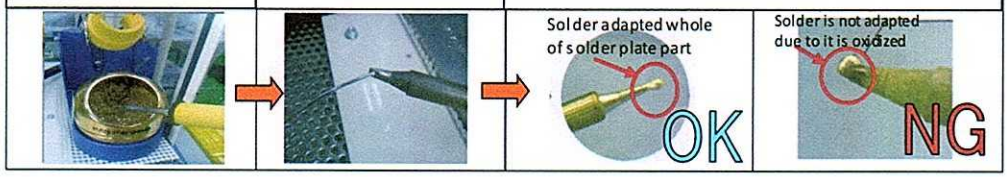
	Process Name/ Title:		Document No:	WI-PRO-COM-003
NBC	SOLDERING PROCESS/ Management of Iron and Vacuum Nozzle			
	WORK INSTRUCTION		Effective Date:	May 6, 2019
	Product Code/Name: ALL	Customer Code: ALL	Rev. No.: 0	Page No.: Page 1 of 1

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers

Before Working

1. Confirm condition of iron after 10min since power on.

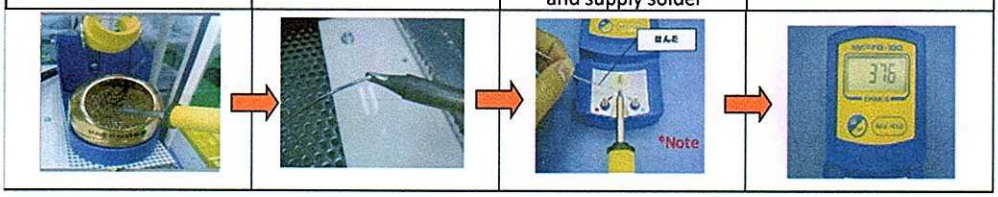
① Clean iron	② Put string solder	③ Confirmation



In case of NG, report to leader and re-check with leader, then if it is needed, change part.

2. Measure temperature of iron.

① Clean iron	② Put string solder	③ Put iron on sensor and supply solder	④ Read display



*Point of measuring

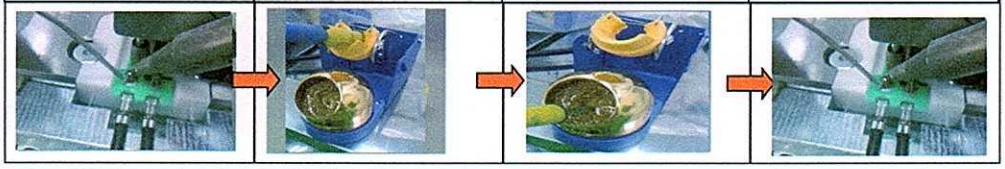
① To sensor, put iron horizontally from foreside.

② Put center of solder plate part on center of sensor.

During working

When put iron on the stand, left solder on iron

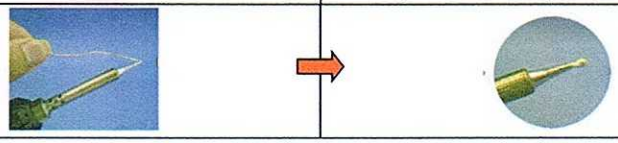
① Soldering	② Put on stand (Not-clean iron)	③ Clean iron (Just before soldering)	④ Re-soldering



After working

Finish with condition that solder is on iron

① Put solder on iron which is heated	② Put solder which looks little bit bigger than usual on iron, then after turn power off.



Due to iron is covered by solder, iron can avoid oxidize and can use longer.

※Before break time, do not turn off and must cover iron by solder

						Prepare	Check	Approve
						05/03/19		
05/06/2019	0	Transferred work instruction from NBC Japan (NBPS-9014).(for history purpose only)	J. Lorzano	O. Merin	O. Merin	J. Lorzano	O. Merin	O. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	05/06/2019	

NBC (Philippines)
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