ASSEMBLY INSTRUCTIONS

STEP 1: WIRE PREPARATIONS
- 1.1 SPLICE POSITIVE AND NEGATIVE WIRES
- 1.2 SOLDER THE WIRES INTO A SOLDER CUP

STEP 2: PWD PREPARATION
- 2.1 REMOVE BURRS FROM TRACES EDGES
- 2.2 ENLARGE MOUNTING HOLES TO 3 MM
- 2.3 BAKE PWB AT 60 DEG C FOR 4 HOURS
- 2.4 CLEAN PWB WITH IPA
- 2.5 APPLY SOLDER ONTO PADS 2 OF D1 AND D2

STEP 3: SOLAR CELLS BONDING
- 3.1 ABRADE PAD 1 ON D1 AND D2 WITH GRIT 200 SANDPAPER
- 3.2 CLEAN WITH IPA
- 3.3 BOND PAD 1 ON D1 AND D2 WITH EPO-TEK H20E IAW AD8
- 3.4 CURE AT 80 DEG C FOR 3 HOURS

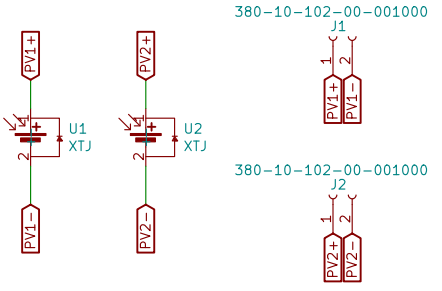
STEP 4: SOLDER REMAINING PARTS WITH Sn63b TYPE R SOLDER IAW AD5

STEP 5: STAKE COMPONENTS WITH SOLITHANE 113 IAW AD4 AND AD6

STEP 6: INSPECT IAW AD1 TO AD5

STEP 7: VERIFY SOLAR CELL PERFORMANCE

H1 MountingHole
H2 MountingHole
H3 MountingHole
H4 MountingHole



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