Process Name/ Title:	Document No:	WI-PRO-CNC-005
Wire Cutting and Crimping / Wire Confirmation Standard		
WORK INSTRUCTION	Effective Date:	**November 18, 2024**
Product Code/Name: **All** / Customer Code: **All**	Rev. No.: **3**	Page No.: **1 of 1**

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers

1. When to conduct wire confirmation

   Start, Middle and End of the shift.
   When there is change in wire type and/or wire size during the shift.
   When there is change in terminal during the shift.
   When there is machine adjustment or repair during the shift.
   When there is applicator change during the shift.

2.

Confirmation Points	Number of Samples	Tools / Instrument	Document	Note	Example of defect	Records/Remarks/ Quality Pointers
Wire type Wire diameter Wire color	Start (n=1)	Visual confirmation	・Wire label / specifications ・Work Instruction sheet ・Wire Cutting Ledger	Write on daily report (confirm with label, size, marking, and number of core wire) Compare with wire cutting ledger	Different wire type Different wire diameter Different wire color	
Strip Length	Start (n=1) End (n=1)	Steel ruler Scale Loupe	・Wire Cutting Ledger	Write actual strip length on daily report *per model, per lot and when strip length and wire diameter is changed	Long Strip length Short strip length Cross section is slanted Uneven strip or cut	Refer to Tolerance for Strip Length WI-PRO-CNC-017
Core wire	Start (n=2) End (n=1)	Magnifying Glass Peak Lupe	・Write judgment on develop sheet for crimp data	Confirm when strip length and wire diameter is changed	Cut = 1 or more Scar= 2 or more	
③◆ Wire Crimp Height	Start (n=2) Middle (n=1) End (n=2)	Point micrometer	・Write value on develop sheet for crimp data ・Write value daily report	(Midterm Check Wire Crimp Height) Machine: Once per 4000 Hand: Once per 2000 ・1st piece and Last piece of each model	Vary as per standard based on develop sheet for crimp data	
Wire Crimp Width	Start (n=1)	Vernier caliper	・Write value on develop sheet for crimp data		Vary as per standard based on develop sheet for crimp data	
Insulation Crimp Height	Start (n=1) End (n=1)	Vernier caliper	・Write value on develop sheet for crimp data	*Summarize when instructed	Vary as per standard based on develop sheet for crimp data	
Insulation Crimp Width	Start (n=1) End (n=1)	Vernier caliper	・Write value on develop sheet for crimp data	*Check when instructed	Vary as per standard based on develop sheet for crimp data	
Crimp Burr Height	Start (n=1) End (n=1)	Blade micrometer Point micrometer	・Write value on develop sheet for crimp data	To check, compare with wire crimp height. *Summarize when instructed	Crimp burr is big Size of crimp burr on both sides are different	
Shape of crimp	Start (n=1) End (n=1)	Visual confirmation	・Work instruction sheet [list of crimp defect]	Confirm any time during work	Based on list of crimp defect	
③◆ Tensile Strength	Start (n=2) End (n=1)	Pushpull gauge	・Write value on develop sheet for crimp data	Lowest value will be plotted on the graph	Tensile strength value is less than the standard based on develop sheet for crimp data	
Bell-mouth	Start (n=1) End (n=1)	Magnifying Lens Peak Lupe Visual confirmation	・Write judgment on develop sheet for crimp data	Confirm at any time during work	Based on list of crimp defect item no. 5	
Terminal	Start (n=1)	Visual confirmation	・Wire Cutting Ledger ・Write on Daily Report	Compare wire cutting ledger and label *In case of both side has terminal, write both ①②	Terminal Part Number is different from ledger	
Wire Length	Start (n=2) End (n=1)	Scale	・Wire Cutting Ledger	Write actual strip length on daily report	Long dimension Short dimension	
Indentation Mark	Start (n=2) End (n=1)	Visual confirmation	・Write judgment on develop sheet for crimp data	Confirm any time during work	Deep grip mark on insulation	

3. * For Items with no instructions to check or items Not Applicable, write / on develop sheet for crimp data.
   ** In case defect or abnormality is encountered, follow STOP-CALL- WAIT Procedure.

Refer to WI-PRO-CNC- 015

Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve
11/18/2024	③	Added special characteristic "diamond mark" in wire crimp height and tensile strength and remove stabilizer width	W. Bergado	C. Calayan	W. Carbillon
01/03/2023	2	Include checking of indentation mark on crimp wire	W. Valdez	O. Merin	O. Merin
12/13/2021	1	Add details for checking the strip length and the wire crimp height	W. Valdez	D. Cornero	O. Merin
07/10/2017	0	Previously established Work Instruction(for history purpose only). Initial issue.	J. Garcia/ Z. Mendez	O. Merin	T. Sugiyama

Prepare	Check	Approve
W. Bergado	C. Calayan	W. Carbillon

Est. date: July 10, 2017