

PRODUCT SPECIFICATION

Rechargeable Lithium Ion Battery

Model : 18650HE4 2500mAh



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1. General Information

1.1 Scope

This product specification defines the requirements of the rechargeable lithium ion battery to be supplied to the customer by LG Chem.

1.2 Application: Power Tools

1.3 Product classification: Cylindrical rechargeable lithium ion battery

1.4 Model name: 18650 HE4

2. Nominal Specification

Item	Condition / Note	Specification
2.1 Capacity	Std. charge / discharge	Nominal 2500 mAh (C_{nom})
2.2 Nominal Voltage	Average for Std. discharge	3.60V
2.3.1 Standard Charge (Refer to 4.1.1)	Constant current Constant voltage End condition(Cut off)	1250mA 4.2V 50mA
2.3.2 Fast charge (Refer to 4.1.3)	Constant current Constant voltage End condition(Cut off)	4000mA 4.2V 100mA
2.4 Max. Charge Voltage	-	4.20 \pm 0.05V
2.5 Max. Charge Current	-	4000mA
2.6.1 Standard Discharge (Refer to 4.1.2)	Constant current End voltage(Cut off)	500mA 2.5V
2.6.2 Fast Discharge (Refer to 4.1.3)	Constant current End voltage(Cut off)	10000mA, 20000mA 2.5V
2.7 Max. Discharge Current	For continuous discharge	20000mA
2.8 Weight	Max.	47.0 g
2.9 Operating Temperature (Cell Surface Temperature)	Charge Discharge	0 ~ 50 -20 ~ 75
2.10 Storage Temperature (for shipping state ¹)	1 month 3 month 1 year	-20 ~ 60 -20 ~ 45 -20 ~ 20

* Shipping state : About 40% capacity of fully charged state

3. Appearance and Dimension

3.1 Appearance

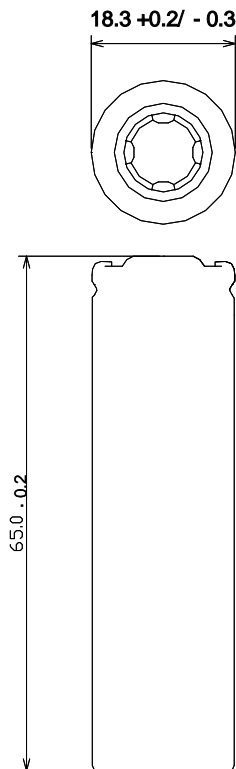
There shall be no such defects as deep scratch, crack, rust, discoloration or leakage, which may affect the commercial value of the cell.

3.2 Dimension

Diameter : $18.3 + 0.2/-0.3$ mm (Max. 18.5 mm)

'LDPHWHU LV GHILQHG DV WKH ODUJHVW GDWD YDOXH PHDVXUHG R

Height : 65.0 ± 0.2 mm (Max. 65.2 mm)



4. Performance Specification

4.1 Standard test condition

4.1.1 Standard Charge

8QOHVV RWKHUZZLVH VSHFLILHG 36WDQGDUG &KDUJH' VKDOO FRQV

The cell shall then be charged at constant voltage of 4.2V while tapering the charge current. Charging shall be terminated when the charging current has tapered to 50mA. For test purposes, charging shall be performed at $23^{\circ}\text{C} \pm 2^{\circ}\text{C}$.

4.1.2 Standard Discharge

Discharge shall be performed at constant current of 500mA to 2.5V. Discharging is to be performed at $23^{\circ}\text{C} \pm 2^{\circ}\text{C}$ unless otherwise noted (such as capacity versus temperature).

4.1.3 Fast Charge / Discharge condition

Cells shall be charged at constant current of 4000mA to 4.2V with end current of 100mA. Cells shall be discharged at constant current of 10000mA and 20000mA to 2.5V. Cells are to rest 10 minutes after charge and 30 minutes after discharge.

