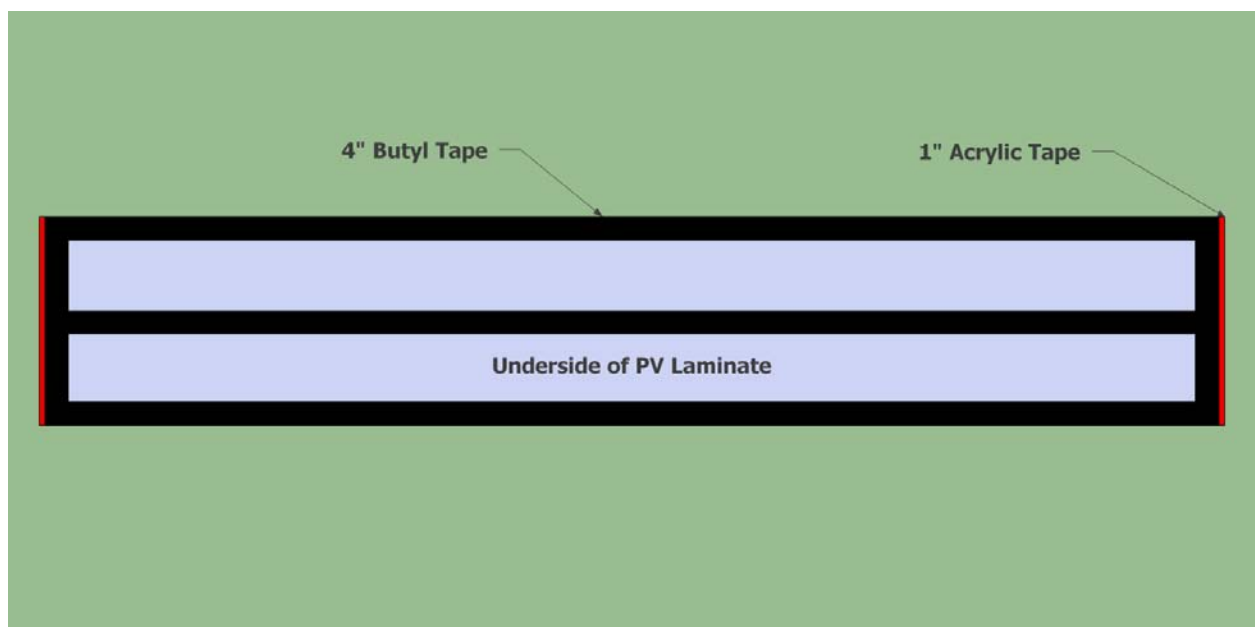


## XR Series Technical Bulletin

# New Taping Pattern for Metal

The XR designation represents a series of modules up to 18 feet (5.5 m) in length and 27 lbs (12 kg) in weight. These modules are designed for installations that are either flat or curved in one dimension along the length of the module. The thin-film solar cells used are fabricated on 0.005 inch (0.125 mm) thick steel wafers and are encapsulated with an outdoor-qualified polymer encapsulation system. The modules are intended to be applied to the roof substrate using a butyl adhesive tape. This bulletin is intended to provide updated recommendations on the taping pattern to installers of Xunlight modules. The information in this bulletin supersedes corresponding information in earlier manuals and documents.

## Recommended Tape Pattern and Mounting



## Instructions

1. Measure and mark roof area where laminate(s) are to be installed.
2. Clean area with roofing manufacturers recommended cleaner.
3. Apply 3 - 4" (75 -102 mm) wide butyl adhesive tape to the roof in the pattern shown above.
4. Apply 1" (25mm) wide acrylic tape to the short ends of the laminate as shown above.
5. Roll out laminate(s) using a ~16 inch (400 mm) diameter cardboard core.
6. Adjust laminate over tape.
7. When the laminate is in the correct position, peel the release film off the adhesive at the junction box end and secure the laminate.
8. Roll the laminate back to the starting position (towards the J box end).
9. Peel the remaining release film.
10. Roll laminate out onto the adhesive tape.
11. Using a rubber roller press the laminate into the adhesive using 5 to 10 pounds (2-4 kg f) of pressure.