
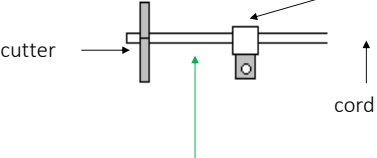
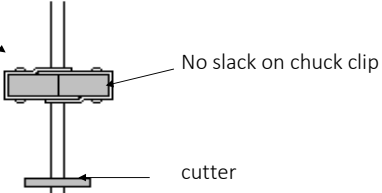



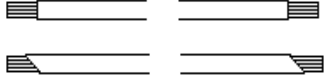
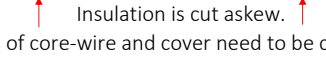

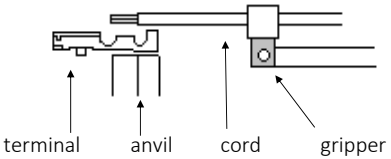
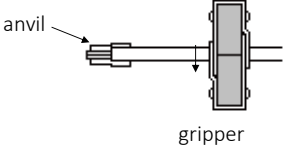



| | | | | | | |
|---|---|----------------|-----------------|--|------------------|--|
|  | Process Name/ Title: | | Document No: | | WI-PRO-CNC-029 | |
| | Wire Cutting and Crimping / Checkpoints for Gripper Set-Up | | Effective Date: | | December 1, 2022 | |
| | WORK INSTRUCTION | | Rev. No.: | | 1 | |
| | Product Code/Name: | Customer Code: | Page No.: | | 1 of 1 | |
| | ALL | ALL | | | | |

| No. | Work Procedure/ Illustration | Records/Remarks/ Quality Pointers |
|-----|---|--------------------------------------|
| | <p>Applicable Machine Models : C550 • 551 • 555 • 556 • 558</p> <p>Checkpoints before starting operation Check the center of grip - Rear end Cutter side</p> <p>① Stop the machine by step operation where the cutter enters, check by visual observation there is no bend on the wire clamped at grip. Also check there is no slack at chuck clip of grip.</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>check from side</p>  </div> <div style="text-align: center;"> <p>check from top</p>  </div> </div> <p>Note: Wire towards cutter direction must be straight</p>  <p>⚠ ② Check also the gripper mark on the insulation of wire. There is no gripper mark on the insulation of wire</p> | |
| | <div style="display: flex; justify-content: space-between;"> <div style="width: 48%;"> <p>NG CONDITION:</p>  </div> <div style="width: 48%;"> <p>GOOD CONDITION</p>  </div> </div> | |
| | <p>③ Strip the wire and check stripping condition.</p> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>(front) (rear)</p> <p>GOOD</p>  <p>NO GOOD</p>  <p>Insulation is cut askew.</p> </div> <div style="width: 50%;"> <p>✖ If there is slack on the chuck clip of gripper scratch, bend, or crush will occur.</p>  </div> </div> <p>Both ends of core-wire and cover need to be cut straight.</p> <p>Note : Grip center of cutter is normally pre-adjusted at machine setting, so there is no need of specific adjustment. But when any gap occurs due to machine trouble, follow STOP-CALL-WAIT Procedure.</p> <p>Check the center of grip - Rear end Crimp side</p> <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <p>check from side</p>  <p>Wire needs to be on top of the terminal</p> </div> <div style="text-align: center;"> <p>check from top</p>  <p>Wire needs to be at the center of anvil.</p> </div> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> <p>(C551 • 555 • 558 - adjustment of grip position)</p> <div style="display: flex; align-items: center;">  <div style="margin-left: 10px;"> <p>* By step action on screen move the grip to the position of rear end crimp, by ▲ marked direction button (touch sensor) adjust front/rear and right/left.</p> </div> </div> </div> | WI-PRO-COM-008 |

| | | | | | | | | |
|----------------|----------|--|------------------------|----------|-------------|------------|------------|---------|
| | | | | | | Prepare | Check | Approve |
| 12/01/2022 | 1 | Add details for the checking of gripper mark | W. Bergado | O. Merin | O. Merin | | | |
| 07/10/2017 | 0 | Establish ISO format. Initial issue. | J. Garcia Z. Mendez | O. Merin | T. Sugiyama | | | |
| Eff./Rev. Date | Rev. No. | Details of change | Revise | Check | Approve | Est. date: | 07/10/2017 | |

| | | |
|--|--|-----------|
| CONFIDENTIAL: ©2017 NBC; all rights reserved. Any misuse or misappropriation, including unauthorized copying, reproduction in any form, disclosure or publishing of this document or any information herein is strictly prohibited. | NBC (Philippines) MASTER COPY | DCC Stamp |
|--|--|-----------|