



LEATHER
SECTOR
SKILL
COUNCIL

Qualification Pack



Transforming the skill landscape



Knitting machine operator - Footwear

QP Code:

NSQF Level: 4

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Brief Job Description

Knitting machine operator operates the knitting machine to produce shoe uppers, repair the yarn related faults, operates the ancillary units of knitt machines, identify and sort the wastes, demonstrate and check the quality of the product during production, repair or report the non conforming products.

Personal Attributes

This job requires the individual to be able to coordinate internally and externally within the organization. Individual should be able to demonstrate good mathematical reasoning, management skills and good relationship builder with others. A individual with good eyesight, Hand - eye co ordination with good motor skills required.

Applicable National Occupational Standards (NOS)

Compulsory NOS:

1. [TSC/N4106: Operate the flat bed knitting machine](#)
2. [TSC/N4107: Piecing the yarn and doffing the fabric roll in the knitting machine](#)
3. [TSC/N4108: Repair yarn related faults in Flat Bed Knitting](#)
4. [LSS/N7303: Contribute to achieving product quality in knitting operations](#)
5. [LSS/N8501: Maintain the work area, tools and machines](#)
6. [LSS/N8601: Maintain health, safety and security at workplace](#)
7. [LSS/N8701: Comply with industry, regulatory and organizational requirements](#)

Qualification Pack (QP) Parameters

Sector	Leather
Sub-Sector	Non-Leather Footwear
Occupation	Knitting (Non - Leather Footwear)
Country	India
NSQF Level	4
Aligned to NCO/ISCO/ISIC Code	NCO-2015/8152.09

Minimum Educational Qualification & Experience	5th Class with 0-6 Months of experience Basic knowledge of Knitting process is desirable but not mandatory
Minimum Level of Education for Training in School	5th Class
Pre-Requisite License or Training	NA
Minimum Job Entry Age	18 Years
Last Reviewed On	NA
Next Review Date	NA
NSQC Approval Date	
Version	1.0

TSC/N4106: Operate the flat bed knitting machine

Description

This unit is about carrying out procedure for operating the sequence of flat knitting machine

Scope

This unit/task covers the following: operate the knitting machine repair yarn related faults at the knitting head and fabric press-offs carry out maintenance activities material handling and safety at workplace other tenting responsibilities

Elements and Performance Criteria

Operate the knitting machine

To be competent, the user/individual on the job must be able to:

1. start the machine
2. operate the control switches for starting and stopping the knitting machine
3. follow the signal lamps used in machines
4. ensure proper functioning of the knitting machine by verifying the display panel
5. ensure the machines are operated in accordance with workplace procedures.
6. ensure the yarns are run through correct yarn-paths at operating tensions according to machine-builder's instructions
7. ensure the production is monitored for faults, and variations notified, in accordance with workplace procedures.
8. ensure the machines are monitored for continuous functioning of all systems, and variations notified, in accordance with workplace procedures.
9. ensure the production is removed from machines in accordance with workplace procedures.
10. ensure the documentation of production is completed in accordance with workplace procedures.
11. ensure the machines are lubricated as directed in the machine manual
12. ensure the yarn paths, eyelets, knitting heads, machines, and working environment are clean and free of contamination.
13. check whether the yarns are properly fed in the knitting machine
14. knot the yarn in case of breakage
15. doff the full fabric roll
16. view the display panel or signal and identify the reasons for machine stoppages if any
17. ensure the knitting machine is running in the set speed by viewing the display panel
18. ensure the working area is clean
19. ensure proper functioning of machine

Repair yarn related faults at the knitting head and fabric press-offs

To be competent, the user/individual on the job must be able to:

20. rethread incorrectly-positioned yarns in accordance with workplace procedures.
21. join broken yarns or new ends
22. fix fabric press-offs

23. reset machines for restart
24. Arrange after fault correction, style changes, and pattern changes
25. ensure the feeder is working properly and yarn is uniformly fed into the feeder.

Carry out maintenance activities

To be competent, the user/individual on the job must be able to:

26. support the fitter for carrying out maintenance activities
27. ensure the gsm, loop length variation is within the limits and if it's abnormal report it to superiors.
28. inform the supervisor and maintenance incharge in case of a jam
29. support the fitter during minor breakdown
30. ancillary process machines are operated in accordance with machine-builder's instructions
31. safety precautions that comply with workplace procedures are observed.
32. the working environment is kept clean and free of contamination

Material handling and safety at workplace

To be competent, the user/individual on the job must be able to:

33. ensure proper material handling of yarn, cone and empty cone
34. ensure using proper material handling of tools and equipments
35. ensure safety while operating the machine.
36. using of safety gadgets like caps, masks, ear plugs and shoes and verifying the safety stop motions

Other tenting responsibilities

To be competent, the user/individual on the job must be able to:

37. ensure the fabric produced is free from outside damages
38. collect usable waste to be weighed at shift end and to be placed in the specified area
39. inform superiors immediately, if any break down or fault in the machine is noticed
40. ensure the proper functioning of signal lamps
41. ensure that machine is always working properly, if any deviations inform superiors immediately
42. identify yarn wastes by fibre content and sorted according to workplace procedures
43. identify fabric wastes are identified and sorted according to workplace procedures.
44. provide all relevant information of the current working process to the next shift operator before relieving

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** standard operating procedures (SOP) and regulations in a knitting mill
- KU2.** safe working practices to be adopted in knitting mill
- KU3.** quality systems and other processes practiced in the knitting unit of the mill
- KU4.** reporting to the supervisor or higher authority in case of emergency
- KU5.** color coding adopted for different counts/products in the knitting mill
- KU6.** process and material flow in a knitting unit of the mill

