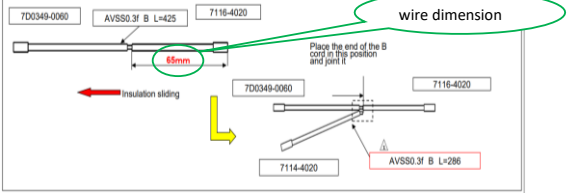
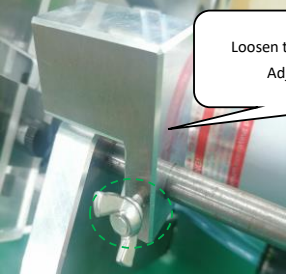
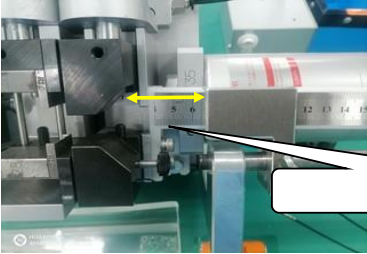
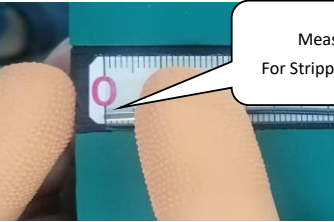
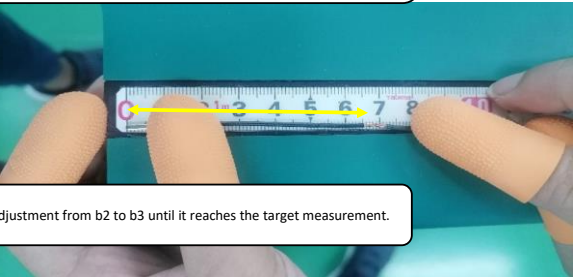




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	Manual Stripping Process and Stripper Change Over		Effective Date:		June 24, 2024	
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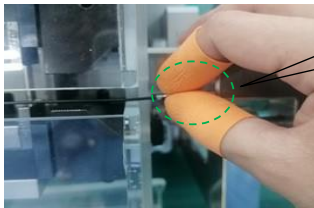
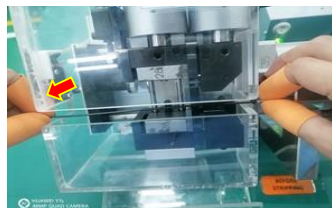



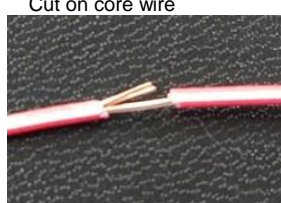




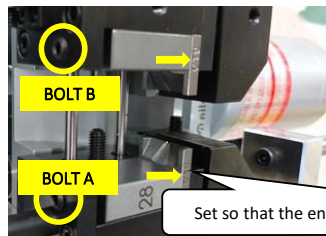
No.	Work Procedure/ Illustration	In-Charge
1	Check work area. Conduct 5's on table.	Operator
2	Perform stripping machine checking	Operator
	A. Preparation a1. Prepare the box containing wires for stripping on the right side of the working table. a2. Prepare a box for stripped wires (After stripping) on the left side of the working table. a3. Prepare cutting ledger for the part number for which the stripped wires will be made. a4. Prepare Identification Tag and Daily Report a5. Use finger cots before start of the operation.	Operator
	B. Before Start Operation b1. Check the cutting ledger, and check the wire dimension of peeling area.  b2. Adjust the stopper by loosening the bolt on the back and move it left and right. Note: If already set the stopper no need to adjust. Check only if the bolt is totally lock. b3. Set the stopper to get the target dimension using scale ruler.   Note: Make sure the bolt is totally lock. b4. After adjustment, Strip the insulation and measure the dimension.   b5. After getting the good stripping length, Fill in the daily Report with complete details.	Operator
	C. Start Operation c1. Get 1 bundle from the box and remove rubber and paper on the wire bundled. c2. Place the wire on before stripping. c2. Get the wire one by one.	Operator
		Operator

						Prepare	Check	Approve
06/24/2024	1	Consider finger cots and sensor during operation	W. Bergado	C. Calayan	W. Carbillon			
02/15/2024	0	Initial Issue	W. Bergado	C. Calayan	W. Carbillon	W. Bergado	C. Calayan	W. Carbillon
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	February 15, 2024	

