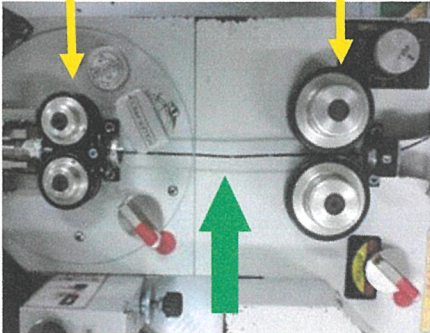
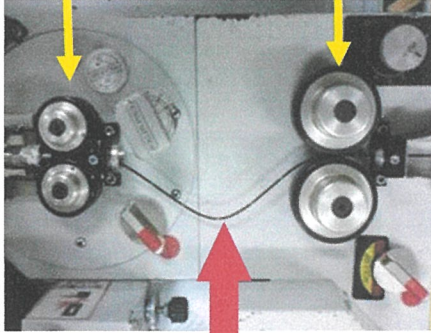
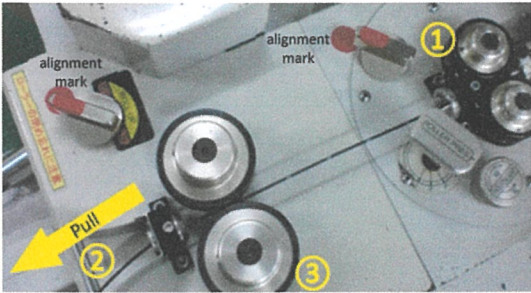
	Process Name/ Title:		Document No:	WI-PRO-CNC-021	
	Wire Cutting and Crimping / Wire Setting on Feeding Rollers ( Koder Automatic Machine)		Effective Date:	July 10, 2017	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Rev. No.:	Page No.: Page 1 of 1		
ALL	ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>* Koder Automatic Machine (Models : C550 • 551 • 555 • 556 • 558)</p> <div> <div> 1 Mecha roller W Mecha roller  <p>GOOD</p> </div> <div> 1 Mecha roller W Mecha roller  <p>NO GOOD</p> </div> </div> <p><b>Important Points:</b></p> <ul style="list-style-type: none"> <li>※ Wire between 1 mecha roller and W mecha roller needs to be straight and sag-free.</li> <li>※ In case the machine stops for these errors, immediate check is needed for the sag of wire between the rollers.</li> <li>※ Each time wire joint is taken out or diameter and/or color of wire is changed, check for any sag of wire between the rollers.</li> <li>※ If wire is not straight or rollers are not closed there is a possibility of inconsistency or variation in length.</li> </ul> <div> <div> 1 Mecha Roller  <p>W Mecha Roller</p> </div> <div> <p>After the wire is set, follow below steps.</p> <ol style="list-style-type: none"> <li>① Close 1 mecha roller.</li> <li>② Pull wire towards arrow direction.</li> <li>③ Close W mecha roller.</li> </ol> <p>Make sure rollers are properly locked. Check alignment mark ( • red).</p> <p>Do not forget to close rollers.</p> </div> </div>	

Eff./Rev.Date	Doc/DRCN No.	Rev. No.(if applicable)	Details of change	Revise	Check	Approve	Est. date:	07/10/2017
-	NBCP-1165	NA	Previously established Work Instruction( for history purpose only)	-	-	-		
							Prepare	Check
							Garcia / Z. Mendez	O. MERIN T. SUGIYAMA

NBC (Philippines)  
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