




	Process Name/ Title:		Document No:	WI-PRO-CNC-067	
	Minor Trouble Shooting in Normal Machine		Effective Date:	August 19, 2021	
	WORK INSTRUCTION		Rev. No.:	0	
	Product Code/Name: ALL	Customer Code: ALL	Page No.: Page 1 of 2		

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
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## 1. Front Crimp Error

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
1.1 Wire crimp height is different from the wave form in the panel (wave form is color red)	<ul style="list-style-type: none"> <li>Measure the crimp height using point micrometer</li> </ul>	<ul style="list-style-type: none"> <li>Measure the actual crimp wire</li> <li>Origin the point micrometer, must 0.000 display and no gap in point and zero in spindle.</li> </ul> 	<ul style="list-style-type: none"> <li>Press "OK" in the panel to ok the graph. Proceed to mass production.</li> </ul>	<ul style="list-style-type: none"> <li>Adjust crimp height in the panel. Target the given specs. base on the standard</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator/ Leader/Freeman
1.2 Unstrip Wire	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Produce sample wire only and check the strip wire.</li> <li>After adjustment core diameter, Evaluate the strip wire</li> </ul>	<ul style="list-style-type: none"> <li>Continue production.</li> <li>Record the value of new core diameter in cut depth value record refer to F-PRO-CNC-007</li> </ul>	<ul style="list-style-type: none"> <li>Adjust core diameter and cutter move back to smaller value</li> <li>Possible cutter blade is already reach the shots or worn out.</li> </ul> 	Leader / Freeman  Leader / Freeman
1.3 Wire crimp position not center to anvil	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Perform step by step in machine until the wire is in the front applicator and check if the wire is center to anvil.</li> <li>After center the wire, conduct 100% inspection on the first 100 output after adjustment.</li> </ul>	<ul style="list-style-type: none"> <li>Continue production.</li> <li>Continue production.</li> </ul>	<ul style="list-style-type: none"> <li>Adjust the position of wire center to anvil</li> <li>Inform Leader/Freeman</li> </ul>	Leader / Freeman  Leader / Freeman
1.4 Stuck terminal slug	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Remove stuck terminal in applicator</li> <li>Clean applicator using air gun.</li> </ul>	<ul style="list-style-type: none"> <li>Continue production.</li> </ul>	<ul style="list-style-type: none"> <li>Inform Leader/Freeman</li> </ul>	Leader / Freeman
1.5 Wire tangled In wire roller	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Untangled the wire and press F+ in operating panel</li> </ul>  <p>Refer to WI-PRO-CNC-030</p>	<ul style="list-style-type: none"> <li>Check the wire length after manually feed the wire</li> <li>Continue production.</li> </ul>	<ul style="list-style-type: none"> <li>Check all wire rollers and re-set up again.</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator

## 2. Rear Crimp Error


Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
2.1 Wire crimp height is different from the wave form in the panel (wave form is color red)	<ul style="list-style-type: none"> <li>Measure the crimp height using point micrometer</li> </ul>	<ul style="list-style-type: none"> <li>Measure the actual crimp wire</li> <li>Origin the point micrometer, must 0.000 display and no gap in point and zero in spindle.</li> </ul> 	<ul style="list-style-type: none"> <li>Press "OK" in the panel to ok the graph. Proceed to mass production.</li> </ul>	<ul style="list-style-type: none"> <li>Adjust crimp height in the panel. Target the given specs. base on the standard</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator/ Leader/Freeman
2.2 Unstrip Wire	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Produce sample wire only and check the strip wire.</li> <li>Evaluate strip wire</li> <li>After adjustment core diameter, Evaluate the strip wire</li> </ul>	<ul style="list-style-type: none"> <li>Continue production.</li> <li>Record the value of new core diameter in cut depth value record refer to F-PRO-CNC-007</li> </ul>	<ul style="list-style-type: none"> <li>Adjust core diameter and cutter move back to smaller value</li> <li>Possible cutter blade is already reach the shots or worn out.</li> </ul> 	Leader / Freeman  Leader / Freeman
2.3 Stuck terminal slug	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Remove stuck terminal in applicator</li> <li>Clean applicator using air gun.</li> </ul>	<ul style="list-style-type: none"> <li>Continue production.</li> </ul>	<ul style="list-style-type: none"> <li>Inform Leader/Freeman</li> </ul>	Leader / Freeman

