
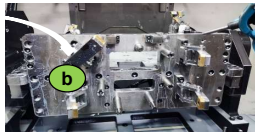



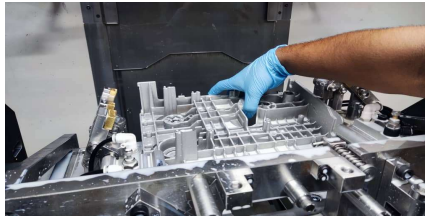
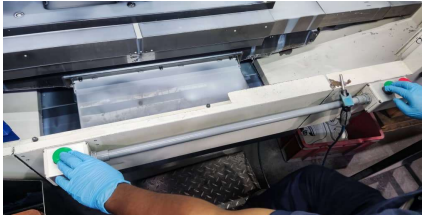


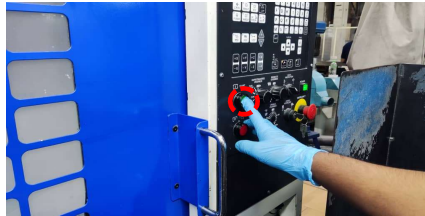











WORK INSTRUCTION

| | | | | | | |
|------------|-----------|-----------|------------------|-------------|-----------------|------------------------|
| DEPARTMENT | MACHINING | CUSTOMER | SATO | W.I. NUMBER | WI-0888-01-MC01 | QA-P03-T6 |
| PROCESS | LOADING | PART NAME | CENTER FRAME P68 | | | REV : 9 (E.D 01.02.21) |

REFER TO WI-ENG-GEN-01 FOR SPECIAL PRODUCT CHARACTERISTIC SYMBOL (SYM)

| | | | |
|---|---|---|--|
| 1 | STEP : Blow fixture | 2 | STEP : Load Machined part from Fixture A to Fixture B |
| SYM. | PHOTO : | SYM. | PHOTO : |
| TOOL |   | TOOL |  |
|  | KEY POINT/QUALITY ISSUE : Keep fixture clean |  | KEY POINT/QUALITY ISSUE : Make sure part is loaded properly. |
| 3 | STEP : Load Raw Part to Fixture A . | 4 | STEP :Push two GREEN button. |
| SYM. | PHOTO : | SYM. | PHOTO : |
| TOOL |  | TOOL |  |
|  | KEY POINT/QUALITY ISSUE : Make sure part is loaded properly. |  | KEY POINT/QUALITY ISSUE : To clamp part. |
| 5 | STEP: Press START button. | 6 | STEP: After finish machining, Open door and press button Green & Red . |
| SYM. | PHOTO : | SYM. | PHOTO : |
| TOOL |  | TOOL |  |
|  | KEY POINT/QUALITY ISSUE : To run machine. |  | KEY POINT/QUALITY ISSUE : To unclamp part. |
| 7 | STEP : After finish machining, Open door and Take Out Machined part from Fixture B . | 8 | STEP : Put Machined part from Fixture B into water tank and use air spray gun. |
| SYM. | PHOTO : | SYM. | PHOTO : |
| TOOL |  | TOOL |   |
|  | KEY POINT/QUALITY ISSUE : To unload part. |  | KEY POINT/QUALITY ISSUE : To clear apt and remove excess coolant/water. |
|  | | | |

| PCR NO | REV NO | REASON | EFFECTIVE DATE | PREPARED | CHECKED | APPROVED |
|--------|--------|--------|----------------|----------|---------|----------|
| | 0 | CREATE | 1/7/2024 | AA | YN | KS |
| | | | | | | |
| | | | | | | |

Remark : Max 8 step for each job/process is allowed