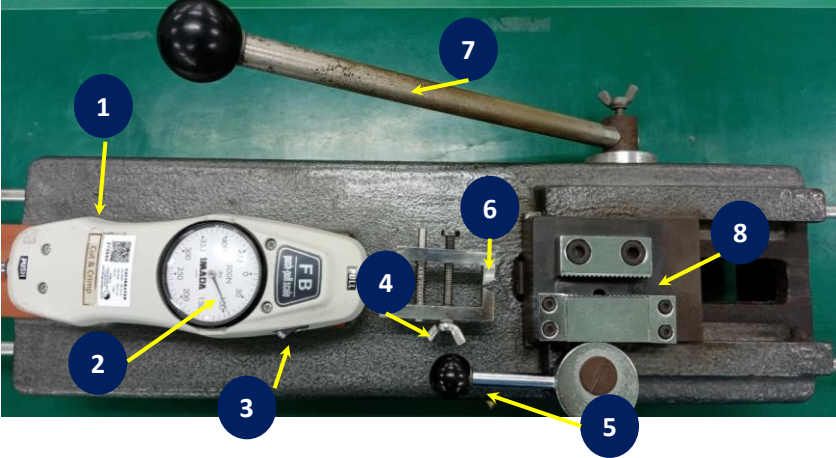
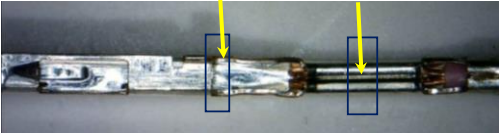
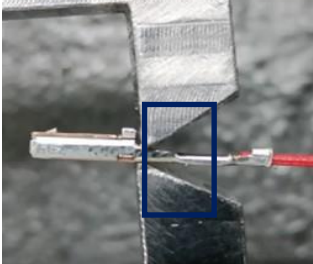
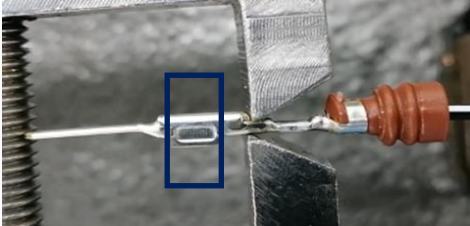
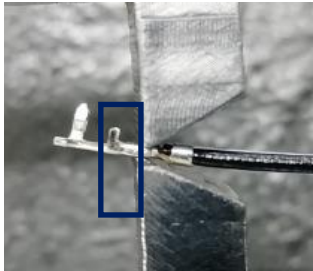
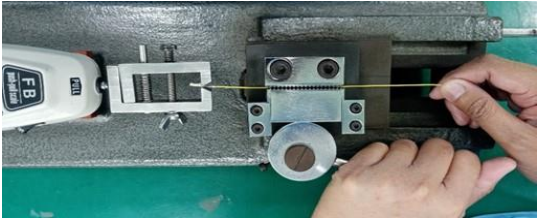



	Process Name/ Title:		Document No:		WI-PRO-CNC-007	
	Wire Cutting and Crimping / Tensile Strength Test Procedure		Effective Date:		February 12, 2025	
	WORK INSTRUCTION		Rev. No.:		3	
	Product Code/Name: All		Customer Code: All		Page No.: 1 of 2	

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>PUSH AND PULL GAUGE</p>  <p>Parts of the Push and Pull Gauge</p> <ol style="list-style-type: none">1. Guide2. Needle3. Switch4. Thumbscrew5. Wire Grip Lever6. Terminal Clamp7. Operating Lever8. Wire Grip	<p>Sample Crimped wire (minimum length is 120mm)</p> <p>For Daily Equipment Inspection Refer to F-PRO-CNC-002C</p>

PROCEDURE

2	<p>A. FOR STRAIGHT WIRE</p> <p>a1. Place terminal on terminal clamp (6) a2. then fix thumbscrew (4).</p> <p>CLAMPING POINT</p>  <p>Note: Follow the crimp position base on the illustration and type of terminal.</p>	 <p>Female Terminal - Area A</p>  <p>Male Terminal - Area A</p>  <p>7D Terminal - Area A</p>
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3	<p>a3. Place wire on wire grip (8), a4. then fix wire grip lever (slightly pull the wire) (5) Wire must be properly fixed on wire grip.</p> 	<p>Make sure the wire is straight</p>
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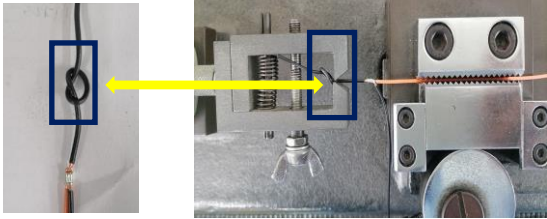






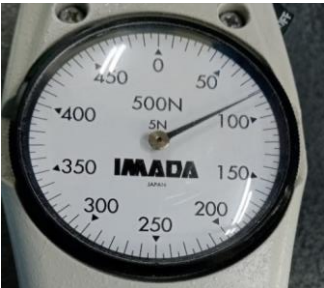
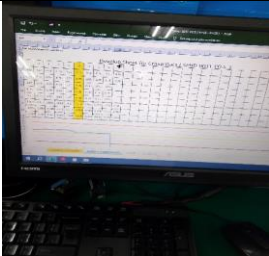
						Prepare	Check	Approve
02/12/2025	3	Include jointed wire in the procedure	W. Bergado	C. Calayan	W. Carbillon	 W. Bergado	 C. Calayan	 W. Carbillon
11/18/2024	2	Added special characteristic "diamond mark" in tensile strength	W. Bergado	C. Calayan	W. Carbillon			
01/04/2022	1	Detailed procedure and additional check item	W. Valdez	D. Cornero	O. Merin			
07/10/2017	0	Initial issue.	A. Garcia/ Z Mendez	O. Merin	T. Sugiyama			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	July 10, 2017	

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	Process Name/ Title:		Document No:		WI-PRO-CNC-007	
	Wire Cutting and Crimping / Tensile Strength Test Procedure		Effective Date:		February 12, 2025	
	WORK INSTRUCTION		Rev. No.:		3	
	Product Code/Name:	Customer Code:	Page No.:		2 of 2	
All		All				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers	
3 B. FOR JOINTED WIRE 4 <ul style="list-style-type: none"> b1. Knot the single wire to hook the wire b2. Hook the wire on the terminal clamp (6) b3. Clamp the joint wire to wire grip (8) b4. then fix wire grip lever (slightly pull the wire) (5) Wire must be properly fixed on wire grip.		Make sure the wire is straight	
5	Turn on Switch (3)	 <div>Position of Switch if ON</div>  <div>Position of Switch if OFF</div> 	(Note: If Switch is not turned on, needle will go back to 0 automatically after pulling.)
6	Confirm needle (2) position, it must be on 0 (zero) point. If not, adjust guide until needle reaches 0 (zero) point.	 	
7	Pull operating lever (7) slowly to destroy sample wire.		If operating lever is pulled rapidly, different or incorrect value will be displayed if this happens, get another sample wire and repeat steps 1-5.
8	After sample wire is destroyed, confirm value by reading the figures where the needle is pointing at.	 <div>Example = 80 N</div>	a. Check the standard value of the Strength Test in Develop Sheet if above the standard. b. If found below standard value inform Leader in charge
9	◆ Input the value of tensile strength in develop sheet		Refer to WI-PRO-CNC-015

*In case of any abnormality encountered, follow STOP - CALL - WAIT procedure.

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