

Reinforced semi-flexible solar panels (ARFLX and FLPROC series)

HANDLING AND FITTING MANUAL

Thank you for purchasing this product. The following guidelines apply only to ARFLX and FLPROC series reinforced semi-flexible solar panels with ETFE coating and front-and-back contact solar cells with metal bus bars. This manual should not be used for any other solar panel of a different series, material or solar cell type.

Any work should follow the required safety standards and applicable regulations. The product should be handled and installed by professionals or appropriately qualified persons. Suitable precautions and safety measures should be taken in all cases.

I. Delivery

Please remember to examine the condition of the box(es) containing the solar panel(s) immediately upon delivery. If you notice that the package has incurred any form of damage (i.e. it is deformed, punctured, torn, stained etc) you must sign for the delivery as “damaged”. This will be essential to the post-incident investigation with the courier, in the case that the contents of the box are also damaged.

Place the box containing the solar panel on a flat level surface, and open it carefully, without removing the solar panel from the foam packaging. Examine the surface of the solar panel and the condition of each black solar cell for any signs of damage. Keep the solar panel flat in the packaging while performing this visual inspection. Do not put any pressure on the solar panel (i.e. do not press down on the solar panel with your hands when checking for damage). Slight discolouration of solar cells or remnants of glue on top of the surface are permissible and are not classed as damage, as neither of these factors will affect the performance of the solar panel.

If you see any cracks in the solar cells or creases in the plastic surface coating, along with corresponding damages to the carton box, please contact your supplier immediately with photographic evidence for assessment.

Before removing the solar panel from its packaging, please check the dimensions and confirm that the solar panel fits in the required space.

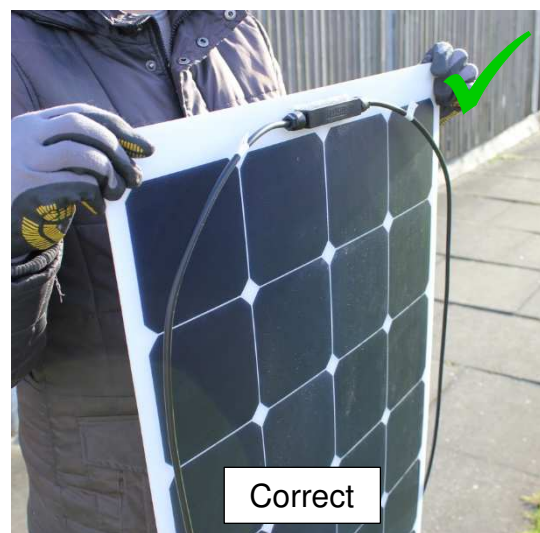
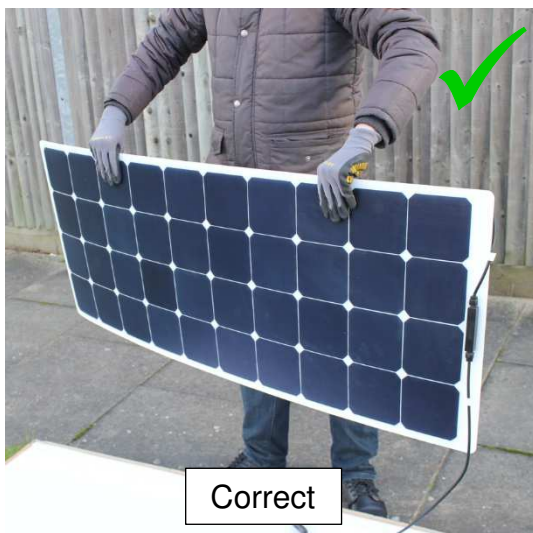
II. Handling

