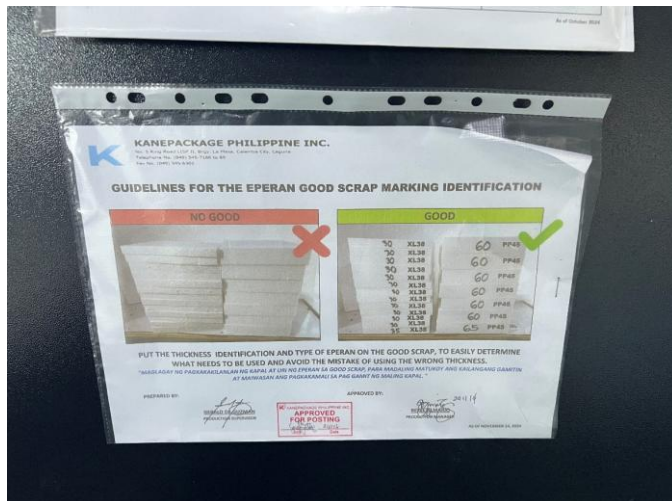




Make Guidelines of Identification Marking for Eperan Good Scrap Thickness.



Guidelines are posted on Pressing Area.

Inclusion in Pressing Work Instruction the attachment of item thickness requirement on the die-blade (Sticker).

