**CONTACT DETAILS OF THE AWARDING BODY FOR THE QUALIFICATION**

**Name and address of awarding body:** Central Institute of Plastics Engineering and Technology (CIPET), Ministry of Chemicals and Fertilizers, Department of Chemicals and Petrochemicals, Govt. of India, Hajipur, Industrial Area, Vaishali, Bihar. 844102.

**Name and contact details of individual dealing with the submission**

Dr. P.C. Padhi, Director& Head, CIPET Hajipur, Industrial Area, Vaishali, Bihar. 844102. Ph: +91-6224-277424,270085,273515.

E-mail address**:**cipetpatna@gmail.com, hajipur@cipet.gov.in

**SUMMARY**

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| **Qualification Title:** Pipe & Profile Extrusion - Machine Operator |
| **Nature and Purpose of the qualification:**  A CIPET trade certificate for Pipe & Profile Extrusion - Machine Operator and the he individual at work sets up and operates the blow moulding machine to produce good quality products from Plastics materials. He is responsible for produce bottles, containers or others hollow objects from plastics resin by operating semi & fully automatic and advance blow Moulding machines, troubleshooting process problems and performing minor maintenance to ensure continued operation of the production line. They are also responsible for completing the output learn Good Manufacturing Practices. |
| **Body/bodies which will award the qualification:**  Central Institute of Plastics Engineering and Technology (CIPET), Ministry of Chemicals and Fertilizers, Department of Chemicals and Petrochemicals, Govt. of India, Hajipur, Industrial Area, Vaishali, Bihar. 844102. |
| **Body which will accredit providers to offer courses leading to the qualification:**  Central Institute of Plastics Engineering and Technology (CIPET), Ministry of Chemicals and Fertilizers, Department of Chemicals and Petrochemicals, Govt. of India, Hajipur, Industrial Area, Vaishali, Bihar. 844102. |
| **Body/bodies which will be responsible for assessment:**  The assessment is being carried out at Central Institute of Plastics Engineering and Technology (CIPET), Ministry of Chemicals and Fertilizers, Department of Chemicals and Petrochemicals, Govt. of India, Hajipur, Industrial Area, Vaishali, Bihar. 844102. |
| **Occupation(s) to which the qualification gives access:**  Pipe & Profile Extrusion - Machine Operator occupation in Plastics product manufacturing process. |
| **Proposed level of the qualification in the NSQF:** |
| **Anticipated volume of training/learning required to complete the qualification:**  720 Notional hours. |
| **Entry requirements / recommendations:**  Minimum qualification – Preferably Min -Class X/ITI, Minimum age - 18 years completed. |
| **Progression from the qualification:**  The Pipe & Profile Extrusion - Machine Operator has a clear pathway. |
| **Planned arrangements for the Recognition of Prior learning (RPL):**  RPL arrangements are being developed and will be informed in due course of time. |
| **International comparability where known:** It will be carried out in next phase as comparability is being verified. |
| **Date of planned review of Qualification:** 20.10.2017 |

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| **Format Structure of the Qualification:** | | | |
| **Title and Identification code of component** | **Mandatory/ Optional** | **Estimated Size (Notional Hours)** | **Level** |
| 1. Basics Plastics Raw Material &   Extrusion Concept | M | 120 |  |
| 1. Health and safety practices   maintaining at workplace | M | 60 |  |
| 1. Plastics Compounding / Mixing | M | 60 |  |
| 1. Perform the HDPE /PVC Pipe   Extruder Machine Operation | M | 90 |  |
| 1. Perform the Plastic Film   Extruder Machine Operation | M | 150 |  |
| 1. To Carryout House Keeping | M | 120 |  |
| 1. Reporting & Documentation | M | 60 |  |
| 1. To Carry Out Quality Checks | M | 60 |  |
|  |  | 720 |  |

