

	Process Name/ Title:				Document No:		WI-PRO-SHM-019	
	SOLDERING-Iron Cleaning				Effective Date:		April 23, 2025	
	WORK INSTRUCTION							
	Product Code/Name:		Customer Code:		Rev. No.:		Page No.:	
ALL		ALL						

  

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers									
	<p><b>Pb free's ratio of heat is higher than Pb. Therefore, it is difficult to melt.</b></p> <p><b>(Ref: 1-5 Condition of soldering)</b>            ※ Ratio of heat: the calorific value which is needed to increase 1°C of object 1g.</p> <p><b>1 METHOD OF CLEANING</b>            (1) Use wire cleaner. (Ref: 3-8 wire cleaner)            (2) Clean iron with wire cleaner 2~3 times, check if there is foreign matter attachment.            (Ref: 4-7) ※ Cleaning is done when there is small amount of solder covering the iron.</p> <p><b>2 PURPOSE OF CLEANING</b>            If iron's solder is removed completely, it takes longer time for solder to melt.            For prevention, left solder enough to cover the iron tip.</p> <div style="text-align: center; margin: 20px 0;"> </div> <p><b>3 FREQUENCY OF CLEANING</b>            (1) When picking iron from the stand. (per one cycle)            (2) When iron is not moisted when soldering.            (3) When too much solder is left on the iron after soldering.</p> <p><b>4 IMPORTANCE OF CLEANING</b>            Below chart shows defect, if iron is not cleaned:</p> <p style="text-align: center;">Chart #4-7 Importance of iron cleaning</p> <table border="1" style="width:100%; border-collapse: collapse; margin-top: 10px;"> <thead> <tr> <th>#</th> <th>Defect</th> <th>Reason</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>Solder volume is not stable.</td> <td>Too much solder left on iron.</td> </tr> <tr> <td>2</td> <td>Iron is not moisted by solder.</td> <td>Iron is oxidized.</td> </tr> </tbody> </table>	#	Defect	Reason	1	Solder volume is not stable.	Too much solder left on iron.	2	Iron is not moisted by solder.	Iron is oxidized.	
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1	Solder volume is not stable.	Too much solder left on iron.									
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						Prepare	Check	Approve
4/23/2025	1	Change Customer code	L.Famodulan	A.Ayop	W.Carbillon			
7/1/2017	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:	July 1, 2017	

  

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