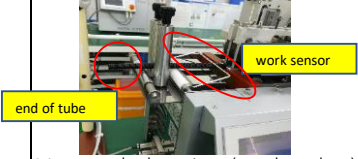
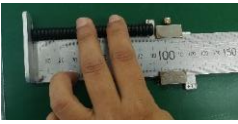


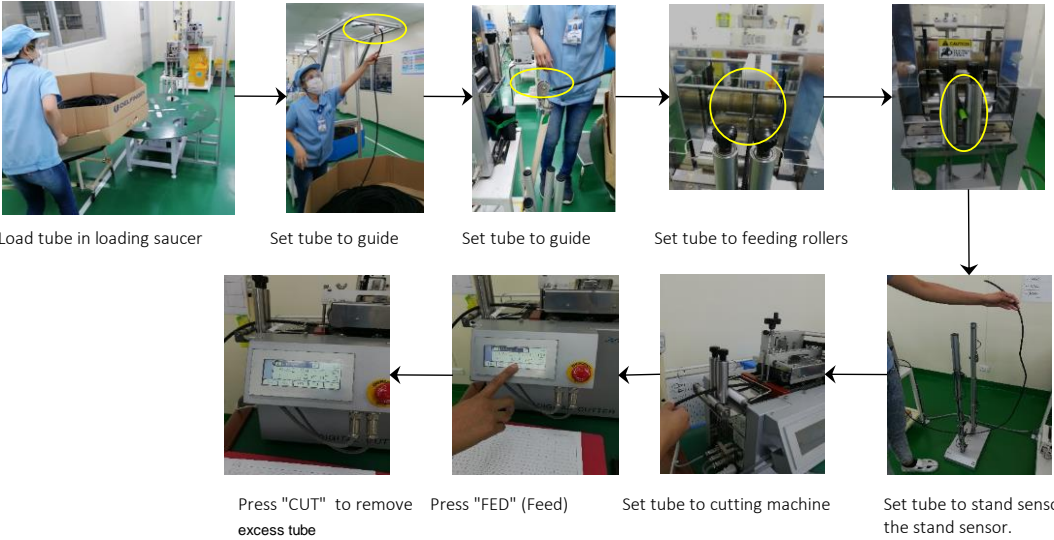
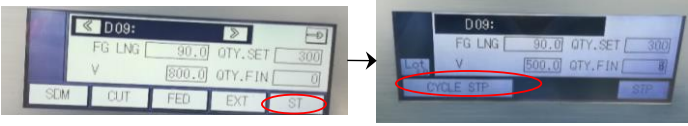
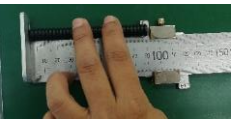
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	Corrugated Tube Cutting / Tube Replenishment		Effective Date:	July 23, 2021	
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Product Code/Name: ALL		Customer Code: ALL	Page No.:		Page 1 of 2

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers																																																												
1	Stop the machine when the end of the tube reaches close to working sensor 																																																													
2	Measure the last piece (good product), check appearance and cross section and put in beside of cutting ledger 																																																													
3	Fill-out daily report and call Senior Line Leader/Line leader or Freeman to check the last piece. Senior Line Leader/Line leader or Freeman will sign on daily report. write by operator then SL/LL or FM will sign after checking <table border="1"> <thead> <tr> <th>Product Name</th> <th>Diameter</th> <th>Color</th> <th>Thickness</th> <th>Slit</th> <th colspan="3">Tube Length</th> <th colspan="3">Cross Section</th> <th>Quantity</th> <th>Defect Quantity</th> <th>Error</th> <th>Leader Signature</th> </tr> <tr> <th>Production Lot No.</th> <th colspan="4">Material Lot No.</th> <th>1st Piece</th> <th>2nd Piece</th> <th>Last Piece</th> <th>1st Piece</th> <th>2nd Piece</th> <th>Last Piece</th> <th></th> <th></th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>7M0365-7020</td> <td>7B</td> <td>-</td> <td>-</td> <td>-</td> <td>90</td> <td>90</td> <td>90</td> <td>00</td> <td>00</td> <td>00</td> <td>500</td> <td>0</td> <td>III</td> <td>Arianna</td> </tr> <tr> <td>7-7</td> <td colspan="4">2016-06-05 (01)</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Product Name	Diameter	Color	Thickness	Slit	Tube Length			Cross Section			Quantity	Defect Quantity	Error	Leader Signature	Production Lot No.	Material Lot No.				1st Piece	2nd Piece	Last Piece	1st Piece	2nd Piece	Last Piece					7M0365-7020	7B	-	-	-	90	90	90	00	00	00	500	0	III	Arianna	7-7	2016-06-05 (01)														
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4	Operator will write the start time of tube replenishment. <table border="1"> <thead> <tr> <th colspan="4">SET UP and EXPECTED DOWNTIME MONITORING</th> </tr> <tr> <th>TIME</th> <th>DURATION (mins)</th> <th>ACTIVITY</th> <th>DETAILS</th> </tr> </thead> <tbody> <tr> <td>8:00-8:02</td> <td></td> <td>A</td> <td></td> </tr> <tr> <td>8:02-8:06</td> <td></td> <td>B</td> <td></td> </tr> <tr> <td>8:06-8:09</td> <td></td> <td>C</td> <td></td> </tr> <tr> <td>9:42-</td> <td></td> <td>H</td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> <tr> <td>-</td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	SET UP and EXPECTED DOWNTIME MONITORING				TIME	DURATION (mins)	ACTIVITY	DETAILS	8:00-8:02		A		8:02-8:06		B		8:06-8:09		C		9:42-		H		-				-				-				-				-				-				-				-								
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5	Get the tube from the warehouse. Use cart to carry the tube. 																																																													
6	Place parts label and Parts supply kanban on its designated area.																																																													

