

WORK INSTRUCTION

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Section	Cutting
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Process Name Spreading Process - EASTMAN NA - 600F **Objective** To guide the operator in operating the Eastman NA-600F machine for Spreading operation.

User
Spreading Operator
Previous Process
Receiving of Fabrics
Next Process
Cutting

PPE

Wear hairnet

Wear Mask

Legend

Find / search / reading

Inspection

Safety Point

Attach Information

Storage

TOTAL CYCLE TIME

1740 sec

1 **A** **B**

Task:

TT TIME:
22 sec

Description:
(A) Twist the Power Switch to the right to align it to number 1 in order to "ON" and wait for initialization. (B) Click the main menu icon to return to main operation menu.

*(A)Tuyoka ang Power Switch padulong tuo para ma linya sa number 1 aron mo on ug huwaton ang pag initialization.
(B) Pinduton ang main menu icon para mobalik sa iyang main operation menu.*

2

Task:

TT TIME:
25 sec

Description:
Check the cutting daily plan with the list of PO's corresponding cut numbers in required sequence scheduled on the day.

I-check ang mga PO nakalista sa cutting daily plan nga anaay cut numbers base sa gipangayo nga sumusunod na skedyul sa kana nga adlaw.

3 **A** **B**

Task:

TT TIME:
51 sec

Description:
(A) Check if marker is available in the marker rack together with the Spreading/Cutting Worksheet attached to it. (B) Verify the details in the Spreading/Cutting Worksheet versus the marker information such as Style No., Marker Name, Flow No., Marker Length, Size and Ratio.

(A) I-check kung ang marker naa sa marker rack kauban ang spreading/cutting worksheet nga naka pilit niini. (B) Tan-awa ang mga detalye sa Spreading/Cutting Worksheet ug ang sa marker nga impormasyon kung tugma sama sa Style No., Marker

4 **A** **B**

Task:

TT TIME:
87 sec

Description:
(A) Check and get the fabrics and place on the machine. Unpack and identify the correct face side (based on Trim Card). (B) Place the fabrics in the spreading machine.

Safety: Use the strength of the lower body upon lifting the fabric to avoid back stress pain.

*(A) I-check ug kuha-a ang fabric ug ipatong babaw sa makina. Habuwaon ug Tan-awa ang sakto nga face side (basi sa Trim Card). (B) Ibutang ang fabric sa spreading nga makina.
Luwas: Gamiton ang kusog sa ubos nga parte sa lawas para*

5

Task:

TT TIME:
30 sec

Description:
Get the fabric roll sticker and record details into the Spreading/Cutting Worksheet such as roll no., color, dye lot no. and fabric roll length and fill in all other information. (Name of Spreaders and Time the spreading started).

Tang-tanga ang sticker ug isuwat ang mga detalye sa Spreading/Cutting Worksheet sama sa roll no., color, dye lot no. ug fabric roll length ug isuwat usab sa Spreading/Cutting Worksheet ang pangalan sa spreader ug oras sa pagspread.

6 **A** **B**

Task:

TT TIME:
67 sec

Description:
(A) Lay the base paper on top of the spreading table to correspond with the marker length. (B) Lay the marker on top of the base paper.

(A) Ipatong ang papel sa ibabaw sa spreading table. (B) Ipatong ang marker ibabaw sa papel.

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