


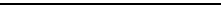
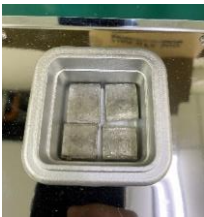

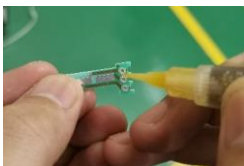
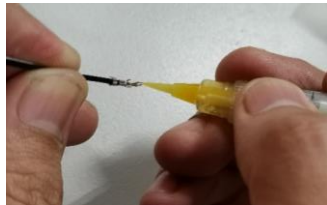
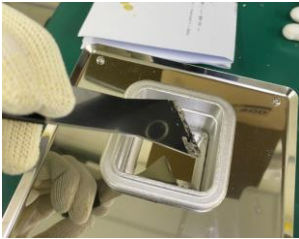



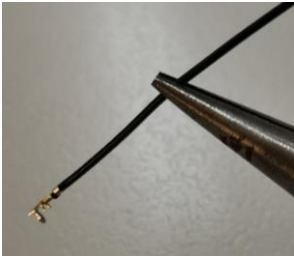
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
A.	Applying solder on Stator or Crimped Terminal in soldering pot	
1	<p>Prepare necessary tools & PPE before process.</p> <div>    </div> <div>    </div>	<p>PPE</p>  <p>Eye goggles</p>  <p>Cotton Gloves</p>
2	<p>Put the tools/ Flux & expired stators or crimped terminal (n=5 per lot) for evaluation in the provided trays.</p> 	
3	<p>Put the Soldering Pot in stable position then plug to socket (220V) then press the Power On button.</p> <div>   </div>	
4	<p>Turn the knob clockwise to its maximum setting (number 6).</p> <div>   </div>	

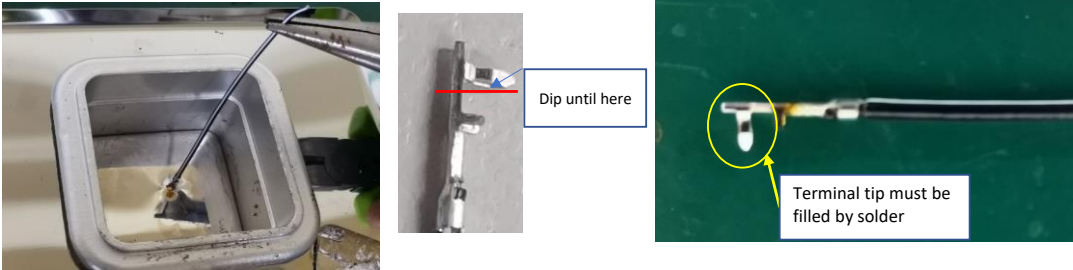
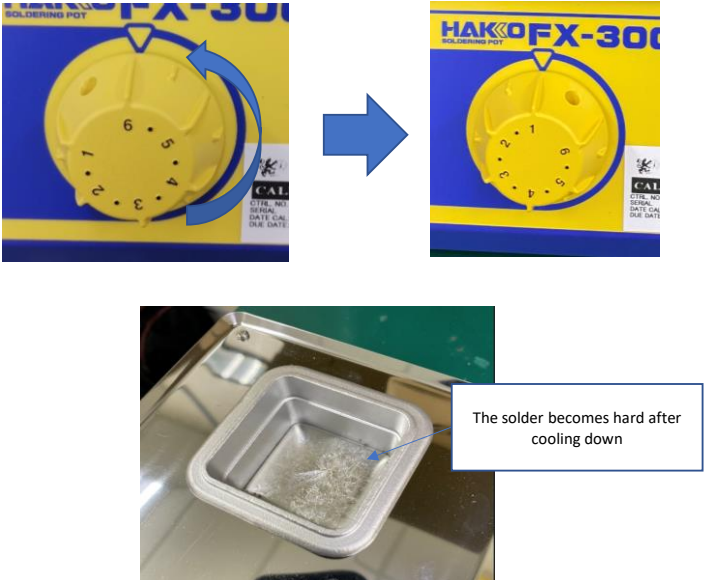
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	12/14/20
						Prepare:  Check:  Approve: 	


