

	Process Name/ Title:			WI-PRO-SHM-024		
7	Hotmelt P	Document N	√o:			
7	WORK INSTI	Effective Da	ite:	June 15, 2023		
4	Product Code/Name:	Customer Code:	Rev No ·	-	Page No :	1 of 2

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				Hotmelt P	rocess	Document N	lo:	WI-PRO-SHM-024		
				WORK INSTRUCTION		Effective Da	ite:	June 15, 2023		
ш				Product Code/Name:	Customer Code:	Rev. No.:	_	Dogo No.	1 of 2	
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	do.			Work Procedure	/ Illustration			Records/	Remarks/	

<u>∕</u>5∖1

No.

Every Shift Check Machine Temperature (Bottom, Upper, Middle Plate Bottom and Upper Die) Conduct 2x Purging and 3x or more Dummy test

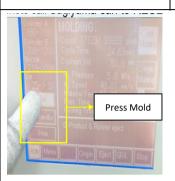
Check the Machine Temperature (Refer to WI- PRO-SHM-034)

Always wear ESD gloves

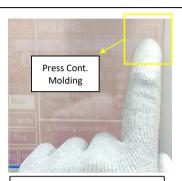
Quality Pointers

Always conduct checksheet checking





1.Press the "Mold" in the HM Machine Screen.



Work Procedure/ Illustration

2.Press "Cont. Molding" in the HM Machine Screen.



1.The "Start Molding" will appear on the screen,press the "YES" button.



1.Using right hand get one soldered wire/harness on the rack starting from the left side to right side.





Pressing must be in this area only. Do not stress the PCB.

Ensure not to touch or hit the PCB components to prevent from damage.

Make sure to gently pull out the PCB on the rack.

2. Insert the PCB tip in the lower die using right hand then gently press the lower part using left thumb to set the harness in the machine.









3. Repeat the process until 4 soldered harness/wire set to the machine.

Ensure that the left arm block the sensor while putting the PCB

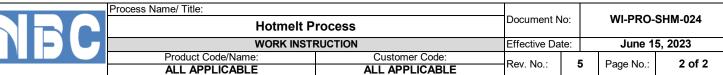
Make sure wires are inside the wire guide to avoid smashed wire.



						Prepare	Check	Approve
06/15/2023	5	General revision based on actual process.	C. Recto	W.Carbillon	O. Merin		,	
04/22/2022	4	Include proper holding on product during alingment of wire and change picture of no. 4 from Left to right become Right to Left	L. Famodulan	C. Luna	O. Merin	9	Spalsh	16
05/13/2021	3	Update proper insertion of PCB, proper removal of gate cuts and include I.S as inspection reference.	A.Ayop	D. Cornero		C. Rect	W.Earbillon	9 Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date	e: July 1,	2017

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No.	Work Procedure/ Illustration						Records/Remarks/ Quality Pointers		
∕ \$\ 4	1. Arrange the lower part of wires/harness then hold using left hand. 2. Using right hand slide the slider lock to fix lower part of wires/harness.					Ensure to arrange to wire/ harness properly.			
<u>∕s</u> \5	Sensor Left hand		the start	g both hands,press t button(GREEN) c both side of the ine,same timing.	on Du	he sensor a	g avoid blocking ea to prevent lefects.		
<u>/\$</u> \ 6		left hand,unlocked the slider lock then the Hotlemted PCB from the lower die.	2.Put the hotmelted PCB holder then repeat p		cc	PCB on hotr anduct STOF	tered stuck-up melt machine P-CALL-WAIT. RO-SHM-006.		
<u>/\$\</u> 7		ing the next product ,using right ne Hotmelted PCB in the holder.	one by PRO-SI	nove the gate cuts y one. Refer to WI HM-028 for prope te cuts removal.	r E	noval of the	ow the proper hotmelted PCB RO-SHM-028.		
<u>\$</u> 8					i En	f encountere	on of the Leader d abnormality v Stop-Call-Wait		

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1. Conduct the inspection process. Refer to IS-

PRO-SHM-013 for the inspection checkpoints.

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2.Put the inspected Hotmelted wires/harness in the box.

if encountered abnormality.