- KU7.** understanding the importance of yarn, types of yarn, yarn count, types of fabric, loop length, gsm, importance of yarn and fabric quality
- KU8.** importance of flat knitting machine, various parts in a knitting machine and their functions
- KU9.** function of a feeder
- KU10.** importance & functions of signal lamps
- KU11.** different control buttons in knitting machine
- KU12.** knowledge of different functions in display panel and procedure to operate the knitting machine
- KU13.** types of waste
- KU14.** procedure for collecting waste
- KU15.** guidelines for operating the material handling tools and equipments
- KU16.** importance of cleanliness at work place
- KU17.** procedure to identify the normal defects in fabric and actions needed to correct them
- KU18.** guidelines for carrying out cleaning activities
- KU19.** guidelines for carrying out maintenance activities
- KU20.** importance of material handling
- KU21.** types of material handling equipments used
- KU22.** functions and methodology for operating different material handling equipments
- KU23.** safety gadgets used in a knitting department

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** write clear and short sentences
- GS2.** read and comprehend written instructions
- GS3.** communicate with supervisor appropriately
- GS4.** talk to others to convey information effectively
- GS5.** apply problem-solving approaches in different situations
- GS6.** refer anomalies to the supervisor
- GS7.** seek clarification on problems from others
- GS8.** apply good attention to detail
- GS9.** check your work is complete and free from errors
- GS10.** Procedure to identify and remove the defects in fabric
- GS11.** Procedure for cleaning the wastes and waste segregation
- GS12.** Procedure to carryout cleaning activities in knitting machine
- GS13.** Procedure for cleaning the knitting machine area.
- GS14.** Procedure to carryout basic maintenance activities in knitting machine
- GS15.** Maintain cleanliness at work place

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Operate the knitting machine</i>	26	43	-	32
1. start the machine	1	2	-	1
2. operate the control switches for starting and stopping the knitting machine	1	2	-	1
3. follow the signal lamps used in machines	1	2	-	2
4. ensure proper functioning of the knitting machine by verifying the display panel	1	2	-	1
5. ensure the machines are operated in accordance with workplace procedures.	1	2	-	1
6. ensure the yarns are run through correct yarn-paths at operating tensions according to machine-builder's instructions	2	2	-	2
7. ensure the production is monitored for faults, and variations notified, in accordance with workplace procedures.	1	3	-	2
8. ensure the machines are monitored for continuous functioning of all systems, and variations notified, in accordance with workplace procedures.	1	2	-	2
9. ensure the production is removed from machines in accordance with workplace procedures.	1	2	-	2
10. ensure the documentation of production is completed in accordance with workplace procedures.	2	2	-	2
11. ensure the machines are lubricated as directed in the machine manual	1	2	-	2
12. ensure the yarn paths, eyelets, knitting heads, machines, and working environment are clean and free of contamination.	2	2	-	2
13. check whether the yarns are properly fed in the knitting machine	2	4	-	2
14. knot the yarn in case of breakage	1	2	-	1

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
15. doff the full fabric roll	1	2	-	2
16. view the display panel or signal and identify the reasons for machine stoppages if any	2	4	-	2
17. ensure the knitting machine is running in the set speed by viewing the display panel	2	2	-	2
18. ensure the working area is clean	2	3	-	2
19. ensure proper functioning of machine	1	1	-	1
<i>Repair yarn related faults at the knitting head and fabric press-offs</i>	6	11	-	9
20. rethread incorrectly-positioned yarns in accordance with workplace procedures.	1	2	-	2
21. join broken yarns or new ends	1	2	-	2
22. fix fabric press-offs	1	1	-	1
23. reset machines for restart	1	2	-	1
24. Arrange after fault correction, style changes, and pattern changes	1	2	-	2
25. ensure the feeder is working properly and yarn is uniformly fed into the feeder.	1	2	-	1
<i>Carry out maintenance activities</i>	7	14	-	8
26. support the fitter for carrying out maintenance activities	1	2	-	1
27. ensure the gsm, loop length variation is within the limits and if it's abnormal report it to superiors.	1	2	-	1
28. inform the supervisor and maintenance incharge in case of a jam	1	2	-	1
29. support the fitter during minor breakdown	1	2	-	1
30. ancillary process machines are operated in accordance with machine-builder's instructions	1	2	-	1
31. safety precautions that comply with workplace procedures are observed.	1	2	-	2

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
32. the working environment is kept clean and free of contamination	1	2	-	1
<i>Material handling and safety at workplace</i>	4	7	-	4
33. ensure proper material handling of yarn, cone and empty cone	1	2	-	1
34. ensure using proper material handling of tools and equipments	1	2	-	1
35. ensure safety while operating the machine.	1	2	-	1
36. using of safety gadgets like caps, masks, ear plugs and shoes and verifying the safety stop motions	1	1	-	1
<i>Other tenting responsibilities</i>	9	11	-	9
37. ensure the fabric produced is free from outside damages	1	1	-	1
38. collect usable waste to be weighed at shift end and to be placed in the specified area	1	1	-	1
39. inform superiors immediately, if any break down or fault in the machine is noticed	1	1	-	1
40. ensure the proper functioning of signal lamps	1	1	-	1
41. ensure that machine is always working properly, if any deviations inform superiors immediately	2	3	-	2
42. identify yarn wastes by fibre content and sorted according to workplace procedures	1	1	-	1
43. identify fabric wastes are identified and sorted according to workplace procedures.	1	1	-	1
44. provide all relevant information of the current working process to the next shift operator before relieving	1	2	-	1
NOS Total	52	86	-	62

National Occupational Standards (NOS) Parameters

NOS Code	TSC/N4106
NOS Name	Operate the flat bed knitting machine
Sector	Textiles & Handlooms
Sub-Sector	Knitting
Occupation	Knitting
NSQF Level	4
Credits	TBD
Version	1.0
Last Reviewed Date	21/01/2015
Next Review Date	01/03/2016
NSQC Clearance Date	05/08/2015

TSC/N4107: Piecing the yarn and doffing the fabric roll in the knitting machine

Description

This unit is about carrying out piecing, cleaning and maintenance activities in the knitting department

Scope

This unit/task covers the following: Attending the machine on yarn breakage Piecing the yarn Checking the quality of piecing Carryout doffing

