











	Process Name/ Title:		Document No:	WI-PRO-COS-023	
	<b>CONTACT SWITCH ASSEMBLY/</b> Cleaning iron		Effective Date:	July 25, 2022	
	<b>WORK INSTRUCTION</b>		Rev. No.:	3	
	Product Code/Name:	Customer Code:	Page No.:		Page 1 of 1
	ALL	3 ALL			

Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
<b>1.) Items to be used</b> <div style="border: 2px solid red; padding: 5px; color: red; font-weight: bold;">           Attention:            DO NOT use with non-PB free solder         </div>  <div style="border: 1px solid black; padding: 2px; margin-top: 5px;">             Hakko: Cleaner of iron: 599B-01           </div> <div style="border: 1px solid black; padding: 2px; margin-top: 5px;">             Hakko: Cleaning wire: 599-029           </div>	Check the condition of soldering tip after cleaning. See pictures as reference  <div style="border: 1px solid red; border-radius: 50%; width: 50px; height: 50px; margin: 5px auto;"></div>  <div style="border: 1px solid red; border-radius: 50%; width: 50px; height: 50px; margin: 5px auto;"></div>
<b>2.) Timing of cleaning iron</b> After each soldering (1x), clean before proceeding to next usage.	
<b>3.) Times of cleaning iron</b> Put iron into cleaning wire twice and clean.	
<b>4.) How to clean iron</b> <ul style="list-style-type: none"> <li>• To remove waste, put iron into cleaning wire at different position in 1st time and 2nd time.</li> <li>• Must have no remaining carbide and flux residue.</li> <li>• Do not overclean iron too much.</li> <li>(Make sure there are thin solder is left.)</li> <li>• To make heat bridge, make appropriate amount of solder.</li> </ul> 	 <div style="border: 1px solid red; border-radius: 50%; width: 50px; height: 50px; margin: 5px auto;"></div>  <div style="border: 1px solid red; border-radius: 50%; width: 50px; height: 50px; margin: 5px auto;"></div>
<b>5.) Maintenance of cleaning wire</b> <ul style="list-style-type: none"> <li>• When cleaning, confirm the cleaner label. Do not use it both for PB and non-PB free at same time.</li> <li>• Spin cleaning wire and loosen it.</li> <li>• Remove waste of solder in cleaner and put in the designated bin. (Use gloves this time)</li> </ul> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>Confirm Label</p> </div> <div style="text-align: center;">  <p>Cleaning of Tip Cleaner</p> </div> </div> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>Spin cleaning wire and loosen</p> </div> <div style="text-align: center;">  <p>① Take cover out</p> </div> <div style="text-align: center;">  <p>② Dispose solder waste from tray</p> </div> <div style="text-align: center;">  <p>When cleaner is hardened and could not remove waste, change it immediately.</p> </div> </div>	If No Good, Replace a new one, then properly dispose the NG Soldering Tip
<b>6.) Change cleaning wire</b> <ul style="list-style-type: none"> <li>• Even wire is maintenance, still it is not removed waste, change wire.</li> <li>• Replace when the cleaning wire becomes hard (refer to IS-PRO-SHM-002 Cleaning Wire Boundary Sample)</li> </ul>	

07/25/2022	3	Change Customer Code	L. Famodulan	C. Lalican	O. Merin	Prepare	Check	Approve
07/30/2018	2	Add pictures of Good / Bad condition of soldering tip	L. Alarzar	M. Demiden	O. Merin			
03/16/2018	1	Additional important points in the procedure.	L. Alarzar	M. Demiden	O. Merin			
01/06/2017	0	Established ISO format. Initial issue	M. Vasallo	O. Merin	T. Sugiyama			
-	NA	Previously established work instruction from NBC Shanghai-NBHS- 1689(for history purpose only)	Takenaka	Ichikawa	Sato			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	01/06/2017	

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