

| | Process Name/ Title: | | | | | | |
|---|----------------------|----------------------------------|--------------|-----|----------------|--------|--|
| ١ | SOLDERING-Ir | on Cleaning | Document No: | | WI-PRO-SHM-019 | | |
| | WORK INSTE | WORK INSTRUCTION Effective Date: | | te: | April 23, 2025 | | |
| | Product Code/Name: | Customer Code: | Dov. No. | 1 | Page No.: | 1 of 1 | |
| | A1 I | A ALI | Rev. No.: | | | | |

ALL

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

Pb free's ratio of heat is higher than Pb.Therefore, it is difficult to melt.

(Ref: 1-5 Condition of soldering)

※ Ratio of heat: the calorific value which is needed to increase 1°C of object 1g.

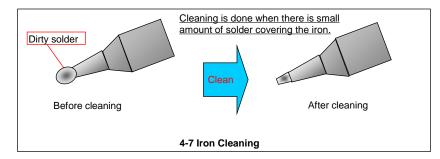
METHOD OF CLEANING

- (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) X Cleaning is done when there is small amount of solder covering the iron.

2 PURPOSE OF CLEANING

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.



3 FREQUENCY OF CLEANING

- (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.

IMPORTANCE OF CLEANING

Below chart shows defect, if iron is not cleaned:

Chart #4-7 Importance of iron cleaning

| # | Defect | Reason | | | | | |
|---|--------------------------------|-------------------------------|--|--|--|--|--|
| 1 | Solder volume is not stable. | Too much solder left on iron. | | | | | |
| 2 | Iron is not moisted by solder. | Iron is oxidized. | | | | | |

| | | | | | | Prepa | re | Check | Approve |
|----------------|----------|---|-------------|----------|-------------|---------|-------|-------------------|-------------|
| | | | | | | | | | |
| | | | | | | 1 1 | | <i>\(\sigma\)</i> | |
| 4/23/2025 | 1 | Change Customer code | L.Famodulan | A.Ayop | W.Carbillon | Damag | صلا | Arms | Lough, |
| 7/1/2017 | 0 | Previously established Work Instruction from NBC Japan (for history purpose only) | A. Yocor | O. Merin | T. Suguyama | L.Famoo | dulan | A.Ayep) | W.¢arbillon |
| Eff./Rev. Date | Rev. No. | Details of change | Revise | Check | Approve | Est. da | ite: | July 1 | , 2017 |

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