

No.

Process Name/ Title:

High Speed Machine Applicator Replacement Document No: Method

WI-PRO-CNC-070

February 10, 2022

WORK INSTRUCTION Product Code/Name: Customer Code: n/a n/a

Work Procedure/ Illustration

Effective Date: Rev. No.:

0

Page No.:

Page 1 of 3

Records/Remarks/

Quality Pointers

Green light are in operation. Yellow light is complete stop Red light have error

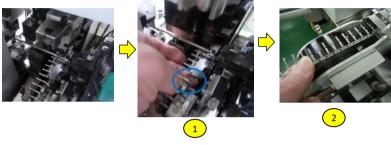
A. Check the machine as stop.

A. Check if the machine is completey stop.



B. Remove the terminal from applicator

- 1. Pull up the feeder claw using left hand
- 2. Pull out the terminal

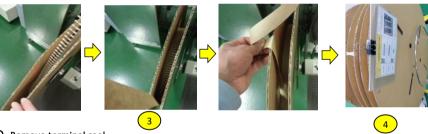


Pay attention to Terminal deformation. As much as possible Hold the carrier side



C. Roll the remaining terminal

- 3. Roll the paper reel back to the terminal reel until it covers and protect the terminal.
- 4. Tape the end of paper reel to the side of terminal reel and attached kanban request card.



D. Remove terminal reel

- 5. Press the reel stopper lock and pull out the terminal reel
- 6. Remove the remaining terminal reel.
- 7. Return the remaining terminal on the terminal rack



8. Get the next terminal

9. Check terminal Part number and cutting ledger



VI		CUTTING LEDGER						ž.,	Г	
		COTTING LEDGER						Effective Date:		1
INDA		Model:		75L175-0300A		Wire Qty:	15	Rev No.:	1	
		200				Specification deta	ils			ē
Wire Type	Size	Color	Sim serios	rusing Terminal	Rubber Seal	Wire Peeling Measurement	Rubber Seal	Terminal	Plating	C
AVSS	0.3	R	191	SPH0 -001T-P0.5		2.5 ~ 3.5		1674311-1	A	17
.0	н	V	195			2.5 ~ 3.5				PE
	#	Υ	197	ir.		2.5 ~ 3.5		н		
W	п	Р	203			2.5 ~ 3.5		н		BL
	п	В	207			2.5 ~ 3.5				DE

Reel stopper lock



						Prepare	Check	Approve
						00	Morgao	(//2/
02/10/2022	0	Initial issue	W. Valdez	D. Cornero	O. Merin	W. Valdez	D. Cornero	O Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	02/10	/2022



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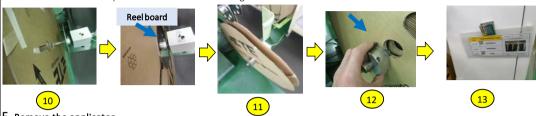
Document No:
WI-PRO-CNC-070

WORK INSTRUCTION Effective Date: February 10, 2022

Product Code/Name: Customer Code: Rev. No.: 0 Page No.:

E. Set the next terminal

- 10. Insert the terminal reel to the shaft of reel stand until it touch the reel board.
- 11. Install the reel stopper lock.
- 12. Insert the reel stopper lock while pressing the lock
- 13. Remove the kanban request card and attached in designated area.



Work Procedure/ Illustration

F. Remove the applicator

14. Upper Applicator

Push the lever part, release the applicator lock and pull it out



Bring back the removed applicator to proper location

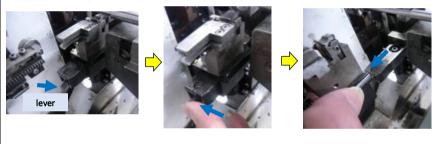
Page 2 of 3

Records/Remarks/

Quality Pointers

15. Lower applicator

Push the lever part, release the applicator lock and pull it out



G. Set the next applicator

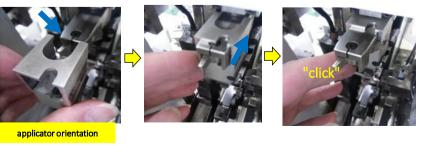
16. Lower applicator

Insert applicator and slide forward the applicator until its makes a 'click" sound.



17. Upper Applicator

Insert applicator and slide forward the applicator until its makes a 'click" sound.



Check the applicator orientation before insert.

Check the applicator orientation before insert.

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Page No.:

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Page 3 of 3

No. Work Procedure/ Illustration H. Set the terminal 18. Roll out the paper reel from the terminal reel. 19. Get the end part of terminal and hold on the terminal carrier. 20. Set the terminal to terminal guide 21. Insert the terminal to terminal sensor until reach the lower applicator. Pay attention to Terminal deformation. Pay attention to Terminal deformation. As much as possible Hold the carrier side

- 22. Manually feed the terminal, press "Feed Terminal on rear" or "Feed Terminal on front"
- 23. Conduct step by step to crimp the terminal.
- 24. Produce sample
- 25. Proceed to mass production.

If encountered any problem perform STOP, CALL and WAIT.