

## SOLDERING TABS TO SOLAR PANELS

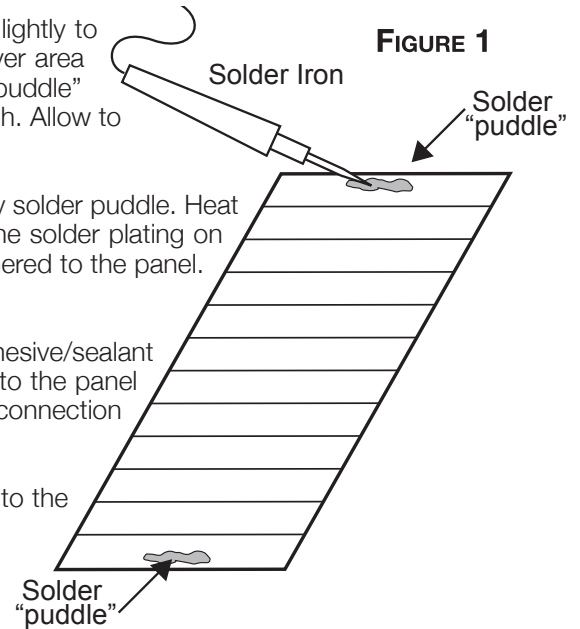
Congratulations on the purchase of this quality Solar Panel.  
Please observe these guidelines to obtain reliable free energy from the Sun.

**1- NOTE:** If panel has plastic insulating coating, carefully scratch the top surface lightly to remove before soldering. Cut special solder piece in half. Place piece of solder over area along edge of metallized glass strip on panel. Heat with a solder iron tip until a "puddle" of solder is formed –you may have to move the tip back and forth about half an inch. Allow to cool. See Figure 1. Repeat for other edge of panel.

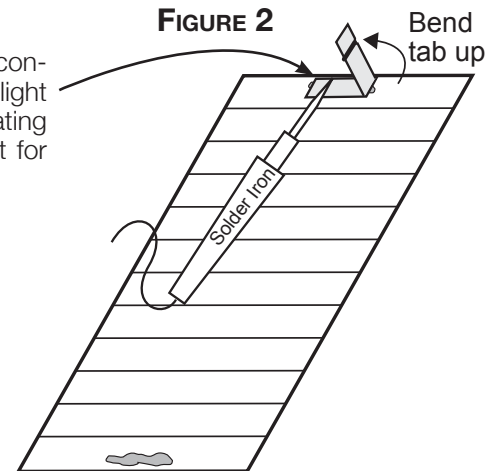
**2-** Now bend tab at right angle as shown (see Figure 2) and place tab on top of dry solder puddle. Heat the part of the top surface of the tab that is directly over the solder puddle until the solder plating on the tab melts and causes the tab to attach to the solder puddle that is already adhered to the panel. Repeat for the other side of the panel.

**3-** After both tabs are cooled down, spread a liberal amount of the contact adhesive/sealant called "All Purpose Household GOOP™" over the part of the tab that is attached to the panel (see Figure 3). This provides mechanical strength as the solder alone is for electrical connection and does not provide enough mechanical strength.

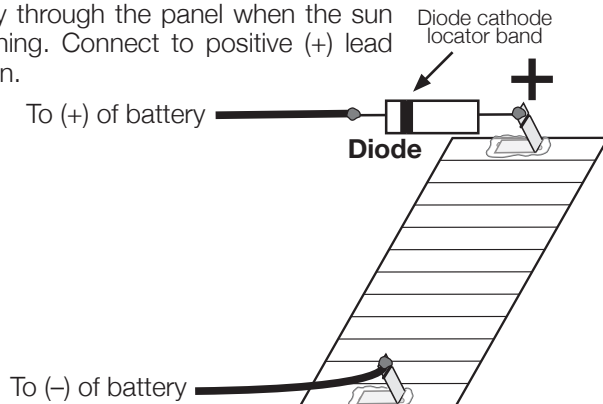
**4-** After the "GOOP™" dries, you may solder flexible hookup leads of your choice to the tabs using regular 60/40 rosin core solder.



Heat top surface of tab directly in contact with solder puddle using a slight pressure on iron tip until solder plating on tab adheres to puddle. Repeat for other tab.



The diode provided prevents discharge of a battery through the panel when the sun isn't shining. Connect to positive (+) lead as shown.



Cover tab with "GOOP™"

