

Date of 1st issue : 19 - 1 - 2005

Date of revision :

PART NUMBER

LPC 423448**NEW GENERATION**

Capacity (Typ.)

660 mAh

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CUSTOMER APPROVAL

Date :

I confirm my project is corresponding to the specification LPC 423448.
I have read the specification (including 8.Safety Warning section),
and I will keep informed my final customer accordingly.

Company Name :

Name :

Sign :

1. Scope

This specification shall be applied to Lithium ion polymer battery- model number LPC 423448.

2. System: Rechargeable Lithium-ion Polymer Battery

3. Cell Model (Marking): 423448

4. Cell Model Number: LPC 423448

5. Ratings

5.1. Nominal Capacity [at 0.2C (126mA)]:	630 mAh (minimum) 660 mAh (typical)
5.2. Nominal Voltage:	3,7V (average voltage at 0,2C discharge).
5.3. Charging Voltage:	4.20 \pm 0.05V
5.4. Max. Charging Current:	630 mA
5.5. Charging Method: constant current constant voltage	
Standard Charge(0,5C):	315 mA (constant current) charge to 4.20V, then 4.2V (constant voltage) for 3.5hr or 13mA (0,02C) cut off.
Quick Charge(1C):	630 mA (constant current) charge to 4.20V, then 4.2V (constant voltage) for 3.0hr or 13mA (0,02C) cut off.
5.6. Max. Continuous Discharge Current:	1260 mA
5.7. Discharge Cut-off Voltage:	2,75 V
5. 8. Cell Dimensions (Refer to the attached drawing)	
Thickness:	4,2 \pm 0,3 mm (measured with weighing 300gf at 25 \pm 2 °C)
Width:	34 \pm 0,5 mm (measured with weighing 300gf at 25 \pm 2 °C)
Length:	48 \pm 1 mm (not including tab length)
5.9. Cell Weight:	13,5 \pm 1,5 g
5.10. Operating Temperature	
Discharge:	-20 °C ~ +60 °C
Charging:	0 °C ~ +45 °C
Storage:	-20 °C ~ +45 °C (for less than 1 month) -20 °C ~ +35 °C (for less than 6 month)

6. Battery Performance

6.1. Visual Inspection

There shall be no such defects as remarkable scratches, cracks, leakage or deformations.

6.2. Standard Test Condition.

6.2.1. Standard Test Condition

Test new cells within one month after shipment from our factory and the cells shall not be cycled over five times before the tests.

All the tests in this specification shall be conducted in an ambient temperature of $+25^{\circ}\text{C} \pm 5^{\circ}\text{C}$ under a humidity of 25% to 85%, unless otherwise specified.

6.2.2. Measuring Instrument or Apparatus

6.2.2.1. The dimension measurement shall be implemented by instruments with equal or more precision seal of 0.01mm.

6.2.2.2. Standard class specified in the national standard or more sensitive class having inner impedance more than 10kOhms /v

6.2.2.3. Impedance shall be measured by a sinusoidal alternating current method(1kHz LCR meter).

6.2.2.4. The current measurement shall be implemented by instruments with equal or more precision scale of $\pm 0.1\%$ and the constant voltage precision shall be implemented with $\pm 0.5\%$, and the Timing precision should be not below 0.1%.

6.2.2.5. The temperature measurement shall be implemented by instrument with equal or more precision seal of $\pm 0.5^{\circ}\text{C}$

6.3. Electrical Characteristics

6.3.1. Standard Charge

The cell shall be charged at a constant current of 315 mA(0,5C) to 4.2V and then at constant voltage of 4.2V with a charging time of 3.5 hours or 13mA (0,02C) cut off.

6.3.2. Rated Capacity (0.2C): 630mAh (minimum)

The capacity shall be measured at a discharge current of 126 mA (0.2C) and a cut-off voltage of 2,75V after the standard charge (Section 6.3.1.)

6.3.3. High Rate Discharge Capacity (1C): 85% (minimum) of Rated Capacity

The capacity shall be measured at a discharge current of 630 mA (1.0C) and a cut-off voltage of 2,75V after the standard charge (Section 6.3.1.)

6.3.4. Low Temperature Discharge Capacity (0°C): 80% (minimum) of Rated Capacity

The capacity shall be measured at a discharge current of 126mA (0.2C) in an ambient temperature of $0^{\circ}\text{C} \pm 2^{\circ}\text{C}$ and a cut-off voltage of 2,75V after the standard charge (Section 6.3.1.)

