

Process Name/ Title:					
Minor Trouble Shooting in Normal Machine		Document No:		WI-PRO-CNC-067	
WORK INST	Effective Date:		August 19, 2021		
Product Code/Name:	Customer Code:	Rev. No.:	0	Page No.:	Page 1 of 2
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No. Work Procedure/ Illustration Records/Remarks/
Quality Pointers

ALL

1. Front Crimp Error

ALL

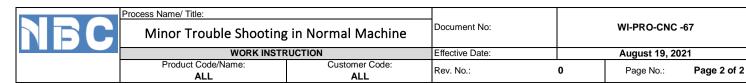
Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
1.1 Wire crimp height is different from the wave form in the panel (wave form is color red)	Measure the crimp height using point micrometer	Measure the actual crimp wire Origin the point micrometer, must 0.000 display and no gap in point and zero in spindle.	Press "OK" in the panel to ok the graph. Proceed to mass production.	Adjust crimp height in the panel. Target the given specs, base on the standard Inform Leader/Freeman	Machine Operator/ Leader/Freeman
1.2 Unstrip Wire	Visually check	Produce sample wire only and check the strip wire.	Continue production.	Adjust core diameter and cutter move back to smaller value	Leader / Freeman
		After adjustment core diameter, Evaluate the strip wire	Record the value of new core diameter in cut depth value record refer to F-PRO-CNC-007	Possible cutter blade is already reach the shots or worn out.	Leader / Freeman
1.3 Wire crimp position not center to anvil	Visually check	Perform step by step in machine until the wire is in the front applicator and check if the wire is center to anvil. After center the wire, conduct 100% inspection on the first 100 output after adjustment.	Continue production. Continue production.	Adjust the position of wire center to anvil Inform Leader/Freeman	Leader / Freeman Leader / Freeman
1.4 Stuck terminal slug	Visually check	Remove stuck terminal in applicator Clean applicator using air gun.	Continue production.	Inform Leader/Freeman	Leader / Freeman
1.5 Wire tangled In wire roller	Visually check	Untangled the wire and press F+ in operating panel Refer to WI-PRO-CNC-030	Check the wire length after manually feed the wire Continue production.	Check all wire rollers and re-set up again. Inform Leader/Freeman	Machine Operator

2. Rear Crimp Error

Possible Cause	How to check	What to do	Good Result	No Good Resu	lt	Person In - Charge
2.1 Wire crimp height is different from the wave form in the panel (wave form is color red)	Measure the crimp height using point micrometer	Measure the actual crimp wire Origin the point micrometer, must 0.000 display and no gap in point and zero in spindle.	Press "OK" in the panel to ok the graph. Proceed to mass production.	Adjust crimp height i panel.Target the given specs. base on the star Inform Leader/Freen	ndard	Machine Operator/ Leader/Freeman
2.2 Unstrip Wire	Visually check	Produce sample wire only and check the strip wire. Evaluate strip wire After adjustment core diameter, Evaluate the strip wire	Continue production. Record the value of new core diameter in cut depth value record refer to F-PRO-CNC-007	Adjust core diameter cutter move back to so value Possible cutter blade already reach the shot worn out.	naller	Leader / Freeman Leader / Freeman
2.3 Stuck terminal slug	Visually check	Remove stuck terminal in applicator Clean applicator using air gun.	Continue production.	Inform Leader/Freen	nan	Leader / Freeman
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08/19/2021 0		Initial issue	W. Valdez	D. Cornero O. Merin	W. Valde	z D. Cornero OME

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	No. Work Procedure/ Illustration						Records/Remarks/ Quality Pointers
2.4	l Wire ta		-	9	Check the wire length after manually feed the wire Continue production.	Check all wire rollers and re-set up again. Inform Leader/Freeman	Machine Operator
3.	. CPF	Stop					

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
3.1 Wire stuck in CPF or wire	Visually check	Untangled the wire and turn on the	Check the wire length.	Check all wire affected in	Machine Operator
stuck in wire bobbin		CPF button	Continue Production.	the conveyor	
				Inform Leader/Freeman	
		 Press F + in operating panel and 			
		produce one good length.			
1		Refer to WI-PRO-CNC-030			

4. Joint Detection

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
4.1 Joint wire reach in wire joint	Visually check	Press F + in operating panel and	Check the wire length.	Check all wire affected in	Machine Operator
sensor		produce one good length.	Continue Production.	the conveyor	
				Inform Leader/Freeman	
4.2 Stuck up wire in wire roller	Visually check	Unstuck the wire in wire roller	Check the wire length.	Check all wire affected in	Machine Operator
sensor		Press F + in operating panel and	Continue Production.	the conveyor	
		produce one good length		• Inform Leader/Freeman	

5. Front Terminal Run Out

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
5.1 No terminal is detected by the terminal sensor	Visually check	Turn off the terminal sensor Replenish the new terminal	Continue Production.	Inform Leader/Freeman	Machine Operator
5.2 No wire detected in wire clip sensor	,	Replenish the wire and insert the wire in wire clip sensor Refer to WI-PRO-CNC-057	Continue Production.	Inform Leader/Freeman	Machine Operator

6. Rear Terminal Run Out

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
6.1 No terminal is detected by	Visually check	Turn off the terminal sensor	Continue Production.	Inform Leader/Freeman	Machine Operator
the terminal sensor		• Replenish the new terminal			

Note: Any error occurred record the details in Set-up and Downtime Monitoring

• If any problem encoutered during troubleshooting perform STOP, CALL and WAIT.

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