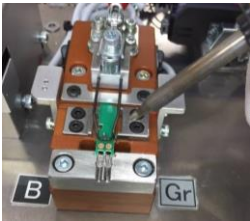









	Process Name/ Title:		Document No:	WI-PRO-COM-020	
	SOLDERING-Time Management		Effective Date:	May 13, 2022	
	WORK INSTRUCTION		Rev. No.:	0	
Product Code/Name:	Customer Code:	Page No.:	1 of 1		
ALL	ALL				

No.	Work Procedure/ Illustration			Records/Remarks/ Quality Pointers
	Temperature of iron: 345°C±5°C Soldering time: more than 2s less than 5s			
		Details of Work Solder must start from LEFT to RIGHT	Check Point NG lamp will turned ON when; 1. soldered less than 2 sec 2. soldered more than 5 sec 3. iron is put back to stand 3 times - This is used for hot-melt process	Quality management • Manage soldering time • Prevent re-soldering
①				
		 After soldering, GO lamp turned on.  Go to next step	 NG lamp will turned ON when soldering time is not complete  Report defect	
		Details of Work Return iron to stand.	Check Point NG lamp will turned ON when; workpiece is removed from the jig without returning the iron to the stand.	Quality management • Prevent re-soldering and defects
②				
		 If soldering is complete, GO lamp will turned on.  Go to next step	 NG lamp will turned ON when soldering time is not complete  Report defect	
OPERATOR IS NOT ALLOWED TO RESET. IN CASE OF ABNORMALITIES, IMMEDIATELY REPORT TO PIC-LEADER/ASV/SV				



Use stopwatch for validation of soldering time.
 This can be done in a weekly basis.
 (Note: 1 second of Go-lamp should correspond to 1 second using stopwatch.)

05/13/22	0	Transfer from WI-PRO-SHM-020 to WI-PRO-COM-020	C. Lalican	O. Merin	O. Merin	Prepared	Checked	Approved
Eff./Rev. Date	Rev. No.	Details of change	Revise	Check	Approve	Est. date:	05/13/2022	

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