	Process Name/ Title: High Speed Machine Applicator Replacement Method		Document No:	WI-PRO-CNC-070	
	WORK INSTRUCTION		Effective Date:	February 10, 2022	
	Product Code/Name: n/a	Customer Code: n/a	Rev. No.: 0	Page No.: Page 1 of 3	


No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>A. Check the machine as stop. A. Check if the machine is completely stop.</p>  <p>B. Remove the terminal from applicator 1. Pull up the feeder claw using left hand 2. Pull out the terminal</p>   <p>C. Roll the remaining terminal 3. Roll the paper reel back to the terminal reel until it covers and protect the terminal. 4. Tape the end of paper reel to the side of terminal reel and attached kanban request card.</p>   <p>D. Remove terminal reel 5. Press the reel stopper lock and pull out the terminal reel 6. Remove the remaining terminal reel. 7. Return the remaining terminal on the terminal rack.</p>    <p>8. Get the next terminal 9. Check terminal Part number and cutting ledger</p>   	<p>Green light are in operation. Yellow light is complete stop Red light have error</p> <p>Pay attention to Terminal deformation. As much as possible Hold the carrier side</p>  <p>Reel stopper lock</p> 

02/10/2022	0	Initial issue	W. Valdez	D. Cornero	O. Merin	Prepare	Check	Approve
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	02/10/2022	


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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>E. Set the next terminal</p> <p>10. Insert the terminal reel to the shaft of reel stand until it touch the reel board.</p> <p>11. Install the reel stopper lock.</p> <p>12. Insert the reel stopper lock while pressing the lock</p> <p>13. Remove the kanban request card and attached in designated area.</p> <div data-bbox="169 443 1243 651">  </div> <p>F. Remove the applicator</p> <p>14. Upper Applicator Push the lever part, release the applicator lock and pull it out</p> <div data-bbox="193 743 1074 972">  </div> <p>15. Lower applicator Push the lever part, release the applicator lock and pull it out</p> <div data-bbox="177 1066 1034 1310">  </div> <p>G. Set the next applicator</p> <p>16. Lower applicator Insert applicator and slide forward the applicator until its makes a 'click' sound.</p> <div data-bbox="173 1440 1046 1666">  </div> <p>17. Upper Applicator Insert applicator and slide forward the applicator until its makes a 'click' sound.</p> <div data-bbox="177 1736 1018 2011">  </div>	<p>Bring back the removed applicator to proper location</p> <p>Check the applicator orientation before insert.</p> <p>Check the applicator orientation before insert.</p>

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>H. Set the terminal</p> <p>18. Roll out the paper reel from the terminal reel.</p> <p>19. Get the end part of terminal and hold on the terminal carrier.</p> <p>20. Set the terminal to terminal guide</p> <p>21. Insert the terminal to terminal sensor until reach the lower applicator.</p>  <p>22. Manually feed the terminal, press "Feed Terminal on rear" or "Feed Terminal on front"</p> <p>23. Conduct step by step to crimp the terminal.</p> <p>24. Produce sample</p> <p>25. Proceed to mass production.</p> <p style="color: red; text-align: center;">If encountered any problem perform STOP, CALL and WAIT.</p>	 <p><i>Pay attention to Terminal deformation. As much as possible Hold the carrier side</i></p>