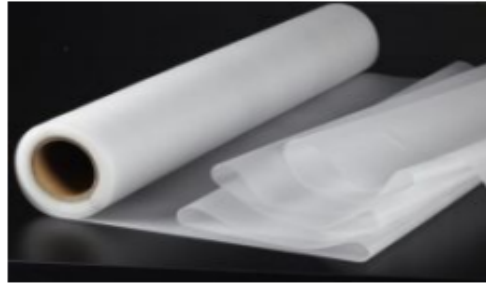


## EVA- B601



EVA (Ethylene Vinyl Acetate Copolymer) is used as the main raw material for EVA film which is for encapsulating solar modules. EVA film is Produced by thermal processing and forming equipment when EVA is fully mixed With some modified accessory ingredients. EVA film is easy to handle for it is inviscid under room temperature. When encapsulating solar modules, the processing requirements should be followed. From bottom to top, we place glass, EVA, solar cell, EVA and TPT(TPE,PET) , then all these will be put in to the preheated Laminator to be laminated and solidified. The solidified solar cell, after being fixed with aluminium alloy frame and terminal box and then being tested and packed, becomes the solar cell module.

### 1.Laminating and solidifying process conditions:

Solidifying way		Fast solidifying(B601)
Laminating and solidifying	Temperature of hot plates (°C)	138-140
	Time of the creation of vacuum(min)	5
	Time of pressure increasing and keeping(min)	13-15

### 2.Laminating and solidifying operating instructions:

(1) The laminating process conditions can vary according to the laminator's property. Different laminator may have different laminating process conditions.

(2) The temperature of laminator's working environment is different from laminating temperature, and accordingly, the process conditions are different. Generally speaking, in summer, the time used to create vacuum is shorter than that in winter.

(3) The higher the laminating or solidifying temperature is, the shorter the time will be. Contrarily, the lower the temperature is, the longer the time will be. If the temperature of laminator or curing box is even, relatively higher solidifying temperature can save time and cut cost, and also can increase production efficiency.

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### 3. Quality Assurance:

ISO9001  
 ISO14001  
 SGS  
 UL/TUV

### 4. Laminating curing process condition:

Curing mode		
Laminating curing	Hot-plate temp(℃)	143-145℃
	Vacuum time (min)	5.5Min (-101.3MPa)
	Laminating time (min)	-60KPa 20s -40KPa 10s -20Kpa 600s

### 5. Product test:

Test Item	Test Standard	Unit	Standard Values	Test Values
Density	ISO1183	g/cm <sup>3</sup>		0.96
Tensile Strength		MPa	≥15	26
Elongation at break	GBT1040.2-2006	%	≥400	450
Optical Transmission	GBT2410-2008	%		>91
Shrinkage	QB/BJBM-01-2010	TD	≤3	<2
		MD	≤3	<2
Cross-linking Rate after laminate(143-145℃,16min)	QB/BJ-03-152	%	≥75	82-86
Dielectrical strength	GBT1408-2006	Kv/mm		60
Volume Resistance	GBT1410-2006	Ω		7.8*10 <sup>14</sup>
Peeling strength	Backsheet	GB/T2790	≥60	>80
	Glass		≥40	>80
UV cutoff wavelength	GBT2410-2008	nm		360
Water-absorbing rate	GBT1034-1998	%		0.1



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