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| **Body/Bodies which will carry out assessment:**  A Separate department/ body -Training Assessment Wing of Central Institute of Plastics  Engineering and Technology (CIPET), Ministry of Chemicals and Fertilizers, Department of Chemicals and Petrochemicals, Govt. Of India, Hajipur, Vaishali, Bihar 844102.  **Will the assessment body be responsible for RPL assessment?**  RPL arrangements are being developed and will be informed in due course of time.  **Describe the overall assessment strategy and specific arrangements which have been put in place to ensure that assessment is always valid, consistent and fair and show that these are in**  **line with the requirements of the NSQF:**  With uniformity and setting of learning outcomes for different Jobs Roles the assessment of candidates will be at learning outcome level. Assessment criterion has been defined for each learning outcome and it includes both theoretical and practical skills on which the candidate will be assessed. The question suite which will be used to check the skills of the trainee would include  **Theoretical test suite –** Will include multiple choice questions, audio-video question etc.  which will test the trainee on his knowledge of the subject  **Practical Knowledge suite –** Practical knowledge can be tested through Assessor driven evaluation/test, Situational Judgment Tests etc to test practical core competence. A mix of these would be able to evaluate the trainee on his practical knowledge of the  Qualification Document.  **Assessment strategy:**   1. Assessment criteria for Qualification Document have been developed. Each Learning Outcome have separate marks for Theory and Practical Skills. 2. The Training Assessment Wing will have assessors who will not be associated with training activities and will be provided training on the said work. Thus it will ensure that the assessment carried out is fair and consistent. 3. Set of question bank developed to assess the theoretical and practical knowledge. To   ensure the quality, each trainees get the unique set of question   1. Student has to score minimum marks separately for theoretical and practical skill and overall percentage should also be 50% for theory and 70% for practical. 2. Empanelment of subject matter expert as assessor to assess trainee specifically on practical skills 3. Assessments are preferably conducted by written examination papers in English/   regional languages according to the requirement.   1. It has been ensure that TP/trainer should not be present during assessment |

**Assessment Process Flow:**

**Request for evaluation of batch by**

**Training Partner**



**Allocation of batch to Training Assessment wing**



**Evaluation of batch by Training Assessment wing as per schedule and as per Assessment Process**



**Assessment observation data input sheet from Training Assessment wing including viva, practical and theory marks**



**Result finalization**



**Uploading of result on IT database platform**

**Summative Assessment**:

Based on the Total Marks allotted for the specific subject, formal evaluation shall be conducted. Based on secured marks, candidates shall be declared pass or fail.

Steps undertaken for summative assessment:

1. Based on Completion of Batch, Evaluation Schedule shall be prepared
2. Identified Assessor is nominated for Evaluation
3. Setting up of separate Question Paper for Theory & Practical Examination
4. Conduct of examination as per the schedule
5. Evaluation & Certification

**Evidence Collected during Assessment:** Theoretical Answer Sheets, Practical Exam Sheets,Evaluation Sheets, Jobs produced during practical Exams.

**Protocol for Selection of Assessors:**

* The Assessors should have the minimum qualification: Degree in Engineering.
* The Assessors should have minimum 5 years of Experience in the relevant field.

**ASSESSMENT EVIDENCE**

**Assessment Guidelines:**

1. Criteria for assessment for each Qualification Document will be created by CIPET.
2. Each Assessable outcome (AO) will be assigned marks proportional to its importance in Learning Outcome and few performance criteria may be allotted marks in combine.
3. Each Learning Outcome will be assessed both for theoretical knowledge and practical which is being proportionately demonstrated in the table below.
4. The assessment for the theory part will be based on knowledge bank of questions created by CIPET which will contain multiple choice theory questions and Practical question database with mark allotment criteria.
5. To pass the Qualification Document, every trainee should score a minimum of 50 % in Functional and all Generic Learning Outcome’s.
6. In case of successfully passing only certain number of Learning Outcome’s, the trainee is eligible to take Subsequent assessment on the balance Learning Outcome’s to pass the Qualification Document.