4.2 Electrical Specification

Item	Condition	Specification
4.2.1 Initial AC Impedance	Cell shall be measured at 1kHz after charge per 4.1.1.	20 m é, without PTC
4.2.2 Initial Capacity	Cell shall be charged per 4.1.1 and discharged per 4.1.2 within 1h after full charge.	2500 mAh (C_{nom})
4.2.3 Cycle Life	Cells shall be charged and discharged per 4.1.3, 300 cycles(10A) and 200 cycles(20A) .A cycle is defined as one charge and one discharge. 301 st (10A) and 201 st (20A) discharge capacity shall be measured per 4.1.1 and 4.1.2	60 % (of C_{nom} in 2.1)

4.3 Environmental specification.

Item	Condition	Specification
4.3.1 Storage Characteristics	Cells shall be charged per 4.1.1 and stored in a temperature-controlled environment at $23^{\circ}\text{C} \pm 2^{\circ}\text{C}$ for 30 days. After storage, cells shall be discharged per 4.1.2 to obtain the remaining capacity .	Capacity remaining rate $\geq 90\%$ (of C_{nom} in 2.1)
4.3.2 High Temperature Storage Test	Cells shall be charged per 4.1.1 and stored in a temperature-controlled environment at 60°C for 1 week. After storage, cells shall be discharged per 4.1.2 and cycled per 4.1.1 and 4.1.2 for 3 cycles to obtain recovered capacity .	No leakage, Capacity recovery rate 80% (of C_{nom} in 2.1)

* Remaining Capacity : After storage, cells shall be discharged with standard condition(4.1.2) to measure the remaining capacity.

** Recovery Capacity : After storage, cells shall be discharged with standard discharge condition(4.1.2), and then cells shall be charged with standard charge condition(4.1.1), and then discharged with standard discharge condition(4.1.2). This charge / discharge cycle shall be repeated three times to measure the recovery capacity.

4.3.3 Thermal Shock Test	65°C (8h) → 3hrs → -20°C (8h) for 8 cycles with cells charged per 4.1.1 After test, cells are discharged per 4.1.2 and cycled per 4.1.1 and 4.1.2 for 3 cycles to obtain recovered capacity.		No leakage Capacity recovery rate 80% (of C _{nom} in 2.1)
4.3.4 Temperature Dependency of Capacity	Cells shall be charged per 4.1.1 at 23°C ± 2°C and discharged per 4.1.2 at the following temperatures.		
	Charge	Discharge	Capacity
	23	-10	60% (of C _{nom} in 2.1)
		0	80% (of C _{nom} in 2.1)
		23	100% (of C _{nom} in 2.1)
		60	95% (of C _{nom} in 2.1)

4.4 Mechanical Specification

Item	Condition	Specification
4.4.1 Drop Test	Cells charged per 4.1.1 are dropped onto an oak board from 1 meter height for 1 cycle, 2 drops from each cell terminal and 1 drop from side of cell. (Total number of drops =3).	No leakage No temperature rising
4.4.2 Vibration Test	Cells charged per 4.1.1 are vibrated for 90 minutes per each of the three mutually perpendicular axes (x, y, z) with total excursion of 0.8mm, frequency of 10Hz to 55Hz and sweep of 1Hz change per minute.	No leakage

4.5 Safety Specification

Item	Condition	Specification
4.5.1 Overcharge Test	Cells are discharged per 4.1.2, then charged at constant current of 3 times the max. charge condition and constant voltage of 4.2V while tapering the charge current. Charging is continued for 7 hours (Per UL1642).	No explosion, No fire
4.5.2 External Short - Circuiting Test	Cells are charged per 4.1.1, and the positive and negative terminal is connected by a 100 m ³ -wire for 1 hour (Per UL1642).	No explosion, No fire

4.5.3 Overdischarge Test	Cells are discharged at constant current of 0.2C to 250% of the minimum capacity.	No explosion, No fire
4.5.4 Heating Test	Cells are charged per 4.1.1 and heated in a circulating air oven at a rate of 5°C per minute to 130°C. At 130°C, oven is to remain for 10 minutes before test is discontinued (Per UL1642).	No explosion, No fire
4.5.5 Impact Test	Cells charged per 4.1.1 are impacted with their longitudinal axis parallel to the flat surface and perpendicular to the longitudinal axis of the 15.8mm diameter bar (Per UL1642).	No explosion, No fire
4.5.6 Crush Test	Cells charged per 4.1.1 are crushed with their longitudinal axis parallel to the flat surface of the crushing apparatus (Per UL1642).	No explosion, No fire

5. Caution

Warning for using the lithium ion rechargeable battery. Mishandling of the battery may cause heat, fire and deterioration in performance. Be sure to observe the following.

