



Samples Evaluation Form

The purpose of this document is to expedite the sample processing, and gives us the critical information points you are most interested in knowing. While the completed sample package will always contain the general observations and information, the following questions will give you a more helpful and personal sample experience.

Please include this form with your samples and send to the contact and address below:

Nordson SELECT, Inc.
Attn: Process Lab
3010 N. First Street
Spokane Valley, WA 99216
Phone: +1 509.924.4898

Date: _____

Company: _____

Mailing Address: _____

City: _____

State: _____ Postal Code: _____ Country: _____

Contact at company: _____

Email Address: _____

Company contact number: _____ Extension: _____

Nordson SELECT Sales Rep: _____

We would like to see 5 of each of the samples you would like to run on the machine. This is so we can have at least one (1) PCB for process development. The sample you choose to send should be an example of a product that is time consuming or labor intensive. If possible, please send assembly instructions and noted areas of difficulty. The sample should be an unsoldered example of a product; however soldered product can be used for estimation purposes. We recommend not clinching all leads if pre-assembling the PCB; unless necessary for your process.



Alloy Type:

Lead

Lead-free: (We will default to SN100C as we find this to be a better suited alloy for Lead-free selective soldering. SAC305 or SnCX Plus alloy will be used upon request.)

Flux Type:

No-clean.... (no post wash or cleaning of the board)

Water soluble.... (yes, we are cleaning the board after soldering)

Specific type _____ (We have fluxes that have been proven to work well with our machine for Lead and Lead-free, No clean and water soluble in the demo lab. If no specific type is listed, we will use what we feel will work the best.)

Solder joint quality requirements:

Class 2

Class 3

Any additional parameters we should know about?

Flux application:

Drop-jet

Atomized sprayer

We default to using a Drop-jet precision fluxer for No-clean applications, and the atomized spray fluxer for water soluble, or when post cleaning is required. While the atomized spray fluxer can be slightly faster for coverage, the overspray will need to be addressed.

Current process:

Wave solder in pallets

Hand soldered

Current Cycle time _____

Total cycle time per board or panel:

_____ This cycle time should be conceived from real process actions that are currently in place. To clarify, if a PCB/Panel current soldering time is 2 minutes, however this requires 5 minutes of prep, for masking or fixturing, as well as 3 minutes to “clean” any prep material from the PCB, there is 10 minutes of labor involved to process this PCB/Panel. This becomes our target time to beat (we will strive to be 3-4 times faster).

If necessary, can the samples be preheated:

Yes: If yes, is there a maximum allowed temp of parts/board _____ (will not exceed 120 degrees Celsius)

No



Current difficulties areas/parts to solder:

Notes:

If you have any questions, please don't hesitate to contact one of our process lab technicians:

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