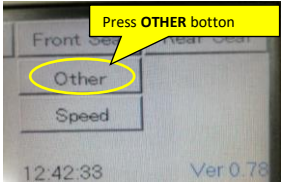
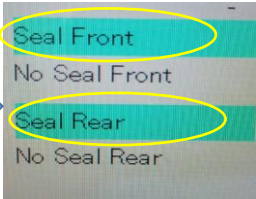

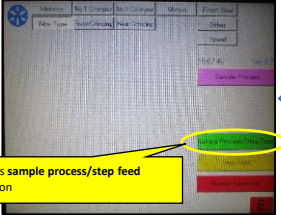

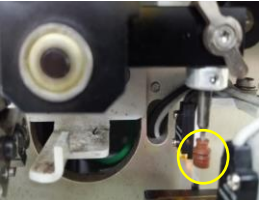

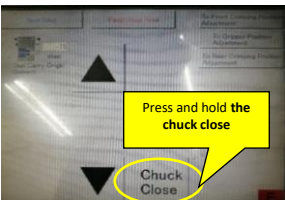



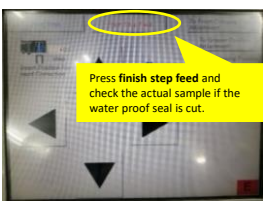
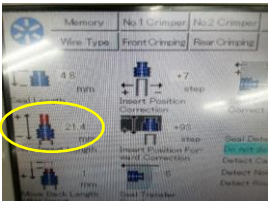


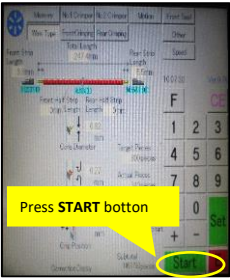
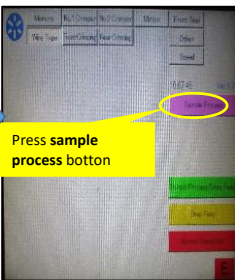

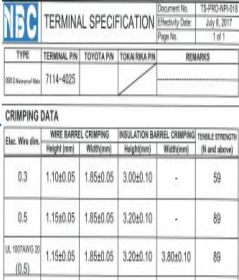
	Process Name/ Title:		Document No:	WI-PRO-CNC-054	
	WIRE CUTTING and CRIMPING/PROCESS FLOW		Effective Date:	October 17, 2024	
	WORK INSTRUCTION		Rev. No.:	10	Page No.:
	Product Code/Name:	Customer Code:			3 of 6
ALL		ALL			

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p><b>For Waterproof Seal Set-up</b></p> <p>7 Check the insertion of water proof seal.</p>              <p>8 Check the appearance of actual sample of inserted water proofseal. The gap of stripped wire and water proofseal is must be 0.5mm to 1mm.</p> 	<p><b>NOTE:</b> Press and hold the chuck close to check if the water proof seal is fit in chuck and properly close to avoid crack or damage water proof seal. Used arrow display on monitor for adjustment of carry chuck forward or backward.</p>





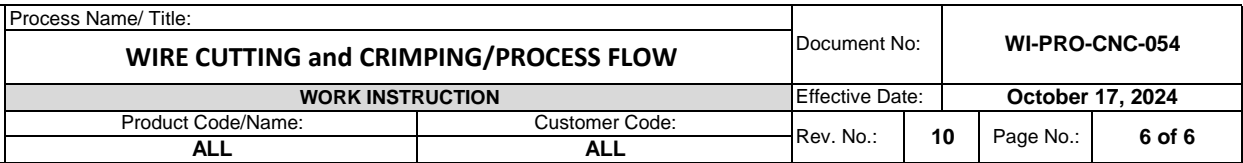
	Process Name/ Title:		Document No:	WI-PRO-CNC-054	
	WIRE CUTTING and CRIMPING/PROCESS FLOW		Effective Date:	October 17, 2024	
	WORK INSTRUCTION		Rev. No.:	10	Page No.:
	Product Code/Name:	Customer Code:	5 of 6		
ALL		ALL			

