

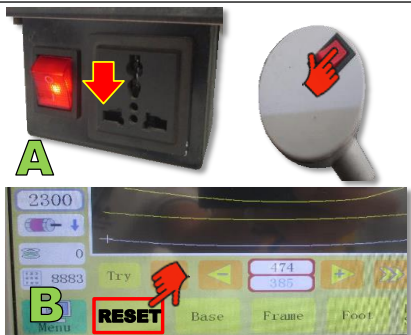
WORK INSTRUCTION

Document No.	WI-PR-029
Section	Auto Template
Revision No.	01
Effective Date	15-Feb-21
Page No.	1 of 3

Process Name	Auto Template Process (BOK-8040)		Objective	To guide the operator in operating the BOK-8040 machine for Auto Template operation.
User	Auto Template Operator			
Previous Process	Cutting			
Next Process	Loading			
PPE	  Wear helmet Wear gloves			
Legend	 Find / search / reading  Inspection  Safety Point  Attach Information  Storage			
TOTAL CYCLE TIME	760 sec			

1

Task:

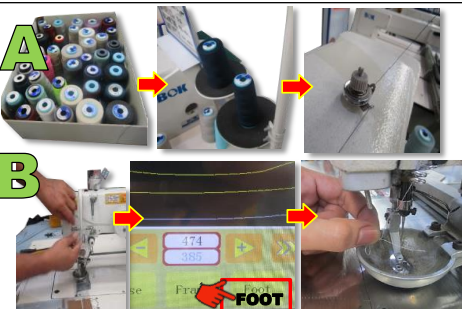


TT TIME: 30 sec

Description:
(A) Press the main switch button "I" to switch on the machine and turn on the lights for the needle. (B) Wait for the initialization. Once the home menu appears, click the reset icon.
Hazard: Make sure the machine is not grounded.
(A) Paandaron ang makina pinaagi sa pagpindot sa ubos nga bahin sa main switch nga nahimutang sa ilalom ug pasigaon usab ang mga suga para sa dagom. (B) Huwaton ang pag-initialize. Kung mupakita na ang home menu, pinduton ang reset.
Note: Siguroa na ang machine kay dili grounded.

4

Task:

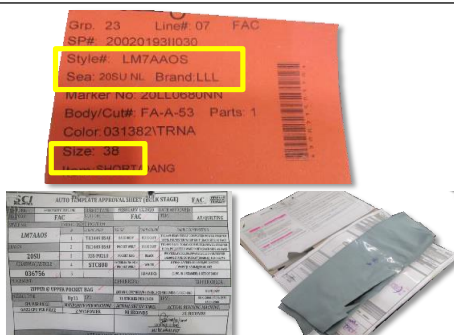


TT TIME: 38 sec

Description:
(A) Get the threads from the receptacle. Place one thread to the revider and another thread to the machine. (B) Insert the thread to the thread guide, tensioner and needle hole. Click the "foot" icon to show the needle hole.
Hazard: Needle Breakage Control Measure(s): Eye guard
(A) Kuhaon ang hilo sa receptacle. Ibutang sa revider ang usang hilo ug ang usa ngadto sa machine. (B) Pasulod ang tumoy sa hilo sa thread guide, sa tensioner ug sa bangag sa dagom. Pinduton ang "foot" icon para makita ang bangag sa dagom.

2

Task:

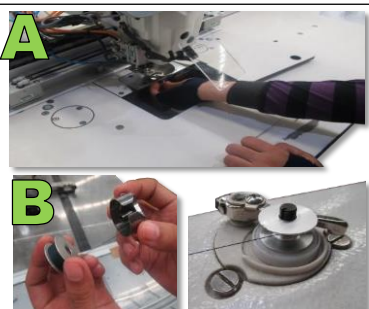


TT TIME: 5 sec

Description:
Check the current load based on Bundle Card. Check the Style, Size & Season. Identify the materials to use specified on the style mock-up.
Tan-awun ang naaprobahan nga mock-up arun sa pag-ila ug unsa nga style ang ipadagan, ang seamer pattern ug ang hilo nga gamiton.

