

	Process Name/ Title: Tube Cutting / Corrugated Tube Digital Cutting Machine Control Panel		Document No:	WI-PRO-CNC-004	
	WORK INSTRUCTION		Effective Date:	July 10, 2017	
	Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 0	Page No.:	Page 1 of 1

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers		
	A	Main Screen 1			
	B	Screen in Progress			
	C	Main Screen 2			
	Screen	No.	Keys Name		
A	①	CUT	Used to manually cut corrugated tube. Also used to reset blade to original position. (Press key for approximately 2-3 seconds to cut)		
	②	FED	Used to manually feed tube.		
	③	ST	Used to start machine operation.		
	④	➡	Used to switch the screen from main screen 1 to main screen 2 and vice versa.		
	⑤	< >	Used to change data set		
	⑥	FG LNG	Used to set the target cutting length.		
	⑦	V	Used to set desired speed.		
	⑧	QTY. SET	Used to set target quantity.		
	⑨	QTY. FIN	Displays actual cut quantity.		
	⑩	Lot	Displays the lot quantity set.		
B	⑪	CYCLE STP	Used to complete one cycle cut before stopping machine operation.		
	⑫	STP	Used to stop machine operation.		
C	⑬	OFFSET	Used to offset measurement.		
	⑭	COS	Counter Screen - Displays actual blade and chopping board usage count number.		
	⑮	LOT	Used to set lot quantity so machines automatically stops every set lot quantity is completed.		
	⑯	⬅	Used to switch the screen from main screen 1 to main screen 2 and vice versa.		
	⑰	ENV	Used to switch from main screen 2 to configuration screen.		

NBC (Philippines)
MASTER COPY

							Prepare	Check	Approve
-	NBCP-1217	NA	Previously established work instruction(for history purpose only)	-	-	-	J. Garcia / 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	