**Title of the Component:** Pipe & Profile Extrusion - Machine Operator

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| **Assessable outcome** | | **Assessment criteria for the**  **outcome** | | |
| **LO** | **Assessable outcome Description** | **Theory** | **Practical** | **Total** |
| 1. Basics Plastics Raw Material & ExtrusionConcept | AO1. Understanding Types of Plastics used in Extrusion and Its Properties  AO2. Selection Plastics Raw Materials based on the Items Produced.  AO3. Storing and Handling of Raw Materials and House Keeping  AO4. Types of Extruders Used in the Extrusion Process and their Parts  AO5. Types of Dies Used for different Extruded Products.  AO6. Haul Off Units 2 6 8  AO7. Storing and Handling of Finished Products and House Keeping.  AO8. Types of Additives, Master Batches  AO9. Types of Mixing and Compounding  AO10. Measurement of Additives and Materials and  Maintaining Formulations.  AO11. Storing, Handling of Raw Materials in Compounding Area and House Keeping  AO12. Understanding Safety Equipments and Its Use.  AO13. Do’s and Don’t in Area of Operation  AO14. Safety Precaution Majors before Operations. | 36 | 84 | 120 |
|  | **Sub total** | 36 | 84 | 120 |
| 1. Health and safety practicesmaintaining at work place. | AO1. Identify activities which can cause potential injury  through sharp objects, burns, fall, electricity, gas leakages, radiation, poisonous fumes, chemicals, loud noise etc  AO2. Identify areas in the work places which are potentially  hazardous/ unhygienic in nature  AO3. Conduct regular checks with support of the  maintenance team on machine health to identify potential hazards due to wear and tear of machine  AO4. Inform the concerned authorities about the potential risks identified in the processes, workplace area/ layout, materials used etc  AO5. Inform the concerned authorities about machine  breakdowns, damages which can potentially harm man/ machine during operations  AO6. Create awareness amongst other by sharing  information on the identified risks  AO7. Support the Safety team and the supervisor in creating the risk mitigation plan  AO8. Follow the instructions given on the equipment manual  describing the operating process of the equipment  AO9. Follow the Safety, Health and Environment related practices developed by the organization  AO10. Ensure relevant safety boards/ signs are placed on the shop floor  AO11. Operate the machine using the recommended  Personal Protective Equipment (PPE) and ensure team members also use the related PPEs at the workplace  AO12. Maintain a clean and safe working environment near the work place and ensure there is no spillage of chemicals,  production waste, oil, solvents etc.  AO13. Attend all safety and fire drills to be self-aware of safety hazards and preventive techniques  AO14. Maintain high standards of personal hygiene at the work place  AO13. Ensure that the waste disposal is done in the  designated area and manner as per organization SOP.  AO16. Inform appropriately the medical officer/ HR in case of  self or an employee’s illness of contagious nature so that preventive actions can be planned for others  AO17. Immediate First Aid action to be taken in case of any fatal accident due to Fire, Electricity, Gas, Chemicals etc  AO18. Immediate Action to be taken in case Fire, Gas, Chemicals etc | 24 | 56 | 80 |
|  | **Sub total** | 24 | 56 | 80 |
| 1. Plastics   Compounding /Mixing | AO1. Understanding Types of Chemicals, Additives and Colorants.  AO2. Properties and Importance of Chemicals, Additives and Colorants and Pigments.  AO3. Properties changes by adding Chemicals, additives and pigments in Plastics.  AO4. Formulation laid down for different Products.  AO5. Types of Blenders , Mixers and their Parts  AO6. Preparation Batches as per the formulations.  AO7. Loading and unloading of Batches.  AO8. Temperature, Pressure and Speed involved in Blenders and Mixers.  AO9. Importance of each and every Parameters.  AO10. Precaution to be taken care during the batch  preparation.  AO11. Storing of batches after preparation.  AO12. Understanding Safety Equipments and Its Use.  AO13. Do’s and Don’t in Area of Operation  AO14. Safety Precaution Majors before Operations. | 24 | 56 | 80 |
|  | Sub total | 24 | 56 | 80 |
| 4.  Perform the  HDPE /PVC  Pipe Extruder  Machine  Operation | AO1. Types of HDPE / PVC Extruders.  AO2. Extruder Parts and Their Functions.  AO3. Pressure and Vacuum Sizing Units  AO4. Types of Dies Used for different Extruded Pipes.  AO5. Operations of Haul Off Units  AO6. Dismantling and assembling Extruder Parts.  AO7. Safety Precaution taken during assembling and  disassembling.  AO8. Common Process Parameter like Temperature, Pressure and Speed and its controls.  AO9. Effect of process parameters on Product Properties  AO10. Trial Production and checking product stabilization.  AO11. Actual Production and Parameter / Process Control.  AO12. Quality Check and Continuous Production.  AO13. Post production and storing.  AO14. Common faults found and trouble shooting.  AO15. Segregation of faulty product and action taken.  AO16. Disposal of faulty products as per laid down  procedure.  AO17. Understanding Safety Equipments and Its Use.  AO18. Do’s and Don’t in Area of Operation  AO19. Safety Precaution Majors before Operations. | 27 | 63 | 90 |
