

	Process Name/ Title: Wire Cutting and Crimping / Quality Check After Adjustment and Repair		Document No:	WI-PRO-CNC-031	
	WORK INSTRUCTION		Effective Date:	December 13, 2021	
	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>* During operation, when machine or applicator is adjusted and/or repaired, quality check must be done.</p> <p>Applied Model: Automatic Cut and Crimp Machine</p> <p>① Replacement of cutter blade</p> <p>② Replacement of applicator parts</p> <p>Example:</p> <div style="display: flex; align-items: center;"> <div style="margin-right: 20px;">  <p>Develop Sheet for Crimp Data</p> <table border="1"> <thead> <tr> <th colspan="2">Mon / Day</th> <th>15</th> <th>15</th> </tr> </thead> <tbody> <tr> <td rowspan="8" style="writing-mode: vertical-rl; transform: rotate(180deg);">Wire Crimp Height (mm)</td> <td>Start</td> <td>1.103</td> <td>1.104</td> </tr> <tr> <td>Start</td> <td>1.103</td> <td>1.103</td> </tr> <tr> <td>Middle</td> <td>1.094</td> <td></td> </tr> <tr> <td>End</td> <td>1.107</td> <td></td> </tr> <tr> <td>End</td> <td>1.103</td> <td></td> </tr> <tr> <td>ΣX</td> <td>5.510</td> <td></td> </tr> <tr> <td>X</td> <td>1.102</td> <td></td> </tr> <tr> <td>R</td> <td>0.013</td> <td></td> </tr> </tbody> </table> </div> <div> <p>Last piece before abnormality occurred</p> <p>New sample after repair and adjustment</p> </div> </div> <p>Check quality of last piece (before abnormality occurred) Gather all required data and write it on develop sheet.</p> <p>After repair and adjustment, produce sample, check quality gather data and write it on develop sheet (new column)</p> <p>* In case of parts replacement, (applicator parts or cutter blade) write details on NOTE column. Details of changes will be recorded on the 4M changepoint control form</p> <table border="1" style="width: 100%;"> <tr> <td style="width: 20%;">Note</td> <td style="width: 80%;">Replacement of Cutter</td> </tr> </table> <p>❖ In case there is an occurrence of defect during the operation:</p> <ol style="list-style-type: none"> Scrap entire lot if below defects are found. <ul style="list-style-type: none"> Cut = 1 or more Scar = 2 or more Pulling Out = 1 or more For other defects, if there is no problem with the preceding 200 units after inspection, the entire lot is passable. 	Mon / Day		15	15	Wire Crimp Height (mm)	Start	1.103	1.104	Start	1.103	1.103	Middle	1.094		End	1.107		End	1.103		ΣX	5.510		X	1.102		R	0.013		Note	Replacement of Cutter	<p>F-PRO-COM-008</p>
Mon / Day		15	15																														
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Note	Replacement of Cutter																																

						Prepare	Check	Approve
12/13/2021		Change developsheet details			W. Valdez	D. Comero	O. Merin	
07/10/2017	0	Previously established Work Instruction(for history purpose only)			J. Garcia	O. Merin	T. Sugiyama	
Eff./Rev. Date	Rev. No.	Details of change			Revise	Check	Approve	Est. date: 07/10/2017

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