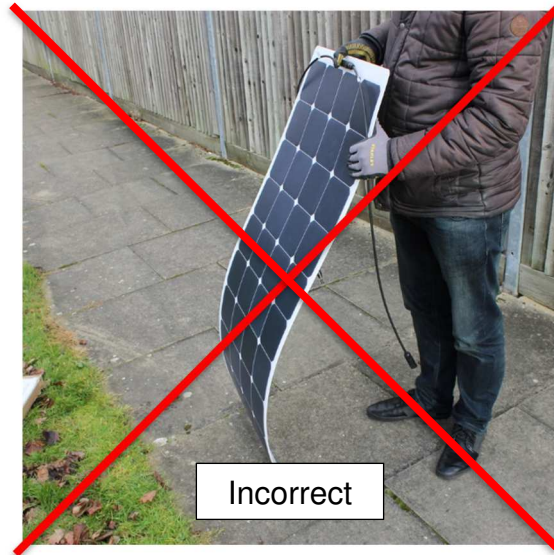
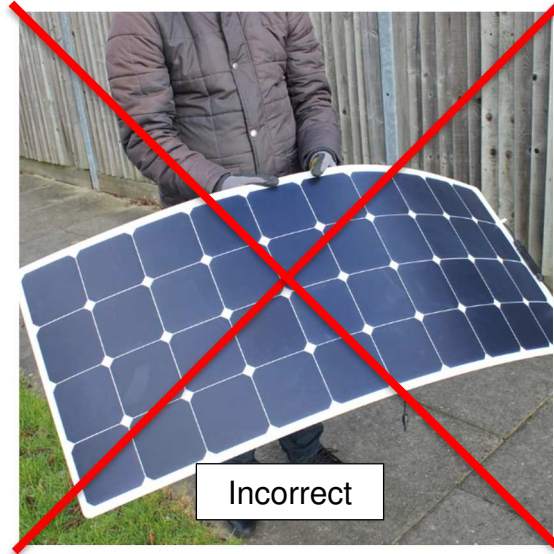
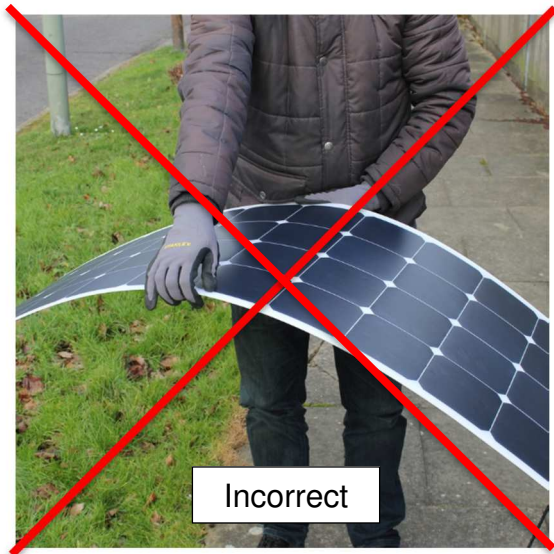
This product must be handled with care at all times. Detailed guidance on handling is provided below.

Even though this solar panel is semi-flexible, **it is recommended to bend it only once**: upon permanent mounting to a curved surface. It is not designed to be repeatedly flexed (for example, it is not suitable for constant movement in the wind like a sail). It should not be suspended in the air; it must be fixed to a rigid surface. Allowing the solar panel to flex repeatedly multiple times might shorten the lifetime of the product.

- Do NOT bend the solar panel unnecessarily – keep it as straight as possible at all times. When gripping the solar panel, ensure that your fingers do not cause any local stress or curving of the material.
- Do NOT step on the solar panel or put any pressure on it until it is securely mounted on to a rigid surface. No pressure should be applied if there is any void space underneath the solar panel.
- Do NOT rest the solar panel on any of its corners or edges as this will cause the panel to bend under its own weight.
- Do NOT apply unnecessary force to the solar panel (i.e. do not throw it or mishandle it in any way, even if it is still packaged).
- Do NOT puncture the solar panel.
- Do NOT lean the solar panel on sharp or angular objects.
- Do NOT use the junction box or the connection cable as a handle.
- Do NOT stack the solar panels once they have been removed from their original foam and cardboard packaging (the sharp edges of the junction box may damage the front surface of another solar panel).
- Do NOT install or handle the solar panels in windy weather.

