

Solder Connector Assembly Work Order

Project:

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Assembly Name:	Drawing Number:	Build To Rev.	Assembly Serial Number:
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Build History/Changes Incorporated:

Step No.	Type	Description	Perf By:	Date
1		SOLDER WIRES IN CONNECTOR # PER SCHEMATIC:		
		-BLOW OUT SOLDER CUPS		
		-INSPECT SOLDER CUPS INSURE FREE OF DEBRIS AND THAT GOLD PLATING IS FREE OF FLAWS		
		-TIN CUPS AND REMOVE SOLDER (3X)		
		-AVOID SPILLOVER		
		-INSTALL WIRES PER SCHEMATIC		
		-CUT AND STRIP WIRES		
		-INSPECT STRIPS		
		-TIN WIRES		
		-INSPECT TINNING		
		-SOLDER WIRES IN CUPS		
		-CLEAN EACH SOLDER CONNECTION AFTER SOLDERING, USE ISOPROPANOL.		
		-AFTER ALL CONNECTIONS MADE CLEAN CONNECTIONS USING XYLENE AND RINSE USING ISOPRPOANOL.		
		-INSPECT		
		M.I.T. QA		
		ONR		
		-SLEEVE CONNECTIONS USING SHRINK TUBING		

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