

WORK INSTRUCTION

Document No.	WI-PR-069
Section	Printing Production
Revision No.	01
Effective Date	1-Oct-21
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Process Name

Printing Process

Objective

To guide the Printer and Printing personnel during printing production

User

Printer / Printing
Personnel

Previous Process

Table Changeover

Next Process

Curing

PPE



Wear



Wear hairnet



Wear respirator

Legend



Find / search / reading



Inspection



Safety Point



Attach Information



Storage

TOTAL CYCLE TIME

22,890.78 sec

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TT TIME:

365

Description:

Prepare all needed tools and material and verify printing information from Approved Bulk Mock-up & Info Sheet.

Andamon ang tanang kinahanglang gamit ug i-verify ang impormasyon sa pagprint gikan sa Approved Bulk Mock-up ug Info Sheet.



TT TIME:

2350

Description:

Call out Roving QC to check the quality of all the printed cut parts. Roving QC takes out 1 sample from the print batch and give to QC TL for checking (sample vs. approved mock-up) and approval.

Tawgun ang Roving QC para mususi sa kalidad sa tanang giprintahan nga cut parts. Magkuha ug usa ka sample gikan sa print batch ang Roving QC ug ihatag sa QC TL para sa checking (sample vs. approved mock-up) ug approval.



TT TIME:

60

Description:

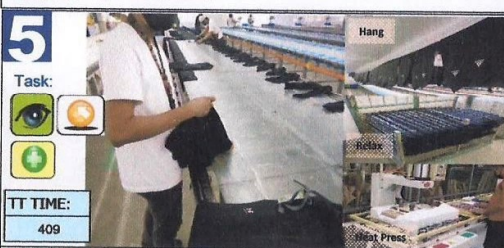
Print the base print for 1 piece cut part and call out Roving QC to verify logo placement accuracy.

Hazards: Volatile Organic Content Risks: Health problems/Skin rashes
Action to be taken: Wear adequate PPE - Respiratory Mask (solvent); Rubber Gloves in cleaning screens (solvent)

Magprint ug base print sa usa ka cut part ug tawagon ang Roving QC para i-verify kung sako ang pagpwesto sa logo.

Peligro: Volatile Organic Content Risko: Problema sa panglawas/pagpangilabagha

Aksyon: Pagsuot ug saktong PPE - Respiratory Mask (solvent); Rubber Gloves sa paglimpyo sa screen (solvent)



TT TIME:

409

Description:

Remove printed cut parts from the table after QC TL has approved the printing batch. Hang/relax/heat press depending on the drying process indicated in the Info Sheet. Note: Only certified operator can operate the Heat Press machine.

Hazards: Pressing/Hot surface Risk: Physical injury/ burn

Action to be taken: Two hand switches

Tangtangan ang mga cut parts sa lamisa. Ihayhay o i-relax o i-heat press kini depende sa pamaagi sa pagpauga nga gibutang sa Info Sheet. Pahimangno: Certified operator lamang ang maka operate sa heat press machine.

Peligro: Pag-ipit/init nga parte sa makina Risko: Pagkaangol/ agkapaso
Aksyon: Two hand switches



TT TIME:

19706.78

Description:

Start printing of cut parts based on the settings indicated in the Approved Mock-up. Run the table dryer after every coat of print. Printer checks output after every 10 pcs to control quality.

Hazards: Moving Equipment; Paint & Chemicals Risk: Physical injuries; Health problems

Action to be taken: Sensors; Wear adequate PPE - Respiratory Mask (solvent); Rubber Gloves in cleaning screens (solvent)

Sugden ang pagprinta base sa settings nga nakabutang sa Approved Mock-up. Paanderon ang table dryer human sa kada coating sa printa. Susihon sa Printer ang human kada napulo ka cut part pag kontrol sa kalidad.

Peligro: Nagsibog nga ekipo; Pintal ug Kemikal Risk: Pagkaangol; Problema sa panglawas

Aksyon: Sensor; Pagsuot ug saktong PPE - Respiratory Mask (solvent); Rubber Gloves sa paglimpyo sa screen (solvent)