Visit Report

To : PEJI
Cc : FNM, CAAG, GUOS, ZHLE, ZHAI, GUOC, LAIC, LINR, XUEA, LIAW, FUJT, WEIW, CHJM
From : CHER

Date of visit: 05 July 2023
Date of report: 07 July 2023

Meikexin

Participants	:	Meikexin	: Mr. Zhao *(Project manager)*
		EMS	: J. Peng, R. Chen
OEM	:	DPL	
Sales responsible	:	PEJI	
Distributor	:	/	
Location	:	Quanzhou, Fujian	
Application	:	Embedded pole housing	
Segment Code	:	110	
Project number	:	PDS not initiated yet	
Material	:	Grivory GVX-5H BK	
USP	:	High stiffness & Good dielectric strength	
Potential	:	10 t/a	
SOP	:	Q4.2025	

1. Target of visit

Obtain status for TR 90 UV embedded pole housing project.
Trial support on site and obtain more information about the GVX-5H embedded pole housing project. (Molder ordered 125kg material for trials)

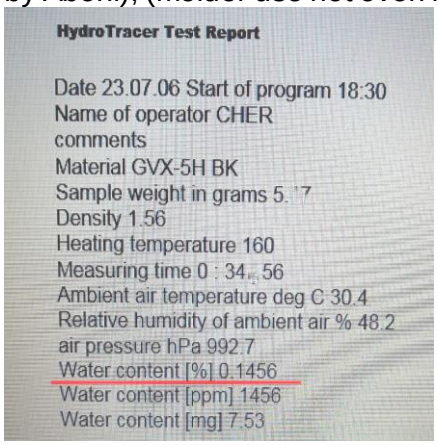
2. Summary

- TR 90 UV embedded pole housing testing results are positive currently, the whole results will available at the end of Sep.2023.
- DPL develop thermal plastic embedded pole housing, because GVX-5H already pass test in Nari/ China stage grid, so we recommend GVX-5H for this project.
- Got 15pcs samples with GVX-5H for testing, project at material testing and evaluation stage, need 2 years at least to finish testing and evaluation.
- In GVX-5H trial meet drooling issue, drooling issue due to moisture content too high (0.1456%, checked by Aboni).
- We offer tool improvement comments and processing improvement comments to molder for drooling issue.

3. Details

- DPL tested our material TR 90 UV for transparency embedded housing project at Dec.2021, so far testing results positive, the whole testing results will available at the end of Sept.2023.

- The new embedded pole housing project needs thermal plastic resin, we recommend GVX-5H to test. The project is high confidential, customer don't release more information to us, currently the main material for embedded pole is still epoxy resin, customer don't want to let other companies (especially competitors know they are testing thermal plastic resin).
- Need around two years to finish relative tests (electrical performance testing / environment testing / mechanical performance testing).
- At this trial met drooling issue, the main reason is moisture content too high (0.1456%, checked by Aboni), we optimized injection parameters (back pressure / hot tip temperature / screw loosening), the drooling issue improved, but can't solved completely. Due to customer worry that void will produced in part inside, they refuse to use lower back pressure.
- We suggest molder to improve some items:
  1) Need prepare more raw material for trial and injection parameters optimization, otherwise can't better samples. (This time not enough material to optimize injection parameters, even purging barrel and screw.
  2) Need use desiccant dryer to dry material and assure moisture contact ≦ 0.1%(checked by Aboni), (molder use hot oven in this trial (115℃/6~7hrs), not follow our requirement).



  3) Use valve pin hot tip instead of open type hot tip, it can well solve drooling issue.
  4) One part weight about 3.0kg, the existing gate size too small, need to change it.

4. Actions

No.	Action	Resp.	Due date
1	Obtain GVX-5H embedded pole project development schedule and initiate PDS.	PEJI	28th Jul.2023
2	Obtain testing results for TR 90 UV embedded pole housing	PEJI	30th Sept.2023

Best regards

Ryan Chen