5.1 Cautions for Use and Handling

- y : KHQ XVLQJ WKH DSSOLFDFWLRQ HTXLSSHG ZLWK WKH EDWWHU\ UHI
- y Please read the specific charger manual before charging.
- y Charge time should not be longer than specified in the manual.
- y When the cell is not charged after long exposure to the charger, discontinue charging.
- y Battery must be charged at operating temperature range 0 ~ 45 .
- y Battery must be discharged at operating temperature range -20 ~ 60 .
- y Please check the positive (+) and negative(-) direction before packing.
- y When a lead plate or wire is connected to the cell for packing, check out insulation not to short-circuit.
- y Battery must be stored separately.
- y Battery must be stored in a dry area with low temperature for long-term storage.
- y Do not place the battery in direct sunlight or heat.
- y Do not use the battery in high static energy environment where the protection device can be damaged.
- y When rust or smell is detected on first use, please return the product to the seller immediately.
- y The battery must be away from children or pets
- y When cell life span shortens after long usage, please exchange to new cells.

5.2 Prohibitions

- y Do not use different charger. Do not use cigarette jacks (in cars) for charging.
- y Do not charge with constant current more than maximum charge current.
- y Do not disassemble or reconstruct the battery.
- y Do not throw or cause impact.
- y Do not pierce a hole in the battery with sharp things. (such as nail, knife, pencil, drill)
- y Do not use with other batteries or cells.
- y Do not solder on battery directly.
- y Do not press the battery with overload in manufacturing process, especially ultrasonic welding.
- y Do not use old and new cells together for packing.
- y Do not expose the battery to high heat. (such as fire)
- y Do not put the battery into a microwave or high pressure container.
- y Do not use the battery reversed.
- y Do not connect positive(+) and negative(-) with conductive materials (such as metal, wire)
- y Do not allow the battery to be immersed in or wetted with water or sea-water.

5.3 Caution for the battery and the pack

Pack shall meet under condition to maintain battery safety and last long performance of the lithium rechargeable cells.

5.3.1 Installing the battery into the pack

- The cell should be inspected visually before battery assembly into the pack.
- Damaged cell should not be used. (damaged surface, can-distortion, electrolyte-smell)
- Different Lot Number cells should not be packaged into the same pack.
- 'LIIHUHQW W\SHV RI FHOOV RU VDPH W\SHV EXW GLIIHUHQW FHO

5.3.2 Design of battery pack

- The battery pack should not be connected easily to any charger other than the dedicated charger.
- The battery pack has function not to cause external short cut easily.

5.3.3 Charge

- Charging method is Constant Current-Constant Voltage (CC/CV).
- Charging should be operating under maximum charge voltage and current which is specified in the product specification. (Article. 2.4, 2.5)
- The battery should be charged under operating temperature specified in product specification. (Article. 2.9)

5.3.4 Discharge

- Discharging method is Constant Current (CC).
- Discharging should be operating under maximum discharge current which is specified in the product specification. (Article. 2.7)
- Discharging should be done by cut off voltage which is specified in the product specification. (Article. 2.6)
- The battery should be discharged under operating temperature specified in product specification. (Article. 2.9)

5.3.5 Protection Circuit

- The protection circuit should be installed in the battery pack, charger.
- Charger or pack should have voltage sensing system to control over charge or discharge in order to PDLQWDLQ WKH EDWWHU\¶V QRUPDO RSHUDWLQJ PRGH DQG SURW
- Charger or pack should have warning system for over temperature, over voltage and over current.