5

Task:



TT TIME: 17 sec

Description:
(A) Get the cover plate and set aside. (B) Remove the bobbin from the machine and place it on the revider.
Hazard: Needle Breakage Control Measure(s): Eye guard
(A) Tangtangun ang cover plate. (B) Kuhaon ang bobbin gikan sa makina ug ibutang sa revider.
Peligro: Pagkaputol sa dagom Pagpugong: Atang sa mata

3

Task:



TT TIME: 114 sec

Description:
Get two correct seamer patterns from the seamer rack and put it on the setting table.
Magkuha ug duha ka saktong seamer patterns sa seamer rack ug ibutang sa setting table.

6

Task:



TT TIME: 83 sec

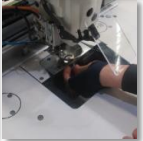
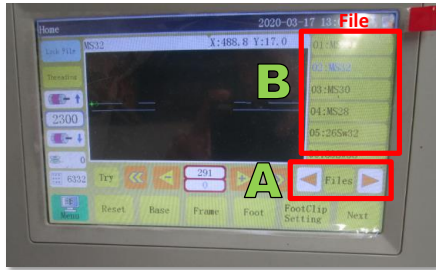
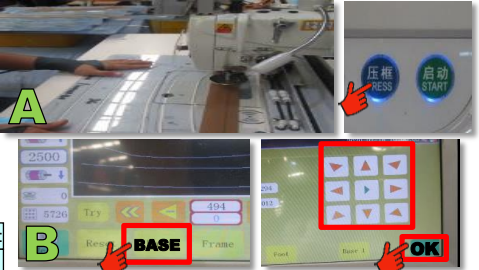
Description:
(A) Push the trigger inward. (B) Touch "NEXT" icon. (C) Click "HOOK". (D) Click green "START" button to start rewinding of thread (E) Confirm "Yes" to start rewinding.
(A) Idugt ang trigger pasulod arun (B) Pinduton ang "NEXT" icon. (C) Pinduton ang "HOOK". (D) Pinduton ang berde nga "START" button. (E) Pinduton ang "Yes" arun pagsugod sa pagrewind sa hilo.

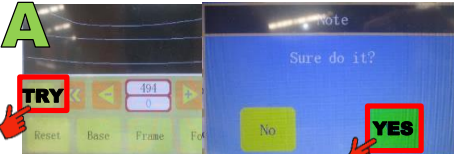
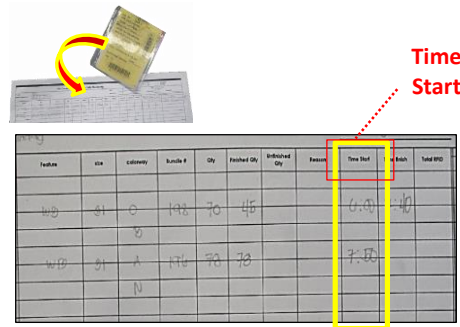
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User	Auto Template Operator				
Previous Process	Cutting				
Next Process	Loading				
PPE	  Wear hairnet Wear gloves				
Legend	 Find / search / reading  Inspection  Safety Point  Attach Information  Storage				
TOTAL CYCLE TIME					
760 sec					

