Line 3 induction: from aluminium slug to packed tube

New starter training · Quillbank Packaging, Tube Plant · Production operators and packers · Revision 4

Line 3 makes collapsible aluminium tubes for creams and gels, about **9,000 tubes an hour**. In your first week you'll work beside a trained operator (your buddy). This guide explains what each machine does, what you must wear, and the three rules that keep everyone safe.

What you must wear on the line

Item	When
Safety shoes with steel toe caps	Always, from the changing room onwards
Hearing protection (ear plugs or ear muffs)	Always near the impact press: it's louder than 85 dB
Safety glasses	Always on the shop floor
Cut-resistant gloves	When handling trimmed tubes or changing trimmer blades
Hair net, no jewellery	Always: loose items can be pulled into rollers

The six stations of Line 3

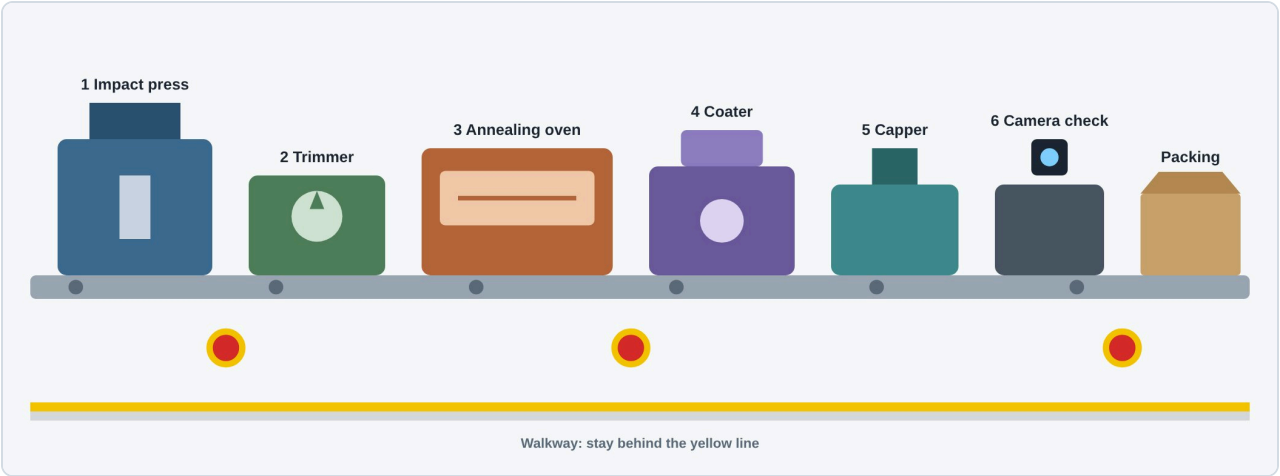

Figure 1. Line 3 from left to right, with the three red emergency stop buttons and the walkway.

1. **Impact press** (far left): a small aluminium disc, the slug, is struck once and flows up into a tube shape in a fraction of a second.

2. **Trimmer**: cuts the open end of the tube to the exact length and cuts the thread on the nozzle.
3. **Annealing oven** (the long orange machine): softens the metal at about 450 °C so the tube can be squeezed without cracking.
4. **Coater**: sprays the inside with a protective lacquer and prints the outside.
5. **Capper**: screws on the cap.
6. **Camera check** (far right): photographs every tube and pushes any faulty one into the reject bin before packing.

Three rules for everyone

> **1. Know where the stop buttons are.** There are three red emergency stop buttons: after the impact press, between the oven and the coater, and before packing. Press one if anyone is in danger. You will never be in trouble for stopping the line.

> **2. Stay behind the yellow line** while the line is running. Only trained operators go past it, and only after the line is stopped and locked.

> **3. Never clear a jam by hand.** Stop the line, call your buddy or the shift lead, and wait. Jams in the trimmer and the capper cause most hand injuries in tube plants.

Your shift

Time	What happens
05:50	Arrive, change, put on your PPE
06:00	Handover from the night shift at the Line 3 board
06:15	Start-up checks with your buddy, then the line starts
Every hour	Take 5 tubes from after the capper and check length, print and cap
10:00 and 12:30	Breaks (the line keeps running; your buddy covers you)
14:00	Handover to the afternoon shift

Why tubes were rejected last month

The camera check rejected 18,400 tubes in October. The reasons:

Reason	Share of rejected tubes

Print smudged or out of place	38%
Wrong length after trimming	26%
Dents from the conveyor	21%
Cap missing or crooked	15%

Your hourly 5-tube check catches most of these early, before a whole hour of tubes is wasted.

Your first week

- **Day 1:** this induction, a walk along the line with your buddy, PPE fitting.
- **Days 2–3:** packing station and the hourly tube check.
- **Days 4–5:** start-up checks and the camera reject bin, with your buddy watching.

Questions? Ask your buddy or the Line 3 shift lead. The first aid room is next to the changing rooms.