 <p>KANEPADEKAP PHILIPPINE INC. 105 KANIPANG LDP, 2nd FLOOR, Calatagan, Quezon, Philippines Tel: (049) 545-1234 Fax: (049) 545-6542</p>	<p>WORK INSTRUCTION MANUAL</p>		<p>DATE OF EFFECTIVENESS 24 11 18</p>	<p>PAGE 1 OF 3</p>
	<p>TITLE CONTROL NUMBER REVISION NUMBER</p>	<p>PREPARED BY CHECKED BY APPROVED BY</p>		
<p>PRESSING MACHINE SET UP OPERATION WI-PR-002-027 03</p>				
<p>A. PURPOSE</p> <ol style="list-style-type: none"> 1. Safety Requirements 2. Anti-lock Offences (During set up) <p>B. GENERAL SAFETY REQUIREMENTS</p> <ol style="list-style-type: none"> 1. Make sure that the machine is "turn off" before doing clearing or maintenance. 2. Keep the emergency stop button. 3. Close guard before trying to break time and after work. <p>C. MAIN CAUSE OF EMERGENCY</p> <ol style="list-style-type: none"> 1. Immediately press the "emergency stop" button in case of emergency. 2. Immediately inform supervisor. 3. Immediately inform Safety. <p>D. ENVIRONMENT</p> <ol style="list-style-type: none"> 1. Always follow the waste segregation (plastic, metal, wood, electronic waste, etc). 2. Always observe energy conservation - Turn off light, machine, electric fan, etc when not in use. 	<p>1. Perform first preventive maintenance at the start of the shift and don't forget to fill the oil in the Machine Checklist for Pressing Machine</p> <p>(PR-002-0100) Item no. 1. Check Oil Level. The Oil Order controls what customer and item you are going to press (which customer and item you can press) and what you will be using and its delivery date. The sections where you will be the press person.</p> <p>Always use anti Preventive Maintenance as mindig ang shift at hawag kalakapan paag at Halagang ang Daily Machine Checklist (DNC) for Pressing Machine</p> <p>(PR-002-0100) 1. Check ang Job Order. Ang Job Order ay naglalaman ng Customer at item na gaganapin kalagit na quantity at kung lahang matanggap ang kalakalagan at item na ibibigay. Nakalapat din kung kung saang saang pagpapayag ang item.</p> <p>2. The drawing is attached with the JO where it illustrates the dimension, type of material and appearance of the item you'll be producing. The drawing is considered as "The Bible" or "The Bible" in the operations group. You must check the drawing and the Job Order if they state the same Customer, Item, Description and type of material to be made. The standard unit of measurement used in KPPS is in millimeters (mm).</p> <p>Ang Drawing ay naglalaman kung kung saang ang mga dimension, Uri ng materyal, at halagang item na gaganapin. Ang Drawing ay naglalaman ng "Bibya" ng mga item na gaganapin. Ang Drawing ay naglalaman ng Customer at item na gaganapin kalagit na quantity at kung lahang matanggap ang kalakalagan at item na ibibigay. Nakalapat din kung kung saang saang pagpapayag ang item.</p> <p>3. Search for the corresponding die blade in the Pressing Die Blade List where it tell you where you can easily locate the required die blade.</p> <p>Halagang ang mga item na gaganapin sa Pressing Die Blade List sa madaling matukoy ang katingal ng ibibigay.</p> <p>4. Get the Blade from the list of blade as contained in the Pressing Die Blade List and confirm if you get the correct blade by checking the label. Operasyon must also check the required item thickness attached on the dieblade label.</p> <p>Ang mga blade mula sa listang ito ay naglalaman sa paglilingkod sa Pressing Die Blade List at kumpirmahan kung nakuha ang ang tamang blade sa pamamagitan ng pagpapayag sa label. Itinuturing ang kung kung saang saang pagpapayag ang item na nakuha ang dieblade label.</p>	<p>5. Search for the corresponding Fiber Plate to be used on that particular Customer. The checked fiber plate #4 is the current one as indicated in the Fiber Plate List.</p> <p>Note: The operator will be the one to attach Fiber Plate Stocker as a new plate will miss.</p> <p>Halagang ang kalakalagan Fiber plate na naglalaman sa item na gaganapin. Kumpirmahan kung kung saang saang pagpapayag ang item na nakuha ang Fiber Plate Stocker.</p> <p>6. Possible: Ang operator ang dapat maglagay ng blade plate together kung may ibigang fiber plate na ayon.</p> <p>7. Types ON the machine and set the blade to the blade stocker with the fiber plate.</p> <p>1-ON ang machine at i-set ang mga blade kumalagan ang fiber plate.</p> 		
<p>7. Set the pressure. You can obtain the pressure of each item from the Pressing Machine Specified Pressure List.</p> <p>1-Set ang pressure. Makukuha ang pressure ng bawat item mula sa Pressing Machine Specified Pressure List.</p> <p>8. Set the item to be pressed on the Machine. Be sure that the operation item is not the same as the item in the die blade stock that will not move during pressing.</p> <p>1-Set ang item na ay gaganapin sa Machine. Siguraduhin na ang operation ng materyal kung matanggap sa gaganapin fiber plate na ibigay ang item na ayon sa machine habang ang operation.</p> <p>9. Step on the foot switch pedal. This step is equivalent to one punch/press of the machine. Punch the item used beyond the operation item together with the die blade kept in contact with the metal plate of the machine.</p> <p>10. Press the pedal with your foot. This step is equivalent to one punch/press of the machine. Punch the item used beyond the operation item together with the die blade kept in contact with the metal plate of the machine.</p> <p>11. Remove the pressed item.</p> <p>12. Remove the pressed item.</p> <p>13. Remove the pressed item.</p> <p>14. Remove the pressed item.</p> <p>15. Remove the pressed item.</p> <p>16. Remove the pressed item.</p> <p>17. Remove the pressed item.</p> <p>18. Remove the pressed item.</p> <p>19. Remove the pressed item.</p> <p>20. Remove the pressed item.</p> <p>21. Remove the pressed item.</p> <p>22. Remove the pressed item.</p> <p>23. Remove the pressed item.</p> <p>24. Remove the pressed item.</p> <p>25. Remove the pressed item.</p> <p>26. Remove the pressed item.</p> <p>27. Remove the pressed item.</p> <p>28. Remove the pressed item.</p> <p>29. Remove the pressed item.</p> <p>30. Remove the pressed item.</p> <p>31. Remove the pressed item.</p> <p>32. Remove the pressed item.</p> <p>33. Remove the pressed item.</p> <p>34. Remove the pressed item.</p> <p>35. Remove the pressed item.</p> <p>36. Remove the pressed item.</p> <p>37. Remove the pressed item.</p> <p>38. Remove the pressed item.</p> <p>39. Remove the pressed item.</p> <p>40. Remove the pressed item.</p> <p>41. Remove the pressed item.</p> <p>42. Remove the pressed item.</p> <p>43. Remove the pressed item.</p> <p>44. Remove the pressed item.</p> <p>45. Remove the pressed item.</p> <p>46. Remove the pressed item.</p> <p>47. Remove the pressed item.</p> <p>48. Remove the pressed item.</p> <p>49. Remove the pressed item.</p> <p>50. Remove the pressed item.</p> <p>51. Remove the pressed item.</p> <p>52. Remove the pressed item.</p> <p>53. Remove the pressed item.</p> <p>54. Remove the pressed item.</p> <p>55. Remove the pressed item.</p> <p>56. Remove the pressed item.</p> <p>57. Remove the pressed item.</p> <p>58. Remove the pressed item.</p> <p>59. Remove the pressed item.</p> <p>60. Remove the pressed item.</p> <p>61. Remove the pressed item.</p> <p>62. Remove the pressed item.</p> <p>63. Remove the pressed item.</p> <p>64. Remove the pressed item.</p> <p>65. Remove the pressed item.</p> <p>66. Remove the pressed item.</p> <p>67. Remove the pressed item.</p> <p>68. Remove the pressed item.</p> <p>69. Remove the pressed item.</p> <p>70. Remove the pressed item.</p> <p>71. Remove the pressed item.</p> <p>72. Remove the pressed item.</p> <p>73. Remove the pressed item.</p> <p>74. Remove the pressed item.</p> <p>75. Remove the pressed item.</p> <p>76. Remove the pressed item.</p> <p>77. Remove the pressed item.</p> <p>78. Remove the pressed item.</p> <p>79. Remove the pressed item.</p> <p>80. Remove the pressed item.</p> <p>81. Remove the pressed item.</p> <p>82. Remove the pressed item.</p> <p>83. Remove the pressed item.</p> <p>84. Remove the pressed item.</p> <p>85. Remove the pressed item.</p> <p>86. Remove the pressed item.</p> <p>87. Remove the pressed item.</p> <p>88. Remove the pressed item.</p> <p>89. Remove the pressed item.</p> <p>90. Remove the pressed item.</p> <p>91. Remove the pressed item.</p> <p>92. Remove the pressed item.</p> <p>93. Remove the pressed item.</p> <p>94. Remove the pressed item.</p> <p>95. Remove the pressed item.</p> <p>96. Remove the pressed item.</p> <p>97. Remove the pressed item.</p> <p>98. Remove the pressed item.</p> <p>99. Remove the pressed item.</p> <p>100. Remove the pressed item.</p>				