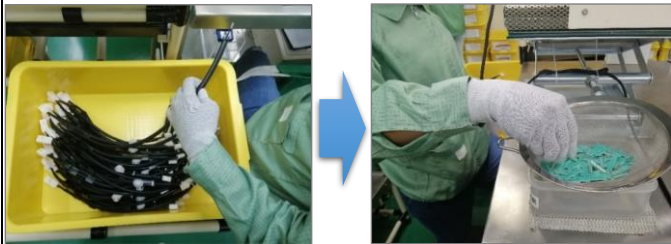









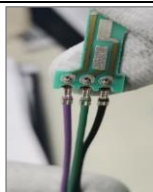


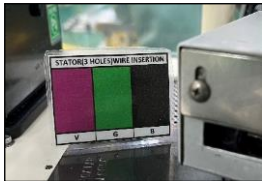
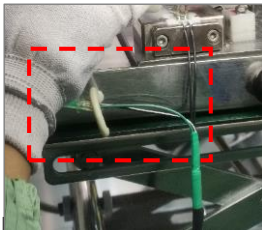

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1				Make sure to wear gloves during process.  Make sure that adjacent switch in soldering machine is set based on the following stator:
	Get harness using left hand and stator using right hand.		Check condition of the stator on magnifying lamp. <i>Refer to GI-PRO-COS-002 for the stator allocation per model.</i>	<div><div>2 HOLES</div><div></div></div> <div><div>3 HOLES</div><div></div></div>
2	 <p>Insert the wires to stator using both hands.</p>			Do not use the stator that already dropped.  Check the condition of terminal before and after the insertion.  Make sure that all terminals are inserted in the stator holes and there should be no tangled wire prior soldering.  For 3 holes, confirm wire setting based on the color guide located at the soldering table.
	<p>For 2 holes</p>  <p>1.Insert the first wire on the right side</p>  <p>2.Insert the second wire on the left side.</p>			
	<p>For 3 holes</p>  <p>1.Insert the black wire on the first hole in the right side</p>  <p>2.Insert the green on the middle hole.</p>  <p>3.Insert the violet wire on the last hole on the left side.</p>			
	<p>For MR Contact</p>  <p>Put Hotmelted PCB at the hook of soldering machine.</p>  <p>Avoid touching hotmelted PCB during soldering.</p>			
				  Make sure that product and stator is in the magnifying lamp during process of insertion.
				 <b>NO GOOD</b>

10/4/2024		Added special character ◆ in soldering temperature.	A.Ayop	W. Carbillon	O. Merin	Prepare	Check	Approve
8/30/2024	10	Include frequency of oxidation, where to conduct and include double handling.	A.Ayop	C.Calayan	W. Carbillon			
12/15/2023	9	Include process for MR Contact models	L. Famodulan	A. Ayop	W. Carbillon			
5/12/2023	8	General revision.Include proper way to prevent oxidation on soldering tip.	C.Recto	.Habla/W.Carbill	O. Merin			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	May 1, 2019	

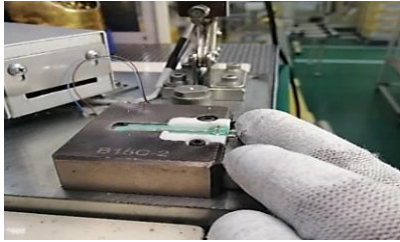
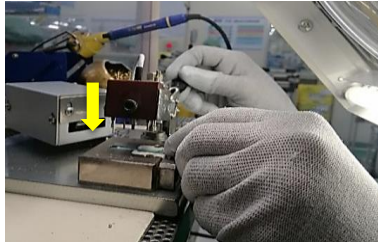


