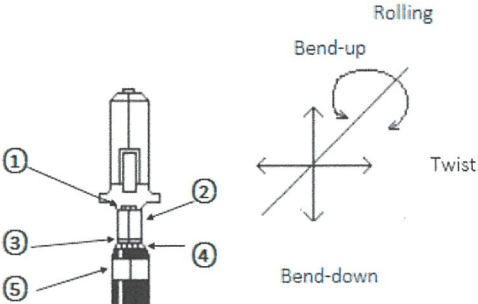
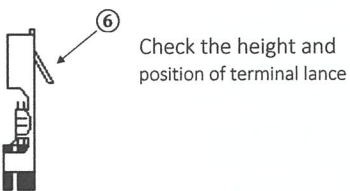
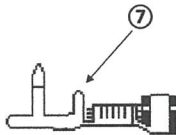



	Process Name/ Title:		Document No:	WI-PRO-CNC-010	
	Wire Cutting and Crimping / Crimp Shape Check - Procedure and Checkpoints		Effective Date:	July 10, 2017	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Page No.:	Page 1 of 1		
ALL	ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p><b>Checkpoints</b></p> <p>① Core wire must be seen at the edge of wire crimp. There must be protruded wire.</p> <p>Criteria : 0.5~1.0mm * If there is no special instruction. Defects: Insulation Biting , Hanging</p> <p>② Wire Crimp Crimped portion must be symmetrical. Joint of wire crimp must be closed. Defects: Push out, Deformity,Sag, Lack of catch</p> <p>③ Bell-mouth Bell-mouth should be seen on the bottom part of wire crimp. Defects: Scar and cut of core wire</p> <p>④ Gap between wire crimp and insulation Insulation must be seen on more than 1/2 of gap. There must be exposed portion of core wire. Defects: Insulation biting, core wire break, Hanging</p> <p>⑤ Insulation Crimp Wire must not be too loose No gap between left and right barrels. Defects: Droop inside, Droop outside, Gap</p> <p>⑥ Terminal Lance Terminal Lance should stay in its original position Defects: Deformed Lance, loose coupler, Broken lance</p> <p>⑦ Stabilizer There should be no deformity. Defects: Deformed Stabilizer, loose coupler, Broken Stabilizer</p>   	
	<p><b>Checking Procedure</b></p> <p>Check in order from point ① to ⑦. Complete the process by checking for other points based on inspection standards.</p> <div style="border: 1px solid blue; padding: 5px; width: fit-content; margin-top: 20px;"> NBC (Philippines) MASTER COPY </div>	IS-PRO-CNC-001 IS-PRO-CNC-002 IS-PRO-CNC-003

							Prepare	Check	Approve
									
-	NBCP-1025	NA	Previously established Work Instruction( for history purpose only)	-	-	-	J. Garcia / Z. Mendez	O. MERIN	T. SUGIYAMA
Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017	