Elements and Performance Criteria

Attending the machine on yarn breakage

To be competent, the user/individual on the job must be able to:

1. identify the machine stoppage by viewing the signal lamps and in display panel
2. identify the reasons for yarn breakage
3. ensure minimum time is taken for attending the yarn breakage in carding department

Piecing the yarn

To be competent, the user/individual on the job must be able to:

4. unwind the yarn from the cone
5. ensure proper piecing
6. draw the yarn through the guide, guide rollers and pass it through the stop motion into the feeder in the delivery zone
7. ensure proper functioning of knitting machine post piecing
8. collect the waste collected during piecing and store the waste at respective waste box
9. segregate the reusable wastes and weigh and record them in a register
10. ensure standard piecing procedure is adopted and quality of piecing is as per standards
11. ensure minimum time is taken for piecing the yarn.
12. ensure safety while carrying out piecing activity

Check the quality of piecing

To be competent, the user/individual on the job must be able to:

13. verify the quality of piecing done in the yarn
14. ensure yarn tension in the creeling section is appropriate
15. ensure proper functioning of the machine

Carry out doffing

To be competent, the user/individual on the job must be able to:

16. collect the empty cones from creel and replace with a full cone
17. ensure whether the fabric roll is ready for doffing by viewing the details in display panel or by manual
18. keep the empty fabric roller ready for replacement
19. to keep the empty fabric roll near the knitting machine in manual doffing

20. to doff the full fabric roll in case of manual doffing
21. ensure proper doffing procedure is followed
22. ensure doffing is carried out properly
23. move the fabric roll to the storage area
24. ensure the knitting machine is properly restarted after doffing

Post doffing responsibilities

To be competent, the user/individual on the job must be able to:

25. ensure proper functioning of knitting machine post doffing
26. ensure proper material handling of yarn, cone and empty cone
27. ensure proper material handling of tools and equipments

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** standard operating procedures (SOP) and regulations in a knitting unit of the mill
- KU2.** safe working practices to be adopted in knitting unit of the mill
- KU3.** quality systems and other processes practiced in the knitting unit of the mill
- KU4.** reporting to the supervisor or higher authority in case of emergency
- KU5.** color coding adopted for different counts/ products in the knitting mill
- KU6.** process flow and material flow in knitting industry
- KU7.** functions of knitting machine
- KU8.** functions of control switches and signal lamps in knitting machine
- KU9.** importance of piecing
- KU10.** importance of doffing
- KU11.** importance of fabric quality
- KU12.** guidelines for piecing the yarn
- KU13.** guidelines for carrying out doffing activity knowledge of different functions in display panel and procedure to operate the knitting machine
- KU14.** importance of cleanliness and safety at work place

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** write clear and short sentences
- GS2.** comprehend written instructions
- GS3.** Communicate with supervisor appropriately
- GS4.** talk to others to convey information effectively
- GS5.** apply problem-solving approaches in different situations
- GS6.** refer anomalies to the supervisor
- GS7.** seek clarification on problems from others
- GS8.** apply good attention to detail

- GS9.** check your work is complete and free from errors
- GS10.** Procedure to collect the yarn from creel zone and condense through the guides, feeders for fabric formation
- GS11.** Standard operating procedure for carrying out piecing activity
- GS12.** Standard operating procedure for carrying out doffing activity
- GS13.** Procedure for segregating the different types of wastes
- GS14.** Procedure for storing reusable waste and weighing them
- GS15.** Procedure for material handling of cone, fabric roll
- GS16.** Maintain cleanliness at work

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Attending the machine on yarn breakage</i>	3	5	-	3
1. identify the machine stoppage by viewing the signal lamps and in display panel	1	1	-	1
2. identify the reasons for yarn breakage	1	2	-	1
3. ensure minimum time is taken for attending the yarn breakage in carding department	1	2	-	1
<i>Piecing the yarn</i>	9	13	-	11
4. unwind the yarn from the cone	1	1	-	1
5. ensure proper piecing	1	1	-	1
6. draw the yarn through the guide, guide rollers and pass it through the stop motion into the feeder in the delivery zone	1	2	-	2
7. ensure proper functioning of knitting machine post piecing	1	2	-	2
8. collect the waste collected during piecing and store the waste at respective waste box	1	1	-	1
9. segregate the reusable wastes and weigh and record them in a register	1	1	-	1
10. ensure standard piecing procedure is adopted and quality of piecing is as per standards	1	2	-	1
11. ensure minimum time is taken for piecing the yarn.	1	2	-	1
12. ensure safety while carrying out piecing activity	1	1	-	1
<i>Check the quality of piecing</i>	3	4	-	3
13. verify the quality of piecing done in the yarn	1	1	-	1
14. ensure yarn tension in the creeling section is appropriate	1	1	-	1

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
15. ensure proper functioning of the machine	1	2	-	1
<i>Carry out doffing</i>	9	16	-	12
16. collect the empty cones from creel and replace with a full cone	1	2	-	1
17. ensure whether the fabric roll is ready for doffing by viewing the details in display panel or by manual	1	2	-	2
18. keep the empty fabric roller ready for replacement	1	2	-	2
19. to keep the empty fabric roll near the knitting machine in manual doffing	1	2	-	2
20. to doff the full fabric roll in case of manual doffing	1	2	-	1
21. ensure proper doffing procedure is followed	1	2	-	1
22. ensure doffing is carried out properly	1	2	-	1
23. move the fabric roll to the storage area	1	1	-	1
24. ensure the knitting machine is properly restarted after doffing	1	1	-	1
<i>Post doffing responsibilities</i>	3	3	-	3
25. ensure proper functioning of knitting machine post doffing	1	1	-	1
26. ensure proper material handling of yarn, cone and empty cone	1	1	-	1
27. ensure proper material handling of tools and equipments	1	1	-	1
NOS Total	27	41	-	32

National Occupational Standards (NOS) Parameters

NOS Code	TSC/N4107
NOS Name	Piecing the yarn and doffing the fabric roll in the knitting machine
Sector	Textiles & Handlooms
Sub-Sector	Knitting
Occupation	Knitting
NSQF Level	4
Credits	TBD
Version	1.0
Last Reviewed Date	21/01/2015
Next Review Date	01/03/2016
NSQC Clearance Date	05/08/2015

TSC/N4108: Repair yarn related faults in Flat Bed Knitting

Description

This unit is about carrying out the Repair of yarn-related faults at the knitting machine

Scope

This unit/task covers the following: Attending the yarn related faults

Elements and Performance Criteria

Attending the yarn related faults

To be competent, the user/individual on the job must be able to:

1. rethread incorrectly-positioned yarns in accordance with workplace procedures
2. identify the reasons for yarn breakage
3. broken yarns or new ends are joined in accordance with workplace procedures.
4. machines are reset for restart in accordance with workplace procedures after fault correction, style changes, and pattern changes.