7 A Task:  TT TIME: 20 sec Description: (A)Once the thread is enough, click the red "STOP" then push the trigger outward to stop rewinding. (B)Take out the bobbin and cut the thread. Return it to the case, attach it to the machine and put the cover plate back on its place. Hazard: Needle Breakage Control Measure(s): Eye guard <i>(A)Kuhaan ang bobbin ug putlon ang hilo. (B) Ibalik sa kaha, itaud balik sa makina ug itabon pagbalik ang cover plate. Peligro: Pagkaputol sa dagom Pagpugong: Atang sa mata</i>		8 B Task:  TT TIME: 18 sec Description: (A)Click the left and right arrow keys beside the "FILE" icon on the screen. (B)Find the File programmed on the machine based on the Feature, Style and Size. Click the preset data. <i>(A)Tuplукon ang left ug right nga arrow key tapad sa "FILE" icon sa screen.(B)Pangitaon ang File No. nga nakaprogram sa makina base sa Feature, Style ug Size. Tuplукon ang file No.</i>		9 A Task:  TT TIME: 152 sec Description: (A) Get one seamer pattern and position it to the machine for testing. The chipped part of the seamer pattern should be fitted into the metal tube. Click the "PRESS" button to clip the seamer pattern. (B) Click the "BASE" icon on the screen. Click the "MOVE" icon. Click the arrow keys on the screen to reposition the origin. Once positioned, touch the "OK" icon. <i>(A) Magkuha ug usa ka seamer pattern ug e-posisyon ngadto sa makina para matesting. Kinahanglan nga itupad sa solenoid ang tumoy sa seamer stick. (B) Tuplукon ang "BASE" nga icon sa screen. Tuplукon ang "MOVE" nga icon. I-posisyon ang origin gamit ang mga arrow. Human maposisyon, tuplokon ang "OK".</i>	
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10 A Task:  TT TIME: 45 sec Description: (A)Click the "TRY" icon and confirm "Yes" to simulate the pattern. Check if the seamer pattern follows the needle. (B)Click "STOP" and "PRESS" buttons when done. <i>(A) Pinduton ang "TRY" nga icon ug ang "Yes" arun sa pagtesting sa pattern. I-check kung ang seamer pattern nisubay ba sa dagom. (B)Pinduton ang "STOP ug ang "PRESS" kung mahuman ug testing.</i>		11 B Task:  TT TIME: 12 sec Description: Prepare the hard pattern of the loaded cutparts. Conduct QC on the cutparts by comparing the hard pattern and the cutparts for the beginning, middle and end of the bundle. Note: Conduct if cutparts are not within required tolerance. <i>Andamun ang hard patter sa mga giload nga cutparts. Magtandi sa hard pattern ug ang cutparts sa sinugdanan, tunga ug katapusan sa bundle. Timan-e: Himoon lang kung bagsak ang cutparts.</i>		12 A Task:  TT TIME: 47 sec Description: (A) List down the necessary detail from the bundle card to the Output Monitoring Form. (B) Indicate the Start Time. <i>(A) Ilista ang kinahanglang detalye gikan sa bundle card ngadto sa Output Monitoring Form. (B) Ibutang ang oras sa pagsugod.</i>	
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7 **A**

Task:



TT TIME: 20 sec

Description:
(A) Once the thread is enough, click the red "STOP" then push the trigger outward to stop rewinding. (B) Take out the bobbin and cut the thread. Return it to the case, attach it to the machine and put the cover plate back on its place.

Hazard: Needle Breakage **Control Measure(s):** Eye guard

(A) Kuhaun ang bobbin ug putlon ang hilo. (B) Ibalik sa kaha, itaud balik sa makina ug itabon pagbalik ang cover plate.

Peligro: Pagkaputol sa dagom **Pagpugong:** Atang sa mata

10 **A**

Task:



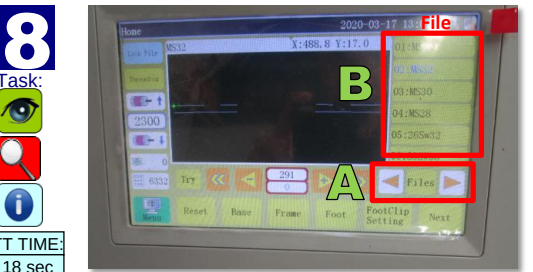
TT TIME: 45 sec

Description:
(A) Click the "TRY" icon and confirm "Yes" to simulate the pattern. Check if the seamer pattern follows the needle. (B) Click "STOP" and "PRESS" buttons when done.

(A) Pinduton ang "TRY" nga icon ug ang "Yes" arun sa pagtesting sa pattern. I-check kung ang seamer pattern nisubay ba sa dagom. (B) Pinduton ang "STOP" ug ang "PRESS" kung mahuman ug testing.

8 **B**

Task:



TT TIME: 18 sec

Description:
(A) Click the left and right arrow keys beside the "FILE" icon on the screen. (B) Find the File programmed on the machine based on the Feature, Style and Size. Click the preset data.

(A) Tuplupon ang left ug right nga arrow key tapad sa "FILE" icon sa screen. (B) Pangitaon ang File No. nga nakaprogram sa makina base sa Feature, Style ug Size. Tuplupon ang file No.

11

Task:



TT TIME: 12 sec

Description:
Prepare the hard pattern of the loaded cutparts. Conduct QC on the cutparts by comparing the hard pattern and the cutparts for the beginning, middle and end of the bundle.

