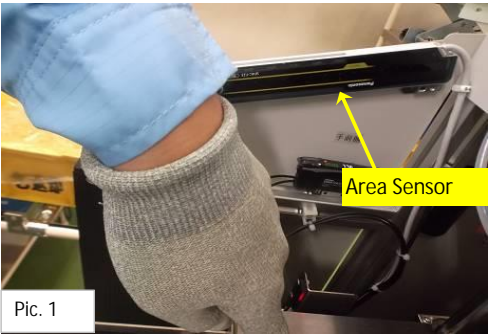
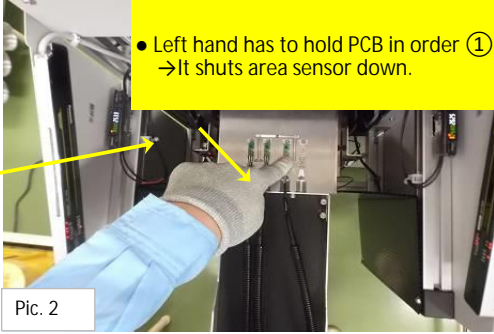

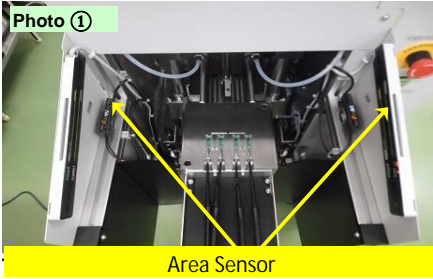
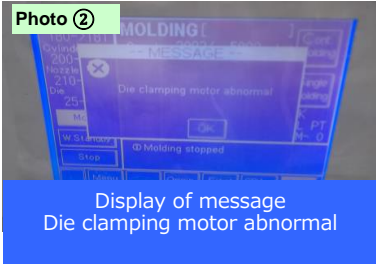


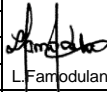


	Process Name/ Title:		Document No:		WI-PRO-SHM-038	
	HOTMELT-Set of Molding		Effective Date:		May 7, 2025	
	WORK INSTRUCTION		Product Code/Name:		Customer Code:	
	ALL		ALL		Rev. No.:	1
				Page No.:	1 of 1	

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers		
<div>  <p>Pic. 1</p> </div> <div>  <p>Pic. 2</p> </div>	<p>Area Sensor</p> <p>● Left hand has to hold PCB in order ①～④. →It shuts area sensor down.</p>			
<p>● Shut area sensor down by left hand (Pic.1), and hold PCB in order ①～④ (Pic. 2). →If area sensor repeats [ON] and [OFF], it becomes [defect of area sensor], and equipment is stopped.</p>				
<p>■ What is defect of area sensor?</p> <p>● As safety function, there are area sensors on molding machine. (left and right) (Ref: Photo ①) If area sensor repeats [ON] and [OFF], [Defect of area sensor] will be appeared. (Ref: Photo ②)</p> <p>Defect of area sensor (Servo amplifier side) is [Prevent entering resistance heating] defect, so this defect is appeared by tempareture of resistance component which is in amplifier. Therefore, it needs time to cool after defect appears due to component's heating.</p>				
<p>Color and condition of area sensor</p> <table border="1"> <tr> <td> <p>● Condition when it is not shutting down by hand. →Light in Green.</p>  <p>Light on Green</p> </td> <td> <p>● Condition when it is shutting down by hand. →Light in Red.</p>  <p>Light on Red</p> </td> </tr> </table> <p>Photo ①</p>  <p>Area Sensor</p> <p>Photo ②</p>  <p>Display of message Die clamping motor abnormal</p>			<p>● Condition when it is not shutting down by hand. →Light in Green.</p>  <p>Light on Green</p>	<p>● Condition when it is shutting down by hand. →Light in Red.</p>  <p>Light on Red</p>
<p>● Condition when it is not shutting down by hand. →Light in Green.</p>  <p>Light on Green</p>	<p>● Condition when it is shutting down by hand. →Light in Red.</p>  <p>Light on Red</p>			
<p>■ When defect of area sensor is appeared</p> <p>● Stop line and report to immediate superior (Stop/Call/Wait)</p>				

						Prepare	Check	Approve
5/7/2025	1	General revision , change customer code	L.Famodulan	A. Ayop	W. Carbillon			
8/15/2017	0	Initial issue.	A. Yocor	O. Merin	T. Sugiyama	L.Famodulan	A. Ayop	W. Carbillon
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	/Est. date: August 15, 2015		

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