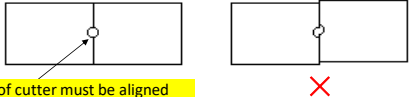

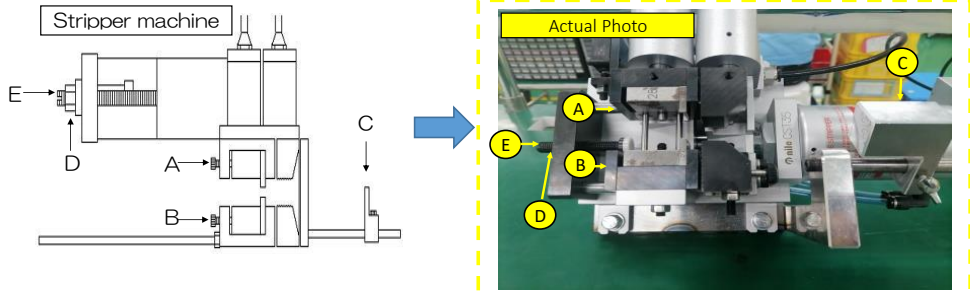
	Process Name/ Title:		Document No:		WI-PRO-CNC-073	
	<b>Manual Stripper Cutter Blade Replacement</b>		Effective Date:		<b>February 06, 2024</b>	
	WORK INSTRUCTION		Product Code/Name:		Customer Code:	
	All		All		Rev. No.: 0	
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No.	Work Procedure/ Illustration	In-Charge																				
1	<p>Loosen bolt <b>A</b> and <b>B</b> and remove the cutter. Refer to <b>Figure 1</b></p> <p>If you loosen the Bolt <b>A</b>, the spacer and cutter will fall, hold them using fingers while loosening them.</p> <p>✖Refer to <b>TABLE 1</b> for cutter type and Wire size.</p> <p><b>TABLE 1</b></p> <table><tr><th>Wire size</th><th>Cutter No.</th><th>Wire size</th><th>Cutter No.</th></tr><tr><td>0.3</td><td>R 1.0</td><td>1.25</td><td>R 1.8</td></tr><tr><td>0.5</td><td>R 1.3</td><td>2.0</td><td>R 2.0</td></tr><tr><td>0.75</td><td>R 1.5</td><td>3.0</td><td>R 3.0</td></tr><tr><td>0.85</td><td>R 1.5</td><td>5.0</td><td>R 5.0</td></tr></table>	Wire size	Cutter No.	Wire size	Cutter No.	0.3	R 1.0	1.25	R 1.8	0.5	R 1.3	2.0	R 2.0	0.75	R 1.5	3.0	R 3.0	0.85	R 1.5	5.0	R 5.0	Maintenance
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2	<p>After installing the cutter, manually turn on the Air Switch and check if there is misalignment on the cutter</p> <p>▪ Check from the side</p>  <p>▪ Check from above</p> 	Maintenance																				
3	Adjust the strip position using the <b>C</b> jig shown in <b>figure 1</b> according to cutting ledger.	Maintenance																				
4	<p>Loosen the nut <b>D</b>, Insert the flathead screwdriver into the notch at the tip of bolt <b>E</b>, and adjust the strip dimension</p> <p><b>Figure 1</b></p> 	Maintenance																				
<p>✖After adjustment, Check again if there are no scratches or cuts on the core wires before you start the operation.</p> <p><b>REMARKS:</b></p> <p>During stripping, set the wire at the joint of the cutter.</p> <p>If the position misalign, core wire will get damage.</p> <p>Make sure that the direction of the stripping cord is correct.</p> <p>If the strip position is incorrect assembly cannot be performed. Misalignment will occur.</p> <p>Before starting the operation, check the terminal on one side (<b>C</b> Side) one by one.</p>		Leaders																				
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						Prepare	Check	Approve
02/06/2024	0	Initial Issue	W. Bergardo	C. Calayan	W. Carbillon	W. Bergardo	C. Calayan	W. Carbillon
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	February 06, 2024	