
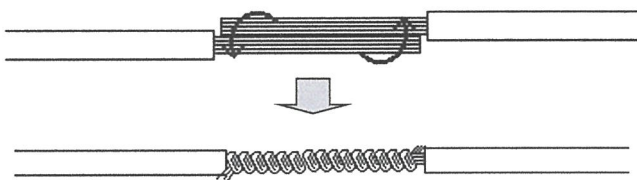


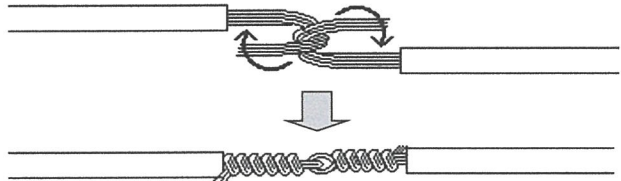

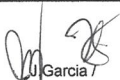


	Process Name/ Title:		Document No:	WI-PRO-CNC-018	
	Wire Cutting and Crimping / Wire Jointing Procedure		Effective Date:	July 10, 2017	
	WORK INSTRUCTION		Rev. No.:	0	
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Two Types of Jointing Method</p> <p>1. Twisting Method</p> <p>① Strip 30 ~ 50mm of the insulation using stripper.</p>  <p>② Lay the core wire to joint and twist them. Twist firmly on both ends. Joint length must be 30mm or more.</p>  <p>Note: Twisted wire must not exceed the overall diameter of the wire. This method is easier to come apart than hooking method. So need to twist firmly to the end.</p> <p>NO GOOD SAMPLE</p>  <ul style="list-style-type: none"> -Short joint - below 30 mm -Not twisted until the end -Twisted wire exceeds the overall diameter of the wire <p>2. Hooking Method</p> <p>① Strip 40 ~ 60mm of the insulation using stripper. Strip is longer than twist method.</p>  <p>② Fold the core wires in half, hook and twist them.</p>  <p>Note: Jointed wire must not exceed the overall diameter of the wire.</p> <p>NO GOOD SAMPLE</p>  <ul style="list-style-type: none"> -Short joint - below 30 mm -Not twisted until the end -Jointed wire exceeds the overall diameter of the wire <p>Important Points:</p> <ul style="list-style-type: none"> ※ To avoid exceeding overall wire diameter, cut half (1/2) of the strands first before jointing. ※ Tensile strength of jointed wires must be over 6kg. 	

NBC (Philippines)
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							Prepare	Check	Approve
									
-	NBCP-1100	NA	Previously established Work Instruction(for history purpose only)	-	-	-	Z. Mendez	O. MERIN	T. SUGIYAMA
Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017	