

PRODUCTION PROCESS CONTROL

1. Production Process

- Materials Preparation
 - Cell Power Classification;
 - EVA, back sheet cutting;
 - Soldering ribbon pre-soaking;
 - Glass Cleaning
 - Material preparation information (checking batch number of the materials, and inventory records...)
- Soldering Process
 - Soldering Temperature control & record ;
 - Soldering quality ;
- Lamination Process
 - Lamination Teflon sheet, membrane maintenance;
 - Lamination settings control;
 - Lamination Temperature control & record ;
 - EVA cross-link test ;
- Trimming
 - Triming temperature and tools
 - Maximum pile-up quauntity of lamination pieces without frame ;
- Framing
 - Sealing control for edge to the frames and junction boxes;
 - Visual inspection of sealing;
 - Curing time control;
- Visual Inspection
 - Visual inspection;
 - Defective modules handling;
- Label, markings and Packaging
 - Label design;
 - Markings for packaging;
 - Carton design;

2. Environment Controlling

- Safety for production;
- Materials/modules transferring methods;
- Working instruction accessibility;
- Workshop cleanness;
- Storage and handling of the defective/unqualified modules;

3. Power Measurement

- Temperature controlling;
- Sun simulator calibration;
- Standard modules checking;
- Sun simulator maintenance (if possible);

4. Tests

- EL test (before and after lamination);
- Insulation test;
- EVA cross-link test;

5. Materials Traceability

- BOM list;
- Materials requisition sheet for daily production;
- Inventory records;
- Work slips.

6. Sampling Verification

- Power Measurement (5% sampling of each container);
- Visual Inspection (According to level I double sampling plan, ISO 2859-1);