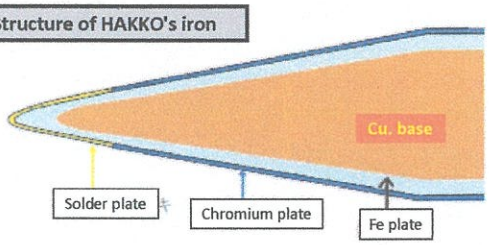
No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers

Structure of HAKKO's iron

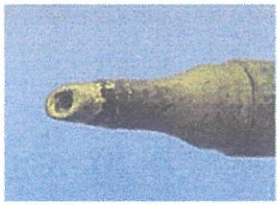


・Iron: Cu part which is coducted well is plated by Fe which doesn't corrode Cu so much.
And soldering part is plated by solder.
The other part is plated by Chromium.

Timing of change iron

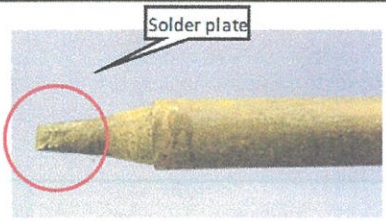
Confirm item	
POINT 1	Because of soldering, Fe part is corroded and get hole.
POINT 2	Solder plate part is oxidized black.
POINT 3	Surface of insert part of heater is oxidized.

POINT1 Because of soldering, Fe part is corroded and get hole.



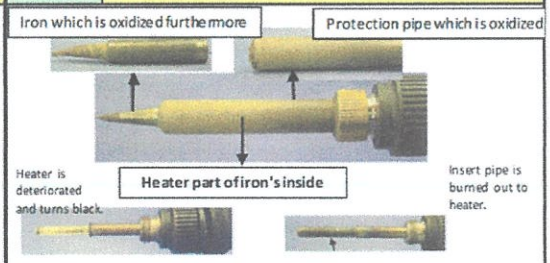
This corrosion is happened due to Fe and Sn of solder is mixed up and melt into solder.

POINT2 Solder plate part is oxidized black.



Fe plate of solder plate part is exposed and from that part, oxidized and color to be blacked.

POINT3 Surface of insert part of heater is oxidized.



*When iron, protection pipe, and heater is oxidized completely, it makes conduction weaker, so change parts.

Check of iron and control date of change

・Each leader check above points and if it is judged it should change, change parts.

・Freaquency of check is 1/D, and confirm when iron's temperature is checked, thenafter signed on daily check sheet.

NBC (Philippines)
MASTER COPY