Rev.Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:
07/23/2021	1	Change tube replenishment set up	W. Valdez	Y. Yamamoto	O. Merin	08/04/2017
04/20/2018	0	Change Leader/Sub Leader to Senior Line Leader/ Line Leader.	M. Vasallo/W. Valdez	W. Carbillon	O. Merin	
08/04/2017	n/a	Established ISO format.	J. Garcia/Z. Mendez	O. Merin	T. Sugiyama	
-	-	Previously established work instruction (for history purpose only)	-	-	-	

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7	<p>Set tube in loading saucer, saucer guide, feeding machine, stand sensor and cutting machine.</p>  <p>Load tube in loading saucer Set tube to guide Set tube to guide Set tube to feeding rollers</p> <p>Press "CUT" to remove excess tube Press "FED" (Feed) Set tube to cutting machine Set tube to stand sensor and "turn on" the stand sensor.</p>	<p>Tube must be inserted to work sensor</p>																																																																																																												
8	<p>Produce two good samples. Choose "ST" to start producing another sample, then "CYCLE STP".</p>  <p>Measure the sample</p>  <p>* If it is on target length (good sample), then produce the second sample and measure it. * If it is No good sample, adjust machine offset.</p>																																																																																																													
9	<p>Fill-out Daily Report</p> <table border="1"> <thead> <tr> <th>Leader Signature</th> <th>Start time</th> <th>Finish time</th> <th>Product Name</th> <th>Diameter</th> <th>Color</th> <th>Thickness</th> <th>Slit</th> <th colspan="3">Tube Length</th> <th colspan="3">Cross Section</th> <th>Quantity</th> <th>Defect Quantity</th> <th>Error</th> <th>Leader Signature</th> </tr> <tr> <th>First Piece</th> <th></th> <th></th> <th>Production Lot No.</th> <th></th> <th></th> <th></th> <th></th> <th>1st Piece</th> <th>2nd Piece</th> <th>Last Piece</th> <th>1st Piece</th> <th>2nd Piece</th> <th>Last Piece</th> <th></th> <th></th> <th></th> <th>Last Piece</th> </tr> </thead> <tbody> <tr> <td>selena</td> <td>8:00</td> <td></td> <td>7M0365-7020</td> <td>7/8</td> <td></td> <td></td> <td></td> <td>90</td> <td>90</td> <td>90</td> <td>OO</td> <td>OO</td> <td>OO</td> <td>500</td> <td>0</td> <td>III</td> <td>Arianna</td> </tr> <tr> <td></td> <td></td> <td></td> <td>7-7</td> <td>7/8</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>2016-06-05 (01)</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>2016-06-05 (02)</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	Leader Signature	Start time	Finish time	Product Name	Diameter	Color	Thickness	Slit	Tube Length			Cross Section			Quantity	Defect Quantity	Error	Leader Signature	First Piece			Production Lot No.					1st Piece	2nd Piece	Last Piece	1st Piece	2nd Piece	Last Piece				Last Piece	selena	8:00		7M0365-7020	7/8				90	90	90	OO	OO	OO	500	0	III	Arianna				7-7	7/8																	2016-06-05 (01)																		2016-06-05 (02)															
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