

	<b>Gautam Solar Private Limited</b>	Document No.	GSPL/TS/001
	Issue Date	01-12-2024	
	Document Title: Technical Specification	Rev. No./Date	00
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Area / Zone	Parameter	Unit	Setting	
			Glass to Glass	Tolerance
Stage-1  (Laminator-1)	Temperature	°C	120	(±10)
	Temp. Upper limit	°C	125	(± 20)
	Temp. Lower limit	°C	115	(± 20)
	Total Vaccum time	Sec.	400	(± 50)
	Upper Vaccum delay	Sec.	10	(±10)
	Upper Vent-1	kPa	-75	(±15)
	Lamination-1	Sec.	10	(± 20)
	Upper Vent-2	kPa	-55	(±15)
	Lamination-2	Sec.	30	(+10, -25)
	Upper Vent-3	kPa	-35	(±15)
	Lamination-3	Sec.	230	(+30, -150)
	Venting Time	Sec.	50	(± 10)

Prepared By:	Approved By:	Documents Status
<b>Quality Manager</b>	<b>Quality Head</b>	

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Area / Zone	Parameter	Unit	Setting	Tolerance
			Glass to Glass	
Stage-2  (Laminator-2)	Temperature	°C	145	(±10)
	Temp. Upper limit	°C	150	(± 10)
	Temp. Lower limit	°C	140	(± 40)
	Total Vaccum time	Sec.	20	(± 20)
	Upper Vaccum delay	Sec.	10	(± 10)
	Upper Vent-1	kPa	-70	(± 20)
	Lamination-1	Sec.	30	(+5, -25)
	Upper Vent-2	kPa	-50	(± 20)
	Lamination-2	Sec.	30	(+5, -25)
	Upper Vent-3	kPa	-50	(± 20)
	Lamination-3	Sec.	500	(± 50)
	Lower Venting Time	Sec.	40	(± 20)
	Upper Venting Time	Sec.	50	(± 20)

Area / Zone	Parameter	Unit	Setting	Tolerance
			Glass to Glass	
Stage-3  (CP-3)	Temperature	°C	50	(± 10)
	Vacuum Time	Sec.	50	(± 30)
	Upper Vent	kPa	-5	(± 50)
	Cooling Time	Sec.	400	(± 50)
	Venting Time	Sec.	30	(± 10)

**Note:** 1) First Chamber Lower Vacuum should reach 300 Pa in 150 sec.  
2) Second Chamber Lower Vacuum should reach 500 Pa in 150 sec.

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