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# 0 NEWEST MODIFICATION / 最新修订

Initial release

Version : 00 First release

# PROCESS REGULATIONS / 过程规则

## 1Scope / 范围

This process instruction describes washing line ..

本工艺指导书是描述去助焊剂清洗线

## 2Process owner/ 过程所有者 / 职责

# AIM AND PURPOSE / 目的

本工艺说明书描述了如何正确操作去助焊剂清洗线, 以及生产工艺流程。

# TERMS AND DEFINITIONS / 术语和定义

## Abbreviation / 缩写词

# PROCESS FLOW / 程序流程

## Processoverview / 过程概述

## Processflow / 程序流程

**助焊剂清洗工艺流程**

| ***Step***  步骤 | ***InGA, Reference***  输入，参考 | ***Steps*** /  流程 | ***OutGA, Result***,  输出，结果 | **E** | **D** | **C** | **I** | ***Explanatio*n** /  说明 | ***Used IT System***  应用IT系统 |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 1 | Incomming products/前制程来料 | Loading  上板 | Fixture/&top plate loading with Panels  装载有生产板的夹具 | OP |  |  |  |  |  |
| 2 | Fixture/&top plate loading with Panels  装载有生产板的夹具 | Flow into tank1 to start clean process  传送进入清洗1槽并开始清洗 | Panels finished 1 time cleaner  完成第一步清洗的板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
| 3 | Panels finished 1 time cleaner  完成第一步清洗的板 | Flow into tank2 to start clean process  传送进入清洗2槽并开始清洗 | Panels finished second time cleaner  完成第二步清洗的板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
| 4 | Panels finished second time cleaner  完成第二步清洗的板 | Flow into tank3 to start clean process  传送进入清洗3槽并开始清洗 | Panels finished third time cleaner  完成第三步清洗的板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
| 5 | Panels finished third time cleaner  完成第三步清洗的板 | Flow into DIW rinse  进入去离子水清洗 | Panels finished DIW rinse  /完成去离子水清洗的生产板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
| 6 | Panels finished DIW rinse  完成去离子水清洗的板 | Flow into Air blow process 进入风干单元 | Panels finished Air blow  完成风干后的板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
| 7 | Panels finished Air blow  完成风干后的生产板 | Flow into unloader / Troylly  进入收板机 | Panels finished Acid rinse/  完成助焊剂清洗流程的板 | OP |  |  |  | Refer to [4.1](#_Definition_/_定义) |  |
|  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |

## RECIPE SELECTION /程序选择

### Recipe management structure /程序管理结构

### Recipe naming rule /程序命名规则

* Process\_P/N\_Version\_POR (or ENG)

### Recipe select access definition/ 程序选择权限定义

* Folder access definition: /文件夹权限定义：工程测试程序文件夹只能用于工程测试，生产程序只能用作生产。

# DESCRIPTION / 描述

## Basic Description of the equipment / 设备描述

### Picture / 图示

### Location / 位置

1 level washing room

### Specification / Technical Data/ 规格 / 技术参数

#### 5.1.3.1 Temp/Conveyor speed/Concentration control 温度/速度/浓度控制

## Corresponding equipment and accessories / 辅助设备和附件

### Equipment / 设备

#### 5.2.1.1 Tools / 工具

Plastic sample bottle 塑料取样瓶

Ultrasonic generator 超声波发生器

#### 5.2.1.2 Chemicals /化学品

Chemical name and purpose / 化学品及用途

### Accessories / 附件

-No applicable/不适用

## Basic Operation of the equipment / 设备操作

### Basic rules / 基本规则

In order to maintain a best quality and high efficiency production, these basic rules must be followed:

为了保证质量以及高效的生产，以下规则必须严格遵从：

### Chemical analyse control化学分析控制

#### 5.3.2.1 Chemical samples/Chemical analyse/dosing /取样/化学分析/药液添加

In order to make sure the analysis result accuracy, operator must follow standard sample-taken Procedure, and use only the standard sample bottle which offered by chemical lab with property label:

