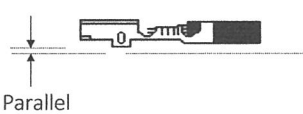
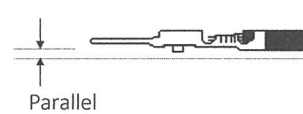
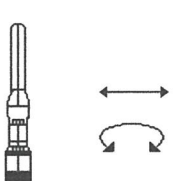
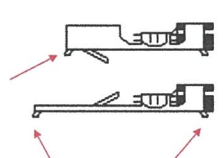
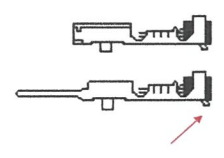
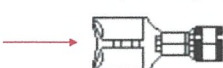
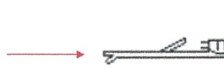
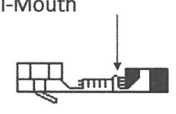
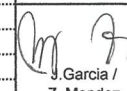


	Process Name/ Title:		Document No:	WI-PRO-CNC-026	
	Wire Cutting and Crimping / Crimp Shape Check		Effective Date:	July 10, 2017	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Page No.:	Page 1 of 1		
ALL	ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Checkpoints During Terminal Set-Up</p> <p>① Crimp Burr Check critical burrs. Measure the difference of readings between blade micro and point micro. *Criteria: If there is no instruction, No crimp burr (0 mm)</p> <p>② Bend Terminal (Bend-up, Bend-down)</p> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <p>*Criteria: If there is no instruction : $\pm 3^\circ$</p> <p>③ Twist and Rolling</p> <div style="display: flex; align-items: center; justify-content: center;">  <div style="margin-left: 20px;"> <p>Twist</p> <p>Rolling</p> </div> </div> <p>*Criteria: If there is no instruction : $\pm 3^\circ$</p> <p>④ Cut off Tab Burr</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>End Type Terminal</p>  <p>Check burrs on both front edge and rear edge.</p> </div> <div style="text-align: center;"> <p>Side Type Terminal</p>  <p>Check on burrs at rear end.</p> </div> </div> <p>*Criteria: There should be no burrs.</p> <p>⑤ Smashed Terminal (female), Opening (male)</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p>female</p> </div> <div style="text-align: center;">  <p>male</p> </div> </div> <p>*Criteria: There should be no crush and no opening.</p> <p>⑥ Bell-Mouth</p> <div style="text-align: center;">  </div> <p>*Criteria: There must be bell-mouth on the bottom part.</p> <p>Note :</p> <ul style="list-style-type: none"> * Monitor above checkpoints at the beginning, during and at the end of work. * In case abnormality is encountered, follow STOP-CALL-WAIT Procedure. 	

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WI-PRO-CNC-015

							Prepare	Check	Approve
									
	NBCP-1076	NA	Previously established Work Instruction(for history purpose only)				J. Garcia / Z. Mendez	O. MERIN	T. SUGIYAMA
Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change			Revise	Check	Approve	Est. date: 07/10/2017