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** standard operating procedures (SOP) and regulations in a knitting mill
- KU2.** safe working practices to be adopted in knitting mill
- KU3.** quality systems and other processes practiced in the knitting mill
- KU4.** reporting to the supervisor or higher authority in case of emergency
- KU5.** color coding adopted for different counts/ products in the knitting mill
- KU6.** process flow and material flow in knitting industry
- KU7.** functions of knitting machine
- KU8.** functions of control switches and signal lamps in knitting machine
- KU9.** importance of piecing
- KU10.** importance of doffing
- KU11.** importance of fabric quality
- KU12.** guidelines for piecing the yarn
- KU13.** guidelines for carrying out doffing activity
- KU14.** functions of different control switches in knitting machine
- KU15.** knowledge of different functions in display panel and procedure to operate the knitting machine
- KU16.** importance of cleanliness and safety at work place

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** write clear and short sentences
- GS2.** Read and comprehend written instructions
- GS3.** Communicate with supervisor appropriately
- GS4.** talk to others to convey information effectively
- GS5.** apply problem-solving approaches in different situations
- GS6.** refer anomalies to the supervisor
- GS7.** seek clarification on problems from others
- GS8.** apply good attention to detail
- GS9.** check your work is complete and free from errors
- GS10.** Procedure for collect the yarn from creel zone and condense through the guides, feeders for fabric formation
- GS11.** Standard operating procedure for carrying out piecing activity
- GS12.** Standard operating procedure for carrying out doffing activity
- GS13.** Procedure for segregating the different types of wastes
- GS14.** Procedure for storing reusable waste and weighing them
- GS15.** Procedure for material handling of cone, fabric roll
- GS16.** Maintain cleanliness at work

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Attending the yarn related faults</i>	6	12	-	7
1. rethread incorrectly-positioned yarns in accordance with workplace procedures	1	2	-	2
2. identify the reasons for yarn breakage	2	4	-	2
3. broken yarns or new ends are joined in accordance with workplace procedures.	1	2	-	1
4. machines are reset for restart in accordance with workplace procedures after fault correction, style changes, and pattern changes.	2	4	-	2
NOS Total	6	12	-	7

National Occupational Standards (NOS) Parameters

NOS Code	TSC/N4108
NOS Name	Repair yarn related faults in Flat Bed Knitting
Sector	Textiles & Handlooms
Sub-Sector	Knitting
Occupation	Knitting
NSQF Level	4
Credits	TBD
Version	1.0
Last Reviewed Date	21/01/2015
Next Review Date	01/03/2016
NSQC Clearance Date	05/08/2015

LSS/N7303: Contribute to achieving product quality in knitting operations

Description

This unit provides performance criteria, knowledge, understanding, skills and abilities to monitor the quality of knitted shoe upper and make individual responsible for the quality of that product.

Scope

The scope covers the following :

- Periodic quality control checks, application of SQC tools, CAPA, random inspection, reporting and documentation

Elements and Performance Criteria

Carry out the inspection on raw materials and tools

To be competent, the user/individual on the job must be able to:

- PC1.** Inspect the work area is free from hazards as per the safety norms of the organization.
- PC2.** Inspect the raw materials received are free from defects and faults as per the quality standards given.
- PC3.** Check randomly the quality and standards of materials such as thread color, denier, tex number etc as per the specification given.
- PC4.** Ensure the machine components and tools are free from faults.
- PC5.** Reject or repair as per the degree of faults.

Carry out quality check at production and knitted shoe upper.

To be competent, the user/individual on the job must be able to:

- PC6.** Set the knitting machine to ensure correct operation.
- PC7.** Operate and set the machine in accordance with machine SOP and workplace standards.
- PC8.** Check randomly on finished shoe upper for quality problems like thread breakage, drop stitch, spirality, loose knit or bowing etc,.
- PC9.** Determine the inspection criteria and work method by analyzing SOP or analyzing problem.
- PC10.** Analyze the quality issue and interpret it in relationship with man, machine, method and material.
- PC11.** Apply SQC and CAPA tools for monitoring quality during production.
- PC12.** Maintain the required productivity and quality level.
- PC13.** Reject or repair as per the degree of faults.
- PC14.** Record and maintain all the document related to the inspection.

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** Standards, policies, and procedures followed in the organization.
- KU2.** Relevant health and safety requirements applicable in the work place.

- KU3.** Reporting structure, inter-dependent functions, lines and procedures in the organization.
- KU4.** Knowledge of how to engage with specialists for support in order to resolve quality issues.
- KU5.** Importance of working in clean and safe environment practices and procedures.
- KU6.** Quality systems and other processes practiced in the knitting unit.
- KU7.** Knowledge of process and material flow in a knitting unit.
- KU8.** Understanding the importance of yarn, types of yarn, yarn count, types of fabric, loop length, importance of yarn, thread, denier, tex number etc.,
- KU9.** Knowledge of knitting machine, various parts of machine.
- KU10.** Knowledge of basic maintenance of knitting machine.
- KU11.** Understand the method of knitted upper making, next process after knitting.
- KU12.** Knowledge of quality issues in knitting process like drop stitch, spirality, barriness, streakiness, needle lines, loose knit etc.,
- KU13.** understand how this quality issues will affect the production in knitting upper and full shoe manufacturing.
- KU14.** General principle of knitting process.
- KU15.** Knowledge of quality tools like paretto, pie chart, bar chart to find the major quality issue to monitor the production.
- KU16.** Application of QC tools to find root cause of the problem.
- KU17.** Knowledge of corrective action and preventive action for the problem.
- KU18.** Various QC inspection techniques like visual inspection, use of tools like scale, tapes, jigs for conforming the specification, etc.,
- KU19.**
 - Personal protective equipment (PPE) and clothing that must be worn during the heat
 - treatment activity and from where can it be obtained.

