
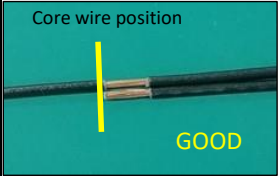
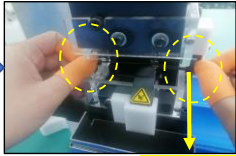





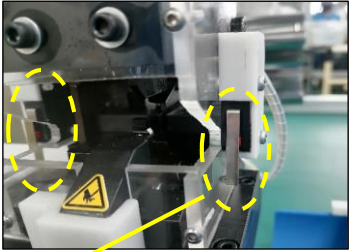


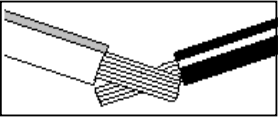
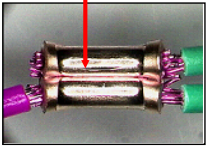

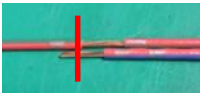

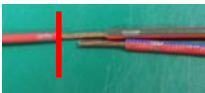

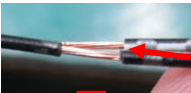
	Process Name/ Title:		Document No:		WI-PRO-CNC-075	
	Jointing Procedure				Effective Date:	
	WORK INSTRUCTION				July 9, 2024	
	Product Code/Name:		Customer Code:		Rev. No.: 1	
ALL		ALL		Page No.: 1 of 2		

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	Check the plan	
2	Select the part number from the working area before proceed to operation (FIFO)	
3	Check the cutting ledger and prepare the necessary color of wires in order from WIP joint.	
A. Joint Preparation <ul style="list-style-type: none"> Get one bundle of stripped wire from the box on the right side of the table and place the wire on the tray. Get one bundle of wire from the box on the right side of the table and place the wire on the tray. Remove rubber band and paper from the bundle of wire Get the wire one by one and start jointing process Use finger cots during operation.To avoid injury. 		
		
B. Jointing Process B1. Conduct Jointing of 2 wires by following the steps below.		
		
		
		
		
	Step 1: Align the stripped wire and core wire.Stripped wire is on the top of the core wire.	
	Step 2: Hold the 2 wires using right hand and hold the wire in the left side. Reached the sensor in applicator	
	Step 3: Step the foot pedal to crimp the joint wire	
	Step 4: After jointing of wire,place the wire directly on the box (left side)	
		
	Step 7: Place one bundle on the box	
		
	Step 6: Align terminal and bundle the wire.Wrapped paper and tie the rubber band.	
		
	Step 5: After finishing one bundle, check the orientation of terminal.	
	Step 8: After finishing one box, Fill in the daily report and identification tag.	
	Step 7: Scan Identification Tag and attached it on the box.	
	Step 8: Move the box to QC Inspection	
Remarks: <div style="display: flex; justify-content: space-around;"> <div>  <p>Applicator Sensor - use applicator sensor to operate the machine.To avoid injury. > Before stepping foot pedal, operator need to push both sensor left and right to work the machine. Make sure the stripped wire is in the good position in the applicator. Note: If the operator did not use the sensor the machine didn't work or</p> </div> <div>  <p>Pincette with sensor holder - Use to remove the stuck terminal or other foreigen materials in applicator. Note: Make sure that the pincette is always in the holder to work the machine.If missing operator didn't operate the machine due to no pincette available.If no available pincette inform to immediate superior.</p> </div> </div>		

						Prepare	Check	Approve
7/9/2024	1	General Revision	W. Bergado	C. Calayan	W. Carbillon	W. Bergado	C. Calayan	W. Carbillon
3/2/2024	0	Initial Issue.	W. Bergado	C. Calayan	W. Carbillon			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	March 2, 2024	

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No.	<div><div><div>1</div></div><div>Work Procedure/ Illustration</div></div>	Records/Remarks/ Quality Pointers
	<div><div><div><div>DO NOT CHANGE THE METHOD OF HOLDING THE WIRE</div><div>Hold one in each hand and do not adjust the applicator position (The crimping position may misalign)</div><div></div><div>Do not set the core wire diagonally</div></div><div></div><div>Jointing part will get damage</div></div><div>Note: If you crimp the core diagonally, the core will get damaged in the jointing part and the tensile strength will decrease</div></div> <div>B2. Conduct Jointing of 4 wires by following the steps below. Step 1: Align the stripped wire and core.Stripped wire is on the top of core wire. Step 2: Hold the 3 wires using right hand and hold the wire in the left side. Reached the sensor in applicator to operate the machine. Step 3: Step the foot pedal to crimp the joint wire Step 4: After jointing of wire,place the wire directly on the box (left side) Step 5: After finishing one bundle, check the orientation of terminal. Step 6: Align terminal and bundle the wire.Wrapped paper and tie the rubber band. Step 7: Place one bundle on the box Step 8: After finishing one box, Fill in the daily report and identification tag. Step 7: Scan Identification Tag and attached it on the box. Step 8: Move the box to QC Inspection Note: In case there are remaining wires on the tray, Conduct 100% inspection of wire color. If there are remaining wires, there is a possibility that the same color of wire was crimped. C. At the end of the shift or at the end of the operation. Perform/Accomplish machine checking and daily report. Turn off the machine. Conduct 5's of machine and working area. If any abnormality or defect encounter,Conduct STOP-CALL and WAIT. <div><div>Sample illustration of defect:</div><div><div><div>Bitting</div></div><div><div>Lowering</div></div><div><div>Protruded Defect</div></div></div></div><div><div>CONFIDENTIAL: Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.</div><div><div>NBC (Philippines)</div><div>MASTER COPY</div></div><div>DCC Stamp</div></div></div>	