
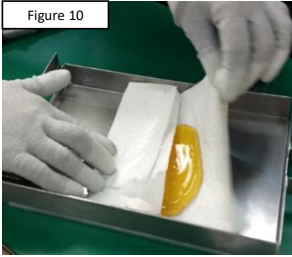


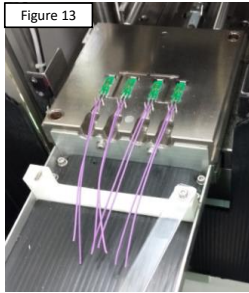
	Process Name/ Title:		Document No:	WI-PRO-SHM-048	
	Purging Process		Effective Date:	February 14, 2020	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Page No.:	Page 1 of 2		
ALL	ALL				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<p>Press "Origin" (Refer to Figure 1) wait until lower die set on its original position</p> <p>Press "Menu" (Refer to Figure 2)</p>	<p>Ensure to wear ESD gloves</p> <p>Ensure to have the right amount of thermelt</p> <p>Ensure to use pure thermelt only in purging</p>
2	<p>Set the purging tray with tissue in the middle plate of the Hotmelt Machine (Refer to Figure 3)</p>	<p>Ensure to put the purging tray</p> <p>Note: Purging will not start unless tray is inserted</p> <p>Frequency of Purge:</p> <p>At least 1x purge</p> <p>Minimum of 30 min. on standby mode (e.g. breaktime, line stop)</p> <p>At least 3x purge depending on thermelt condition (e.g. presence of bubbles, foreign materials, etc.)</p>
3	<p>Press "Purge" (Refer to Figure 4)</p> <p>Press "Mold" (Refer to Figure 5)</p> <p>Two option will appear Cont. Purging and Single Purging</p>	<p>• Every start of the shift</p> <p>• After short/long holidays</p> <p>• After weekends</p> <p>Ensure to select "Cont. Purge"</p>
4	<p>Then Press "Cont. Purging" (Refer to Figure 6)</p> <p>It will alarm after purging was done</p> <p>Then "Ok" will appear in the Hotmelt screen press "Ok" (Refer to Figure 7)</p>	
5	<p>Remove the purging tray in the middle plate (Refer to Figure 8)</p> <p>Remove the excess thermelt in the middle plate. Wipe the middle plate using tissue (Refer to Figure 9)</p>	<p>CAUTION: Hotmelted thermelt is hot. DO NOT TOUCH for safety purposes</p> <p>Ensure to wear gloves while wiping the middle plate</p> <p>Ensure to wipe the middle plate properly</p>

Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Prepare	Check	Approve
						C. Luha	D. Comero	O. Merin
						Est. date: 02/14/2020		

	Process Name/ Title:		Document No:	WI-PRO-SHM-048	
	Purging Process		Effective Date:	February 14, 2020	
	WORK INSTRUCTION		Rev. No.:	0	
	Product Code/Name:	Customer Code:	Page No.:	Page 2 of 2	

No.	Work Procedure/ Illustration		Records/Remarks/ Quality Pointers
7	<p>Check the condition of hotmelted thermelt after purging (e.g. presence of bubbles, foreign materials, etc.)</p> <p>if necessary Repeat Process 1 - 5</p> <p>(Refer to Quality Pointer Frequency of Purging)</p>	<p>Check the condition of hotmelted thermelt after purging (e.g. presence of bubbles, foreign materials, etc.)</p> <p>if necessary Repeat Process 1 - 5</p> <p>(Refer to Quality Pointer Frequency of Purging)</p>	
6	<p>Remove the tissue with hotmelted thermelt (Refer to Figure 10)</p> <p>Dispose into designated trash bin (Refer to Figure 11)</p>	 	<p>CAUTION: Hotmelted thermelt is hot. DO NOT TOUCH for safety purposes</p> <p>Ensure to dispose the hotmelted thermelt in designated bin</p>
8	<p>Conduct 5x Dummy Test (Refer to Figure 12- 14)</p>	 	<p>Ensure to use dummy wire and Dummy PCB</p> <p>Call the attention of the Leader if encountered abnormality</p> <p>Ensure to follow Stop-Call-Wait if encountered abnormality</p>

Dummy Test Flow **Figure 14**