|  | Sub total | 27 | 63 | 90 |
| 5.  Perform the  Plastic Film  Extruder Machine  Operation | AO1. Types of Film Extruders.  AO2. Extruder Parts and Their Functions.  AO3. Air Compressor Pressure Sizing Units  AO4. Types of Dies Used for different Extruded Films.  AO5. Operations of Haul Off Units  AO6. Dismantling and assembling Extruder Parts.  AO7. Safety Precaution taken during assembling and  disassembling.  AO8. Common Process Parameter like Temperature, Pressure  and Speed and its controls.  AO9. Effect of process parameters on Product Properties  AO1. Trial Production and checking product stabilization.  AO2. Actual Production and Parameter / Process Control.  AO3. Quality Check and Continuous Production.Post  production and storing.  AO14. Common faults found and trouble shooting.  AO15. Segregation of faulty product and action taken.  AO16. Disposal of faulty products as per laid down  procedure.  AO17. Understanding Safety Equipments and Its Use.  AO18. Do’s and Don’t in Area of Operation  AO19. Safety Precaution Majors before Operations. | 45 | 105 | 150 |
|  | Sub total | 45 | 105 | 150 |
| 6.  To Carryout  House Keeping. | AO1. Take an overlook of the Area under House Keeping.  AO2. Put appropriate Signage immediately if oily substance / Water spills on the floor to avoid accident  AO3. If certain housekeeping activities require to be  performed by housekeeping staffs, the Inform them.  AO4. If it has to be carried out by self then, Identify the material / equipment required for cleaning the areas.  AO5. Plan the sequence for cleaning the area to avoid resoiling  the cleaned areas and surfaces.  AO6. Display the appropriate signage for the work being conducted.  AO7. Ensure that there is adequate ventilation for the work being carried out.  AO8. Wear the personal protective equipment required for  the cleaning method and materials being used.  AO9. With right cleaning process carry out cleaning activities without disturbing others.  AO10. Report to the appropriate person if any difficulties in  carrying out your work.  AO11. Ensure that there is no oily substance / Water spill on the floor, If found the put the Signage immediately to avoid  accident.  AO12. Follow workplace procedures to deal with any  accidental damage caused during the cleaning process.  AO13. Ensure that, on completion of the work, the area is left clean and dry and free from any leftover or scrap.  AO14. Return the equipment, materials and personal  protective equipment that were used to the right places and check the inventory for the next cycle.  AO15. Dispose the waste garnered from the activity in an appropriate manner.  AO16. Maintain schedules and records for housekeeping duty. | 36 | 84 | 120 |
|  | Sub total | 36 | 84 | 120 |
| 7. CPC/N0325 :  Reporting &  Documentation | AO1. Report data/problems/incidents as per the laid down procedure in the prescribed format and registers.  AO2. Report to the appropriate authority as laid down by the company procedure.  AO3. Identify documentation to be completed relating to the job profile.  AO4. Record details accurately in an appropriate format.  AO5. Complete all documentation within stipulated time according to company procedure.  AO6. Make sure documents are available to all appropriate authorities to inspect  AO7. Respond to requests for information in an appropriate manner whilst following organizational procedures.  AO8. Inform the appropriate authority of requests for information received. | 24 | 56 | 80 |
|  | Sub total | 24 | 56 | 80 |
| 8. CPC/N0326 :  To Carry Out  Quality Checks | AO1. Ensure that total range of checks as per the prescribed national and International standards on regular intervals throughout the shifts.  AO2. Use appropriate measuring instruments, equipment,  tools, accessories etc, as prescribed / required  AO3. Identify non-conformities to quality assurance  standards.  AO4. Identify potential causes of non-conformities to quality assurance standards  AO5. Identify impact on final product due to non conformance  to prescribed Standards.  AO6. Evaluating the need for action to ensure that problems do not reoccur.  AO7. Suggest corrective action to address problem.  AO8. Review effectiveness of corrective action.  AO9. Interpret the results of the quality check correctly  AO10. Take up results of the findings with QC in  charge/appropriate authority.  AO11. Take up the results of the findings within stipulated time  AO12. Record of results of action taken.  AO13. Record adjustments not covered by established  procedures for future reference.  AO14. Review effectiveness of action taken.  AO15. Follow reporting procedures where the cause of  defect cannot be identified. | 24 | 56 | 80 |
|  | Sub Total | 24 | 56 | 80 |
|  | Total | 216 | 504 | 720 |
| **Means of assessment 1:**  The assessment comprise of -Theory Assessment  Viva voce  Practical assessment | | | | |
| **Means of assessment 2:**  Pass/Fail-  The Pass mark of theory written assessment is 50% and for viva and practical assessment is 70%.  The candidate has to pass separately in Theory and Practical. | | | | |