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** Write in basic English/ local language as applicable.
- GS2.** Write and document relevant technical forms, job cards, activity logs, quality reports, daily production sheets as per he prescribed format of the company.
- GS3.** Read and comprehend basic English/ local language as applicable.
- GS4.** Read and understand manuals, health and safety instructions, memos, reports, job cards, SOPs, etc.
- GS5.** communicate the issues effectively with the operators and supervisors and also he/she has to give appropriate feedback.
- GS6.** Evaluate the situation and apply appropriate method of inspection.
- GS7.** Analyse the product review and decide on approval/ rejection based on quality standards of the organization.
- GS8.** Plan quality checks on regular basis.
- GS9.** Ensure quality checks on the raw materials and product made as per customer standards and specifications.
- GS10.** Identify faults, the causes and rectification for deviations from the quality standards.
- GS11.** Discuss and suggest methods for rectification.

- GS12.** Identify possible ways to improve quality and efficiency.
- GS13.** Assess the quality of the material & product to identify defects.
- GS14.** Assess the defects and suggest appropriate action.
- GS15.** Apply balanced judgement to different situations.
- GS16.** Evaluate the critically of the quality defect of the raw material and take appropriate action.
- GS17.** Analyse, evaluate and apply the information gathered from observation, experience, reasoning, or communication to act efficiently.

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Carry out the inspection on raw materials and tools</i>	7	7	-	3
PC1. Inspect the work area is free from hazards as per the safety norms of the organization.	2	-	-	-
PC2. Inspect the raw materials received are free from defects and faults as per the quality standards given.	1	4	-	-
PC3. Check randomly the quality and standards of materials such as thread color, denier, tex number etc as per the specification given.	-	-	-	3
PC4. Ensure the machine components and tools are free from faults.	2	3	-	-
PC5. Reject or repair as per the degree of faults.	2	-	-	-
<i>Carry out quality check at production and knitted shoe upper.</i>	9	13	-	11
PC6. Set the knitting machine to ensure correct operation.	1	3	-	-
PC7. Operate and set the machine in accordance with machine SOP and workplace standards.	2	4	-	-
PC8. Check randomly on finished shoe upper for quality problems like thread breakage, drop stitch, spirality, loose knit or bowing etc.,	-	-	-	5
PC9. Determine the inspection criteria and work method by analyzing SOP or analyzing problem.	2	-	-	3
PC10. Analyze the quality issue and interpret it in relationship with man, machine, method and material.	1	-	-	-
PC11. Apply SQC and CAPA tools for monitoring quality during production.	2	2	-	-
PC12. Maintain the required productivity and quality level.	1	-	-	-
PC13. Reject or repair as per the degree of faults.	-	4	-	-

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
PC14. Record and maintain all the document related to the inspection.	-	-	-	3
NOS Total	16	20	-	14

National Occupational Standards (NOS) Parameters

NOS Code	LSS/N7303
NOS Name	Contribute to achieving product quality in knitting operations
Sector	Leather
Sub-Sector	Non-Leather Footwear
Occupation	Knitting (Non - Leather Footwear), Quality Assurance (Non-leather)
NSQF Level	4
Credits	TBD
Version	1.0
Last Reviewed Date	NA
Next Review Date	NA
NSQC Clearance Date	

LSS/N8501: Maintain the work area, tools and machines

Description

This unit provides Performance Criteria, Knowledge & Understanding and Skills & Abilities required to organise/ maintain work areas and activities to ensure tools and machines are maintained as per norms.

Scope

This unit/task covers the following: Maintenance of the work area, tools and machines

Elements and Performance Criteria

Maintenance of work area, tools and machines

To be competent, the user/individual on the job must be able to:

- PC1.** handle materials, machinery, equipment and tools safely and correctly
- PC2.** use correct lifting and handling procedures
- PC3.** use materials to minimize waste
- PC4.** prepare and organize work
- PC5.** maintain a clean and hazard free working area
- PC6.** deal with work interruptions
- PC7.** move around the workplace with care
- PC8.** maintain tools and equipment
- PC9.** carry out running maintenance within agreed schedules
- PC10.** carry out maintenance and/or cleaning outside responsibility
- PC11.** report unsafe equipment and other dangerous occurrences
- PC12.** ensure that the correct machine guards are in place
- PC13.** work in a comfortable position with the correct posture
- PC14.** use cleaning equipment and methods appropriate for the work to be carried out
- PC15.** dispose of waste safely in the designated location
- PC16.** store cleaning equipment safely after use
- PC17.** complete and store accurate records and documentation
- PC18.** maintain proper lighting, ventilation to make sure general comfort is there while working
- PC19.** give inputs and assist in completing documentation
- PC20.** report the need for maintenance and/or cleaning outside your area of responsibility
- PC21.** ensure safe and correct handling of materials, equipment and tools
- PC22.** maintain appropriate environment to protect stock from pilfering, theft, damage and deterioration

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** personal hygiene and duty of care