6.3.5. Low Temperature Discharge Capacity (-10°C): 70% (minimum) of Rated Capacity

The capacity shall be measured at a discharge current of 126mA (0.2C) in an ambient temperature of $-10^{\circ}\text{C} \pm 2^{\circ}\text{C}$ and a cut-off voltage of 2,75V after the standard charge (Section 6.3.1.)

6.3.6. High Temperature Discharge Capacity (60 °C): 100% (minimum) of Rated Capacity

The capacity shall be measured at a discharge current of 126mA (0.2C) in an ambient temperature of 60 °C \pm 2 °C and a cut-off voltage of 2,75V after the standard charge (Section 6.3.1.)

6.3.7. Storage Characteristics (25 °C)

Capacity Retention: 85% (minimum) of Rated Capacity

Capacity Recovery: 90% (minimum) of Rated Capacity

The capacity retention shall be measured at a discharge current of 126mA (0.2C) and a cut-off voltage of 2,75V after standard charge (Section 6.3.1.) and being stored for 28 days at 25 °C \pm 5 °C. Then, the capacity recovery shall be measured at a discharge current of 126mA (0.2C) and a cut-off voltage of 2,75V after standard charge (Section 6.3.1.).

6.3.8. Storage Characteristics (45 °C)

Capacity Retention: 60% (minimum) of Rated Capacity

Capacity Recovery: 70% (minimum) of Rated Capacity

The capacity retention shall be measured at a discharge current of 126mA (0.2C) and a cut-off voltage of 2,75V after standard charge (Section 6.3.1.) and being stored for 28 days at 25 °C \pm 5 °C. Then, the capacity recovery shall be measured at a discharge current of 126mA (0.2C) and a cut-off voltage of 2,75V after standard charge (Section 6.3.1.).

6.3.9. Internal Impedance: 100 mOhms max

The internal impedance shall be measured at a sine wave alternative current process of 1kHz after the standard charge.

6.3.10. Cycle Life:

The cycle life shall be conducted as the following procedures:

- Step 1 charge the cell with the standard charge (as of section 6.3.1);
- Step 2 discharge the cell at 126mA (0.2C) to 2.75V
- Step 3 repeat Step 1 and Step 2 for 500 times.

The capacity after 300 cycles is expected to be equal to or more than 80% of the rated capacity. The capacity after 500 cycles is expected to be equal to or more than 60% of the rated capacity.

6.3.11. Open Circuit Voltage: 3,6V - 4,1V as of shipment.

6.4. Mechanical Performance

6.4.1. Vibration Test 95% (min) of Rated Capacity, No Leakage

After standard charge (Section 6.3.1.), the battery is vibrated with an amplitude of 0.8mm (1.6mm total maximum excursion) for 60 minutes in three mutually perpendicular directions. The vibration is performed between 10Hz and 55Hz at a rate of 1Hz per minute.

After the completion of the vibration, the capacity shall be measured at a discharge current of 126mA (0.2C) and a cut-off voltage of 2,75V

6.5. Environmental Performance

6.5.1. Thermal Shock Test No Leakage, No Fire, No Explosion

The battery is stored at 75 °C \pm 5 °C for 48 hours, moved to a temperature of -20 °C \pm 5 °C within 5 minutes and stored for 6 hours after standard charge (Section 6.3.1.).

6.6. Safety Performance

6.6.1. Short Circuit Test No Fire, No Explosion

After standard charge (Section 6.3.1.), the battery shall be subjected to a short-circuit condition with a wire of resistance less than 50 mOhms for 1 hour.

6.6.2. Overcharge Test [With a PCM] No Fire, No Explosion

After standard charge (Section 6.3.1.), the battery shall be charged at 1C (630mA)/12V for 2.5 hrs.

6.6.3. Thermal Exposure Test No Fire, No Explosion

After standard charge (Section 6.3.1.), the battery is placed in an oven and is heated up at a rate of 5°C until the temperature reaches 130°C. The oven shall be maintained at 130°C for 60 minutes.

7. Delivery Condition: about 50% charged.

8. Lithium Ion Polymer Battery Handling Guideline - SAFETY concerns WARNING

8.1 In case of contacting the materials from a damaged or ruptured cell or battery:

Eye contact: Washing immediately with plenty of water and soap or for at least 15 minutes. Get medical attention.