To carry the solar panel safely, always ensure that the solar panel is perpendicular to the ground and remains unbent in your hands. The best way to do this is to hold the solar panel along the long edge (keeping this edge in a straight line) as shown in the photos below. Do not carry large solar panels in a horizontally oriented plane (parallel to the ground) as it may cause the panel to bend under its own weight and become damaged. Do not rest the solar panel on the ground so that it begins to bend.





Never attempt to test the “local flexibility” of the solar panel by bending the material of the solar panel near the edges or in the corners. This can easily cause solar cell cracks.

When handling or installing the solar panel, ensure that your grip does not pinch the solar panel in such a way that causes the panel to bend.



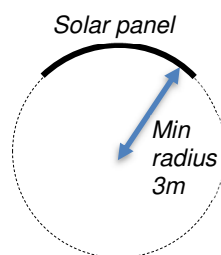


III. Maximum recommended curvature

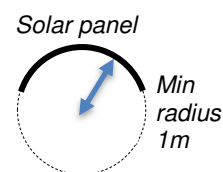
The solar panel has some rigid reinforcement. It can be curved to a certain degree but it will also demonstrate resilience to spring back to its original shape.

The maximum recommended curvature for this solar panel corresponds with the **minimum recommended bending radius** of 3000 mm for ARFLX solar panels, and 1000 mm for FLPROC solar panels. In other words, once curved, the solar panel should follow part of a hypothetical circle with a radius of **at least 3m** for ARFLX, and **at least 1m** for FLPROC series. The solar panel curve should be distributed uniformly across the full length of the solar panel (avoiding “sharp” bending angles or corners).

ARFLX series



FLPROC series



In practice, the minimum recommended radius rule translates into the following requirement: when the solar panel is mounted on a curved surface, there is a **maximum recommended arch height** that the installation must not exceed (when measured against a straight horizontal line).



The maximum recommended height of the arch of a bent solar panel will depend on the length of the solar panel and the series. The tables below provide some examples.

ARFLX series

Length of the panel (cm / ft)	Max recommended height of the arch (mm / in)
50 cm / 1.6 ft	10 mm / 0.4 in
80 cm / 2.6 ft	27 mm / 1.0 in
100 cm / 3.3 ft	42 mm / 1.6 in
120 cm / 3.9 ft	60 mm / 2.4 in
140 cm / 4.6 ft	81 mm / 3.2 in
150 cm / 4.9 ft	93 mm / 3.7 in
170 cm / 5.6 ft	120 mm / 4.7 in
200 cm / 6.6 ft	165 mm / 6.5 in

FLPROC series

Length of the panel (cm / ft)	Max recommended height of the arch (mm / in)
50 cm / 1.6 ft	31 mm / 1.2 in
80 cm / 2.6 ft	79 mm / 3.1 in
100 cm / 3.3 ft	122 mm / 4.8 in
120 cm / 3.9 ft	175 mm / 6.9 in
140 cm / 4.6 ft	235 mm / 9.3 in
150 cm / 4.9 ft	268 mm / 10.6 in
170 cm / 5.6 ft	340 mm / 13.4 in
200 cm / 6.6 ft	460 mm / 18.1 in

Excessive bending must be avoided when handling or installing the solar panels. The maximum recommended arch height examples provided above are for the one-time bend of the solar panel, when permanently mounting it onto a curved surface. Do not mount the solar panel on any surface which may alter the solar panel curvature or constantly flex the solar panel, event to a small extent (i.e. surfaces which are insufficiently rigid).

Important! The surface curvature **must be distributed uniformly** across the entire length of the solar panel. Sharp bending may cause permanent damage to the solar cells.



IV. Fitting to the surface

Whilst fitting the solar panel, the installer must adhere to the appropriate safety guidelines at all times, including those for safety at work, electrical installation and equipment usage, and construction, along with all other regional and national legislation.

The solar panel can be installed in a landscape or portrait orientation, and fixed in place by gluing, screwing or riveting.

