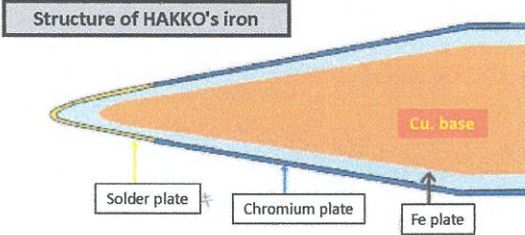

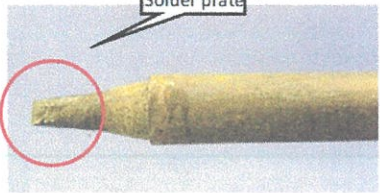
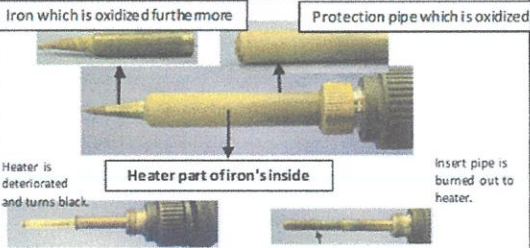


	Process Name/ Title:		Document No:	WI-PRO-COS-009	
	CONTACT SWITCH ASSEMBLY/ How to confirm corrosion of iron		Effective Date:	June 01, 2017	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Rev. No.:	Page No.: Page 1 of 1		
ALL	TRJ				

No.	Work Procedure/ Illustration	Records/Remarks/ Quality Pointers										
	<div style="text-align: center;">  <p>Structure of HAKKO's iron</p> </div> <p>· Iron: Cu part which is conducted well is plated by Fe which doesn't corrode Cu so much. And soldering part is plated by solder. The other part is plated by Chromium.</p> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> Timing of change iron </div> <table border="1" style="width: 100%;"> <tr> <th colspan="2">Confirm item</th> <th>POINT1</th> </tr> <tr> <td>POINT 1</td> <td>Because of soldering, Fe part is corroded and get hole.</td> <td rowspan="3">  This corrosion is happened due to Fe and Sn of solder is mixed up and melt into solder. </td> </tr> <tr> <td>POINT 2</td> <td>Solder plate part is oxidized black.</td> </tr> <tr> <td>POINT 3</td> <td>Surface of insert part of heater is oxidized.</td> </tr> </table> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>POINT2 Solder plate part is oxidized black.</p>  <p>Fe plate of solder plate part is exposed and from that part, oxidized and color to be blacked.</p> </div> <div style="width: 45%;"> <p>POINT3 Surface of insert part of heater is oxidized.</p>  <p>Iron which is oxidized further more Protection pipe which is oxidized</p> <p>Heater is deteriorated and turns black. Heater part of iron's inside Insert pipe is burned out to heater.</p> <p>*When iron, protection pipe, and heater is oxidized completely, it makes conduction weaker, so change parts.</p> </div> </div> <div style="border: 1px solid black; padding: 5px; margin-top: 10px;"> Check of iron and control date of change </div> <ul style="list-style-type: none"> · Each leader check above points and if it is judged it should change, change parts. · Frequency of check is 1/D, and confirm when iron's temperature is checked, then after signed on daily check sheet. <div style="border: 1px solid black; padding: 5px; margin-top: 10px; color: blue; text-align: center;"> NBC (Philippines) MASTER COPY </div>	Confirm item		POINT1	POINT 1	Because of soldering, Fe part is corroded and get hole.	 This corrosion is happened due to Fe and Sn of solder is mixed up and melt into solder.	POINT 2	Solder plate part is oxidized black.	POINT 3	Surface of insert part of heater is oxidized.	
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							Prepare	Check	Approve
-	NBHS-1698	NA	Previously revised Work Instruction from Shanghai (for history purpose only)	Shibasaki	Hamana	Otsuka	M. Vasallo	O. Merin	T. Sugiyama
Eff./Rev. Date	Doc/DRCN No.	Rev. No. (if applicable)	Details of change	Revise	Check	Approve	Est. date:	06/01/2017	