


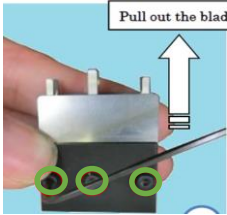
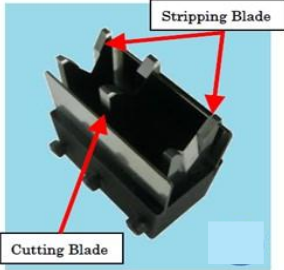

	Process Name/ Title:		Document No:	WI-PRO-CNC-068	
	Changing Cutter Blade in Highspeed Machine		Effective Date:	September 1, 2021	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Rev. No.:	0	Page No.:	Page 1 of 2

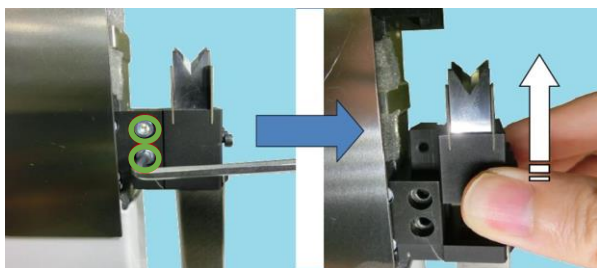
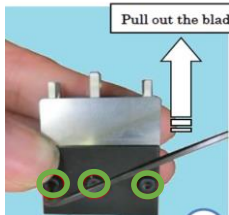
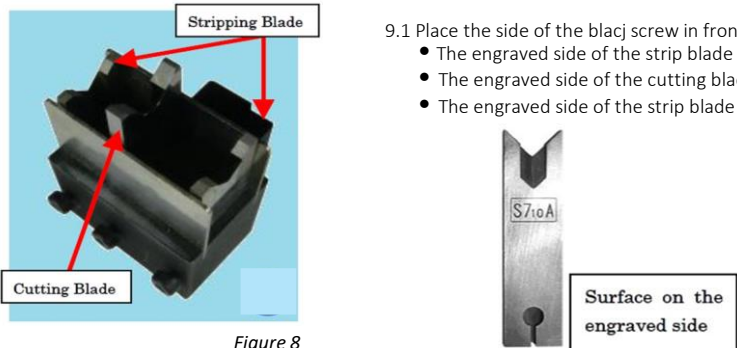
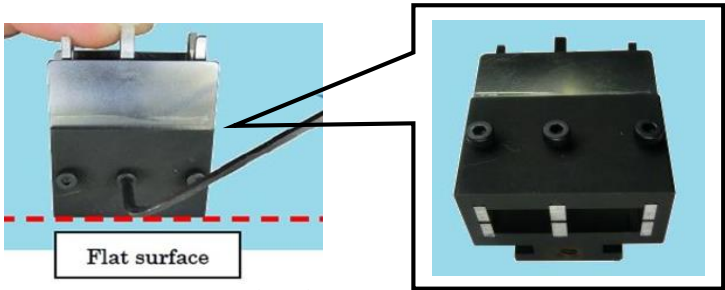
No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>Turn off the machine and air supply in the machine. Remove air hose of Unit 2 by pressing the black ring of one touch fitting as shown in the figure 1 then pull out the air hose.</p>  <p>Figure 1</p>	
2	<p>Using a long screw driver or allen wrench, insert it on the hole as seen in the figure 2.</p>  <p>Figure 2</p>	
3	<p>Then loosen the 2 pcs retaining screws and remove. The <u>upper cutter block</u> can now be pull-out.</p>  <p>Figure 3</p>	Used <u>GLOVES</u> to avoid injury
4	<p>Loosen the screw and pull out the blade. Clean or remove the chips or dust inside the block of cutter blade.</p>  <p>Figure 4</p>	Used <u>GLOVES</u> to avoid injury
5	<p>Change new stripping blade and cutting blade</p>  <p>Figure 5</p> <p>5.1 Place the side of the black screw in front.</p> <ul style="list-style-type: none"> <li>• The engraved side of the strip blade faces rightward.</li> <li>• The engraved side of the cutting blade faces leftward</li> <li>• The engraved side of the strip blade faces leftward</li> </ul>  <p>Surface on the engraved side</p>	Note: Please pay attention to the direction
6	<p>Press the blade and tighten the screw so that the end faces are aligned properly.</p>	

						Prepare	Check	Approve
09/01/2021	0	Initial issue	W. Valdez	D. Cornero	O. Merin	W. Valdez	D. Cornero	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date: 09/01/2021		

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
7	Remove the screw and pull out the <u>lower cutter block</u> . 	Used <u>GLOVES</u> to avoid injury
8	Loosen the screw and pull out the blade. Clean or remove the chips or dust inside the block of cutter blade. 	Used <u>GLOVES</u> to avoid injury
9	Change new stripping blade and cutting blade  9.1 Place the side of the blade screw in front from the right. <ul style="list-style-type: none"> <li>• The engraved side of the strip blade faces leftward.</li> <li>• The engraved side of the cutting blade faces leftward</li> <li>• The engraved side of the strip blade faces rightward</li> </ul>	Note: Please pay attention to the direction
10	Press the blade against the flat surface as shown in figure 9 and tighten the screw so that end faces are aligned properly. 	Use <u>GLOVES</u> to avoid injury
11	Return the lower and upper cutter block and tighten the screw.	
12	Return the air hose to return the air supply.	
13	Turn on the machine and air supply of the machine.	
14	Change cut depth value and evaluate the cut depth.	WI-PRO-CNC-025
<p><b>Note:</b> Checking for damage or worn out cutter blade Follow no. 1 - 3 and 7. Clean the cutter block before checking and always wear gloves.</p> <p>If any problem encountered <b>STOP</b> , <b>CALL</b> and <b>WAIT</b> .</p>		