



12

Finishing

# 12.4 Roll Coater

## 12.4.1 Coating Plywood Panels

Candidate Name: \_\_\_\_\_ Date/Time: \_\_\_\_\_

Evaluator Name: \_\_\_\_\_ Location: \_\_\_\_\_

Completed test successfully:  Yes  No (If no, reason:) \_\_\_\_\_

### Pre-Operation Checklist

#### Level 1

**PERFORMANCE STANDARD:**

- ▶ Verifies parts are sorted by batch according to thickness.
- ▶ Verifies instructions for proper parts loading, spacing, and/or offset.
- ▶ Verifies product standards and tolerances for rejecting a part.
- ▶ Verifies location and process for stacking rejected parts for transfer to rework.
- ▶ Verifies proper stations are running and supplied with coating.
- ▶ Verifies coating supply is adequate and pumps are functioning.

#### Level 2

**PERFORMANCE STANDARD:**

- ▶ Measures and verifies film thickness meets specifications and product requirements.
- ▶ Verifies correct roller speed and direction.
- ▶ Verifies correct roller pressure.
- ▶ Verifies correct coating viscosity for ambient conditions.
- ▶ Verifies and/or corrects roll calibration.
- ▶ Meets Level 1 Performance Standard.

### Considerations:

- ▶ Pre-Operation Checklist is a prerequisite for ANY operation.
  - ▶ Tool/Machine Manufacturer's safety rules and guidelines are followed.
  - ▶ Verifies tool is properly guarded.
  - ▶ Demonstrates knowledge of and proper use of all machine specific controls.
  - ▶ Proper stance and hand position are demonstrated.
  - ▶ Inspect for evidence of defective finish conditions such as but not limited to chatter marks, streaking or part hesitation.
  - ▶ Spot check product following the operation.
  - ▶ Operator clears machine and cleans work area after use.
  - ▶ Required OSHA approved personal protective equipment is worn.
  - ▶ Lock-out/Tag-out procedure is in place and followed.
  - ▶ Operation is completed in a timely manner.
- Please use back side for additional notes

### Operation Checklist

Level 1:	Performance standard:	
Given a batch of plywood panels dimensioned and ready for coating, and roll coater(s) set up and operating correctly, loads parts on to coating line in-feed.	<input type="checkbox"/> Applies glue line using controlled shop method. <input type="checkbox"/> Loads material into press in timely fashion (within allowed open time of glue). <input type="checkbox"/> Unloads panel safely out of machine. <input type="checkbox"/> Face is smooth with no evidence of delamination.	<input type="checkbox"/> Glued surfaces have minimal glue saturation. <input type="checkbox"/> There is minimal adhesive squeeze-out at edges of substrate

Level 2:	Performance standard:	
Given a batch of plywood panels dimensioned and ready for coating, sets up roll coater(s) to proper operating specifications, and loads parts on to coating line in-feed.	<input type="checkbox"/> Powers up rollers and verifies all are functioning. <input type="checkbox"/> Determines roller speed and time relative to adhesive being utilized. <input type="checkbox"/> Determines that panel meets quality standards. <input type="checkbox"/> Powers down rollers.	<input type="checkbox"/> Meets Level 1 performance standard.