The mounting surface for the solar panel should be smooth and even. If the surface is uneven, it is recommended to prepare it prior to the installation by filling in the gaps. For example, spaces between ridges on a vehicle roof can be filled in as the photos below show – this will make mounting easier and quality of bond better. When the gaps are filled in, a greater support surface area for the solar panel will reduce mechanical stress and improve solar panel longevity.



In case of bonding the solar panel, always ensure that your chosen adhesive forms a good bond with the substrate surface and the plastic back sheet of the solar panel.

Before applying any adhesive to the underside of the solar panel, place the panel gently on a non-abrasive flat surface which will not cause any damage to the front side of the solar panel (e.g. its original carton box or foam packaging). Keep the solar panel as straight as possible whilst doing this (handle the solar panel like a sheet of plywood).



Note: take into account the **rebouncing straightening force** of the solar panel. When mounting the solar panel on a curved surface, the panel must be fixed in a curved position until the adhesive gets dry and forms a strong bond between the solar panel and the substrate surface.

Gluing with double-sided tape

In general, gluing with double-sided tape is not recommended on curved surfaces because of the **rebouncing straightening force** of the solar panel. If bonding with tape is required, it is best to use an industrial grade porous (“foam”) tape for this application. Applying the tape across the entirety of the underside of the solar panel will improve the bond quality.

When gluing with double-sided tape:

- Apply the tape onto the solar panel first, by “unrolling” it on the solar panel. Use a soft cloth or a roller to gently apply pressure onto the tape (protective film side) to dispel all air from between the tape and the solar panel. Take care not to force the solar panel to bend underneath.
- If the length / width of the tape exceeds the solar panel, cut the tape carefully around the edges of the solar panel.
- Remove the protective film and stick the solar panel down on a clean and dry surface, keeping the solar panel as straight as possible up. While sticking it down, gently apply pressure on the solar panel with a soft cloth or a roller to ensure that no air is trapped underneath the solar panel (2 people are recommended for the installation).
- Observe the required application temperature for the double-sided tape and the time for the glue to dry.

Warning! Double-sided adhesive tape forms a very strong immediate bond with the contact material and does not allow for repositioning. Attempting to remove the solar panel, even if only partially attached, can seriously damage the solar cells.

Gluing with adhesive

Your chosen adhesive should be suitable for both the solar panel and the mounting surface. It should also be designed for outdoor applications (with a wide temperature range, UV light protection etc). Pay attention to the application temperature and drying time requirements.

The mounting surface must be even, clean (use a degreasing agent) and dry. The installation must be carried out with care and precision, as this permanent method does not allow for repositioning.

Warning! Although preparing the roof surface for better adhesion is permitted (e.g. by removing the old paint, grinding, using a primer etc), you must not use any sand paper or other sharp or abrasive tools on the underside of the solar panel.

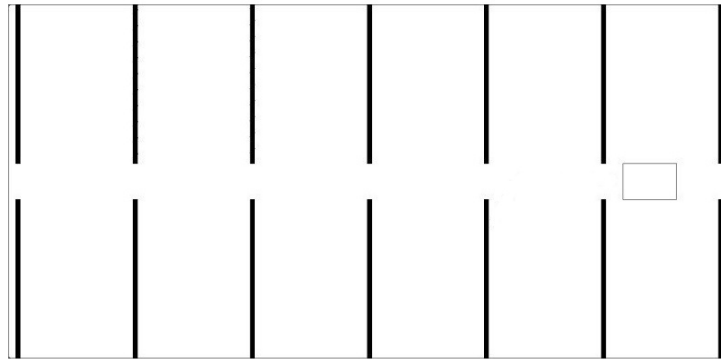
There are two main options for application of the adhesive:

- 1) Apply the adhesive to the underside of the solar panel in parallel beads broken in the middle of the solar panel. Depending on the application the edges of the solar panel can be sealed all the way round with the same adhesive at the end of the installation.

- 2) Cover the entire underside of the solar panel with a layer of adhesive, spreading it evenly with a trowel or a similar tool.

The first option is recommended for smooth and even surfaces. If the surfaces are uneven (for example, roof ridges on a campervan) a larger contact area is recommended for adhesive and the second application option will be the best.

