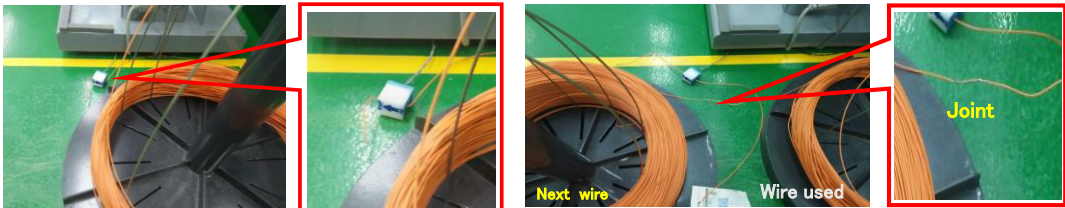
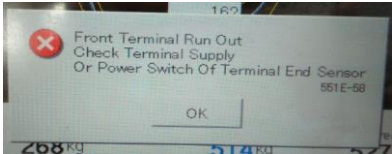





	Process Name/ Title:		Document No:	WI-PRO-CNC-057	
	Wire Presence Sensor		Effective Date:	May 03, 2022	
	WORK INSTRUCTION		Rev. No.:	2	
	Product Code/Name: Common	Customer Code: n/a	Page No.:	Page 1 of 1	

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Reminder: Be sure to use a wire presence sensor, as there is a possibility of dimensional defects etc. due to the blockage of joints in automatic cutting machines.</p> <p>Use the wire presence sensor as follows:</p> <ol style="list-style-type: none"> 1. Insert the end of the wire that is currently in use. 2. When connecting the wires, cut the wire in presence sensor and joint the wire in front. <div>  </div> <p>Caution: When the wire comes off in the wire presence sensor, the machine will stop. (Error)</p> <p>The machine will stop if the wire comes off in the wire presence sensor If the wire is removed, an error "Front terminal run out" will pop-up. If Front terminal run out, check if there is terminal and wire.</p> <p>(See picture below.)</p> <div>  <p>If the error appeared on the screen, check both terminals and wires.</p> </div> <ol style="list-style-type: none"> 3. Connect the wires together, set the next cord and insert the end of the wire again 4. Make sure the wire is well inserted then restart the operation. <p>Do not perform the method below:</p> <p>⚠️ The joint wire is below the wire being inserted this may cause tangled wire.</p> <div>  </div> <p>Do not insert the end of the next wire that you will use. Unless the end of the wire in use and next wire is joint.</p> <p>⚠️ 5. Wire being inserted and joint wire should place at both side of bobbin.</p> <div>  </div>	<p>Note: If the wire is not well inserted the machine will not restart.</p> <p>Note: Short wire defect may be encountered when the wires joint stuck-up in the guide pipe.</p>

						Prepare	Check	Approve
05/03/2022	2	Add details for easy understanding on wire being joint and for next wire and picture	M. Lipaopao	W. Bergado	O. Merin			
06/01/2020	1	Change wire clip sensor to wire presence sensor	W. Valdez	Y. Yamamoto	O. Merin	M. Lipaopao	W. Bergado	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	06/01/2019	