

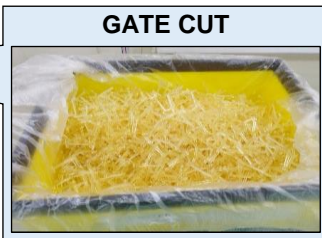

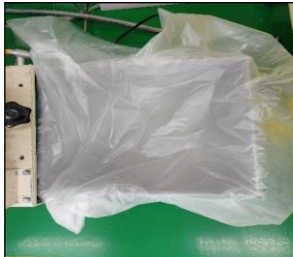




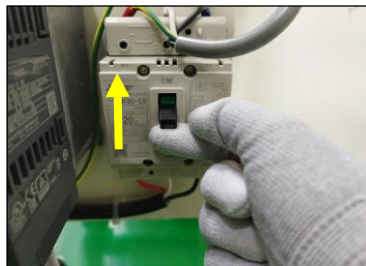






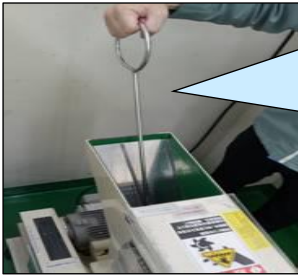





	Process Name/ Title:		Document No:		WI-PRO-SHM-012	
	<b>GRINDER</b>		Effective Date:		<b>April 29, 2023</b>	
	WORK INSTRUCTION		Rev. No.:		2	
Product Code/Name:		Customer Code:		Page No.:		1 of 2
ALL		ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
2.1	<p>Prepare material and tool for grinder.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>1. Conduct machine checking (F-PRO-SHM-005B).</p> </div> <div style="text-align: center;">  <p>2. Get for recycle material then put in the shooter box.</p> </div> <div style="text-align: center;">  <p><b>GATE CUT</b></p> </div> </div> <div style="display: flex; justify-content: space-around; margin-top: 20px;"> <div style="text-align: center;">  <p>3. Pull the catcher box.</p> </div> <div style="text-align: center;">  <p>4. Put clean plastic bag.</p> </div> <div style="text-align: center;">  <p>5. Return the catcher box inside the machine.</p> </div> </div>	<p>Wear gloves during process.</p>
2.2	<p>Open the air supply of grinder machine.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>Pull upward the switch.</p> </div> <div style="text-align: center;">  <p>Rotate counter clockwise until reach the needed supply of air.</p> </div> <div style="text-align: center;">  <p>Press down to lock.</p> </div> </div>	<p>Do not forget to lock the switch of air supply before start the machine.</p>
2.3	<p>Open the switches of the machine.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;">  <p>First, pull upward the SWITCH in the right side to ON.</p> </div> <div style="text-align: center;">  <p>Then press the ON button on the left side.</p> </div> <div style="text-align: center;">  </div> </div>	<p>After opening the switches, check the belt condition on the "BELT STOP CONFIRMATION WINDOW" and if creating/producing unusual noise.</p>  <p>Make sure no other materials or object inside the grinder before turning on the switch.</p>

04/29/2023	2	General revision.	C. Recto	W. Habla/W. Carbillon	O. Merin	Prepare	Check	Approve
07/01/2017	1	Change pusher from pipe to stainless	A. Yocor	O. Merin	T. Sugiyama			
06/13/2017	0	Previously established Work Instruction from Japan (for history purpose only)	-	Takenaka	Nakano	C. Recto	W. Carbillon	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date: 06/13/2017		

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	ALL	ALL			

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
2 4	<p>Open the safety cover of the machine</p>  <p>Slide the safety cover going to the right side of the machine.</p>	
2 5	<p>Put the recycle material into hopper.</p>  <p><b>Hopper</b></p>  <p><b>Pusher</b></p> <p>Use PUSHER when the recycle materials stuck on the hopper to push inside of machine. <b>DO NOT PUT OR USE HAND IN PUSHING MATERIAL.</b></p>	<p>Do not put hand below the safety plastic cover inside hopper to avoid any hand injury.</p> <p>Always use PUSHER when encounter stuck up of recycle materials into hopper.</p> <p>Do not put many recycle material into hopper to avoid stuck up.</p>
2 6	<p>After finished grinding,turn off the two switch.</p>  <p>First, press the OFF button(red) on the left side.</p>  <p>Then push downward the SWITCH in the right side to OFF.</p>	
2 7	<p>Pull out the grinded recycle material from the plastic in the catcher box.</p>  <p>Check condition of grinded recycle material. <b>Refer to IS-PRO-SHM-015</b> for verification. If not within the limit,conduct regrinding of recycle materials.</p>  <p>Put in recycle bag provided.</p> <p><b>NOTE</b></p> <ul style="list-style-type: none"> <li>Recycle material that drop outside plastic was already for dispose.</li> <li>Use plastic bag one time only.</li> <li>Do not forget to write recycling date and cycle number in the bag or label provided.</li> <li>Conduct one time grinder for the gate cut that already for dispose.</li> <li>DO NOT USE HAND WHEN REMOVING ANYTHING STUCK INSIDE MACHINE.USE PUSHER OR CALL MAINTENANCE.</li> </ul>	<p>Make sure to turn off the switch of the machine and the belt has stopped moving by confirming it to "BELT STOP CONFIRMATION WINDOW" before removing the grinded recycle material and anything that stuck in the hopper.</p>  <p><b>BELT STOP CONFIRMATION WINDOW</b></p>