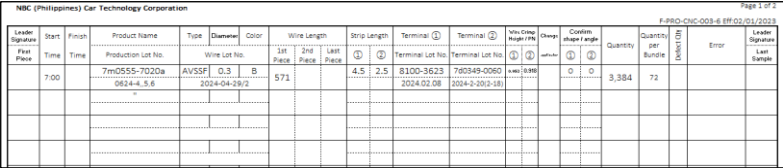
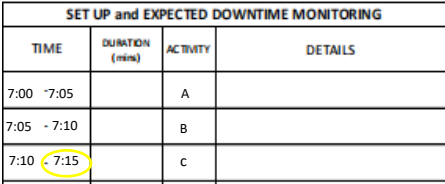

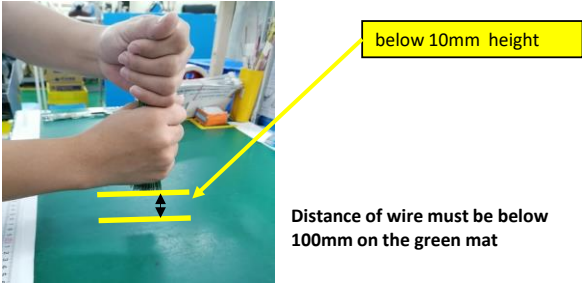
No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
11	<p>(1) sample must be produced first until the terminal specs(target)is met.</p> <p>11.1. Produced the second sample if the first sample terminal specs is already on target.</p> <div>     </div>	

**NOTE:**

Check the measurement of crimped wire base on terminal specification.

Maximum of 5 samples for adjustment of terminal specs and appearance until good sample is met if not STOP CALL WAIT. May change front and rear strip to adjust appearance.



No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
14	<p>Record data on Daily Report</p>  <p>14.1 Call Line Leader and Senior Line Leader for length, appearance and measurement confirmation.</p> <p>14.2 Record End time in Set-up and Downtime monitoring.</p>  <p>15 Accomplish Identification Tag and attach in the Box</p> <p>16 Proceed to Mass Production.</p> <p><b>Note:</b></p> <ol style="list-style-type: none"> <li>100% appearance inspection must be done on the first 100 pieces of output per model per color.</li> <li>During production if encountered machine problem or trouble shooting both side of terminal need to check all the terminal checkpoints and record in Daily Report. Call Leader for verification.</li> <li>For hatsumono or first good product (per model per color) wire length must be measured and actual value must be record on the first piece column.</li> </ol> <p> After cheking the hatsumono put the wire into the hatsumono/owarimono box</p> <ol style="list-style-type: none"> <li>During bundling of wire, Align (taktak) first the big terminal tips softly to avoid deformation of small terminal. If both terminal is small carefully align softly the terminal. Refer to picture below and GL-PRO-CNC-018</li> </ol>  <ol style="list-style-type: none"> <li>Every end of the model wire must be measured and actual value must be record on last piece column in Daily Report. Count actual bundle to verify actual quantity in box refer to identification tag and sign in no. of bundle.</li> <li>Call Line Leader, Senior Line leader and freeman to confirm the last sample by measuring the length and crimp height and insulation height. Put in hatsumono/owarimono box.</li> </ol> <p>Repeat previous step to continue process.</p> <p>Refer to Cutting ledger for the set up and fill out Set up and Downtime monitoring.</p> <p>Use activity Legend</p> <p>During operation when encounter machine error use legend to input downtime and update in Daily Report machine error.</p> <p>At the End of the shift, Produce 2 crimped wire sample ,measure and record in developsheets</p> <p>Continue operation input data needed while machine running.</p>	<p><b>WI-PRO-CNC-038</b></p> <p>Note: Attached first piece label for Hatsumono</p> <p>Note:</p> <p>Follow each step of set up machine first day after vacation then other days will proceed to mass production and checking of machine, instrument, recording of data will conduct while machine is running.</p> <p>Note:</p> <p>Operation may start even first piece is for verification of leader or while leader is on going check of first piece.</p> <p><b>Caution:</b> There is possibility of deformation of terminals if wire are hit to working table strongly.</p> <p>Note: Check terminal specs in the middle of operation to fill out middle specs requirement in developsheets</p> <p>Note: Attach last piece tag, paper tape with model name, lot no., machine no. and 1(first piece), and 2(second piece)</p> <p><b>F-PRO-CNC-009</b> <b>F-PRO-CNC-014A</b></p>
17	<p>Perform/Accomplish machine checking (end).</p> <p>If last day of working day, turn off machine. Conduct 5S of machine and working area</p>	