











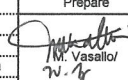




|   |   |                |                 |                |             |
|---|---|----------------|-----------------|----------------|-------------|
|  | Process Name/ Title:                              |                | Document No:    | WI-PRO-CNC-041 |             |
|   | Tube Cutting / Basic Troubleshooting (VT and COT) |                | Effective Date: | April 20, 2018 |             |
|   | WORK INSTRUCTION                                  |                | Rev. No.:       | 1              |             |
|   | Product Code/Name:                                | Customer Code: | Page No.:       |                | Page 1 of 1 |
|   | ALL   | ALL            |                 |                |             |

| No. | Work Procedure/ Illustration   |  |                                    |  | Records/Remarks/<br>Quality Pointers |
|-----|--|--|------------------------------------|--|--------------------------------------|
| No. | Problem  | Action   | Person-In-Charge                   |  |                                      |
| 1.  | Machine stop due to tangled tube (any portion)   | ① Measure tube left on the table before machine stopped.   | Operator                           |  |                                      |
|     |  | ② Record frequency of error or start of downtime on the downtime monitoring.   |                                    |  |                                      |
|     |  | ③ Untangle tube then reset up if necessary   |                                    |  |                                      |
|     |  | ④ Produce good sample and check.   |                                    |  |                                      |
|     |  | ⑤ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 2.  | Stuck Tube on loading saucer   | ① Measure tube left on the table before machine stopped.   | Operator                           |  |                                      |
|     |  | ② Record frequency of error or start of downtime on the downtime monitoring.   |                                    |  |                                      |
|     |  | ③ Remove stuck tube then reset up if necessary.  |                                    |  |                                      |
|     |  | ④ Produce good sample and check.   |                                    |  |                                      |
|     |  | ⑤ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 3.  | Looping on Stand Sensor / Tube overfeed or tube cannot feed  | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Measure tube left on the table before machine stopped.   |                                    |  |                                      |
|     |  | ③ Adjust feeding machine roller setting.   |                                    |  |                                      |
|     |  | ④ Produce good sample and check.   |                                    |  |                                      |
|     |  | ⑤ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 4.  | Unusual sound on rollers                        | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Call the attention of Senior Line Leader or Line Leader and report the situation. Then wait for instruction.   |                                    |  |                                      |
|     |  | ③ Check rollers. Call maintenance personnel if repair is necessary.                       | Line Leader/<br>Senior Line Leader |  |                                      |
|     |  | ④ Perform repair.  | Maintenance                        |  |                                      |
|     |  | ⑤ Reset up tube. Produce good sample and check.  | Operator                           |  |                                      |
|     |  | ⑥ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 5.  | Feeding machine problem                       | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Call the attention of Senior Line Leader or Line Leader and report the situation. Then wait for instruction.   |                                    |  |                                      |
|     |  | ③ Check feeding machine. Call maintenance personnel if necessary.                       | Line Leader/<br>Senior Line Leader |  |                                      |
|     |  | ④ Perform repair.  | Maintenance                        |  |                                      |
|     |  | ⑤ Reset up tube. Produce good sample and check.  | Operator                           |  |                                      |
|     |  | ⑥ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 6.  | Stand sensor problem                          | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Call the attention of Senior Line Leader or Line Leader and report the situation. Then wait for instruction.   |                                    |  |                                      |
|     |  | ③ Check stand sensor. Call maintenance personnel if necessary.                          | Line Leader/<br>Senior Line Leader |  |                                      |
|     |  | ④ Perform repair or adjustment.  | Maintenance                        |  |                                      |
|     |  | ⑤ Reset up tube. Produce good sample and check.  | Operator                           |  |                                      |
|     |  | ⑥ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 7.  | Defective cross section due to blade problem  | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Call the attention of Senior Line Leader or Line Leader and report the situation. Then wait for instruction.   |                                    |  |                                      |
|     |  | ③ Check parts produced. Call maintenance personnel.                                     | Line Leader/<br>Senior Line Leader |  |                                      |
|     |  | ④ Perform repair or blade replacement.   | Maintenance                        |  |                                      |
|     |  | ⑤ Reset up tube. Produce good sample and check.  | Operator                           |  |                                      |
|     |  | ⑥ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |
| 8.  | Defect related to appearance or length        | ① Stop the machine. Record start of downtime on the downtime monitoring.   | Operator                           |  |                                      |
|     |  | ② Call the attention of Senior Line Leader or Line Leader and report the situation. Then wait for instruction.   |                                    |  |                                      |
|     |  | ③ Check parts produced. Identify the problem, call maintenance personnel if necessary.  | Line Leader/<br>Senior Line Leader |  |                                      |
|     |  | ④ Perform necessary adjustment or repair.  | Maintenance                        |  |                                      |
|     |  | ⑤ Reset up tube. Produce good sample and check.  | Operator                           |  |                                      |
|     |  | ⑥ Record end of downtime on the downtime monitoring. Continue normal operation.  |                                    |  |                                      |

Note: For any abnormality other than stated above, follow STOP-CALL-WAIT Procedure

WI-PRO-CNC-015

|                |                |   |  |                       |              |             |   |   |   |
|----------------|----------------|---|--|-----------------------|--------------|-------------|---|---|---|
|                |                |   |  |                       |              |             | Prepare   | Check   | Approve   |
| 04/20/2018     | 2018-L3-WI-053 |  | Change Subleader to Line leader/Senior Line Leader                 | M. Vassallo/W. Valdez | W. Carbillon | O. Merin    |  |  |  |
| 07/10/2017     | 2017-L3-WI-182 | 0   | Established ISO format.  | J. Garcia/Z. Mendez   | O. Merin     | T. Sugiyama |   |   |   |
| -              | NBCP-1211      | NA  | Previously established work instruction (for history purpose only) | -                     | -            | -           | W. Valdez   | W. Carbillon  | O. Merin  |
| Eff./Rev. Date | Doc/DRCN No.   | Rev. No. (if applicable)  | Details of change  | Revise                | Check        | Approve     | Est. date:  |   |   |

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