



VR102601 – Process 010

Revision History

Solder Feed Lines to Mux

Date / Time	Rev	Author	Description
8/26/2017	A	JEB	Original Version

Approvals

Rev	Approval	Customer	Engineering	Mechanical	Software	Mfg	OPS	QA	Test	Sales	Support	Corp
A	DT											
	Initial											

1.0 Process Description

Description	Solder Feed Lines to Mux
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VR Part Number	VR102601
Customer Part Number	355467-01
Configuration	Standard
Model	SRA-16(20x69]
Process Number	VR102601-010
Process Standard	5 Minutes

2. Setup

2.1 Technician




Tech #	Certification Required	Skill	Process	Safety
1	Trained in IPC-610F, ESD S20.20-2014 Training	IPC-610F Soldering Skill and ESD training	Solder of components and mechanical assembly	ESD protection

2.2 Tools

2.2.1 Calibrated Tools

Number	Tool	Description	Rev	Specification	Calibration Requirements	Image
1	None					

2.2.2 Non-Calibrated Tools


Number	Tool	Type	Reference	Image
1	Soldering Iron	ESD	Hakko FX-951 set at 810°F degrees	
2	Flush Diagonal Cutters	ESD		
3	Tweezers	ESD		

VR102601 – Process 010



Solder Feed Lines to Mux

2.3 Materials

#	VR Part Number	Mfg Part #	Manuf	Description	Qty	Requires Serial #	Size	Tolerance	COC Req	Lot Req	Incoming QA Req	Image
1	VR102659		Kester	Kester 48 Flux Cored Lead free solder		N			N	N	N	




2.4 References


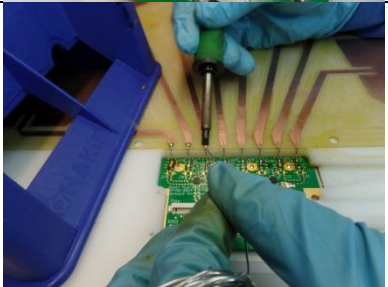
Number	VR Doc Number	Rev	Description	Manuf	Description	Directory
1			None Required			

2.5 Safety

Number	Type	Description	Reference
1	Ventilation	Area needs to be well ventilated around the area where soldering is to take place	OSHA

VR102601 – Process 010
3.0 Procedure

Step	Tech	Tool	Material	Tasks description	Reference Drawing	Image
1	1	3		Bend the bus wires so that it points up and away from the board		
2	1	3		Bend the top of the bus wires so that they align flat with the feed lines		
3	1	3		Press bus wire against FR4 with tweezers		

4	1	2		Cut the excess bus wire off 1/8" from edge of FR4 and discard excess		
5	1	1	1	Solder the bus wires to the feed lines		

4.0 Process Recording

Step	Tasks description	Reference Drawing / Image
1	Update the Traveler after of completion of the feed lines being installed	

5.0 Non Compliance

#	Non Compliance	Disposition	Reference Drawing / Image
1	Bus Wire pulls off / damages the solder pad of the mux	Mark the material with a red dot and create a non-compliance report designating the description of why the part had the solder pad pulled off. Place the material in the non-compliance receptacle.	
2	Poor solder flow on the feed line solder	Remove all solder with a solder wick and attempt the solder again.	
3	Solder bridge on the mux feed line solder pads	Remove all solder with a solder wick and re-solder the feed line.	