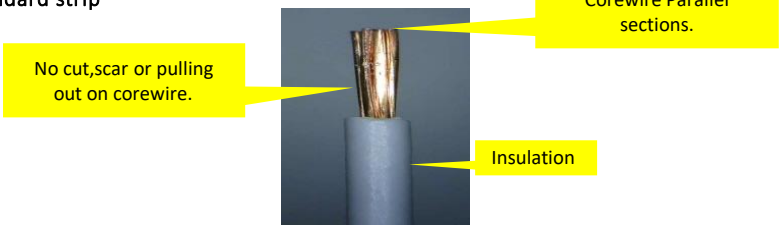
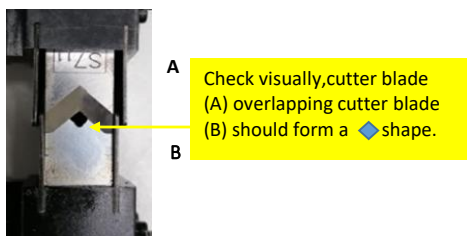
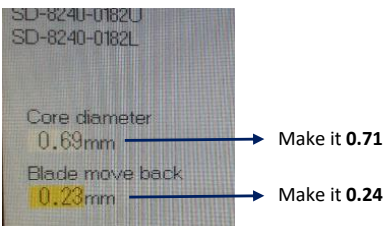
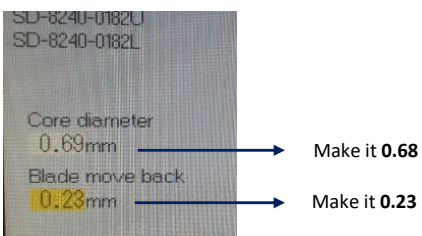
	Process Name/ Title:		Document No:	WI-PRO-CNC-025	
	WIRE CUTTING and CRIMPING / CUTTER BLADE ADJUSTMENT STANDARD		Effective Date:	August 16, 2021	
	WORK INSTRUCTION		Rev. No.:	1	
Product Code/Name:	Customer Code:	Rev. No.:	1		Page No.: 1 of 2
ALL	ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Applicable Model: Koder Electronics Automatic Casting Machine</p> <p>Standard strip</p> 	

	<p>Check Cutter blade Position</p>  <p>NEW BLADE</p> <p>Cut depth value adjustment</p> <p>1.Change the current settings of core diameter and blade move back.</p> <p>2.The adjustment started in cut on core wire then little by little adjust in higher value.</p> <p>{ EXAMPLE }</p>	
--	---	--

<p>⚠ The core diameter value is 0.69 and to get the value of blade move back, divide the core diameter value into 3.And during adjustment of core diameter it should be +2 and adjust blade move back by +1.</p>  <p>Core diameter - is cut depth</p> <p>Blade move back - is pulling of insulation.</p>	<p>⚠ NOTE: If the adjustment value is +1 in core diameter, no need to adjust blade move back.</p>
---	--

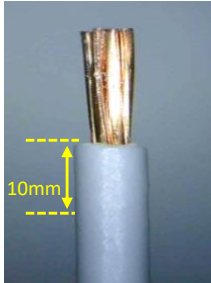



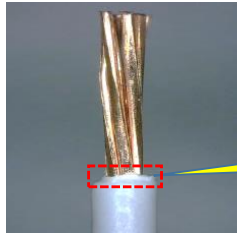
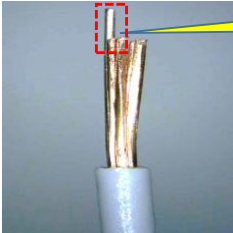
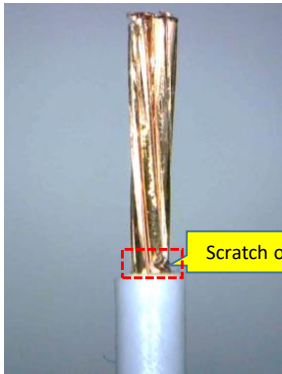
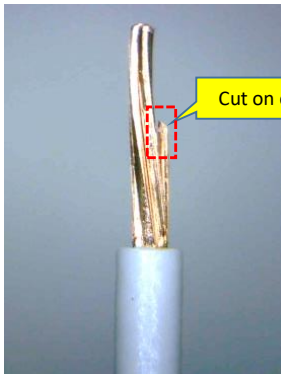
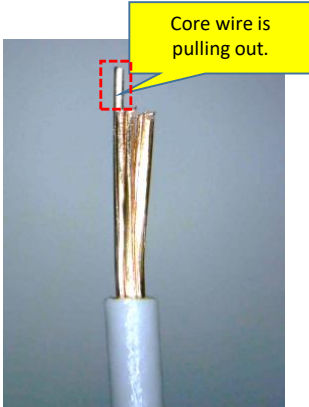
<p>⚠ Unstripped wire/Insulation biting/Pulling out</p> <p>1.Adjust the cut depth in lower value.</p> <p>During adjustment of core diameter it should be -1.</p>  <p>2.Set the best cut depth value.There must be no scar,cut or pulling out of core wire.And after the value is set,evaluate the core wire and continue the set up.</p>	<p>⚠ NOTE: If the adjustment reach more than 2 or 3 then adjust the blade move back by -1.</p>
---	---

Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	Prepare	Check	Approve
8/16/2021	1	Improved Step by Step procedure.Include some details for adjustment	S.Apil	D. Cornero	O.Merin				
July 10,2017	0	Previously established Work Instruction(for history purpose only)	J.Garcia/Z.Mendez	Y.Yamamoto	T.Sugiyama		S.Apil	Y.Yamamoto	O.Merin

<p>CONFIDENTIAL: ©2017 NBC; all rights reserved. Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited.</p>	<p>NBC (Philippines)</p> <p>MASTER COPY</p>	<p>DCC Stamp</p>
---	---	------------------



Process Name/ Title: WIRE CUTTING and CRIMPING/ CUTTER BLADE ADJUSTMENT STANDARD		Document No:	WI-PRO-CNC-025	
WORK INSTRUCTION		Effective Date:	August 16, 2021	
Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 1	Page No.:	2 of 2

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Checking of Cut Depth Using stripper, manually strip about 10 mm so that core wire will not get any scar.</p> <div><div><div>1</div></div><div><div>2</div></div><div><div>3</div></div><div><div>4</div></div></div> <p>Manually strip 10mm.</p>	<p>Core Wire Confirmation standard WI-PRO-CNC-025 NOTE: Check core wires. Must be free from scar and cut.</p>
	<p>Unacceptable Strip Quality 1.Shallow Placement of cutter</p> <div><div></div><div></div></div>	
	<p>2.Excess Deep Placement of Cutter</p> <div><div></div><div></div><div></div></div> <p>NOTE:</p> <ul style="list-style-type: none">• When cut depth adjustment is done,check the last 100 pieces output before cutter blade replacement and the first 100 pieces output after cutter blade replacement.• Scrap all wires used during adjustment.• Use magnifying lens or peak lupe when checking. <p>In charge:</p> <ul style="list-style-type: none">• Senior leader/Line Leader/freeman	