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DCC Stamp

No.	Work Procedure/ Illustration	In-Charge								
	<p>c3. Conduct Stripping of wire and check if the stripping position is correct.</p> <p>c4. Place the tip of the terminal to the stopper using right hand.</p> <p>c5. Pull the wire slightly to the lower left using left hand to make it straight.</p> <div><p>Make sure the tip of wire will not separate to the</p></div> <p>c6. Set the wire in the slot of blade. Gently lower the wire using left hand until you feel the wire is fit in the slot of blade.</p> <p>Note: Make sure you the wire touch the sensor on the left side before press the foot pedal.</p> <div><p>Slot of blade</p><p>Adjust using left hand and fit into the slot of blade.</p><p>Wire will be cut</p></div> <p>c7. After Stripping, check the dimension of the strip position using a tape measure,</p> <p>Note: If the dimension is different, adjust the position of the stopper until the measured strip position matches.</p> <p>c8. Measure the dimension from the tip of the terminal.</p> <p>For Stripped insulation, measure from the tip of the core wire.</p> <p>c9. Produce 2 good samples and call the attention of leaders to check the hatsumono.</p> <p>c10. After checking,Put the wire on the "After Stripping" and proceed to mass production.</p> <p>c11. After completing one bundle, bundle the wire together and check the terminal to make sure they are not facing the wrong direction. And after completing one model, Call the attention of leader to check the Owarimono</p> <div><p>Sample Defect</p><div><p>Cut on core wire</p></div><div><p>Broken wire</p></div><p>✖Make sure the wire is on the slot of blade, if you strip the wire outside the slot the wire will get damaged.</p><p>A Visual inspection is performed on each piece after stripping.</p></div>	<p>Operator / Leaders</p> <p>Operator / Leaders</p>								
1	<p>Stripper Change over</p> <p>Blade Replacement</p> <ul style="list-style-type: none">Replace the blade according to the wire size for stripping. <table><tr><th>Wire size</th><th>Blade No.</th></tr><tr><td>0. 3</td><td rowspan="2">R1. 0</td></tr><tr><td>0. 5</td></tr><tr><td>0. 85</td><td rowspan="2">R1. 7</td></tr><tr><td>1. 25</td></tr></table> <ul style="list-style-type: none">Loosen Bolt A and replace it with a blade you will use.Loosen Bolt B and replace it with a blade you will use. <p>Note: Set the blade in such a way that the blade number stamp is visible.</p> <p>When setting the blade in the guide section, set it without gap.</p> <div><p>There is no misalignment between the upper and</p></div> <div><p>pay attention to the Blade orientation</p></div> <p>After setting the blade, Check the alignment (No misalignment)</p> <p>Refer to WI-PRO-CNC-073</p>	Wire size	Blade No.	0. 3	R1. 0	0. 5	0. 85	R1. 7	1. 25	<p>Maintenace</p> <div><p>Check the blade side No.</p></div> <div><p>BOLT B</p><p>BOLT A</p><p>Set so that the engraving on the blade is visible.</p></div> <div><p>Make sure to tighten the bolt.</p><p>If the bolt is not tight the blade misalignment will occur and the core wire will get damage.</p></div>
Wire size	Blade No.									
0. 3	R1. 0									
0. 5										
0. 85	R1. 7									
1. 25										



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All		All			

No.	Work Procedure/ Illustration	In-Charge
2	Adjustment of Stripping position <ul style="list-style-type: none">Check the dimension of the strip dimension using cutting ledger.Measure the dimension from the tip of the blade and set the strip position to the stopper.Loosen the bolt on the stopper, set it to the stripping position and tighten the bolt. <p>Note: Make sure to tighten the bolt.If the bolt is not tight, misalignment of stopper and strip position will occur.</p>	Operator / Leaders / Maintenance
3	Check the stripping position <ul style="list-style-type: none">Conduct Stripping on the spare of wire and check if the stripping position is correct.Repeat C4 to C7 process. <p>Note: Make sure the wire is on the slot of blade, if you strip the wire outside the slot the wire will get damaged.</p>	Operator / Leaders / Maintenance