Title:

2nd Operation

Revision	Description of Change	Date Effective	Author
A	Initial Release	05/13/99	Dior Wu

Originator

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Title:

2nd Operation

1.0 Purpose

1.1 To outline the requirements for the 2nd Operation process.

2.0 Scope

2.1 This procedure applies to Meritronics.

3.0 Reference

3.1 SOP22 ESD Control Procedure

3.2 SOP11 First Article Procedure

3.3 IPC-R-700 Guidelines for Modification, Rework & Repair of Printed Circuit Board Assembly.

3.4 IPC-A-610 Acceptability of Electronic Assemblies

4.0 Definitions

4.1 PCA - Printed Circuit Assembly

5.0 Responsibilities

5.1 It is everyone's responsibility to follow the ESD procedure and safety rules described in this procedure.

5.2 Operators are responsible for following the documentation to ensure quality product.

5.3 Line supervisors will ensure that operators are trained to this procedure and follow the requirements of First Article Procedure SOP11.

6.0 Equipment

6.1 Soldering iron and appropriate tips to provide tip temperatures from 600 - 900 degrees F.

6.2 Various hand tools

6.3 Air Vac

7.0 Materials

7.1 Wire - 30AWG or as specified by customer requirements

7.2 No-clean solder: Alpha Cleanline 7000 or as specified by customer requirements.

7.3 Water soluble flux: Kester 2331-ZX or specified by customer.

7.4 Loctite Tak Pak 444 or 414 Instant Adhesive

7.5 Loctite Tak Pak 712 Accelerator

7.6 Loctite X-NMS 76820 Debonder

8.0 Records

8.1 MFG021 Hand Soldering Operation Procedure

8.2 MFG019 Air Vac Set-Up and Operation Procedure

8.3 MEP004 Aqueous Cleaner Operation

9.0 Procedures

9.1 Hand solder components per Hand Solder Operation Procedure MFG021. Remove water soluble flux residues manually or use no-clean solder for unwashable components per customer requirment.

9.2 Jumper Wiring

9.2.1 Prepare and solder wire, then attach it to the PCA with TakPak specified per MPI and/or customer documentation in accordance with IPC-A-610.

9.3 All rework shall be performed in accordance with IPC-R-700.

9.4 After installation of jumper wires, wash the PCA in an in-line aqueous cleaner before the end of the shift if aqueous flux is used per MEP004 or if necessary, remove water soluble flux residues manually from the PCA using a brush, water, and disposable wipes. Thoroughly dry the board.