

NAV 25 Soldering Controls

SECTION I – Procedure:

A 1.	<p>Identify the standard the supplier uses for performing soldering.</p> <p>___ MIL- STD 454 ___ IPC-A-610 ___ OTHER</p> <p>IF Other, Specify:</p>	
A 2	<p>a. Does a written detailed procedure exist and is it utilized for the soldering process? Identify procedure number and revision.</p>	<p>___ Yes ___ No ___ N/A</p>
	<p>b. Does a written detailed procedure exist for assembly of components prior to soldering? Identify procedure number and revision.</p>	<p>___ Yes ___ No ___ N/A</p>
A 3.	<p>Are procedures readily available?</p>	<p>___ Yes ___ No ___ N/A</p>
A 4.	<p>Are inspection procedures utilized for soldering? Identify procedure number and revision;</p>	<p>___ Yes ___ No ___ N/A</p>
A 5.	<p>a. Are inspection and manufacturing personnel trained in use of procedures?</p>	<p>___ Yes ___ No ___ N/A</p>
	<p>b. Is this recorded and part of employee’s file’?</p>	<p>___ Yes ___ No ___ N/A</p>

NAV 25 Soldering Controls

A 6.	Are soldering procedures written based on contract-invoked requirements or generic and company based standards?	___ Yes ___ No ___ N/A
A 7	a. Is the procedure approved by the Customer? List Reference Approval Number, if applicable:	___ Yes ___ No ___ N/A
	b. Does the procedure require review/approval by the government?	___ Yes ___ No ___ N/A
A 8.	Are procedures/work instructions adequate for control of:	___ Sat ___ Unsat
	a. (Proper Equipment) etc.	___ Yes ___ No ___ N/A
	b. (Proper Materials) etc.	___ Yes ___ No ___ N/A
A 9.	What type of tools, mechanical strippers, chemical strippers, thermal strippers, holding devices, bending tools, clinching tools are required in the use of the procedures? Specify sample of tools	

NAV 25 Soldering Controls

A 10.	Does procedure include system for identification of inspection status on parts and documentation? (E.g. inspection stamp)	___ Sat ___ Unsat
SECTION II – Record Review		___ Sat ___ Unsat
A 11.	Identify inspection methods used to verify conformance with procedures and standards	___ Sat ___ Unsat
A 12.	What inspection documents exist and are they maintained to confirm inspection process was performed?	___ Yes ___ No
	a. Are inspection documents properly completed and maintained?	___ Yes ___ No
	b. Review and record number of samples: _____	
A 13.	Is traceability maintained for material, which has been soldered?	___ Yes ___ No ___ N/A
A 14.	Is inspection data reviewed and accepted by qualified personnel?	___ Yes ___ No ___ N/A

NAV 25 Soldering Controls

A 15.	Are all tools, gages, meters, utilized for monitoring and/or inspection a part of the manufacturer's calibration program?	___ Yes ___ No ___ N/A
A 16.	Are certifications for raw materials used in soldering process reviewed for acceptance and maintained on file for review?	___ Yes ___ No ___ N/A
A 17.	Are adequate inspection work records maintained?	___ Yes ___ No ___ N/A
A 18.	Are shop traveler and work records traced to the operator/inspection personnel?	___ Yes ___ No ___ N/A
<p>SECTION III – OBSERVATION OF SOLDERING PROCESS Detailed observation of solderer (complete one section for each solderer observed). NOTE: if determined to be N/A, provide explanation.</p>		___ Sat ___ Unsat
A 19.	Identify process being observed. What is being soldered?	
	a. Solderer identification:(name, badge or clock #, shift)	
	b. Basic material(s) being soldered, pc board, wire, assembly, etc.	

NAV 25 Soldering Controls

	c. Identify soldering material, solder type, flux, class, etc.	
	d. Is the solderer qualified for observed soldering procedure?	___ Sat ___ Unsat ___ N/A
	e. Is the solderer familiar with details of the procedure?	___ Sat ___ Unsat ___ N/A
	f. Procedure number:	
	g. Is it readily available to the solderer and inspector?	___ Sat ___ Unsat
A 20.	Are their adequate methods of segregating accepted and rejected materials in use?	___ Sat ___ Unsat
A 21.	Do solder rolls and raw materials have traceable markings on containers. What types of solders are used? (List)	___ Sat ___ Unsat

NAV 25 Soldering Controls

A 22.	Are soldering tools ions correct wattage for ESD or sensitive components.	___ Sat ___ Unsat
A 23.	Are work areas clean from debris and separate from other areas for soldering operations.	___ Yes ___ No
A 24.	Are exhaust equipment utilized in soldering areas to provide fresh air for personnel.	___ Yes ___ No
A 25.	Do controls exist for handling and disposing of solder waste?	___ Yes ___ No

Additional Comments/Concerns: