

Measurement Data for Large North American EMS Company

Facility #1 — Usage Over 6 Months

Measurement Result	Measurements Taken	Percentage	
GREEN	450	84.7%	
YELLOW	37	6.9%	15.1% <i>of time</i>
RED	44	8.2%	

Facility #2 — Usage Over 6 Months

Measurement Result	Measurements Taken	Percentage	
GREEN	99	67.3%	
YELLOW	22	14.9%	32.5% <i>of time</i>
RED	26	17.6%	

YELLOW & RED Measurement Results Could be Due to:

- Environmental conditions during shipping & storage
- Operator error
- Wrong type of solder paste used
- Solder paste too warm or too cold
- Solder paste not mixed long enough
- Solder paste not fit for use
- Temperature & humidity exposure during stencil life
- Same jar of solder paste used multiple times