

Process Name/ Title: **CONTACT SWITCH ASSEMBLY/**

Cleaning iron

Document No:

Effective Date:

WI-PRO-COS-023

WORK INSTRUCTION Product Code/Name: **ALL**

Customer Code: **ALL**

Rev. No.:

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Work Procedure/ Illustration

1.) Items to be used

Attention: DO NOT use with non-PB free solder



Hakko: Cleaner of iron: 599B-01

Hakko: Cleaning wire: 599-029

2.) Timing of cleaning iron

After each soldering (1x), clean before proceeding to next usage.

3.) Times of cleaning iron

Put iron into cleaning wire twice and clean.

4.) How to clean iron

- •To remove waste, put iron into cleaning wire at different position in 1st time and 2nd time.
- ·Must have no remaining carbide and flux residue.
- Do not overclean iron too much.

(Make sure there are thin solder is left.)

·To make heat bridge, make appropriate amount of solder.



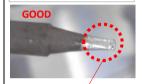
Records/Remarks/ **Quality Pointers**

Check the condition of soldering tip after cleaning. See pictures as reference





With dent on iron tip





No dent and no discoloration

If No Good, Replace a new one, then properly dispose the NG Soldering Tip

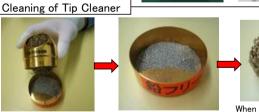
5.) Maintenance of cleaning wire

- ·When cleaning, confirm the cleaner label. Do not use it both for PB and non-PB free at same time.
- Spin cleaning wire and loosen it.
- · Remove waste of solder in cleaner and put in the designated bin. (Use gloves this time)



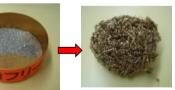






2 Dispose solder

waste from tray



When cleaner is hardened and could not remove waste, change it immediately.

6.) Change cleaning wire

Spin cleaning wire

and loosen

· Even wire is maintenance, still it is not removed waste, change wire.

1 Take cover out

· Replace when the cleaning wire becomes hard (refer to IS-PRO-SHM-002 Cleaning Wire Boundary Sample)

07/25/2022	3	Change Customer Code	L. Famodulan	C. Lalican	O. Merin	Prepare	Check	Approve
07/30/2018	2	Add pictures of Good / Bad condition of soldering tip	L. Alarzar	M. Demiden	O. Merin			\cap
03/16/2018	1	Additional important points in the procedure.	L. Alarzar	M. Demiden	O. Merin	I., A	0 /	
01/06/2017	0	Established ISO format. Initial issue	M. Vasallo	O. Merin	T. Sugiyama	Llandulan	Osta/SlicS	(1/4)
-	NA	Previously established work instruction from NBC Shanghai-NBHS- 1689(for history purpose only)	Takenaka	lchikawa	Sato	L. Famodulan	C. Lalican	Ø. Merin
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est! date:	01/06	/2017