



Process Name/Title:

Trouble Shooting of Cannon's Molding Machine

Document No:

WI-PRO-SHM-041

WORK INSTRUCTION

Effective Date:

DEC 05 2017

Product Code/Name:

Customer Code:

Rev.No.: 0

Page No.:

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Appeared defect of product	Standard C/M	Check Items	C/M	Conditions for resuming mass production
Short Shot	When 3rd defect appeared on 1 shift	Check of volume of refilled materials	Re-fill Materials	After re-fill materials, it is okay to resume mass production
		Make sure there is no jam during route of material supply	Removed jammed materials with bamboo stick	After remove jammed materials, it is okay to resume mass production
		Check volume of cushion. It has to be 48mm and above	Apply following C/M if volume was not increased to enough even shots 10 times straight. 1. Shot 10 times as test after consecutive purge, then confirm it with check item. 2. Purge until consume all the remaining hotmelt, and refill new material. Then shot 10 times as test after purge and confirm it with check item.	After C/M were done, re-check daily check item. And if there are no problem, shot 5 times straight, and if there is no lack of filled-up and no detachment level 4, resume production
		Check actual inside pressure . Actual pressure should be 1.5Mpa and above, less than 4.0Mpa	Change setting of pressure 1 to achieve actual inside pressure 1.5Mpa and above, less 4.0Mpa. Then shot 3 times as test and check inside pressure again. *Target: 2.8± 1.0MPa. When it is still not in range, re-setting and confirm.	
Not-molded	When 1st defect was appeared	There is no left on spool	When there is rest on spool, remove it.	After remove spool, it is okay to resume production
		Check volume of refilled materials	Re-fill Materials	After refill materials, it is okay to resume mass production
		Make sure there is no jam during route of material supply	Removed jammed materials with bamboo stick	After jammed materials, it is okay to resume mass production
		Check volume of cushion. It has to be 48mm and above	Apply following C/M if volume was not increased to enough even shots 10 times straight. 1. Shot 10 times as test after consecutive purge, then confirm it with check item. 2. Purge until consume all the remaining hotmelt, and refill new material. Then shot 10 times and test after consecutive purge and confirm it with check item	
Detachment	When 1st defect (level 4: detach right after) was appeared, or when level 4 detachment appeared on random inspection for passage detachment	Check dirt of die mold	Clean the mold die	After C/M were done, recheck daily check items. And if there are no problem, shot 5 times straight, and if there is no lack of filled-up and no detachment level 4, resume to mass production
		Check actual inside pressure . Actual pressure should be 1.5Mpa and above, less than 4.0Mpa	Change setting of pressure 1 to achieve actual inside pressure 1.5Mpa and above, less 4.0Mpa. Then shot 3 times as test and check inside pressure again. *Target: 2.8± 1.0MPa. When it is still not in range, re-setting and confirm.	
			Apply following C/M if level 4 detachment appeared again, 1. Shot 10 times as test after consecutive purge, then confirm it with check items 2. Purge until consume all remaining hotmelt, and refill new material. Then 10 shot and asper test as consecutive purge and confirm it with check item	
Others:				
Machine Alarm-Safety Device Active	When alarm occurred from turning ON the machine	Check the automatic timer. Check if the setting for HOLIDAY is ON.	Change the setting of automatic timer to OFF button. Reset machine. Wait until the temperature reach the standard. Conduct purging, then dummy trial	After conducting dummy trial, and all dummy are good, proceed to mass production

							Prepare	Check	Approve
n/a	NBPS-9043	n/a	Previously established work instruction. (for history purpose only)	-	-	-	J. Ramilo	O. Merin	T. Sugiyama
Eff./Rev. Date	Doc/DRCN No.	Rev. No(if applicable)	Details of Change	Revise	Check	Approve	Est. date:	DEC 05 2017	

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