- KU2.** safe working practices and organizational procedures
- KU3.** limits of ones own responsibility
- KU4.** ways of resolving with problems within the work area
- KU5.** the production process and the specific work activities that relate to the whole process
- KU6.** the lines of communication, authority and reporting procedures
- KU7.** the organizations rules, codes and guidelines (including timekeeping)
- KU8.** the companies quality standards
- KU9.** the types of records kept, how are they completed and the importance of keeping them accurate
- KU10.** the importance of complying with written instructions
- KU11.** equipment operating procedures / manufacturers instructions
- KU12.** statutory responsibilities under health, safety and environmental legislation and regulations
- KU13.** the quality standards and processes followed by the organization relevant to your role
- KU14.** documentation required for reporting
- KU15.** work instructions and specifications and interpret them accurately
- KU16.** method to make use of the information detailed in specifications and instructions
- KU17.** relation between work role and the overall manufacturing process
- KU18.** the importance of good time keeping and attendance
- KU19.** the importance of minimized production costs
- KU20.** the importance of taking action when problems are identified
- KU21.** different ways of minimizing waste
- KU22.** the importance of running maintenance and regular cleaning
- KU23.** effects of contamination on products i.e. machine oil, dirt
- KU24.** common faults with equipment and the method to rectify
- KU25.** maintenance procedures and manufacturers instructions
- KU26.** hazards likely to be encountered when conducting routine maintenance
- KU27.** different types of cleaning equipment and substances and their use
- KU28.** safe working practices for cleaning and the method of carrying them out
- KU29.** the production process and the specific work activities that relate to the whole process

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** write and document appropriate technical forms, job cards, inspection sheets as required format of the company
- GS2.** read and comprehend basic english to read and interpret indicators in the machine and operating manuals, job cards, visual cards,
- GS3.** read and understand manuals, health and safety instructions, memos, reports, job cards etc
- GS4.** speak and communicate effectively to peers and supervisors
- GS5.** give clear instructions to co-workers, subordinates others
- GS6.** use correct technical term while interacting with supervisor

- GS7.** take appropriate decisions regarding to responsibilities
- GS8.** assess for any damage/faulty component in the concerned machinery and take action accordingly
- GS9.** evaluate the decision and conduct basic trouble shooting
- GS10.** plan and manage work routine based on company procedure
- GS11.** work with supervisors/ team mates to carry out work related tasks
- GS12.** plan for cleaning and lubricating the concerned machinery daily
- GS13.** plan for cleaning the concerned tools and workplace daily before and after operations
- GS14.** ensure and follow organizational procedures pertaining to health and safety are followed
- GS15.** solve operational role related issues
- GS16.** diagnose common problems in the machine based on visual inspection, sound, temperature etc.
- GS17.** analyse, evaluate and apply the information gathered from observation, experience, reasoning, or communication to act efficiently

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Maintenance of work area, tools and machines</i>	15	35	-	-
PC1. handle materials, machinery, equipment and tools safely and correctly	-	2	-	-
PC2. use correct lifting and handling procedures	-	2	-	-
PC3. use materials to minimize waste	-	3	-	-
PC4. prepare and organize work	-	2	-	-
PC5. maintain a clean and hazard free working area	-	3	-	-
PC6. deal with work interruptions	-	2	-	-
PC7. move around the workplace with care	-	3	-	-
PC8. maintain tools and equipment	-	3	-	-
PC9. carry out running maintenance within agreed schedules	2	2	-	-
PC10. carry out maintenance and/or cleaning outside responsibility	1	1	-	-
PC11. report unsafe equipment and other dangerous occurrences	2	1	-	-
PC12. ensure that the correct machine guards are in place	-	1	-	-
PC13. work in a comfortable position with the correct posture	1	1	-	-
PC14. use cleaning equipment and methods appropriate for the work to be carried out	2	1	-	-
PC15. dispose of waste safely in the designated location	2	1	-	-
PC16. store cleaning equipment safely after use	1	1	-	-
PC17. complete and store accurate records and documentation	1	1	-	-

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
PC18. maintain proper lighting, ventilation to make sure general comfort is there while working	1	1	-	-
PC19. give inputs and assist in completing documentation	-	1	-	-
PC20. report the need for maintenance and/or cleaning outside your area of responsibility	-	1	-	-
PC21. ensure safe and correct handling of materials, equipment and tools	1	1	-	-
PC22. maintain appropriate environment to protect stock from pilfering, theft, damage and deterioration	1	1	-	-
NOS Total	15	35	-	-

National Occupational Standards (NOS) Parameters

NOS Code	LSS/N8501
NOS Name	Maintain the work area, tools and machines
Sector	Leather
Sub-Sector	Footwear, Goods & Garments, Finished Leather
Occupation	All Occupations
NSQF Level	4
Credits	NA
Version	1.0
Last Reviewed Date	31/03/2015
Next Review Date	31/03/2017
NSQC Clearance Date	18/06/2015

LSS/N8601: Maintain health, safety and security at workplace

Description

This unit provides Performance Criteria, Knowledge & Understanding and Skills & Abilities required to comply with health, safety and security requirements at the workplace and covers procedures to prevent, control and minimize risk to self and others

Scope

This unit/task covers the following:

- Compliance with health, safety and security requirements at work

Elements and Performance Criteria

Compliance with health, safety and security requirements at work

To be competent, the user/individual on the job must be able to:

- PC1.** comply with health and safety related instructions applicable to the workplace
- PC2.** use and maintain personal protective equipment as per protocol
- PC3.** carry out own activities in line with approved guidelines and procedures
- PC4.** maintain a healthy lifestyle and guard against dependency on intoxicants
- PC5.** follow environment management system related procedures
- PC6.** identify and correct (if possible) malfunctions in machinery and equipment
- PC7.** report any service malfunctions that cannot be rectified
- PC8.** store materials and equipment in line with manufacturers and organizational requirements
- PC9.** safely handle and move waste and debris
- PC10.** minimize health and safety risks to self and others due to own actions
- PC11.** seek clarifications, from supervisors or other authorized personnel in case of perceived risks
- PC12.** monitor the workplace and work processes for potential risks and threats
- PC13.** carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned
- PC14.** report hazards and potential risks/ threats to supervisors or other authorized personnel
- PC15.** participate in mock drills/ evacuation procedures organized at the workplace
- PC16.** undertake first aid, fire-fighting and emergency response training, if asked to do so
- PC17.** take action based on instructions in the event of fire, emergencies or accidents
- PC18.** follow organization procedures for shutdown and evacuation when required