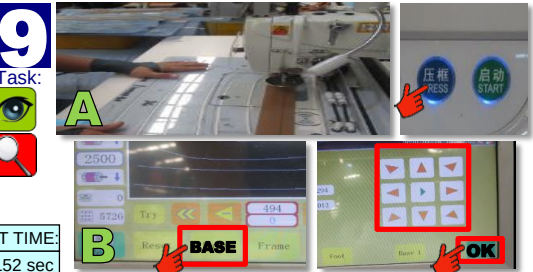
Note: Conduct if cutparts are not within required tolerance.

Andaman ang hard patter sa mga giload nga cutparts. Magtandi sa hard pattern ug ang cutparts sa sinugdanan, tunga ug katapusan sa bundle.

Timan-e: Himoon lang kung bagsak ang cutparts.

9 **A**

Task:



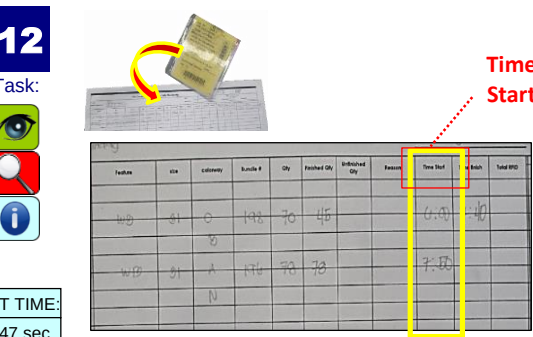
TT TIME: 152 sec

Description:
(A) Get one seamer pattern and position it to the machine for testing. The chipped part of the seamer pattern should be fitted into the metal tube. Click the "PRESS" button to clip the seamer pattern. (B) Click the "BASE" icon on the screen. Click the "MOVE" icon. Click the arrow keys on the screen to reposition the origin. Once positioned, touch the "OK" icon.

(A) Magkuha ug usa ka seamer pattern ug e-posisyon ngadto sa makina para matesting. Kinahanglan nga itupad sa solenoid ang tumoy sa seamer stick. (B) Tuplupon ang "BASE" nga icon sa screen. Tuplupon ang "MOVE" nga icon. I-posisyon ang origin gamit ang mga arrow. Human maposisyon, tuplupon ang "OK".

12

Task:



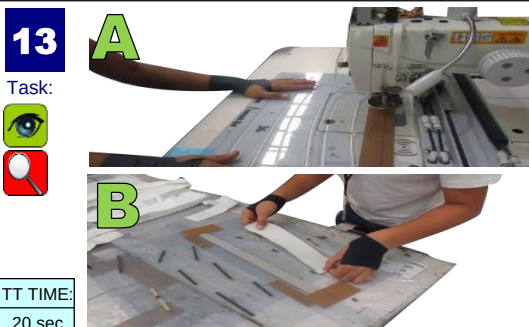
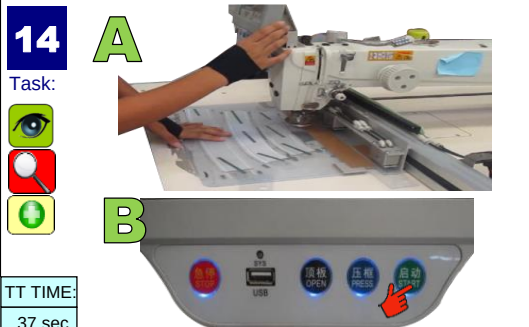
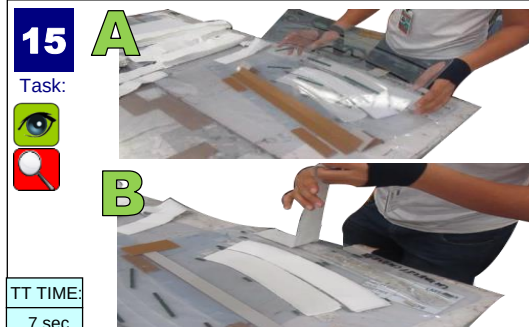
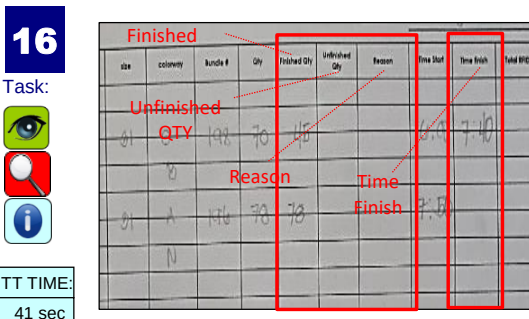
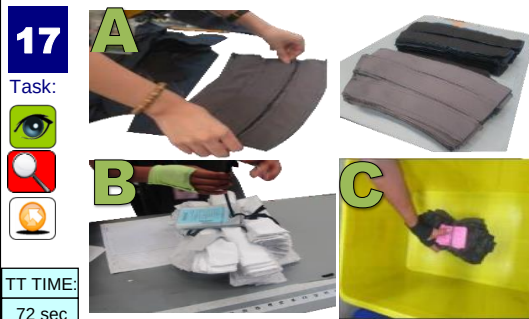
TT TIME: 47 sec