**EVIDENCE OF LEVEL**

**Level of qualification**

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| **Title /Name of Qualification/Component:** Pipe & Profile Extrusion - Machine Operator  **Level:** | | | |
| **NSQF Domain** | **Outcomes of the**  **Qualification/Component** | **How the job role**  **relates to the NSQF**  **Level descriptors** | **NSQF**  **Level** |
| **Process** | Pipe & Profile Extrusion - Machine Operator is expected to ensure housekeeping and  safety in the production area and select  the correct die, etc he/she has to-  Understanding the work order and  the process requirement from the  supervisor  Arranging the required raw  material and Dies for the process  To interact with the supervisor in  order to understand the  production schedule  To plan the day’s production  activities based on the supervisor’s  instructions  To collect material data sheet,  machine instructions and work  manuals  To ensure availability of  consumables and plastics  materials for production in  sufficient quantity as per  production plan/supervisor  instructions.  Clearly understanding the does  and don’ts of the manufacturing  process as defined in SOPs/ Work  Instructions or defined by  supervisors.  Check availability of the personal  protective equipment’s (PPE) like  Gloves, Goggles etc.  Ensure that the required material  is procured from the store before  starting the process  Understand the dies required for  executing the required operation  and ensure that the same is  available for operation.  If die is not available collect the  same from die storage area  Add the raw material in the  machine using material loader or  by manual feeding.  Ensure dies are clean if not clean  with soft cotton cloth.  Ensure cleaning of the area around  the apparatus for any oil, grease,  combustible substances etc. so as  to prevent any accident  Ensure availability of the coolant  and working of valves to circulate  the coolant to cool and solidify  plastic  Understand the raw material like  plastics granules, fillers, bonding  additives etc. required for  executing the activity  Refer the queries to supervisor if  they cannot be resolved by the  operator  Confirm self - understanding to the  supervisor once the query is  resolved so that all doubts &  queries can be resolved before the  actual process execution  He is responsible for checking the  operations of the equipment  Feeding the granules as per  requirement  Perform visual inspection of the  output products  Achieve productivity, quality and  safety standards as per company’s  norms  Report problems to supervisor  He will be responsible for  Inspecting the finished components  keeping records of production and  defects  conducting minor repair/deflashing  if any on output parts  which can be reworked  The role holder will interact with  maintenance team and material  management team  The individual needs to ensure  sorting, streamlining & organizing,  storage and documentation,  cleaning, standardization and  sustenance across the plant and  office premises of the organization  He needs to understand Market  Information Management  Client Relation Management  Marketing knowhow and strategy  He also needs to understand and  practice Entering, update and  maintain data in MS Office  system/ Office open source  system. | Pipe & Profile Extrusion - Machine Operator job requires  limited range of  activities which  are familiar and  predictable like  availability of  consumables,  safety PPE, raw  material used,  basic machine  parts and its  functions etc.  He should  understand the  raw material like  plastics granules,  fillers, bonding  additives etc.  required for  executing the  activity, Dies  required, their  types etc. |  |
| **Professional**  **knowledge** | The user/individual on the job needs to  know and understand:  raw material like plastics granules,  fillers, bonding additives etc.  required for executing the activity  Storing and Handling of Raw  Materials and House Keeping  Machine Cleanliness and safety  requirements for commencing  Compounding Mixing & Blender.  General Principle, process  knowledge & working procedure  of extrusion machine.  Identification & troubleshooting  the various defects in products  produced in extrusion machine. | Machine Operator  - Plastics Extrusion  should  understand and  know factual  knowledge about  process, principle  of plastics  extrusion  Technique and its  operation, trouble  shooting, Quality  and Inspection  etc. |  |
