

WORK INSTRUCTION

Document No.	WI-PR-038
Section	Embro Production
Revision No.	04
Effective Date	1-Feb-21
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Process Name	Embroidery Process - TAJIMA - TFKN920	Objective	To guide the operator in operating TAJIMA - TFKN920 Machine for Embroidery Operation.
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User

Embro Operator

Previous Process

Cut Parts Sorting

Next Process

Loading

PPE



Wear hairnet



Wear gloves



Wear face mask



Ear Plugs

Legend



Find / search / reading



Inspection



Safety Point



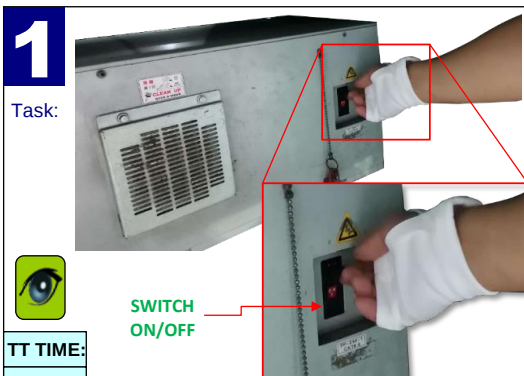
Attach Information



Storage

TOTAL CYCLE TIME

840 seconds



Task:

TT TIME:
7 sec.

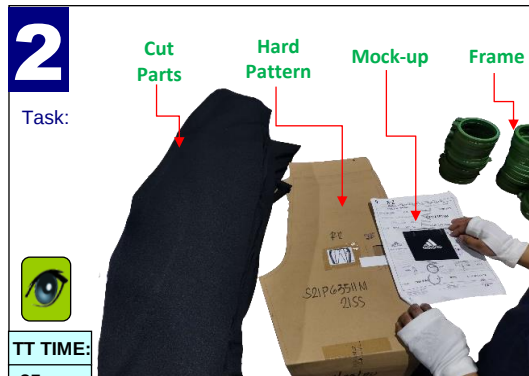
Description:

Turn "ON" the embroidery machine.

CAUTION: Ensure that hands are dry before switching on the machine to avoid electric shock.

I-"ON" ang makina sa embroidery.

Pagbantay: Siguruha nga ang mga kamot uga sa wala pa i-on ang makina para makalikay sa electric shock.



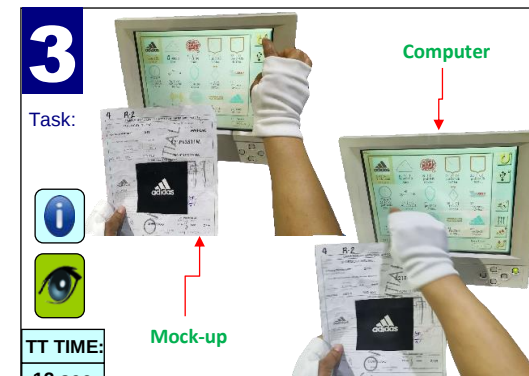
Task:

TT TIME:
25 sec.

Description:

Prepare mock-up, thread, hard pattern, and cut parts to be used.

I andam ang mock-up, hilo, hard pattern, ug ang cut parts nga gamiton.



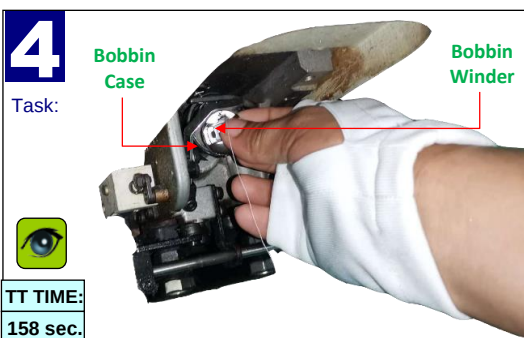
Task:

TT TIME:
12 sec.

Description:

Set the computer and reset the design logo based from the mock up.

I-set ang kompyuter ug i-reset ang design nga logo base sa mock up.



Task:

TT TIME:
158 sec.

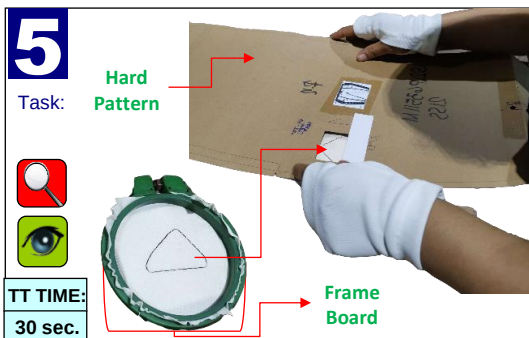
Description:

Set-up the threads, place the bobbin winder to bobbin case and insert thread to needle.

