of-specification results * responding to and/or reporting equipment failure within level of responsibility * locating emergency stop functions on equipment * following isolation and lock-out/tag-out procedures as required to take process and related equipment off-line in preparation for cleaning and/or maintenance within level of responsibility * completing workplace records as required * conducting shift handover procedures * maintaining work area to meet workplace cleaning standards * using process control systems according to enterprise procedures * inspecting seams according to enterprise procedures * cleaning and sanitising equipment according to enterprise procedures * following relevant work health and safety procedures. | |

| Knowledge Evidence |
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| An individual must be able to demonstrate the knowledge required to perform the tasks outlined in the elements and performance criteria of this unit. This includes knowledge of:   * purpose and basic principles of filling and closing, including the properties and requirements of packaging materials used, hermetic sealing and properties of containers used for this purpose, coding requirements and related legal requirements, including product weight * the flow of this process and the effect of the filling and seaming process on downstream processes * basic operating principles of equipment, including main equipment components, status and purpose of guards, equipment operating capacities and applications, and the purpose and location of sensors and related feedback instrumentation * quality characteristics of the filled and closed container, including seam components and integrity requirements within level of responsibility for inspection * effect of raw material characteristics on filling and seaming * quality parameters for cans and ends * methods used to prepare product for filling * effect of process variables, including headspace, fill temperature and vacuum, on the process * operating requirements and parameters, and corrective action required where operation is outside specified operating parameters, including restart procedures following a crash or jam-up * typical equipment faults and related causes, including signs and symptoms of faulty equipment and early warning signs of potential problems * techniques used to monitor the production/packing process, including inspecting, measuring and testing as required by the process * inspection or test points (control points) in the process and the related procedures and recording requirements * contamination/food safety issues associated with filling and seaming, and related control measures * common causes of variation and corrective action required * work health and safety hazards and controls * requirements of different shutdowns as appropriate to the process and workplace production requirements, including emergency and routine shutdowns, and procedures to follow in the event of a power outage * isolation, lock-out and tag-out procedures and responsibilities * procedures and responsibility for reporting production and performance information * environmental issues and controls relevant to the process, including waste collection and handling procedures related to the process * basic operating principles of process control, where relevant, including the relationship between control panels and systems and the physical equipment * cleaning and sanitation procedures for filling and closing product in cans. |

| Assessment Conditions |
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| Assessment of skills must take place under the following conditions:   * physical conditions: * a workplace or an environment that accurately represents workplace conditions * resources, equipment and materials: * personal protective clothing and equipment * filling and closing and related equipment and services * materials to be filled as required * packaging components/consumables * sampling schedules and test procedures and equipment as required * cleaning procedures, materials and equipment as required * documentation * specifications: * work procedures, including advice on safe work practices, food safety, quality and environmental requirements * production schedule * information on equipment capacity and operating parameters * specifications, control points and operating parameters * recording requirements and procedures.   Assessors of this unit must satisfy the requirements for assessors in applicable vocational education and training legislation, frameworks and/or standards. |

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