

	Process Name/ Title:		Document No:		WI-PRO-COM-019	
	Soldering Machine Cleaning		Effective Date:		September 11, 2024	
	WORK INSTRUCTION		Rev. No.:		6	Page No.:
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All		All				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
1	<div></div> <div>Get the vaccum cleaner then vaccum the soldering machine, shooter and ESD mat to clean out excess solder and dust.</div>	<div>Important Notice: 1. Ensure that soldering body is turned-off during cleaning 2. Ensure to wear gloves while cleaning the soldering machine 3. Do not move the magnifying glass while brushing the soldering jig for eye protection. 4. Use Googles during cleaning of jig or machine</div> <div>5</div>
2	<div><div>1</div></div> <div>Get cleaning wire holder , open the cover and disposed solder waste in the proper disposal. Return to its position.</div> <div><div>2</div></div> <div>GOODNO GOOD</div> <div>Frequency of cleaning Every day after breaktime (short /long) ,clean the area so it is free from wire strands in the working area.</div> <div>Check wire cleaning condition , immediately change cleaning wire if it is already have detached wire scrap , worn-out and hardened.</div> <div>Note : Check the wire cleaner reference at your soldering area.</div>	<div>Holding the product while cleaning is prohibited.</div> <div>NO GOOD Change the cleaning wire holder immediately if it is already deformed or worn-out to avoid damage to the soldering tip or stick.</div>
3	<div></div> <div>For hotmelt soldering Clean the probe pin and soldering jig with flux remover then, clean again with alcohol to remove the remaining flux remover. For Contact Switch use alcohol only.</div>	<div>6 Make sure that all flux was removed to prevent probe pin from stuck up. Do not use bamboo stick to remove the flux on soldering jig to avoid broken probe pin.</div>


09/11/2024	6	Include proper cleaning of probe pin	L.Salonga	A. Ayop	W.Carbillon	Prepared	Checked	Approved
06/03/2024	5	Include proper use of googles during cleaning of soldering machines	L. Famodulan	A. Ayop	W.Carbillon			
02/21/2024	4	Revise procedure on cleaning soldering jig and probe pin.	A.Ayop	C.Calayan	W.Carbillon			
01/23/2024	3	Revise procedure on cleaning soldering jig and probe pin.	A.Ayop	C.Calayan	W.Carbillon			
08/01/2023	2	General revision	L. Famodulan	W. Cabillon	O. Merin			
07/04/2022	1	Cleaning of Soldering jig prior production after breaktime	L. Famodulan	C. Luna	O. Merin			
05/07/2022	0	Merge Work Instruction of WI-PRO-C0S-053 and WI-PRO-SHM-033 into common procedure	C. Lalican	O. Merin	O. Merin			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	May 07, 2022	

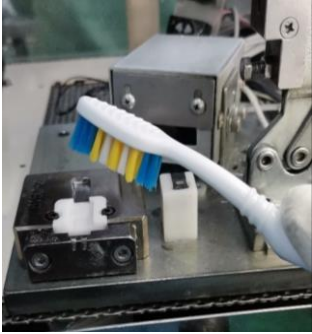



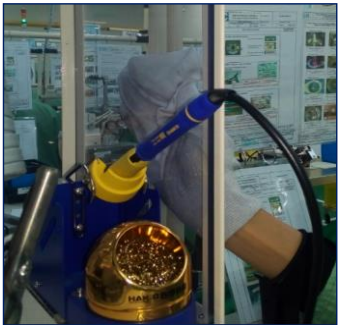
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4	<div></div> <div>Frequency of cleaning Every day after breaktime (short /long) prior production. Jig must free from dust foreign etc.</div> <div>When encountering rust or waste during running , immediately clean the jig Note : Use googles</div> <div>For CSW , use "Alcohol" for cleaning, Do NOT use "Flux remover" to avoid discoloration.</div>	<div>When soldering brush tip looks like below picture immediately change it.</div> <div></div> <div>NO GOOD</div> <div>Holding the product while cleaning is prohibited.</div>
5	<div></div> <div>Frequency of cleaning Clean the rack after finishing it with hot melt prior to soldering to avoid foreign object in the PCB</div> <div>Hotmelt soldering rack , use soldering brush.</div>	<div>Holding the product while cleaning is prohibited.</div>
6	<div></div> <div>Using wipes clean the soldering machine cover inside and out , wipe the soldering body and soldering iron holder.</div>	
7	<div></div> <div>Clean working table and mesh wire table it will free from foreign objects.</div>	

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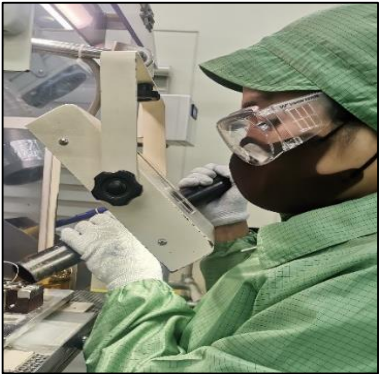
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DO'S and DON'T

DO'S



Use a vacuum when cleaning jigs or machines to avoid any dusting off.

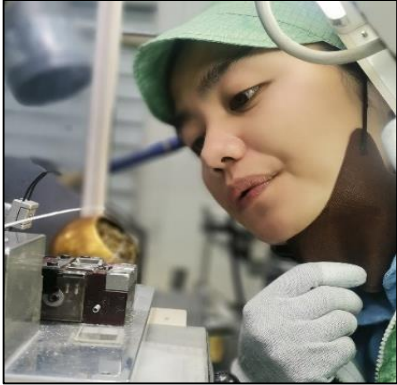


Keep your goggles on when cleaning the jigs or machine.



6 Use cotton buds with flux remover to remove the flux on soldering jig.

DONT'S



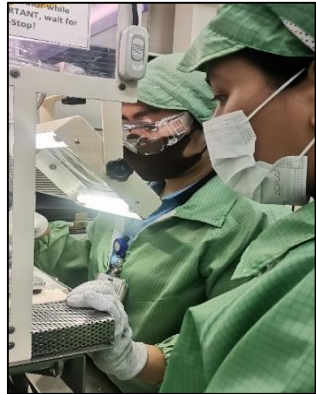
Avoid blowing when cleaning the jig to avoid dust and dirt hitting the eyes.



Googles is strictly implemented during the cleaning of machines and jigs.



6 Do not use bamboo stick to remove the flux on soldering jig.



6 Avoid chatting during cleaning.