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

1 Check work area. Conduct 5's on table.

2 Perform machine and instrument checking

A. Preparation

a1. Prepare cutting ledger for the part number for which the jointed wires will be made.

a2. Prepare terminal and applicator.

Note: Check the Part number of terminal and applicator using cutting ledger.

a3. Prepare the box containing wires for jointing on the right side of the working table.

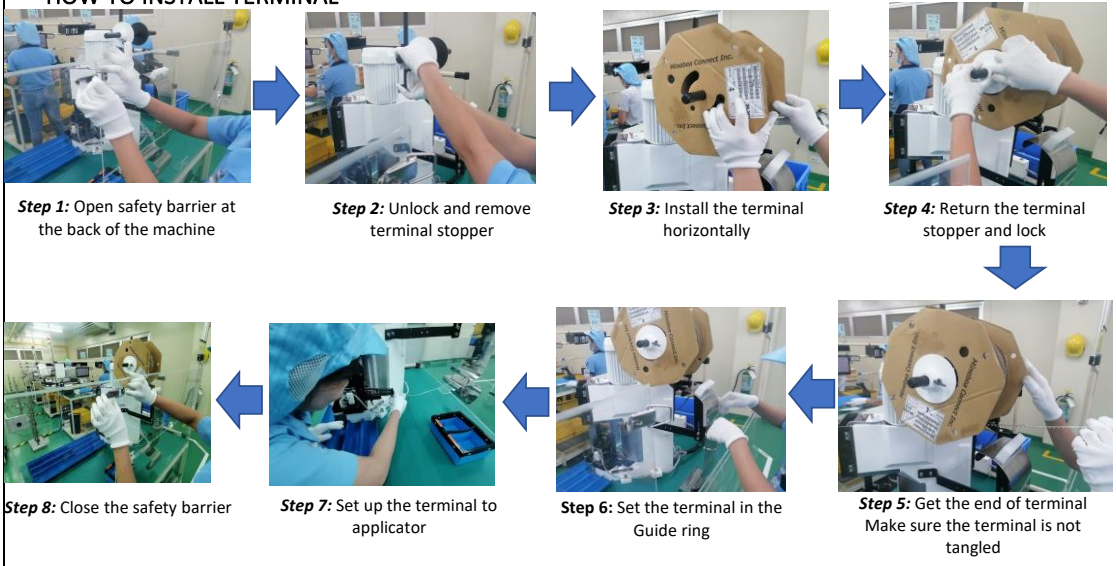
a4. Prepare a box for jointed wires (After Jointing) on the left side of the working table.

B. Before Operation

b1. Set the applicator and terminal and conduct initial crimping check.

⚠1 **HOW TO INSTALL TERMINAL**

Use gloves during set - up of terminal



Step 1: Open safety barrier at the back of the machine

Step 2: Unlock and remove terminal stopper

Step 3: Install the terminal horizontally

Step 4: Return the terminal stopper and lock

Step 5: Get the end of terminal Make sure the terminal is not tangled

Step 6: Set the terminal in the Guide ring

Step 7: Set up the terminal to applicator

Step 8: Close the safety barrier

⚠1 **HOW TO REMOVE TERMINAL**

Step 1: Unlock the applicator to remove the terminal

Step 2: Open the safety cover at the back of the machine

Step 3: Slowly roll the terminal until they reached the end of terminal

Step 4: Tie the end of terminal

Note: Make sure no tangled during winding of terminal

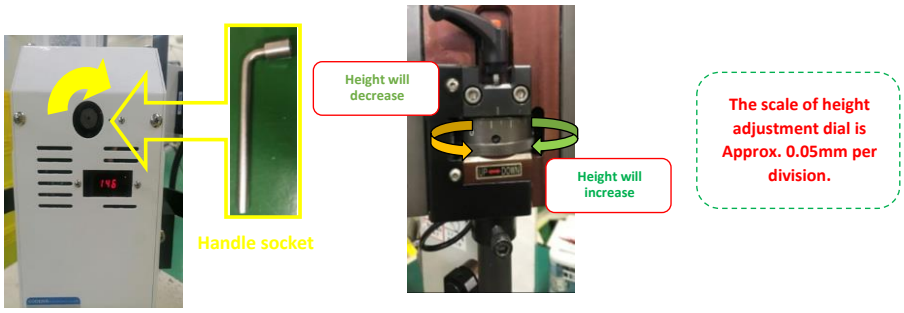
Step 5: Unlock the terminal stopper and remove the terminal

Step 6: Place the terminal in the terminal rack

Note: Make sure the position of terminal is horizontal to avoid loose winding

Step 7: Close the safety barrier.

						Prepare	Check	Approve
06/24/2024	1	Consider how to install and remove terminal to avoid tangled	W. Bergado	C. Calayan	W. Carbillon	W. Bergado	C. Calayan	W. Carbillon
2/20/2024	0	Initial issue	W. Bergado	C. Calayan	W. Carbillon			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	February 21, 2024	

No.	Work Procedure/ Illustration	Records/Remarks/Quality Pointers
	b2. After setting the applicator and terminal, turn the manual handle at the back of the machine and check that it turns easily. ● If the manual handle does not turn, increase the height and turn the manual again. ● When the manual handle turns, crimp one wire, check the height, and begin height adjustment.  ● Open the safety cover and loosen the height adjustment dial fixing lever. ● Turn the height adjustment dial in the direction you want to adjust it. ● Tighten the height adjustment dial fixing lever, crimp one sample, and check the height. ● Once the height is set to the specified height, tighten the height adjustment dial fixing lever and press the confirm pressure button to complete the adjustment. **Note:** Make sure to tighten the height adjustment dial fixing lever. The height may change during crimping b3. Height Checking    When the sample is in the center value, Press the pressure determination button ● Check the terminal reel part no. to be crimped using the cutting ledger. ***Step 1 .*** Crimp 2 samples for measurement ***Step 2*** . Measure the wire crimp height and wire crimp width **Note**: If the standard do not match, adjust the height, repeat step 1 and 2 Do not exceed the adjustment range; if adjustment is not possible, stop the operation and call the attention of leader ***Step 3.*** Conduct tensile strength ***Step 4*** . Record the result on Crimp Data ● Write details on Daily Report. ● Produce 2 good sample. ● Call the attention of leader to check the owarimono (first piece) ● After checking start production. ● Fill in identification tag after finish 1 box **C. End of Operation** c1. Condcut sample checking ***Step 1.*** Crimp 1 sample for measurement ***Step 2*** . Measure the wire rimp height and wire crimp width **Note**: If there is abnormality in height, width or tensile strength Inform immediately the leader and abnormality. ***Step 3.*** Conduct tensile strength ***Step 4*** . Record the result on Crimp Data c2. End Machine daily checksheet c3. 5's the area	Turning to the left the front increase the height, turn to the right to lower it.