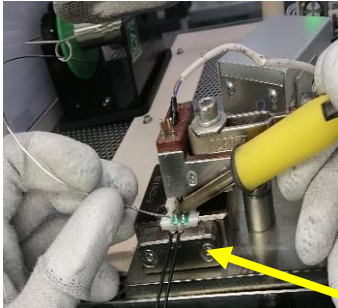
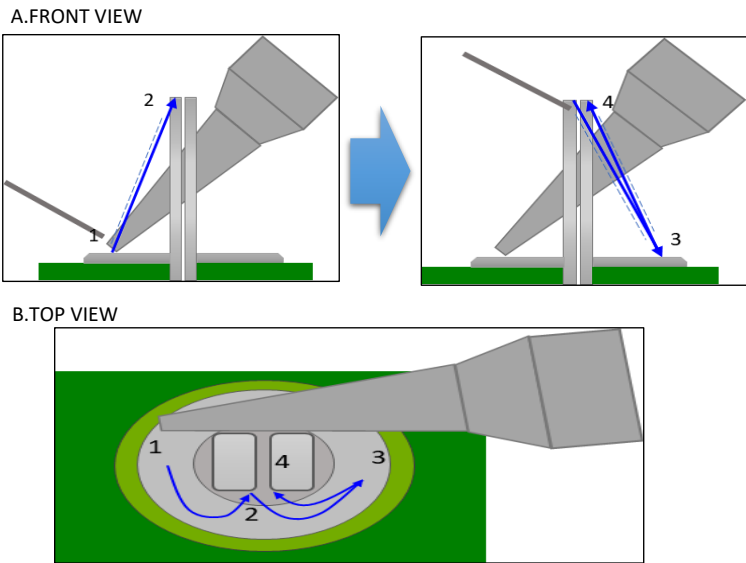
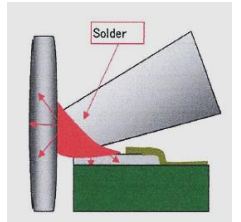
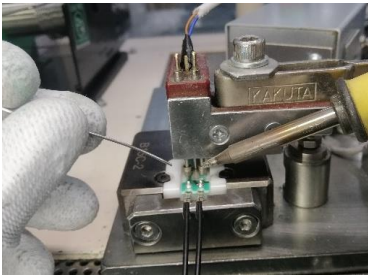
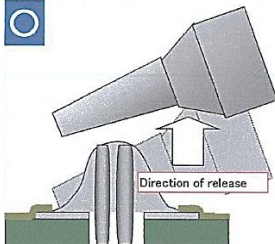
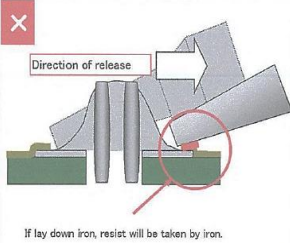
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3			Make sure the stator is set correctly to the jig before locking the clamp and probe pin is not stuck up to avoid denting and deformation on the stator.
	1.Set the stator with wire inserted to the soldering jig using left hand.	2.Pull the clamp downward to lock the stator into jig using right hand.	
4			Refer to WI-PRO-COS-023 for proper cleaning of soldering tip. Make sure to follow proper position of the soldering tip. ⚠ Temperature control limit of iron: 345°C ± 3°C( 342°C to 348°C ) Make sure to use Pb Free lead wire. Soldering iron cleaner 599B-01, HAKKO (FX951) TIP: T12-D16
	1.Get the soldering iron into holder then clean 2 times in the cleaning wire using right hand.	2.Get the soldering wire using left hand then position the soldering tip on the first terminal(left side)45° angle using right hand.	
5			<b>Heat bridge</b> is when you have a little bit of solder on tip where it comes in contact with the soldering lead to enhance the heat transfer between tip and solder joint.  Make sure to release the lead wire first then releasing soldering tip is in upward direction to avoid solder defects such as insufficient solder, detached/lifted solder and horn.
	1.Supply the soldering lead on tip of iron to form a "heat bridge", slide upward going to the terminal tip,slide downward going to the right side of terminal then slide back to terminal tip.Short GO sound will be heard after soldering 2sec but less than 5 secs.	<b>SEQUENCE OF LEAD WIRE</b>	
			<b>RE-SOLDER IS STRICTLY PROHIBITED.</b> <b>IF ENCOUNTERED DEFECT OR ANY ABNORMALITY CALL THE ATTENTION OF THE LEADER.</b> Make sure to use hook in 2 heads model except on 7L0117
	2.Release the lead wire first then the soldering tip in upward direction. Repeat the process on the next terminals going to the right side.		





