


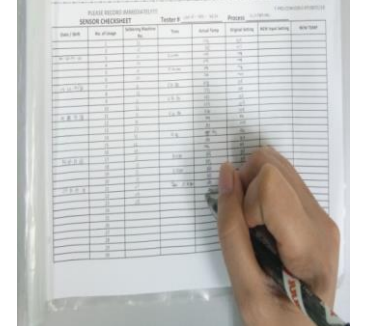

	Process Name/ Title:		Document No:		WI-PRO-SHM-009	
	Adjustment of Soldering Iron's Temperature (If below 30x usage only)		Effective Date:		November 18, 2024	
	WORK INSTRUCTION		Rev. No.:		2	
	Product Code/Name:	Customer Code:	Page No.:	1 of 1		
	ALL	ALL				

No.	Work Procedure/ Illustration			Records/Remarks/ Quality Pointers
To confirm soldering iron and sensor before adjustment of iron's temperature				
No.	Details of work	Illustration	Checkpoint	Records/Remarks/ Quality Pointers
1	Checking of Soldering Temperature Machine X using TESTER A Measured Value MACHINE X: 332°C Call Leader for support		2 ◆ STANDARD Temp Req. : 345°C ± 5	Operator: RECORD value on the Sensor checksheet, use RED pen if NO GOOD reading F-PRO-COM-029
2	DO NOT IMMEDIATELY ADJUST THE TEMPERATURE OF MACHINE X, instead Check also temperature of MACHINE Y Measured Value MACHINE Y: 334°C		2 ◆ STANDARD Temp Req. : 345°C ± 5	
3	If MACHINE Y is also NO GOOD Confirm by checking the temperature of MACHINE Z Measured Value Machine Z: 345°C		IF MACHINE Z is within the Standard Temperature Requirement. C/M: ADJUST the TEMPERATURE of MACHINE X & Y	
4	OTHER CONDITION: IF ALL MACHINES HAVE NO GOOD READING. DO NOT IMMEDIATELY CHANGE THE SENSOR, Instead USE TESTER B to confirm		IF ALL Temperature using TESTER B is within LIMIT, C/M: CHANGE THE SENSOR OF TESTER A	Leader: RECORD value on the Sensor checksheet F-PRO-COM-029
5	OTHER CONDITION: IF THERE IS STILL NO GOOD READING, EVEN AFTER USING TESTER B, CHECK THE IRON		IF SOLDERING IRON still have NO GOOD Reading to both TESTERS C/M: CHANGE THE IRON TIP Check the temperature again for confirmation 2 ◆ STANDARD Temp Req. : 345°C ± 5	Operator: RECORD value on Daily Checksheet Hotmelt Soldering Iron Temperature F-PRO-COM-029

						Prepare	Check	Approve
11/18/2024	2	Put black diamond mark in standard temp. requirement.	A.Ayop	W.Carbillon	W.Carbillon			
05/01/2019	1	Change of form stated and delete Subleader as the PIC. Change Customer Code.	M. Demiden	O. Merin	O. Merin			
06/01/2017	0	First Issuance	A. Yocor	O. Merin	T. Sugiyama			
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	June 1, 2017	

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