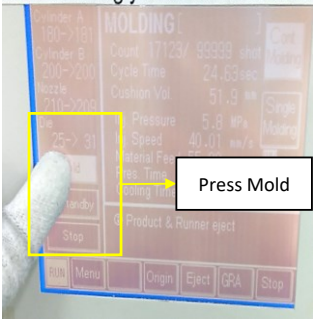
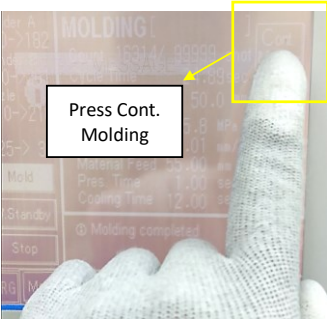
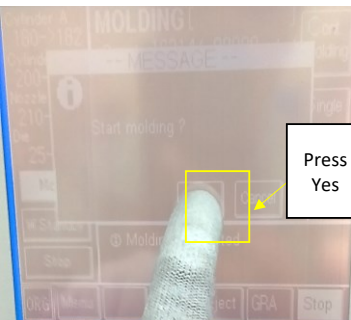

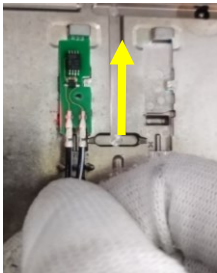

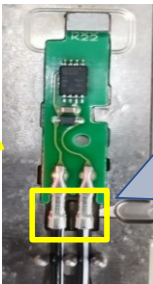


	Process Name/ Title:		Document No:		WI-PRO-SHM-024		
	Hotmelt Process		Effective Date:		June 15, 2023		
	WORK INSTRUCTION		Product Code/Name:		Customer Code:		
	ALL APPLICABLE		ALL APPLICABLE		Rev. No.:	5	Page No.:

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
5.1	Every Shift Check Machine Temperature (Bottom, Upper, Middle Plate Bottom and Upper Die) Conduct 2x Purging and 3x or more Dummy test	Check the Machine Temperature (Refer to WI- PRO-SHM-034)	Always wear ESD gloves Always conduct checksheet checking
5.2	<div>    </div> <div> 1.Press the "Mold" in the HM Machine Screen. </div> <div> 2.Press "Cont. Molding" in the HM Machine Screen. </div> <div> 1.The "Start Molding" will appear on the screen,press the "YES" button. </div>		
5.3	<div>     </div> <div> 1.Using right hand get one soldered wire/harness on the rack starting from the left side to right side. </div> <div> 2.Insert the PCB tip in the lower die using right hand then gently press the lower part using left thumb to set the harness in the machine. </div> <div>   </div> <div> 3.Repeat the process until 4 soldered harness/wire set to the machine. </div> <div> Pressing must be in this area only. Do not stress the PCB. </div>		Ensure not to touch or hit the PCB components to prevent from damage. Make sure to gently pull out the PCB on the rack. Ensure that the left arm block the sensor while putting the PCB Make sure wires are inside the wire guide to avoid smashed wire.

Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Prepare	Check	Approve
06/15/2023	5	General revision based on actual process.	C. Recto	W.Carbillon	O. Merin			
04/22/2022	4	Include proper holding on product during alignment of wire and change picture of no. 4 from Left to right become Right to Left	L. Famodulan	C. Luna	O. Merin			
05/13/2021	3	Update proper insertion of PCB, proper removal of gate cuts and include I.S as inspection reference.	A.Ayop	D. Cornero	O. Merin			
Est. date:			July 1, 2017					

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DCC Stamp

