	Process Name/ Title:		Document No:		WI-PRO-SHM-021	
	SOLDERING-Solder wire supply		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
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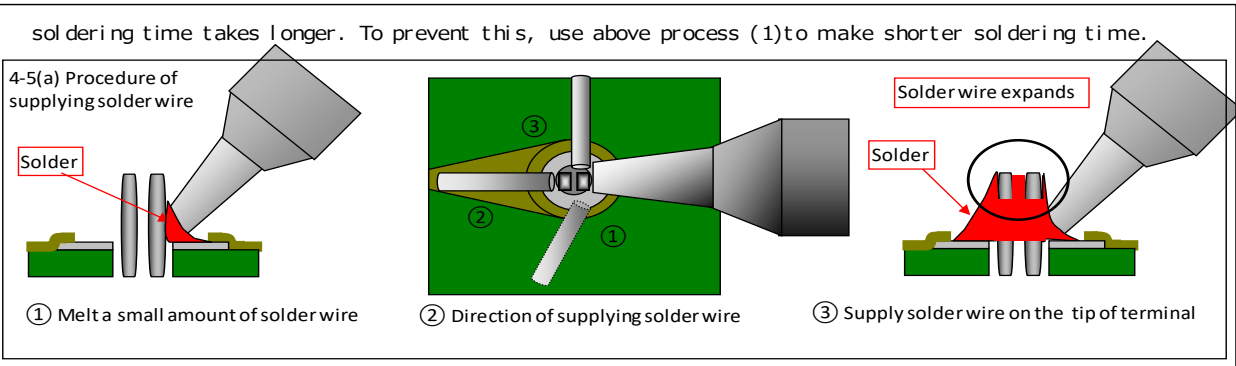
Lead Free solder has poor wettability and spreadability, because it is easily oxidized and has high surface tension. Soldering time takes longer, because of that,there is a possibility of huge amount of flux formation after soldering.

1 METHOD OF SUPPLYING SOLDER WIRE & PREVENTION OF FLUX ACCUMULATION (4-5(a))

- Put solder wire directly on the iron, and supply solder wire constantly (little by little), it must form a heat bridge. (4-5(a)①)
- Move and supply solder wire based on the direction shown at (4-5(a)②)
- Supply solder wire to expand the whole terminal. (4-5(a)③)

2 CONTROL OF SOLDERING TIME & POSITION

Since, Pb free's melting point is higher 32~37°C than lead (Sn-37Pb), therefore soldering time takes longer. To prevent this, use above process (1)to make shorter soldering time.

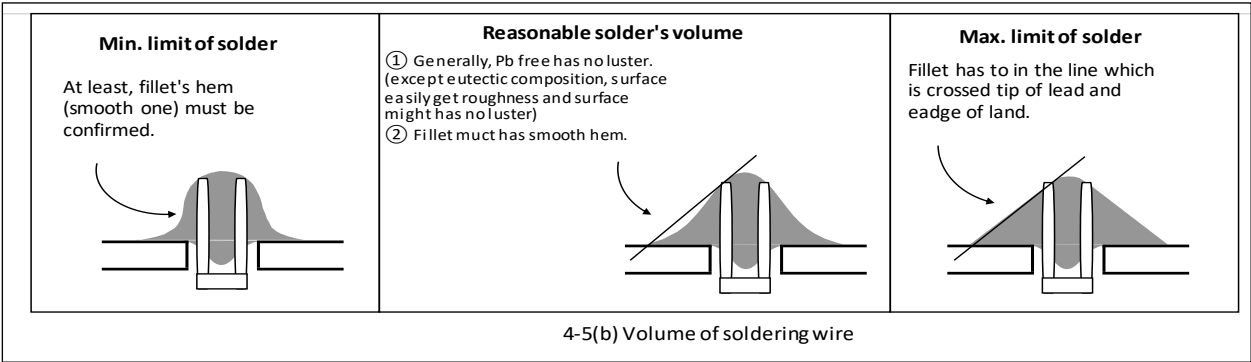





3 CONTROL OF VOLUME

Below chart 4-5(b) shows limit samples of volume quantity.

4 CONTROL OF SOLDER WIRE SUPPLY

- To prevent weak connection if solder supply is not enough.
- To prevent crack and other defects such as excessive flux formation if solder supply is too much.



						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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