


	Process Name/ Title:					Document No:		WI-PRO-SHM-015		
	<b>SOLDERING-Safety Conditions</b>					Effective Date:		April 23, 2025		
	WORK INSTRUCTION					Rev. No.:		1		
	Product Code/Name:		Customer Code:			Page No.:		1 of 1		
ALL		ALL								

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>Harmful substance and fume which is formed by flux's heat decomposition and melted solder coexist in condition of soldering. (It is called [Flux fume])  98% of flux fume reduced when there is 25cm distance from the source.  It is not harmful to the health, but however operator worry about the smell.</p> <p>So it still needs consideration and scheme of ventilation to remove these harmful substance completely.  Below are the list of items to be observed.</p> <p>※1 Harmful of Flux fume (Smoke)  Size of harmful substance of Flux fume (Smoke) which formed from solder is 0.05~10μm in general. And the most dangerous size of substance is 0.5~10μm. (It is stored in lungs)  This harmful substance includes a lot of stimulants and causes sob, pain of eyes, and asthma. Also, if it touches the human body, it will cause stimulus and allergy of skin.  So it is recommended to install equipments to improve condition.</p> <p><b>1. DETAILS OF WORK</b>  (1) Distance of face from source must be more than 25cm (Provision of safety cover)  (2) Worker must wear ESD gloves and face mask . (To prevent burns and inhale fumes)  (3) Area must be well ventilated and have exhaust fan.  (4) Pay attention to avoid flux and solder ball.  (5) Soldering iron must be far from flammable substances such as alcohol.  (6) Do not touch iron and always check electrical cord.</p> <p><b>2. CONDITIONS</b>  (1) Pay attention to harmful substance (such as lead of solder, flux, and etc.) that attached to the clothes.  (Make sure to follow 5S)  (2) Worker must wash hands after working.  (3) Clean work place. (To prevent solder powder and foreign objects from mixing)  (4) It is prohibited to put many irons (plugs) in one source, because it will cause fire.</p> <div data-bbox="220 1149 1169 1653">  </div> <p style="text-align: center;"><b>Fig. 1-Safety Conditions</b></p>	

						Prepare	Check	Approve
4/23/2025	1	Change customer code	L.Famodulan	A.Ayop	W.Carbillon			
6/22/2017	0	Previously established Work Instruction from NBC Japan (for history purpose only)	A. Yocor	O. Merin	T. Suguyama	L.Famodulan	A.Ayop	W.Carbillon
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	June 22, 2017	

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