Skin Contact: Washing immediately with water and soap.

Inhalation of Vented Gas: Remove to fresh air. Get medical attention.

Ingestion: Get medical attention immediately.

8.2 Keep away batteries from children.

8.3 The cells/ batteries are requested to be stored within a proper temperature range specified in this specifications.

8.4 Do not store batteries in a manner that allows terminals to short circuit.

8.5 Do not place batteries near heating sources, nor exposed to direct sunlight for long periods. Elevated temperatures can result in reduced battery service life.

8.6 Charging Battery

Use only approved chargers and procedures. Improperly charging a cell or battery may cause the cell or battery to flame or damage.

Charge the battery using the "CCCV" or constant current /constant voltage method.

Do not charge the battery with a current or voltage higher than the specified maximum value in this specifications. The absolute maximum charging voltage is 4.25V per cell.

Prohibit reverse charging of the battery. The battery must be connected correctly.

8.7 Discharging Battery

Discharge battery at the max current specified in this specification. If you plan to discharge battery at a higher current than the max current, please consult us.

Avoid discharge the battery below 2.75V for each cell.

Do not over-discharge the battery. Over-discharging can damage the performance of the battery. It should be noted that the cell/battery would be at an over-discharged state by its self-discharge characteristics in case the cell is not used for long time. In order to prevent over-discharging, the cell/battery shall be charged periodically to maintain between 3.7V and 4.1V.

8.8 Operation Temperature

The battery shall be operated (stored, charged and discharged) in the temperature specified in this specifications.

8.9 Cell/Battery Protection Circuit Module (PCM)

The cell/battery must be equipped with a PCM that protects the cell/battery from overcharging, overdischarging and over-current.

8.10 Battery Short Circuit

Do not short-circuit a battery. A short circuit can result in over-heating of the terminals and provide an ignition source. More than a momentary short circuit will generally reduce the cell or battery service life and can lead to ignition of surrounding materials or materials within the cell or battery if the seal integrity is damaged. Extended short-circuiting creates high temperature in the cell and at the terminals. Physical contact to high temperatures can cause skin burns. In addition, extended short-circuit may cause the cell or battery to flame.

8.11 Prohibit reversing cell polarity within a battery assembly.

8.12 The cell edge of the heat seal zone is electrically conductive. Avoid the edge cross battery terminals, PCB, or conductive surfaces

8.13 Do not bend, fold or fall the battery or part of the battery. It may cause the battery be damaged and result in the battery swelling, leaking, explosion or ignition

8.14 Do not open or manipulate the folded cell edge.

8.15 Do not bend or fold the sealing edge. And do not tear off the sealing film.

8.16 Battery Pack Design

The battery housing should have sufficient mechanical strength.

No sharp edge components shall be inside the battery housing. The sharp edge may destroy the cell packaging.

No cell movement is allowed in the battery housing.

The ultrasonic head shall not directly/ or indirectly pressed the cell if you need to enclose the battery housing by ultrasonic method. Please consult us for designing the ultrasonic head.

Avoid designing airtight battery housing.

8.17 Battery Assembly

We recommend ultrasonic welding or spot welding to connect battery with PCM or other parts.

If you employ manual solder method to connect tab with PCM, please pay attention to the followings:

Use a solder with temperature controlled and ESD

Soldering temperature should not exceed 350 °C

Soldering time should not be longer than 3s

Soldering times should not exceed 5 times

Keep battery tab cold down before next time soldering.

Do not directly heat cell body. It may cause the battery be damaged by heat above 90 °C

8.18 Battery Disassembly

Never disassemble a battery.

Should a battery unintentionally be crushed, thus releasing its contents, rubber gloves must be used to handle all battery components. Avoid inhalation of any vapors that may be emitted.

8.19 Do not mixed Batteries and Types. Avoid to use old and new cells or cells of different sizes, different chemistry or types in the same battery assembly.

8.20 Other Warnings

Do not heat or dispose the battery into fire, water or other liquids.

Do not put the battery into microwave, washing machine or drying machine.

Do not put the battery onto oven.

Do not use a damaged battery.

8.21 Others

We shall make no liability for problems that occur when the above specifications are not followed.

9. Remarks

If any matters with this specification arises, it shall be revised by mutual agreements.

10. Battery drawing