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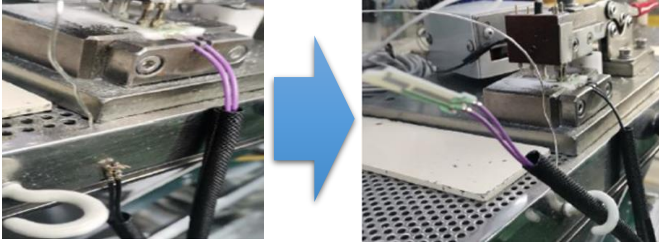
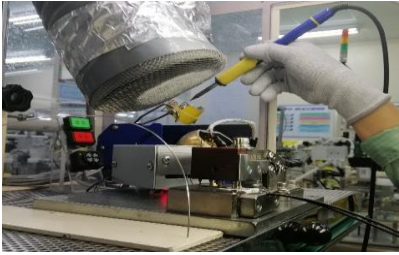

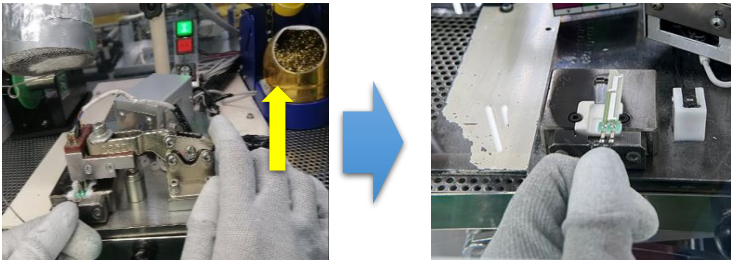
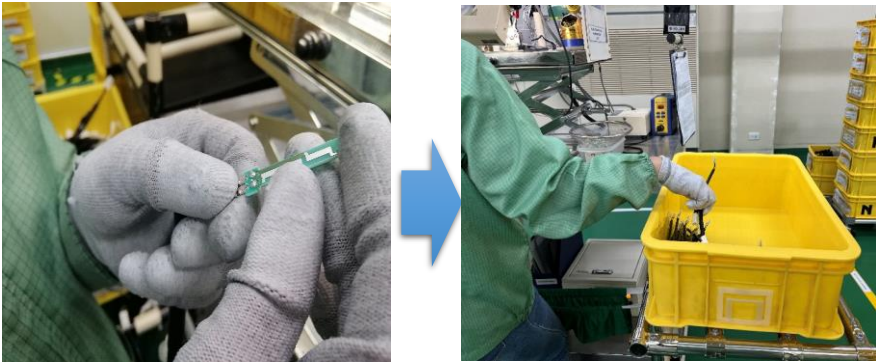
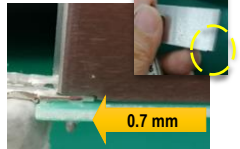
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5	 <p><b>NOTE:</b> For 2 heads, after soldering the first head ( right/long ) ,put it on the attached hook on soldering table to prevent the iron tip from hitting the wires during soldering of the second head(left/short).</p>	Oxidation must be conducted in soldering jig during long break and end of shift only.
6	 <p>Return soldering iron to the holder.</p>	Make sure soldering tip will not hit other part of the soldering machine or table.
7	 <p>While waiting for the Go lamp / alarm to activate, get another product using left hand.</p>	
8	 <p>Pull upward the clamp to unlock the soldered stator to the jig using right hand then remove it using left hand.</p>	Long GO alarm will be heard once soldering process completed.
9	 <p>Conduct visual inspection then put on the designated box.</p>	<p>*Use 10x Magnification lamp to check condition of the product.</p> <p>*Refer to WI-PRO-COS-022 for procedure of confirming the soldered part.</p> <p>*Refer to IS-PRO-COS-011 for standard sequence of soldering inspection.</p> <p>*Use terminal height measuring jig for the verification of terminal height</p> 

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	<div>PROPER WAY TO PREVENT OXIDATION ON THE SOLDERING TIP</div> <div>   </div> <div> <div>1.Get lead wire using left hand and soldering tip on the holder using right hand.</div> <div>   </div> <div>3.After cleaning,put lead wire on the tip of soldering iron.</div> <div>  <div> <div>NOTE:</div> <div>Before using soldering iron again in mass production, make sure to clean the soldering tip in the cleaning wire.</div> <div>   </div> </div> <div>4.Put back the soldering iron into the holder.</div> </div> </div>	<div>Conduct this process every:</div> <div>a.Every breaktime</div> <div>b.Line stop</div> <div>(abnormality,going to CR)</div> <div>c.End of the shift</div> <div>Make sure no on-going product in the soldering machine during conducting this process.</div> <div>  <div>GOOD</div> <div>(W/OUT PRODUCT)</div> </div> <div>  <div>NO GOOD</div> <div>(WITH PRODUCT)</div> </div>