

	<b>WORK INSTRUCTION</b>				Effectivity Date:	May 11, 2021	
	<b>COUNTER SET-UP</b>				Validity Date:	n/a	
	Process Name/Title:		Product Name/Code: <b>ES1-7M0508 &amp; 7M0519</b>		Customer:	<b>TRJ</b>	
	Purpose:		<input type="checkbox"/> PROTOTYPE <input type="checkbox"/> PRE-LAUNCH <input checked="" type="checkbox"/> MASSPRO		Document No.:	WI-ENG-PDE-182	
					Revision No.:	1	Page No.: 1 of 4

PARTS:	N/A				JIG	1. Assembly jig 2. Counter	
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION			TOOLS/PPE	QUALITY POINTERS	
1	n/a	<div style="text-align: center;">COUNTER</div> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px;">CLAMP ASSEMBLY JIG</div> </div> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px;">COUNTER BACK VIEW</div> </div> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px;">ANDON SWITCH</div> </div> <div style="text-align: center;"> <div style="border: 1px solid red; padding: 2px;">CLAMP ASSEMBLY JIG</div> </div> </div>			<div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <b>Safety Instruction</b>            Be sure to wear prescribed personal protective equipment during operation (gloves, finger cots, etc.)         </div> <div style="border: 1px dashed red; padding: 5px; margin-bottom: 5px;"> <b>Housekeeping</b>            1. Maintain and always practice 5's.            2. Personal things on the workplace is prohibited. Keep it in your locker.         </div> <div style="border: 1px dashed red; padding: 5px;"> <b>Alert level</b>            For any trouble, inform the Assembly Assistant Supervisor or Line Leader for immediate corrective action.         </div>	<p>Note: Before conduct Clamp assembly, make sure that operator put the tray box in tray holder to continue the process.</p> <p style="color: red; font-weight: bold; text-align: center;">*This process is for Operator/Leaders</p>	

Revision History								Prepared by	Reviewed by	Approved by	Noted by
05/11/21	1	Remove validity date				J. Loterte	C. Villanueva	A. Shimamura	A. Arañes		
10/23/20	0	Excluded from WI-ENG-PDE-039B and WI-ENG-PDE-040B				J. Loterte	R. Peñaloza	A. Shimamura	A. Arañes		
Eff. Date	Rev. No	Details of Change				Revise	Check	Approve	Noted	Established Date: October 18, 2019	


  

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<b>PARTS:</b>	n/a				<b>JIG</b>	n/a
<b>NO.</b>	<b>PROCESS NAME</b>	<b>WORK PROCEDURE/ ILLUSTRATION</b>			<b>TOOLS/PPE</b>	<b>QUALITY POINTERS</b>
1	COUNTER SET-UP (continuation)	<div>    <p>4. Put empty box on tray holder using both hands, Box sensor light will <b>ON</b>.</p> </div>				<p>Note: Before conduct Clamp assembly, make sure that operator put the tray box in tray holder to continue the process.</p> <p>1. No missing box</p>
2	Condition during process	<div>  <p>1. If happens that operator proceed without putting the box on tray, LED for Skip process will <b>ON</b>. <b>Buzzer will be heard.</b></p> </div> <div>  <p>2. Everytime that operator put the assembled parts to box, LED light for Jig will be <b>ON</b>. Counter will start to add the quantity of assembled parts. <b>Go sound will be heard.</b></p> </div> <div>  <p>3. After finished the last assembled parts to complete the required quantity, LED light for counter will be <b>ON</b>. <b>Go sound will be heard.</b> It's time for Leader to reset the Counter.</p> </div>			N/A	<p>Note: Before conduct Clamp assembly, make sure that operator put the tray box in tray holder to continue the process.</p> <p><b>*This process is for Operator</b></p> <p>1. No skip process</p>

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## COUNTER SET-UP

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TRJ

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WI-ENG-PDE-182

Purpose:

☐ PROTOTYPE

☐ PRE-LAUNCH



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PARTS:	N/A			JIG	n/a
NO.	PROCESS NAME	WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
3	n/a How to Reset	<div data-bbox="651 475 1451 762"><p><b>RESET</b> is when operator encountered abnormality.</p><p><b>COUNTER RESET</b> if already reached the required quantity.</p><p><b>TOTAL COUNTER RESET</b> to count the over all output for every shift.</p></div> <div data-bbox="640 852 1464 1091"></div> <div data-bbox="640 1123 1464 1305"><p>1. Get the <b>RESET KEY</b>. Insert the reset key to <b>COUNTER RESET</b> using right hand. The quantity will go back to Zero.</p><p>This will be the indication that operator already finished one box and can proceed to another box.</p><p>Remove the loaded box and replace with the empty box using both hands.</p></div>	n/a	<p><b>*This process is for Leaders only</b></p> <p>1. Use the reset option according to it's purpose.</p>	

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PARTS:		N/A			JIG	n/a
NO.	PROCESS NAME		WORK PROCEDURE/ ILLUSTRATION	TOOLS/PPE	QUALITY POINTERS	
4	n/a	After Operation	<div></div>	n/a	<b>*This process is for Operator/Leaders</b>	

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