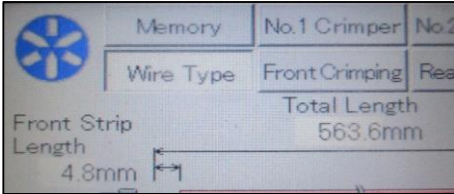
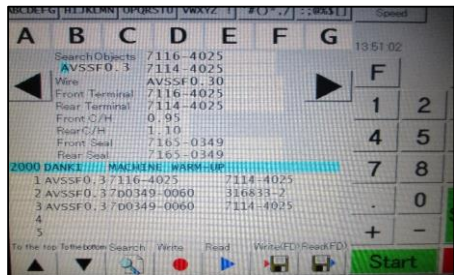
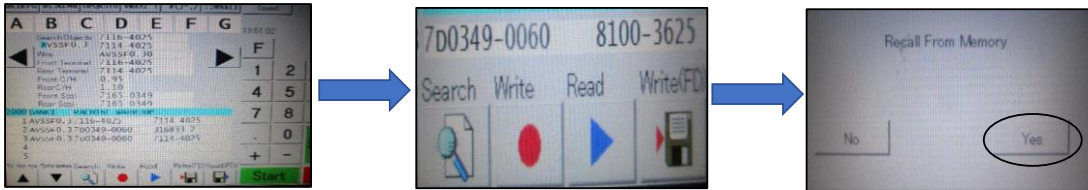
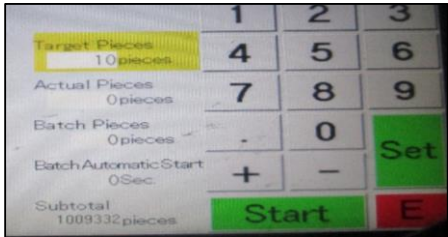
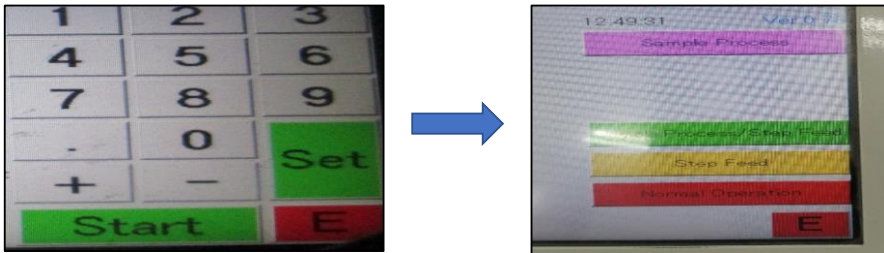
	Process Name/ Title:		Document No:	WI-PRO-CNC-063
	Procedure of machine checking		Effective Date:	May 17, 2021
	WORK INSTRUCTION		Rev. No.:	0
Product Code/Name:	Customer Code:	Rev. No.:	0	Page No.: Page 1 of 2
ALL	ALL			


No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>Confirm 1st. Sound of gush from air nozzle for insulation scum</p> <p>1.1 Click the memory bottom</p>  <p>1.2 Select the memory of DANKI</p>  <p>1.3 Press the read button and recall the memory</p>  <p>1.4 Input the quantity on target pieces and then press the set button</p>  <p>1.5 Press The start button and proceed to normal operation</p> 	<p>Note:hear the sounds if there is unusual sound.if you hear unusual sound meaning there is a problem in machine.operator must STOP-CALL-WAIT.</p>


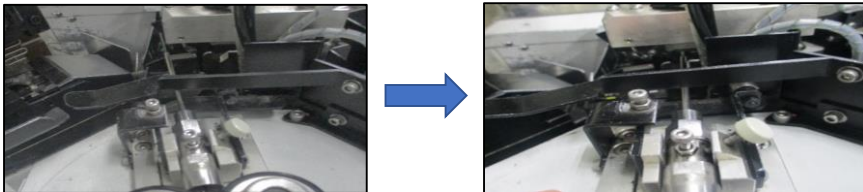

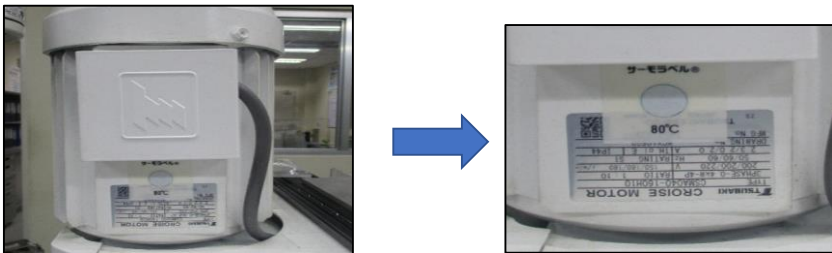
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Prepare	Check	Approve
			S.Apil	Y.Yamamoto	O. Merin	S.Apil	Y.Yamamoto	O. Merin
						Est. date: 05/17/2021		

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	Process Name/ Title:				
	Procedure of machine checking		Document No:	WI-PRO-CNC-063	
	WORK INSTRUCTION		Effective Date:	May 17, 2021	
	Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 0	Page No.:	Page 2 of 2

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
2	<p>Check emergency switch button</p> <p>Press the emergency switch to stop the machine during running to check if the emergency button will function</p> 	
3	<p>Confirm position of guide pipe</p> <p>The pipe must be center on the cutter blade</p> 	
4	<p>Confirm air pressure</p> <p>Check if the pressure is within the tolerance</p> <p>Insulation scum (0.2 ~ 0.4 MP)</p> <p>Grip (0.3 ~ 0.5 MP)</p> <p>Guide Plate (0.2 ~ 0.4 MP)</p> <p>Chuck (0.1 ~ 0.3 MP)</p> <p>Waterproofseal (0.4 ~ 0.6 MP)</p> 	
5	<p>Thermo label (FRONT and REAR)</p> <p>Blue color must be at the edge of circle</p> 	<p>Note: If the whole circle covered by blue, machine reach the maximum degree temperature(80°C) and can cause over heat the machine.</p>
6	<p>Unusual Sound</p> <p>Check after Operation is finished</p> <p>Last sound of gush from air nozzle for Insulation scum</p>	<p>Note: Repeat Procedure no. 1</p>