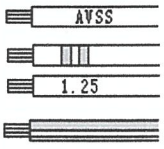
Process Name/ Title:		Document No:	WI-PRO-CNC-006
Wire Cutting and Crimping / Wire Confirmation Method			
WORK INSTRUCTION		Effective Date:	**July 10, 2017**
Product Code/Name: **ALL**	Customer Code: **ALL**	Rev. No.: **0**	Page No.: **Page 1 of 1**

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers

1. Wire type, size and color



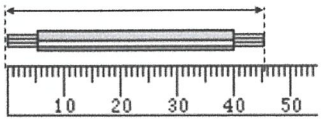
Wire Type:
Confirm with label and marking

Wire Diameter:
Confirm with label and marking

Wire Color:
Confirm with label

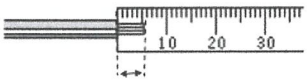
* Visual check wire type, diameter and color then compare with wire cutting ledger, work instruction sheet

2. Wire length

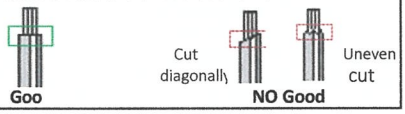


* Measure from end of core wire to the other end of core wire

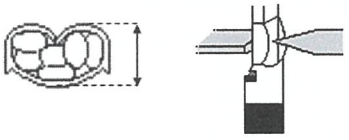
3. Strip length



* Measure from end of insulation to end of core wire

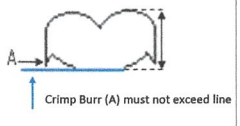


4. Wire Crimp Height

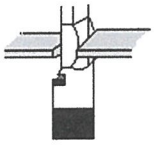


* Measure center of wire crimp using point micrometer

5. Crimp Burr

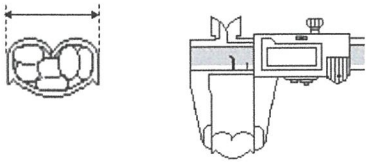


* Measure wire crimp using point micrometer then measure again using blade micrometer.
Get the difference.
Height of crimp burr must be 0.



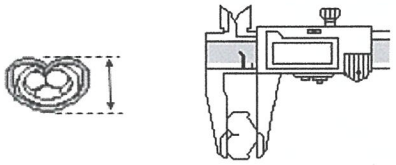
* Measure center of wire crimp using blade micrometer.

6. Wire Crimp Width



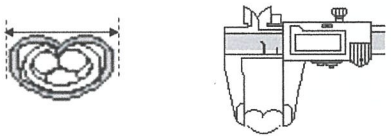
* Measure wire crimp width using vernier caliper

7. Insulation Crimp Height



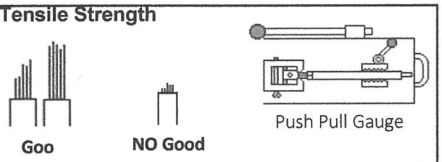
* Measure Insulation Crimp Height using Vernier caliper

8. Insulation Crimp Width



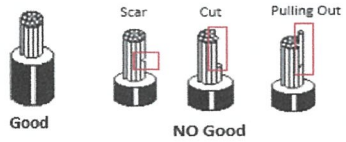
* Measure Insulation Crimp Width using Vernier caliper

9. Tensile Strength



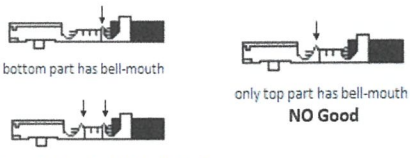
Wire size	Push Pull Gauge
0.1~0.3	20kg / 200N
0.5~1.25	50kg / 500N
2.0~5.0	100kg / 1000N

10. Core Wire



* To check, manually strip 5~10 mm from end of insulation then confirm using magnifying lens or peak lupe
* NG: Cut = 1 or more , Scar = 2 or more , Pulling Out = 1 or more

11. Bell-mouth



* Confirm using magnifying lens or peak lupe

12. Shape of Crimp

* Refer to list of crimp defect WI-PRO-CNC-00

13. Terminal

* Confirm Part Number of terminal with label and Wire cutting ledger

NBC (Philippines)
MASTER COPY

							Prepare	Check	Approve
							J.Garcia / Z. Mendez	O. MERIN	T. SUGIYAMA
-	NBCP - 1002	NA	Previously established Work Instruction(for history purpose only)	-	-	-			
Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017	

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