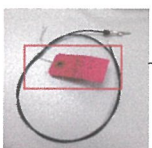
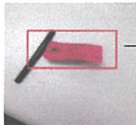
	Process Name/ Title: Cutting and Crimping / Treatment of In-Process Defect		Document No:	WI-PRO-CNC-036	
	WORK INSTRUCTION		Effective Date:	April 20, 2018	
	Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 1	Page No.:	Page 1 of 1

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers																																								
	<p>When defect is found follow below instruction to deal with it.</p> <p>⚠ 1. Once defect is found, call the attention of Senior Line leader or Line leader to inform them about the defect. After Senior Line leader or Line leader have confirmed the defect, operator must put red tag on it.</p> <p>For crimped wire: (wire cutting and crimping / crimping inspection)</p> <div style="display: flex; justify-content: space-around; align-items: center;">  <div style="border: 1px solid black; padding: 5px; background-color: #f0f0f0;"> 1990 - 01 - 01 CI 1 7M0212-7020 1-1 Hanging Justin Bieber </div>  <div style="border: 1px solid black; padding: 5px; background-color: #f0f0f0;"> 1990-01-01 VT 1 7M0212-7020 1-1 Length Variation (Ok-73±3mm, NG - 68mm) Justin Bieber </div> </div> <p>2. Place the defective product with red tag on the defective item box.</p> <p>3a. Operator will write the details on daily report and defect details.</p> <p>For Wire Cutting and Crimping / Crimping Inspection</p> <table border="1" style="margin: 10px auto;"> <caption>DEFECT DETAILS</caption> <thead> <tr> <th>Quantity</th> <th>Defect Name</th> <th>Product Name (lot no.)</th> <th>Cause/Analysis</th> <th>Corrective Action</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Hanging</td> <td>7M0212-7020 1-1</td> <td>Improper set-up</td> <td>Reset up</td> </tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table> <p>For Tube Cutting</p> <table border="1" style="margin: 10px auto;"> <caption>DEFECT DETAILS</caption> <thead> <tr> <th>Quantity</th> <th>Defect Name</th> <th>Product Name (lot no.)</th> <th>Cause/Analysis</th> <th>Corrective Action</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Variation (Ok-73±3mm, NG - 70mm)</td> <td>7M0212-7020 1-1</td> <td>Improper set-up</td> <td>Reset up</td> </tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table> <p>⚠ 3b. Senior Line leader or Line leader will write the details of defect on white board "Today's Defect".</p> <p>⚠ 4. At the end of the shift, operator must accomplish summary of defects. Senior Line leader or Line leader will check the update on summary of defects every last working day of the week.</p> <p>⚠ Note:</p> <ul style="list-style-type: none"> * Defect analysis, investigation and countermeasure implementation will be facilitated by Senior Line leader or Line leader. * For serious defects(major) and defects encountered the first time, a short meeting will be conducted by Senior Line leader or Line leader to discuss and give awareness to all members. * In case defect is found by crimping inspector, Senior Line leader or Line leader will inform and show machine operator the defect and explain action items to avoid the defect, then operator will sign red tag as acknowledgement of the information. * Line Leader will collect all the defective units every end of the shift. 	Quantity	Defect Name	Product Name (lot no.)	Cause/Analysis	Corrective Action	1	Hanging	7M0212-7020 1-1	Improper set-up	Reset up											Quantity	Defect Name	Product Name (lot no.)	Cause/Analysis	Corrective Action	1	Variation (Ok-73±3mm, NG - 70mm)	7M0212-7020 1-1	Improper set-up	Reset up											<p>F-PRO-CNC-003 F-PRO-CNC-005 F-PRO-CNC-012</p> <p>F-PRO-CNC-014A F-PRO-CNC-014B</p>
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04/20/2018	2018-L3-WI-049	⚠	Change Subleader to Line Leader/ Senior Line Leader	M. Vasallo/W. Valdez	W. Carbillon	O. Merin	Prepare	Check	Approve
07/10/2017	2017-L3-WI-177	0	Established ISO format.	J. Garcia/Z. Mendez	O. Merin	T. Sugiyama			
-	NBCP-PD-WI160413-024	NA	Previously established work instruction (for history purpose only)	-	-	-			
Eff./Rev.Date	Doc/DRCN No.	Rev. No. (if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017	