For the default first application option, apply thick 10-12mm adhesive beads on the rear of the solar panel, in parallel to each other, as shown in the diagram and the photo below:



Break the adhesive lines in the middle of the solar panel with a gap of 70-100 mm. This will even the pressure and allow for additional escape routes for air and water if the edges of the solar panel are not sealed at the end of the installation.



The adhesive lines can be as close to each other as required (the number of lines depends on the strength your chosen adhesive), but a minimum gap of at least 70 mm between lines is recommended. In general, for most plastic / fibreglass / metal surfaces and a good quality adhesive, a gap of 100 - 150 mm between parallel adhesive beads would form a strong bond.

To adhere the glued solar panel to the mounting surface:

- It is recommended to use two people, particularly for large solar panels.
- Minimise bending of the solar panel when attaching it to the surface, keeping it as straight as possible.
- When pressing down the solar panel to the mounting surface, we recommend using a cotton cloth or a hand-roller to evenly distribute the compacting pressure.
- If not using a cloth or roller, use a flat hand to distribute the pressure (no point load) and press the solar panel gently in a wiping motion.

Important! For difficult shaped / curved surfaces where a rebounding motion of the solar panel is likely, use other means to secure the solar panel in place while the adhesive dries. This may involve using weights (distributed evenly across the solar panel) or strong industrial tape. If you decide to use tape, ensure that no residual glue is left on the solar panel surface after you remove the tape.

If multiple solar panels are mounted on the same surface, or if the edges of the solar panel are close to other objects (such as a roof skylight), leave a gap between the solar panels (or between the solar panel and nearby objects) of at least 2mm to compensate for the linear expansion of material under different temperatures.

Important! If mounting a solar panel on a non-horizontal façade or a difficult mounting surface (e.g. glass, wood, concrete, brick, canvas etc.) the instructions provided above are not applicable. Please seek special guidance for installations of this nature.

Drilling, screwing and riveting

Mounting by self-tapping screws or securing the solar panel with fasteners via mounting holes are both good methods of fitting the solar panel. To secure the solar panel using one of these methods:

- Mounting holes can be drilled into the corners of the solar panel and along the long edges in gaps between the solar cells corners.
- Holes should be positioned at least 8 mm away from the solar cells or any visible metal contacts.
- Before the self-tapping screws are tightened, edges of the drilled holes must be sealed with an adhesive / secured with rivets to avoid the risk of future delamination of the solar panel material or internal corrosion of the metal composite layer.

Mounting with Velcro tape

Fitting the solar panel using strips of Velcro tape is possible but it is not recommended on curved surfaces due the strong rebounding force of the solar panel. This method is also not recommended for vehicles and speedboats due to the wind drag which might cause the solar panel to detach.

Once the solar panel has been mounted with Velcro tape, it should be treated as a permanent installation. Attempting to remove the solar panel, particularly if a large part of

or the entire back surface is covered with Velcro, can seriously damage the solar cells if the panel undergoes a puncturing stress or a sharp local bend.

Fitting a solar panel with a rear junction box

If your solar panel features a junction box on the underside (BJB, JBB and similar sub-series), we do not recommend using a double-sided adhesive tape to mount it, especially on uneven surfaces with irregularities. This is because it will be harder to ensure that the cable entry hole (junction box recess) under the solar panel is fully waterproof. Please use a suitable adhesive instead.

To fit a solar panel with a rear junction box:

- Most rear junction box solar panels come with a round junction box. Drill a round, appropriately sized hole in the mounting surface (typically 30 mm) so that the rear junction box fits in it well.
- Place the solar panel on a soft, non-abrasive surface with the rear side facing upwards, and apply the adhesive in beads as described above.
- Apply a thick adhesive ring (at least 12mm line diameter) around the junction box to form a closed seal around it, and bond the solar panel to the surface.
- Two people are recommended to perform this installation.