08/19/2021	0	Initial issue	W. Valdez	D. Cornero	O. Merin	W. Valdez	D. Cornero	O. Merin	
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	Minor Trouble Shooting in Normal Machine				
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No.	Work Procedure/ Illustration					Records/Remarks/ Quality Pointers
2.4	Wire tangled In wire gripper	<ul style="list-style-type: none"><li>Visually check</li><li>Check the applicator if have stuck terminal</li></ul>	<ul style="list-style-type: none"><li>Remove wire on the gripper</li><li>Remove stuck terminal in applicator</li></ul>	<ul style="list-style-type: none"><li>Check the wire length after manually feed the wire</li><li>Continue production.</li></ul>	<ul style="list-style-type: none"><li>Check all wire rollers and re-set up again.</li><li>Inform Leader/Freeman</li></ul>	Machine Operator


### 3. CPF Stop

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
3.1 Wire stuck in CPF or wire stuck in wire bobbin	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Untangled the wire and turn on the CPF button</li> </ul>  <ul style="list-style-type: none"> <li>Press F + in operating panel and produce one good length.</li> </ul>  <p>Refer to WI-PRO-CNC-030</p>	<ul style="list-style-type: none"> <li>Check the wire length.</li> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Check all wire affected in the conveyor</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator


### 4. Joint Detection

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
4.1 Joint wire reach in wire joint sensor	<ul style="list-style-type: none"> <li>Visually check</li> </ul> 	<ul style="list-style-type: none"> <li>Press F + in operating panel and produce one good length.</li> </ul> 	<ul style="list-style-type: none"> <li>Check the wire length.</li> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Check all wire affected in the conveyor</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator
4.2 Stuck up wire in wire roller sensor	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Unstuck the wire in wire roller</li> <li>Press F + in operating panel and produce one good length</li> </ul>	<ul style="list-style-type: none"> <li>Check the wire length.</li> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Check all wire affected in the conveyor</li> <li>Inform Leader/Freeman</li> </ul>	Machine Operator

### 5. Front Terminal Run Out

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
5.1 No terminal is detected by the terminal sensor	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Turn off the terminal sensor</li> </ul>  <ul style="list-style-type: none"> <li>Replenish the new terminal</li> </ul>	<ul style="list-style-type: none"> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Inform Leader/Freeman</li> </ul>	Machine Operator
5.2 No wire detected in wire clip sensor	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Replenish the wire and insert the wire in wire clip sensor</li> </ul> <p>Refer to WI-PRO-CNC-057</p>	<ul style="list-style-type: none"> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Inform Leader/Freeman</li> </ul>	Machine Operator

### 6. Rear Terminal Run Out

Possible Cause	How to check	What to do	Good Result	No Good Result	Person In - Charge
6.1 No terminal is detected by the terminal sensor	<ul style="list-style-type: none"> <li>Visually check</li> </ul>	<ul style="list-style-type: none"> <li>Turn off the terminal sensor</li> </ul>  <ul style="list-style-type: none"> <li>Replenish the new terminal</li> </ul>	<ul style="list-style-type: none"> <li>Continue Production.</li> </ul>	<ul style="list-style-type: none"> <li>Inform Leader/Freeman</li> </ul>	Machine Operator

**Note:** Any error occurred record the details in Set-up and Downtime Monitoring

- If any problem encountered during troubleshooting perform **STOP, CALL** and **WAIT**.