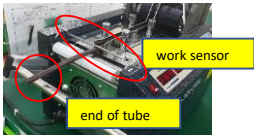






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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers																																																																															
1	<p>Stop the machine when the end of the tube reaches close to working sensor</p> 	<p>F-PRO-CNC-005</p> <p>F-PRO-CNC-004</p>																																																																															
2	<p>Measure the last piece (good product), check appearance and cross section and put the tube beside cutting ledger.</p>  																																																																																
3	<p>Fill-out daily report.</p> <p>write by operator</p> <p>then Senior Line Leader/ Line Leader or freeman will sign after checking</p> <table border="1"> <tr> <td>S</td> <td>DBR</td> <td>0.5</td> <td>-</td> <td>163</td> <td>163</td> <td>163</td> <td>OO</td> <td>OO</td> <td>OO</td> <td>100</td> <td>0</td> <td>III</td> <td>jen</td> </tr> <tr> <td colspan="14">2017-03-01 (02)</td> </tr> </table>		S	DBR	0.5	-	163	163	163	OO	OO	OO	100	0	III	jen	2017-03-01 (02)																																																																
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4	<p>Operator will write the start time of tube replenishment.</p> <table border="1"> <thead> <tr> <th>ACTIVITY Legend:</th> <th>TIME</th> <th>DURATION (mins)</th> <th>ACTIVITY</th> <th>DETAILS</th> </tr> </thead> <tbody> <tr> <td>Set - Up and Expected Downtime</td> <td>8:00-8:02</td> <td></td> <td>A</td> <td></td> </tr> <tr> <td>A Machine and Instrument Checking</td> <td>8:02-8:06</td> <td></td> <td>B</td> <td></td> </tr> <tr> <td>- Machine, caliper, micrometer, maglamp</td> <td>8:06-8:09</td> <td></td> <td>C</td> <td></td> </tr> <tr> <td>B Start of Shift Set- Up/ Adjustment</td> <td>8:42-</td> <td></td> <td>H</td> <td></td> </tr> <tr> <td>-adjust machine, produce 2 samples</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>C Daily Entry - Data and Daily Report</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>(Start and End of Shift)</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>- Tensile test, developsheets, first good product, last good product, daily report</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>D -change due to damaged applicator, unexpected applicator change</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>E Terminal Change</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>F Wire Change</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>G Change Model Set-up and/or lot number</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>change product, applicator change, mid of production machine set up</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>H Tube Replenishment</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>I change Tube length/Color/Diameter (Φ)</td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>	ACTIVITY Legend:	TIME	DURATION (mins)	ACTIVITY	DETAILS	Set - Up and Expected Downtime	8:00-8:02		A		A Machine and Instrument Checking	8:02-8:06		B		- Machine, caliper, micrometer, maglamp	8:06-8:09		C		B Start of Shift Set- Up/ Adjustment	8:42-		H		-adjust machine, produce 2 samples					C Daily Entry - Data and Daily Report					(Start and End of Shift)					- Tensile test, developsheets, first good product, last good product, daily report					D -change due to damaged applicator, unexpected applicator change					E Terminal Change					F Wire Change					G Change Model Set-up and/or lot number					change product, applicator change, mid of production machine set up					H Tube Replenishment					I change Tube length/Color/Diameter (Φ)				
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5	<p>Remove pipe on the loading saucer and place pipe in the pipe stand. Loose bolt in the pipe. Turn off stand sensor.</p> 																																																																																
6	<p>Get the tube from the tube rack or on the box.</p>  	<p>Note: Check the diameter and color of the tube base on the label of material, before perform tube replenish.</p>																																																																															
7	<p>Load vinyl tube on loading saucer, fit the pipe on the tube and lock the pipe.</p> <p>Return the pipe on the loading saucer. Untie or remove the plastic of tube. Cut the end of the Tube</p> <p>End of tube must be on the left side. Loading saucer must rotate counterclockwise.</p> 																																																																																

02/16/2022	3	Change the details of checkpoint during replenishment	W. Bergado	O. Merin	O. Merin	Prepare	Check	Approve
04/26/2021	2	Change content of set up of tube and include freeman for checking hatsumono and owarimono	W. Valdez	W. Carbillon	O. Merin			
04/20/2018	1	Change Sub leader to Senior Line Leader or Line leader	M. Vasallo/W. Valdez	W. Carbillon	O. Merin			
07/10/2017	0	Established ISO format.	J. Garcia/Z. Mendez	O. Merin	T. Sugiyama			
-	NA	Previously established work instruction (for history purpose only)	-	-	-	W. Bergado	O. Merin	O. Merin
Eff./Rev.Date	Rev. No. (if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017	


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8	Place parts label and Parts supply kanban on its designated area. 	<p>Note: Tube must be inserted in work sensor.</p>																																																																																										
9	Set tube in saucer guide. 																																																																																											
10	Set tube in feeding machine and manually feed the machine until the tube reach in stand sensor. 																																																																																											
11	Set in stand sensor and turn on the stand sensor. Set the tube in working sensor and cutting machine. 																																																																																											
12	Manually FEED and CUT tube to remove excess tip. 																																																																																											
13	Produce two good samples. 13.1 Press "start" then stop to produce the 1st sample. 																																																																																											
	13.2 Measure the sample. If sample does not meet the target value, adjust setting until target value is met. Place the first good sample beside of cutting ledger then produce the second sample. 																																																																																											
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15	<p>Call Senior Line Leader / Line leader or Freeman to check the last piece and first 2 good samples of tube prior mass production. Senior Line Leader / Line leader or Freeman will measure the length of tube and verify the diameter of tube using pin gauge. He/She will write the actual length and judgment of cross section cut in daily report. After checking Senior Line Leader/ Line leader or Freeman will sign (last and first samples/piece) in daily report</p> <table><tr><td>jen</td><td>8:00</td><td></td><td>75L175-0300A</td><td>8</td><td>DBR</td><td>0.5</td><td>-</td><td>163</td><td>163</td><td>163</td><td>00</td><td>00</td><td>00</td><td>100</td><td>0</td><td>III</td><td>jen</td></tr><tr><td></td><td></td><td></td><td>7-1</td><td></td><td></td><td></td><td>2017-03-01 (02)</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>zandi</td><td></td><td></td><td>II</td><td>8</td><td>DBR</td><td>0.5</td><td>-</td><td>163</td><td>163</td><td></td><td>00</td><td>00</td><td></td><td></td><td></td><td></td><td></td></tr><tr><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td>2017-03-01 (03)</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table>	jen	8:00		75L175-0300A	8	DBR	0.5	-	163	163	163	00	00	00	100	0	III	jen				7-1				2017-03-01 (02)											zandi			II	8	DBR	0.5	-	163	163		00	00													2017-03-01 (03)											
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