Description:
(A) List down the necessary detail from the bundle card to the Output Monitoring Form. (B) Indicate the Start Time.

(A) Ilista ang kinahanglang detalye gikan sa bundle card ngadto sa Output Monitoring Form. (B) Ibutang ang oras sa pagsugod.

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Next Process	Loading			
PPE	  Wear helmet Wear gloves			
Legend	 Find / search / reading  Inspection  Safety Point  Attach Information  Storage			
TOTAL CYCLE TIME	760 sec			
Task 13	 Task: (A) Get the seamer pattern and place it on the setting table. (B) Open the seamer pattern and mount the cutparts. Ensure that the cutparts are correctly positioned. Then close seamer pattern. TT TIME: 20 sec Description: (A) Kuhaon ang seamer pattern ug ibutang sa setting table. (B) Abrihan ang seamer pattern ug ipapilit ang cutparts. Siguruon nga sakto ang pagkaposisyon sa cutparts. Sirad-an kini.			
Task 14	 Task: (A) Position the seamer pattern to the machine. The end of the seamer pattern should touch the solenoid. (B) Tap the green "START" button to start the sewing. TT TIME: 37 sec Description: (A) I-posisyun ang seamer pattern sa machine. Kinahanglan nga itupad sa solenoid ang tumoy sa seamer pattern. (B) Pinduton ang berde nga "start" button ug kaduha para magsugod ug tahi. Hazard: Needle Breakage Control Measure(s): Eye guard Peligro: Pagkaputol sa dagom Pagpugong: Atang sa mata			
Task 15	 Task: (A) Get and open the the seamer pattern. (B) Remove every sub-assembled cutparts and check the quality of the stitches. TT TIME: 7 sec Description: (A) Kuhaa ug i-open ang seamer pattern. (B) Tangtangan ang mga nahuman nag tahi na mga "cut part" ug e-check ang quality sa mga tahi. Note: QC will conduct Quality Checking for the first output of the bundle and for the overall output. Timan-e: Magchek ang QC sa quality sa unang nahuman ug sa tanang human nga bundle.			
Task 16	 Task: List down the finished and unfinished quantity. Indicate the End Time on the Output Monitoring Form. TT TIME: 41 sec Description: Note: Write the reason for every unfinished quantity Isulat ang kantidad sa nahuman ug wala nahuman nga cutparts Output Monitoring Form. Ibutang usab ang oras sa pagkahuman. Timan-e: Isuwat ang rason sa kantidad nga wala nahuman.			
Task 17	 Task: (A) Arrange the finished cutparts accordingly. (B) Tie the finished cutparts together with the bundle card. (C) Put it in the empty tray. TT TIME: 72 sec Description: (A) Han-ayon ang nahuman na nga cutparts. (B) Higtan ang cutparts uban sa bundle card. (C) Ibutang sa walay sulod nga tray.			
Task 18	 Task: Press the upper portion of the main switch, labeled "O" to turn off the machine after use. TT TIME: 2 sec Description: Hazard: Make sure the machine is not grounded. Pinduton ang ibabaw nga bahin sa main switch, diin naka-label ug "O" arun sa pagpalong sa machine human sa paggamit niini. Note: Siguroa na ang machine kay dili grounded.			

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				Sasa Chang GME Manager