| **Professional**  **skill** | The user/individual on the job needs to  know and understand:  General principles of plastics  extrusion and process  knowledge, die loading and unloading procedure, parameter  settings etc.  Types of plastics like  thermoplastics and the additives  & grades to be used tonnage and  capacity of the machine being  operated.  Different types of tools and  machinery to process the plastic  and trim the output  Various types of cooling systems  and their properties.  How to perform extrusion  machine safety check  Hazards and safety aspects  involved in tape production and  usage of relevant PPEs  Safety procedures to be adopted  to complete die removal process  Detect problems in day to day  tasks:  Support operator in using  specific problem solving  techniques and detailing out the  problems  Discuss possible solution with the  supervisor for problem solving.  The user/individual on the job needs to  know and understand how to:  Plan and organize the work order  and jobs received from the  internal customers/ operator.  Organize all process/ equipment  manuals so that sorting out  The user/individual on the job needs to  know and understand how to:  Follow instructions and work on  areas of improvement identified  Complete the assigned tasks with  minimum supervision  Complete the job defined by the  operator within the timelines and  quality.  The user/individual on the job  needs to know and understand  how to:  Use common sense and make  judgments during day to day  basis  Use basic reasoning skills to  identify and resolve basic  problems  Use intuition to detect any  potential problems which could  arise during operations.  He needs to know about  entrepreneurship associated with  plastics extrusion, its concepts  etc.  He needs to know about  marketing strategy involved for  the products manufactured,  market availability etc | Pipe & Profile Extrusion - Machine Operator should recall  general principles of Plastics  Extrusion  procedure and  process  knowledge which  may be repetitive  type of work in  the area allotted,  Types of plastics  like  thermoplastics  and the additives  & grades to be  used, Dies, Its  types, application  etc. Thus he  should  demonstrate  practical skill,  routine and  repetitive in  Plastics Extrusion  application/  process, he should  also understand  quality concepts  and use in the  area of work  allotted. |  |
| **Core skill** | The user/ individual on the job needs to  know and understand how to:  How to be able to read warnings,  instructions and other text  material on product labels,  components etc  How to enter into the history  card details of the fault identified  in the plastic product  manufactured read equipment  manuals and process documents  to understand the equipment  and processes better.  Read instructions especially  safety instructions especially  symbols while using the  equipment in the plant area logs.  The user/individual on the job needs to  know and understand how to:  Discuss task lists, schedules, and  work-loads with coworkers/  assistants and  supervisors  Question internal customers/  Shop floor operator  appropriately in order to  understand the nature of the  problem and make a diagLOis  Avoid using jargon, slang or acronyms when communicating  with a operator /fellow  subordinates etc. Unless it is  required. | Machine  Operator -  Plastics Extrusion  should be able  to read /write  warnings,  instructions and  other text  material on  product labels,  components etc  with minimum  required clarity,  should have skill  of basic  arithmetic, like  raw material  weights additions  etc. |  |
| **Responsibility** | Pipe & Profile Extrusion - Machine Operator is responsible for his own job and self learning.  He/she Set up basic as well as  all critical process parameters, plastics  raw material handling and operate  Plastics Extrusion Machine in order to  produce good quality products as per  approved specifications by supervisor.  He may need to control/ check multiple  machines at a time. | Pipe & Profile Extrusion - Machine Operator is responsible for  for plastics raw  material  handling, mixing  / compounding  (if required),  performing the  extrusion  operation to  produce Plastics  Pipes / Films as  per the  requirements |  |

**EVIDENCE OF RECOGNITION AND PROGRESSION**

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| **What steps have been taken in the design of this or other qualifications to ensure that there is a clear path to other qualifications in this sector?**  Relevant information was collected from Industries and allied sector working in this area.  The Plastics industries are recruiting people based on the qualification acquired. Maximum of the industries accept this as qualification for selection/short listing of the individual approved by members.  **Vertical Pathway:**  The Occupational Map has been created & attached.  The Pipe & Profile Extrusion - Machine Operator has a clear pathway  **Horizontal Pathway:**  The individual can migrate within the Plastics Processing related industries. |