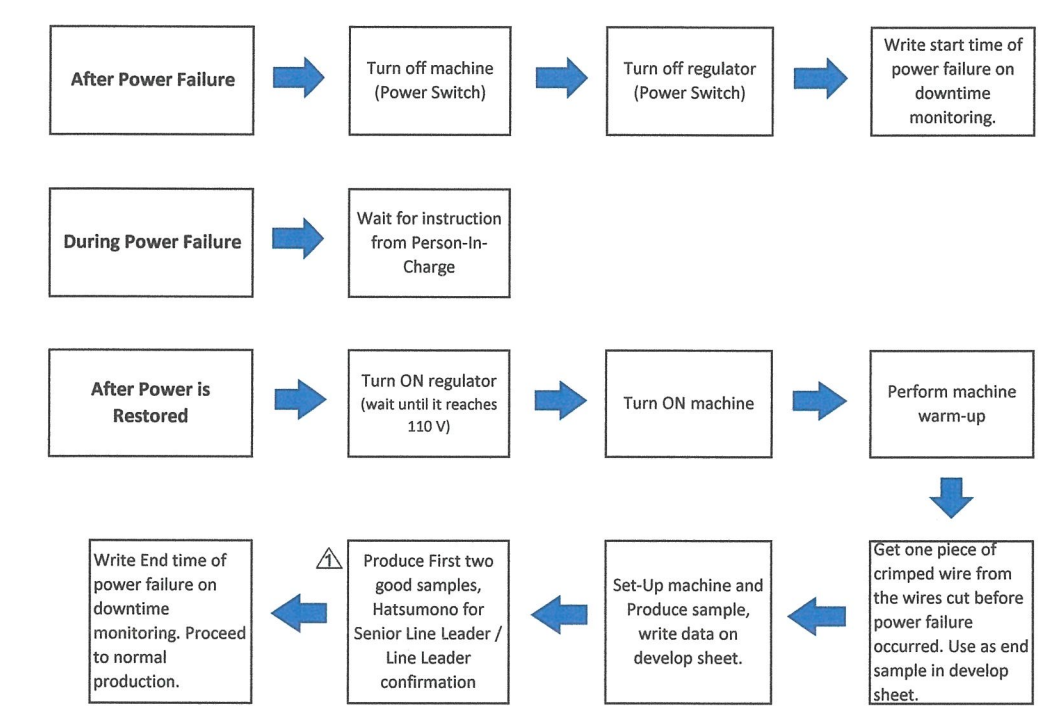
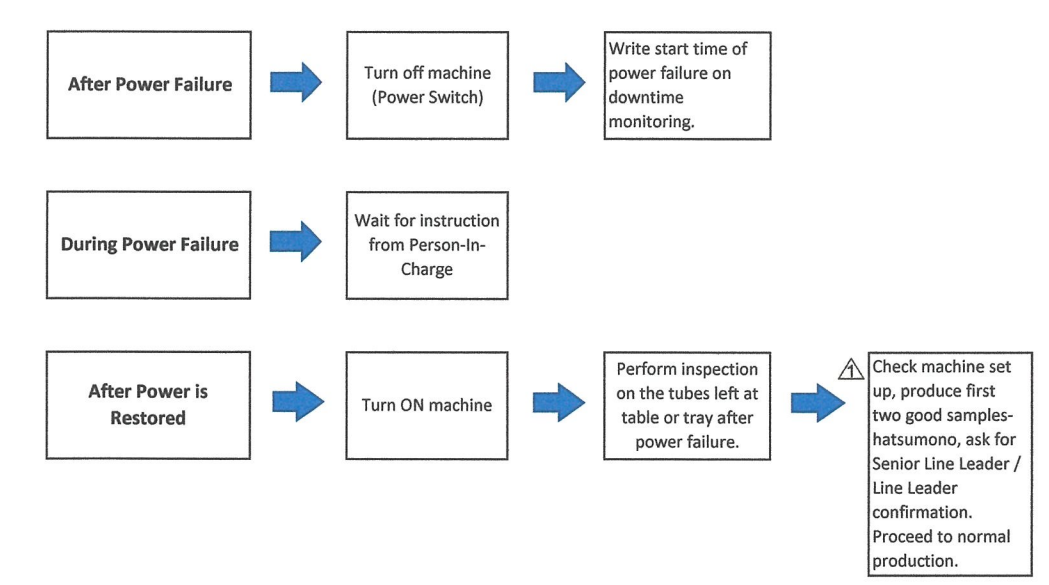
	Process Name/ Title:		Document No:	WI-PRO-CNC-033
	Wire Cutting and Crimping / How to deal with Power failure		Effective Date:	April 20, 2018
	Product Code/Name:	Customer Code:	Rev. No.:	Page No.:
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Wire Cutting and Crimping</p>  <pre> graph LR A[After Power Failure] --> B[Turn off machine (Power Switch)] B --> C[Turn off regulator (Power Switch)] C --> D[Write start time of power failure on downtime monitoring.] E[During Power Failure] --> F[Wait for instruction from Person-In-Charge] G[After Power is Restored] --> H[Turn ON regulator (wait until it reaches 110 V)] H --> I[Turn ON machine] I --> J[Perform machine warm-up] J --> K[Get one piece of crimped wire from the wires cut before power failure occurred. Use as end sample in develop sheet.] K --> L[Set-Up machine and Produce sample, write data on develop sheet.] L --> M[Produce First two good samples, Hatsumono for Senior Line Leader / Line Leader confirmation] M --> N[Write End time of power failure on downtime monitoring. Proceed to normal production.] </pre> <p>Tube Cutting</p>  <pre> graph LR A[After Power Failure] --> B[Turn off machine (Power Switch)] B --> C[Write start time of power failure on downtime monitoring.] D[During Power Failure] --> E[Wait for instruction from Person-In-Charge] F[After Power is Restored] --> G[Turn ON machine] G --> H[Perform inspection on the tubes left at table or tray after power failure.] H --> I[Check machine set up, produce first two good samples-hatsumono, ask for Senior Line Leader / Line Leader confirmation. Proceed to normal production.] </pre> <p>Note : Senior Line Leader / Line Leader will record 4M Change point.</p>	

Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change	Revise	Check	Approve	Est. date:
04/20/2018	2018-L3-WI-047	1	Change Leader and Sub leader to Senior Line Leader and Line Leader	M. Vasallo/ W. Valdez J. Garcia / Z. Mendez	W. Carbillon	O. Merin	07/10/2017
07/10/2017	2017-L3-WI-174	0	Previously established work instruction (for history purpose only)	O. MERIN	T. SUGIYAMA	W. Valdez	