CAUTION: Watch out for the machine and don't touch the tip of the needle to avoid getting pricked.

I-set-up ang mga hilo, ibutang ang bobbin winder sa bobbin case ug i-insert ang hilo sa dagom.

Pagbantay: Pagbantay sa makina ug ayaw paghikap sa tumoy sa dagom aron malikayan nga matunok.



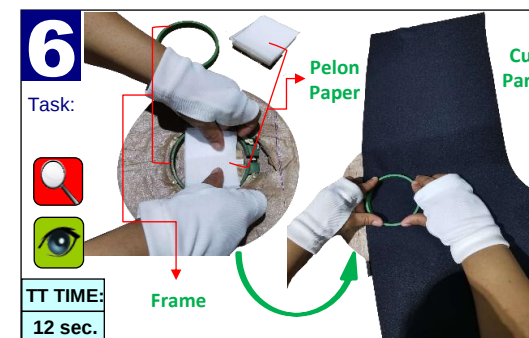
Task:

TT TIME:
30 sec.

Description:

Position the hard pattern to the frameboard to get the center of the design.

Ibutang ang hard pattern sa frameboard aron makuha ang sentro sa disenyo.



Task:

TT TIME:
12 sec.

Description:

Place the pelon paper to frame, then the cut parts to frame.

Ibutang ang pelon nga papel sa frame, pagkahuman ang cut parts sa frame.

Prepared By:

Headrick Nombre
ME Analyst

Monalisa Enicuela
ME Manager

Reviewed by:

Nicholas Chen
CMD Manager

Armond Garcia
EHSS Manager

Daniel Hsieh
QMS Manager

Sasa Chang
GME Manager

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Embroidery Process - TAJIMA - TFKN920

Objective

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Embro Operator

Previous Process

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PPE

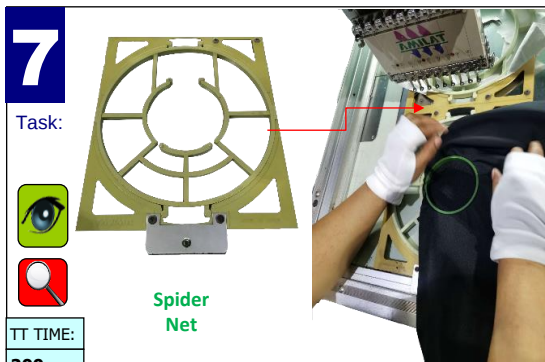


Legend



TOTAL CYCLE TIME

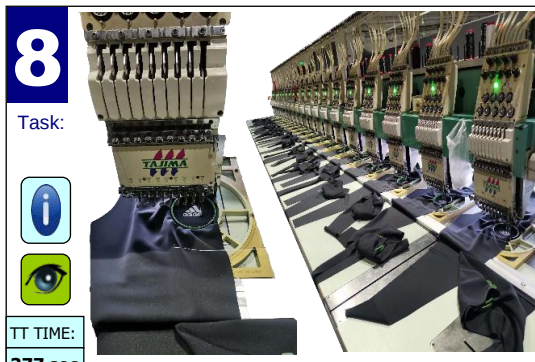
840 seconds



Description:

Insert the frame to Spider Net for embroidery process to position.

I-insert ang frame sa Spider Net alang sa embroidery Process para maposition.



Description:

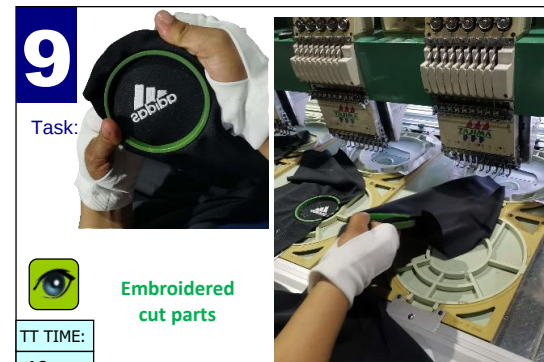
Start the Operation.

Note: Always switch off the machine in case of repairs and if threads are used up or replenishing new threads.

Caution: Hands off if the machine is running.

Sugdan ang operasyon.

Hinumdomi: Kanunay nga palunga ang makina kung adunay mga pag-ayo ug kung adunay ginamit na hilo or mag-ilis og bag-ong hilo. Pagbantay: Pagpalayo sa kamot kung ang makina nagdagan.



Description:

Remove one embroidered cut parts from the machine then check the quality. Once OK, remove the rest embroidered cut parts all together.

Pagkuha ug usa ka binordahan nga cut parts gikan sa makina ug tan-awa ang kalidad niini. Ug kung OK, tang-tanga ang nahabilin nga binordahan sa makina.

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