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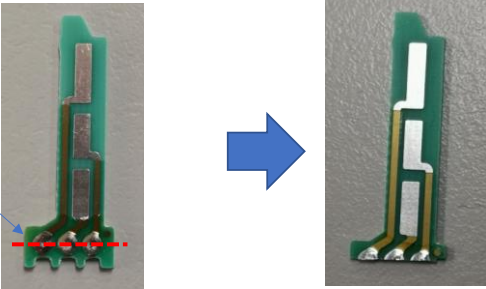
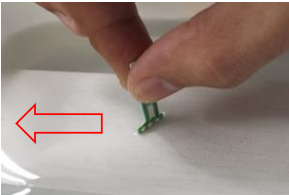
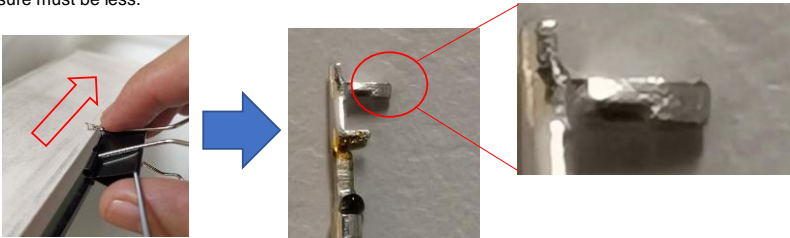
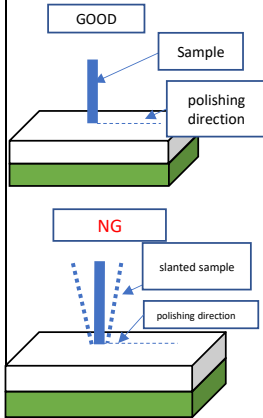
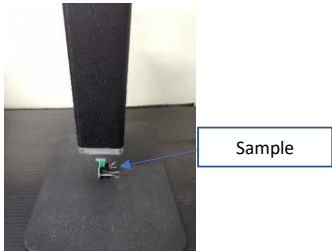
No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
5	<p>Put the solder bars (approx. 4 bars) in soldering pot. If there is already solder bar in soldering pot from previous evaluation, no need to put new solder bars unless it is insufficient.</p> 	<p>Do not touch the surface of pot.</p> 
6	<p>While waiting for the melting of solder bars, put flux on surface of stator or crimped terminal.</p> <p>For stator, no need to put inside the holes. For crimped terminal, both sides of terminal tip & inside the tip must be applied by flux (see below picture for the area where to put flux). Wait for 10 minutes or more to dry the flux, use timer to have accurate duration of drying time.</p> <p>For stator:</p>  <p>Apply flux in this area</p> <p>For Terminal:</p>  <p>Apply flux in this area (both sides & inside the tip)</p>	<p>Do not touch the flux</p> <p>Note: Flux will prevent solder to scatter</p> 
7	<p>Check the soldering pot if the solder bars were already melted. If already melted, remove/set aside the film by using spatula. Turn the setting to 3 or 4 to maintain the appropriate temperature. High Temp may cause burnt stator.</p>  	 <p>This entire device becomes HOT in use. DO NOT TOUCH the metal surfaces or contents.</p> <p>Use gloves.</p>
8	<p>Get the stator or crimped terminal with flux (must meet the drying time of 10mins. or more). Clamp with pliers.</p> <p>Note: The angle of stator must be slightly slant to easily dip in pot.</p> <p>For Stator:</p>  <p>For Terminal:</p> 	<p>Do not touch the flux</p>