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** health and safety related practices applicable at the workplace
- KU2.** potential hazards, risks and threats based on nature of operations

- KU3.** organizational procedures for safe handling of equipment and machine operations
- KU4.** potential risks due to own actions and methods to minimize these
- KU5.** environmental management system related procedures at the workplace
- KU6.** layout of the plant and details of emergency exits, escape routes, emergency equipment and assembly points
- KU7.** potential accidents and emergencies and response to these scenarios
- KU8.** reporting protocol and documentation required
- KU9.** details of personnel trained in first aid, fire-fighting and emergency response
- KU10.** actions to take in the event of a mock drills/ evacuation procedures or actual accident, emergency or fire
- KU11.** occupational health and safety risks
- KU12.** personal protective equipment and method of use
- KU13.** identification, handling and storage of hazardous substances
- KU14.** proper disposal system for waste and by-products
- KU15.** signage related to health and safety and their meaning
- KU16.** importance of sound health, hygiene and good habits
- KU17.** ill-effects of alcohol, tobacco and drugs

Generic Skills (GS)

User/individual on the job needs to know how to:

- GS1.** document and report any health and safety related incidents/ accidents
- GS2.** read and comprehend manuals of operations
- GS3.** read all organizational and equipment related health and safety manuals and documents
- GS4.** read instructions, guidelines/procedures/rules related to the worksite and machine operations
- GS5.** give clear instructions to co-workers, subordinates and other personnel
- GS6.** use correct technical terms while interacting with supervisor
- GS7.** make an appropriate timely decision in responding to emergencies/accidents in line with organization
- GS8.** evaluate and use correct ppe and other safety gear while at the workplace
- GS9.** work with supervisors/ team mates to carry out work related tasks
- GS10.** plan work according to the required schedule
- GS11.** keep work area free from potential hazards
- GS12.** ensure and follow organizational procedures pertaining to health and safety are followed
- GS13.** take appropriate actions during emergencies, accidents or fire at the workplace
- GS14.** resolve issues pertaining to malfunctions in machineries and report if required
- GS15.** identify emergency situations
- GS16.** identify cause effect relationship for the emergencies
- GS17.** analyse, evaluate and apply the information gathered from observation, experience, reasoning, or communication to act efficiently

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Compliance with health, safety and security requirements at work</i>	10	15	-	-
PC1. comply with health and safety related instructions applicable to the workplace	5	1	-	-
PC2. use and maintain personal protective equipment as per protocol	-	0.5	-	-
PC3. carry out own activities in line with approved guidelines and procedures	-	0.5	-	-
PC4. maintain a healthy lifestyle and guard against dependency on intoxicants	-	0.5	-	-
PC5. follow environment management system related procedures	5	0.5	-	-
PC6. identify and correct (if possible) malfunctions in machinery and equipment	-	1	-	-
PC7. report any service malfunctions that cannot be rectified	-	1	-	-
PC8. store materials and equipment in line with manufacturers and organizational requirements	-	0.5	-	-
PC9. safely handle and move waste and debris	-	0.5	-	-
PC10. minimize health and safety risks to self and others due to own actions	-	1	-	-
PC11. seek clarifications, from supervisors or other authorized personnel incase of perceived risks	-	1	-	-
PC12. monitor the workplace and work processes for potential risks and threats	-	1	-	-
PC13. carry out periodic walk-through to keep work area free from hazards and obstructions, if assigned	-	1	-	-
PC14. report hazards and potential risks/ threats to supervisors or other authorized personnel	-	1	-	-

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
PC15. participate in mock drills/ evacuation procedures organized at the workplace	-	1	-	-
PC16. undertake first aid, fire-fighting and emergency response training, if asked to do so	-	1	-	-
PC17. take action based on instructions in the event of fire, emergencies or accidents	-	1	-	-
PC18. follow organization procedures for shutdown and evacuation when required	-	1	-	-
NOS Total	10	15	-	-

National Occupational Standards (NOS) Parameters

NOS Code	LSS/N8601
NOS Name	Maintain health, safety and security at workplace
Sector	Leather
Sub-Sector	Footwear, Goods & Garments, Finished Leather
Occupation	All Occupations
NSQF Level	4
Credits	NA
Version	1.0
Last Reviewed Date	31/03/2015
Next Review Date	31/03/2017
NSQC Clearance Date	18/06/2015

LSS/N8701: Comply with industry, regulatory and organizational requirements

Description

This unit provides Performance Criteria, Knowledge & Understanding and Skills & Abilities required for complying with industry, regulatory and organizational requirements at the workplace.

Scope

This unit/task covers the following: Compliance with industry, regulatory and organizational requirements

Elements and Performance Criteria

Compliance with industry, regulatory and organizational requirements

To be competent, the user/individual on the job must be able to:

- PC1.** carry out work functions in accordance with legislation and regulations, organizational guidelines and procedures
- PC2.** seek and obtain clarifications on policies and procedures, from the supervisor or other authorized personnel
- PC3.** apply and follow these policies and procedures within the work practices
- PC4.** provide support to the supervisor and team members in enforcing these considerations
- PC5.** identify and report any possible deviation to these requirements

Knowledge and Understanding (KU)

The individual on the job needs to know and understand:

- KU1.** the importance of having an ethical and value-based approach to governance
- KU2.** benefits to the company and oneself due to practice of these procedures
- KU3.** specific to the industry/sector, know and understand: legal, regulatory and ethical requirements procedures to follow if someone does not meet the requirements
- KU4.** customer specific requirements mandated as a part of the work process
- KU5.** country / customer specific regulations for the sector and their importance
- KU6.** reporting procedure in case of deviations
- KU7.** limits of personal responsibility