为了保证分析结果准确性,必须按照如下标准取样流程提取药样,并且使用由化学实验室提供的标准药水取样瓶：

#### 1． Sampling step & Sample check time/ 取样步骤:及周期

#### 5.3.2.2 Chemical dosing/药液添加

### Line start 生产线启动

#### Preparation of line start 生产线启动的准备工作

1. Keep all setting is meet the Check List of before start the washing line,

在生产线开线前先进行检查，操作人员必须按照**去助焊剂清洗机检查表**并做好记录。

#### Machine Start /设备开机

1. Switch the main power switch on/ 打开电源开关
2. Check the machine status/检查设备状态
3. Ensure air supplier/PCW is work normal ,Check all tanks filter,valves,level etc.whether work normal/检查各槽 过滤桶，阀门，液位等是否 正常,确认空气气压正常，冷却水正常供给.
4. Operation system turn on/控制系统 开启
5. Check all heaters,bump work condition is normal/ 检查加热器，泵 是否工作正常

。

#### Interrupted production 生产中断

##### Downtime less than 24h/ 生产中断不超过24小时

After the interruption, restart machine based on previous parameters setting to recover , then follow procedure of 5.3.3 “Line start” before production

中断结束后，重设生产参数至要求范围，正常启动设备, 按照5.3.3“ 生产线启动”流程恢复生产.

#### 5.3.3.3.2 Downtime more than 24h/ 生产中断超过24小时

Before restart production , validation is require to be implement to ensure machine return normal condition,

Details pls refer to F.CHQ.BK-05CE.00<<Backend machine desiccant rule for shutdown and startup>>

在恢复正常生产前，需要按照文件F.CHQ.BK-05CE.00<<Backend machine desiccant rule for shutdown and startup>>对设备进行验证以确认设备恢复正常的工作条件.

## Control &Corrective actions for concertrantion OOS/浓度监控及超标纠正措施

Chemical of washing need send to C-lab by Every Monday afternoon for measurement and monitoring,Once got result out of spec, trigger ORP procedure is required according to

Washing清洗剂需要每周一下午送化学实验室进行测量浓度以进行监控，一旦浓度超过规范要求，需要根据文件启动相关应急响应.

## Maintenance / 维护

### Filter/滤芯

Procedure for filter exchange refer to below Pic,过滤芯更换方法参见下图：

1.Ensure Main-breaker is turn off.确保 主电闸是关闭状态。

### Exhaust air duct抽风管

Termly check the condition of the exhaust air duct; ensure it is work normal.

定期检查抽风管畅通情况，确保抽风管能正常运作.

#### **5.6 Washing waste chemical dispose procedure/去助焊剂清洗废液处理流程**

|  |  |  |
| --- | --- | --- |
| Step | Action | **Remark** |
| 1 | WASTE Tank was full  废液桶装满 | Production inform GA (try running first)生产部通知GA 部门 |
| 2 | Take a new empty WASTE Tank from warehouse to Dosing room从仓库领取一个空的废液桶搬运到Washing补液房 | GA inform LOG to take a Empty WASTE tank to dosing room  GA 通知运输部搬运空桶至Washing补液房 |
| 3 | Close the valve then take out the hose and liquidometer from the full WASTE Tank 关闭排液阀门然后从桶中取出排液管。 | GA finished this process  GA负责完成这个流程 |
| 4 | Remove the full WASTE tank and replace a new empty WASTE tank移走装满废液的WASTE桶，更换一个新的空WASTE槽 | LOG finished this Process  LOG负责完成这个流程 |
| 5 | GA the hose and liquidometer into the empty WASTE tank then open the valve将排液管放回到新放置的空的WASTE槽里然后打开排液阀门。 | GA finished this process  GA负责完成这个流程 |
| 6 | Take away the full WASTE tank from dosing room to A13 storage 将装满废液的WASTE桶从补液房搬运到A13仓库 | LOG finished this process  LOG负责完成这个流程 |
| 7 | Supplierto recycle the WASTE tank wichi with waste chemical and (classified as HW42 (900-452-42)  供应商回收装有废弃溶剂的WASTE桶 | Supplier take way the WASTE tank which with waste chemical  供应商回收装有废弃溶剂的WASTE桶 |
|  |  |  |