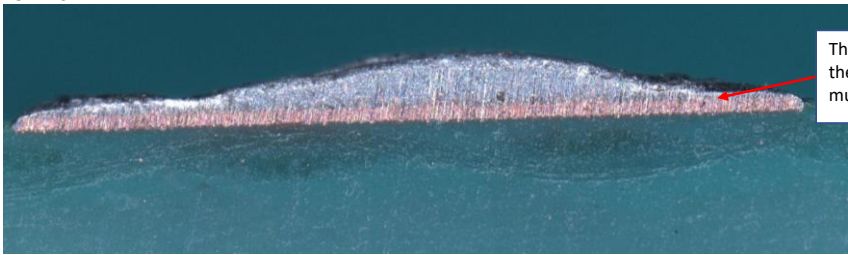
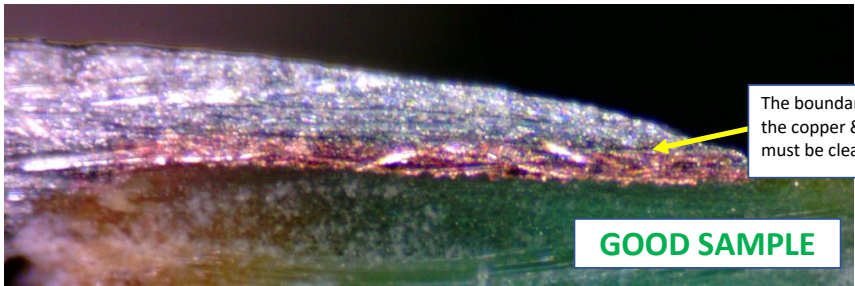

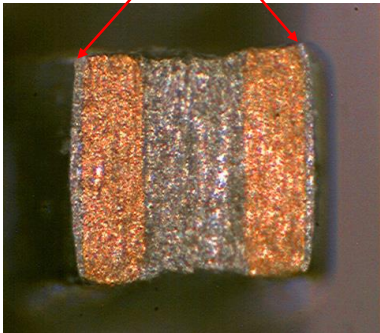
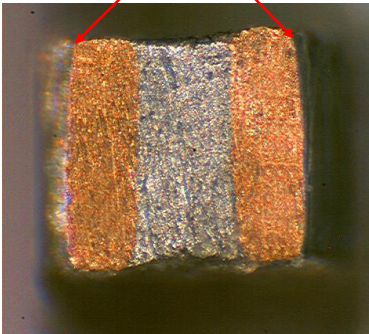
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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
9	<p>Dip the portion with holes into the melted solder for 5 seconds, make sure to scrape the film before dipping. Repeat the process for other expired stators.</p> 	<p>Do not dip the whole stator or insulation of wires in solder. ALWAYS wear eye protection to avoid the possible splash of flux during dipping</p> 
	<p>Dip the terminal pointed tip for 5 seconds, make sure to scrape the film before dipping. Repeat the process for other crimped terminal</p> 	
10	<p>After dipping, turn the knob of soldering pot counterclockwise then turn off. Unplug the solder pot and allow it to completely cool down before putting back to the box.</p> 	<p>Do not leave the soldering pot after turning off.</p> 

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
B.	Stator or Crimped Terminal Cross section Check Prepare the tools for polishing & capturing image	
1.	  <p>Sharpening stone dip in water (Water level must be slightly higher than stone)</p> <p>Microscope camera</p>	
2	<p>For stator: Ask the in-charge of Cutting and crimping to cut the stator in Portable Cross Section machine (see below for the area to cut).</p> 	
4	<p>For stator: Polish the sample stator in upward motion. The stator must be slanted same with the picture below. Pressure must be less.</p>  <p>For terminal: Put the sharpening stone in slant position, clamp the terminal using binder clip then polish the terminal tip in one direction as shown below. Pressure must be less.</p> 	<p>Use the finest portion of Sharpening stone Do not stay on one area Make sure sample is perpendicular to sanding stone during polishing.</p> 
5	<p>After polishing, check the sample in microscope camera. Ask for support in using the camera. Focus the camera on the soldered part then capture. Save the pictures then send to Person In-Charge who will ask the Special Acceptance approval. See page 4 for the reference pictures.</p> 	

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No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers
	<p>REFERENCE PICTURES:</p> <p>For STATOR:</p>  <p>The boundary between the copper & solder must be clear</p>  <p>The boundary between the copper & solder must be clear</p> <p>GOOD SAMPLE</p>  <p>The boundary between the copper & solder is not clear</p> <p>NO GOOD SAMPLE</p> <p>For TERMINAL</p> <div style="display: flex; justify-content: space-around;"> <div> <p>The surface of terminal tip & solder must be clear</p>  <p>GOOD SAMPLE</p> </div> <div> <p>The surface of terminal tip & solder is not clear</p>  <p>NO GOOD SAMPLE</p> </div> </div>	