Assessment Criteria

Assessment Criteria for Outcomes	Theory Marks	Practical Marks	Project Marks	Viva Marks
<i>Compliance with industry, regulatory and organizational requirements</i>	10	15	-	-
PC1. carry out work functions in accordance with legislation and regulations, organizational guidelines and procedures	5	3	-	-
PC2. seek and obtain clarifications on policies and procedures, from the supervisor or other authorized personnel	5	3	-	-
PC3. apply and follow these policies and procedures within the work practices	-	3	-	-
PC4. provide support to the supervisor and team members in enforcing these considerations	-	3	-	-
PC5. identify and report any possible deviation to these requirements	-	3	-	-
NOS Total	10	15	-	-

National Occupational Standards (NOS) Parameters

NOS Code	LSS/N8701
NOS Name	Comply with industry, regulatory and organizational requirements
Sector	Leather
Sub-Sector	Footwear, Goods & Garments, Finished Leather
Occupation	All Occupations
NSQF Level	4
Credits	NA
Version	1.0
Last Reviewed Date	31/03/2015
Next Review Date	31/03/2017
NSQC Clearance Date	18/06/2015

Assessment Guidelines and Assessment Weightage

Assessment Guidelines

Criteria for assessment for each Qualification Pack will be created by the Sector Skill Council. Each Performance Criteria (PC) will be assigned marks proportional to its importance in NOS. SSC will also lay down proportion of marks for Theory and Skills Practical for each PC.

The assessment for the theory part will be based on knowledge bank of questions created by the SSC.

Assessment will be conducted for all compulsory NOS, and where applicable, on the selected elective/option NOS/set of NOS.

Individual assessment agencies will create unique question papers/follow the Question papers created by SSC for theory part for each candidate at each examination/training center (as per assessment criteria below).

The question papers created by assessment agency has to be validated by SSC.

The assessment fully online mode with theory, practical and viva.

Individual assessment agencies will create unique evaluations for skill practical/follow the skill evaluations created by SSC for every student at each examination/training center based on this criterion.

To pass the Qualification Pack, every trainee should score a minimum of 70% of aggregate marks to successfully clear the assessment.

In case of unsuccessful completion, the trainee may seek reassessment on the Qualification Pack.

Recommended Pass % : 70

Assessment Weightage

Compulsory NOS

National Occupational Standards	Theory Marks	Practical Marks	Project Marks	Viva Marks	Total Marks	Weightage
TSC/N4106. Operate the flat bed knitting machine	52	86	-	62	200	30
TSC/N4107. Piecing the yarn and doffing the fabric roll in the knitting machine	27	41	-	32	100	15



Qualification Pack

National Occupational Standards	Theory Marks	Practical Marks	Project Marks	Viva Marks	Total Marks	Weightage
TSC/N4108.Repair yarn related faults in Flat Bed Knitting	6	12	-	7	25	10
LSS/N7303.Contribute to achieving product quality in knitting operations	16	20	-	14	50	25
LSS/N8501.Maintain the work area, tools and machines	15	35	-	-	50	10
LSS/N8601.Maintain health, safety and security at workplace	10	15	-	-	25	5
LSS/N8701.Comply with industry, regulatory and organizational requirements	10	15	-	-	25	5
Total	136	224	-	115	475	100

Acronyms

NOS	National Occupational Standard(s)
NSQF	National Skills Qualifications Framework
QP	Qualifications Pack
TVET	Technical and Vocational Education and Training
SOP	Standard Operating Procedure
QC	Quality Control
QA	Quality Assurance
SQC	Statistical Quality Control
CAPA	Corrective Action and Preventive Action

Glossary

Sector	Sector is a conglomeration of different business operations having similar business and interests. It may also be defined as a distinct subset of the economy whose components share similar characteristics and interests.
Sub-sector	Sub-sector is derived from a further breakdown based on the characteristics and interests of its components.
Occupation	Occupation is a set of job roles, which perform similar/ related set of functions in an industry.
Job role	Job role defines a unique set of functions that together form a unique employment opportunity in an organisation.
Occupational Standards (OS)	OS specify the standards of performance an individual must achieve when carrying out a function in the workplace, together with the Knowledge and Understanding (KU) they need to meet that standard consistently. Occupational Standards are applicable both in the Indian and global contexts.
Performance Criteria (PC)	Performance Criteria (PC) are statements that together specify the standard of performance required when carrying out a task.
National Occupational Standards (NOS)	NOS are occupational standards which apply uniquely in the Indian context.
Qualifications Pack (QP)	QP comprises the set of OS, together with the educational, training and other criteria required to perform a job role. A QP is assigned a unique qualifications pack code.
Unit Code	Unit code is a unique identifier for an Occupational Standard, which is denoted by an 'N'
Unit Title	Unit title gives a clear overall statement about what the incumbent should be able to do.
Description	Description gives a short summary of the unit content. This would be helpful to anyone searching on a database to verify that this is the appropriate OS they are looking for.
Scope	Scope is a set of statements specifying the range of variables that an individual may have to deal with in carrying out the function which have a critical impact on quality of performance required.
Knowledge and Understanding (KU)	Knowledge and Understanding (KU) are statements which together specify the technical, generic, professional and organisational specific knowledge that an individual needs in order to perform to the required standard.

Organisational Context	Organisational context includes the way the organisation is structured and how it operates, including the extent of operative knowledge managers have of their relevant areas of responsibility.
Technical Knowledge	Technical knowledge is the specific knowledge needed to accomplish specific designated responsibilities.
Core Skills/ Generic Skills (GS)	Core skills or Generic Skills (GS) are a group of skills that are the key to learning and working in today's world. These skills are typically needed in any work environment in today's world. These skills are typically needed in any work environment. In the context of the OS, these include communication related skills that are applicable to most job roles.
Electives	Electives are NOS/set of NOS that are identified by the sector as contributive to specialization in a job role. There may be multiple electives within a QP for each specialized job role. Trainees must select at least one elective for the successful completion of a QP with Electives.
Options	Options are NOS/set of NOS that are identified by the sector as additional skills. There may be multiple options within a QP. It is not mandatory to select any of the options to complete a QP with Options.