

Process Name/ Title:								
Corrugated Tube	Cutting / Tube	Document No:		WI-PRO-CNC-050				
Replenisi	hment							
WORK INST	RUCTION	Effective Date:		July 23, 2021				
Product Code/Name:	Customer Code:	Rev. No.:	2	Page No.:	Page 1 of 2			
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	Ston the machine when the end of the tube reaches close to working sensor	

ALL



Measure the last piece (good product), check appearance and cross section and put in beside of cutting ledger



then SL/LL or FM will sign Fill-out daily report and call Senior Line Leader/Line leader or Freeman to check the last piece. after checking Senior Line Leader/Line leader or Freeman will sign on daily report. write by operator

ALL

	Product Name	Diameter Color Thickness Slit Tube Length				oss Sectio		Quantity	Defect Quantity	Error	Leader Signature				
	Production Lot No.		Material	Lot No.		1st Piece	!!!/			2nd Piece	Last Pi v ze	,			Last Piece
	7M0365-7020 7-7	7	B 2016-06	-05 (01)	-	90	90	90	00	00	00	500	0	III	Arianna
\vdash	, ,		1020 00	05 (01)				\sim	-		$\overline{}$				

Operator will write the start time of tube replenishment.

٦	TIVITY
	gend:
	<i>Up and Expected Downtime</i> Machine and Instrument Checking -Machine, caliper, micrometer, maglamp
ı	Start of Shift Set- Up/ Adjustment -adjust machine, produce 2 samples Daily Entry - Data and Daily Report (Start and End of Shift) - Tensile test, developsheet, first good product,last good product, daily report
D	-change due to damaged applicator, unexpected applicator change
F	Terminal Change Wire Change Change Model Set-up and/or lot number change product, applicator change, mid of production machine set up
H	Tube Replenishment
	Change Tube Length/Color/Diameter (φ)

SET U	IP and EXP	ECTED I	DOWNTIME MONITORING
TIME	DURATION (mins)	ACTIVITY	DETAILS
8:00-8:02		Α	
8:02-8:06		В	
8:06-8:09		С	
9:42-		Н	
-			
-			
-			
-			
-			
-			
-			
-			

Get the tube from the warehouse. Use cart to carry the tube.



6 Place parts label and Parts supply kanban on its designated area.

						Prepare	Check	Approve
07/23/2021	<u> 2</u>	Change tube replenishment set up	W. Valdez	Y.Yamamoto	O. Merin			0
04/20/2018	4/20/2018 1 Change Leader/Sub Leader to Senior Line Leader/ Line Lea		M. Vasallo/W. Valdez	W. Carbillon	O. Merin	0.1 Oc	1	_(
08/04/2017	0	Established ISO format.	J.Garcia/Z. Mendez	O. Merin	T. Sugiyama	$1 \sim \gamma$	12	(46.
-	n/a	Previously established work instruction (for history purpose only)	-	-	-	W. Valdez	Y. Yamamoto	Ø. Merin
Rev.Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	08/04	/2017



No.

Process Name/ Till	e:
Corrugate	ed Tube Cutting / Tube
R	eplenishment

WORK INSTRUCTION

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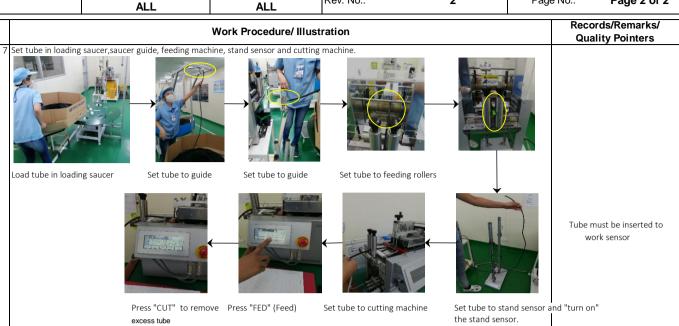
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8 Produce two good samples.

Choose "ST" to start producing another sample, then "CYCLE STP".



Measure the sample



st If it is on target length (good sample), then produce the second sample and measure it.

* If it is No good sample, adjust machine offset.

9 Fill-out Daily Report

Leader Signature	Start	Finish	Product Name	Diameter		Thickness			Tube Length Cross Section										Defect Quantity	Error	Leader Signature
First Piece	time	time	Production Lot No.		Material	Lot No.		1st Piece	2nd Piece	Last Piece	1st Piece	2nd Piece	Last Piece				Last Piece				
selena	8:00		7M0365-7020	7	7 B 2016-06-05 (01)			90	90	90	00	00	00	500	0	III	Arianna				
					7 B 2016-06-05 (02)			90			00		\supset								

10 Call Senior Line Leader/Line leader or Freeman to check the first 2 good samples prior mass production.

Senior Line Leader /Line leader or Freeman will measure and check the samples. He/She will write the actual length and judgment of cross section cut in daily report

After checking Senior Line Leader or Line leader will sign (first samples/piece) in daily report

Leader Signature	Start	Finish	Product Name	Diameter	Diameter Color Thickness Slit				Tube Length				on	Quantity	Defect Quantity
First Piece	time	time	Production Lot No.		Material	Lot No.		1st Piece	2nd Piece	Last Piece	1st Piece	2nd Piece	Last Piece		
selena	8:00		7M0365-7020 7-7		B 2016-06	-05 (01)	<u>-</u>	90	90	90	00	00	00	500	0
arianna	" 7 B 2016-06-05 (02)			90	90	(00	00							

11 Write end time in set up and downtime monitoring.

		, ' ,		
Н	8:00-8:02		Α	
Н	8:02-8:06		В	
	8:06-8:09		С	
<	9:42-9:50		н	
! I	_			

12 Proceed to mass production

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