Important! When positioning the cable coming from the rear junction box solar panel underneath the mounting surface, **ensure that this cable is firmly fixed to this mounting surface from underneath with frequent fixing points**, to avoid any slack, movement, gravity or any other force pulling the cable down or mechanically affecting it in any other way. This is especially important when mounting the solar panels on vehicles, boats, or any other applications which are prone to vibration. If the cable is left to hang without sufficient fixing points, **it might cause regular movement of the cable around the junction box area and will ultimately break soldering joints in the junction box, reducing or stopping the energy output.**

V. Electrical connection

Warning! This product generates electrical current when the front side is exposed to light. Even if the voltage and current from a single solar panel is low, multiple solar panels connected in the same circuit can have a much greater voltage and current. Touching the terminals or wiring may cause an electric shock or burns. To avoid risks, fit an isolator switch for solar panels or cover them during the installation.

When connecting the solar panel(s) to a solar charge controller, remember that most solar charge controllers require a battery connection first, so that they can detect the battery voltage and condition, before they start taking power from the solar panel. The solar panel(s) should only be connected to the solar charge controller after the battery connection has been made live.

Always observe general safety standards, specifications and manuals of the connected equipment, as well as the installation advice below:

- Do not use different types or sizes of solar panels in the same system, unless your installation has been preapproved by your supplier or another qualified person.
- Do not modify the electrical connections of the solar panels. In particular, do not open or remove the junction box.
- Do not cut or pierce the solar panels, as this may cause live components to become exposed and/or damaged.
- Any installation or maintenance of solar panels must take place in dry weather on dry surfaces.
- Use tools with insulated grips only.
- Do not use damaged solar panels (including damages received in transit or during the installation).
- Do not apply any protection covers, coating, paint or varnish to the solar panels.
- Do not drop heavy or sharp items onto the solar panels.
- Do not concentrate sunlight (e.g. from mirrors or lenses) or other sources of artificial light on the solar panels.
- Do not install solar panels in locations where they may be submerged in water for lengthy periods.

Keep the maximum system voltage that can flow through your semi-flexible solar panel(s) to a minimum. In a solar system with **multiple semi-flexible solar panels**, the preferred method of connection is in parallel (rather than in series). It is recommended that:

- For ARFLX series, that the maximum open circuit voltage is kept **within 100V per string**
- For FLPROC series, the maximum open circuit voltage is kept **within 600V per string**

Multiple strings of the same power and voltage should be connected in parallel. Mixing of different series of the solar panels / or solar panels with different product codes should be avoided.

If the voltage generated by your solar array is substantially higher than the voltage of your battery, use a suitable MPPT solar charge controller to maintain high efficiency of the system.

In addition, if your system includes multiple semi-flexible solar panels, for any parallel connection of either individual solar panels or strings of panels, it is recommended to fit suitable blocking diodes to ensure that the system delivers the highest output in any shading conditions. For a single solar panel system connected via a solar charge controller, a blocking diode is typically not required.

When installing multiple solar panels with **rear junction boxes** in the same system, seek wiring advice from your supplier as the panels might require additional blocking or bypass diodes depending on the application and other equipment.

When installing the solar panels, always check that the cabling is not under stress. Do not bend the solar cables below the minimum bending radius of 40 mm. Ensure that the cables are not tight or stretched when mounting the solar panel.

VI. Cleaning and care

Due to the special ETFE surface of these solar panels, dirt and grime will usually be washed away by the rain. Nevertheless, if the solar panel is fully or partially shaded by dirt or debris, this must be cleaned to prevent loss of performance.

Clean the front side of the solar panel gently using a soft cloth (dry or moist, with lukewarm water). **Do not use brushes, scrapers, metal tools, or any high-pressure water tools.** Do not use any cleaning substances and do not allow contact of the surface of the solar panel with any chemicals.

If the solar panel has been used in marine conditions and the surface is covered in sea salt, remove the build-up very carefully, ensuring that the salt crystals do not scratch the solar panel surface.

In areas with low winter temperatures, remove any snow and ice without force (e.g. with a very soft broom) in order to avoid damage to the protective layer of the solar panel.

Inspect the solar panels at least once a year to ascertain that all connections and fixings are tight and corrosion free. Examine the solar cells to confirm that they are not cracked or damaged.