

TENTATIVE

Date 6/Apr./05

**SANYO LITHIUM ION
BATTERY SPECIFICATIONS**

BATTERY CLASSIFICATION LITHIUM ION BATTERY

BATTERY TYPE UR18650F

PURCHASER AboCom Systems, Inc.

[ACCEPTANCE]

Accepted by: _____

Name in block letters: _____

Date: _____

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	1/12
-------	--	------	------

1. Extent of the application

This specification is applied to the SANYO Lithium Ion Battery of the above mentioned type for a Portable Media Player of AboCom Systems, Inc..

2. Battery Classification and Type

- 2.1 Battery Classification SANYO Lithium Ion Battery
- 2.2 Battery Type UR18650F

3. Nominal Specifications

Item	Specification	Remark
3.1 Nominal Capacity	2500mAh	0.2CA discharge
3.2 Nominal Voltage	3.7V	
3.3 End Voltage	2.75V	
3.4 Charging Current (Std.)	1.75A	0 ~ +40°C
3.5 Charging Voltage	4.20V	Tolerance is ±0.03V
3.6 Charging Time (Std.)	3hours	
3.7 Discharging Current (Std.)	1.0C(=2.5)A	-20 ~ +60°C
3.8 Discharging Current (Max.)	5.0A	0 ~ +40°C
3.9 Internal Resistance	Less than 100mΩ	AC Impedance 1kHz
3.10 Weight	Less than 49g	
3.11 Surroundings Temperature range for shipped battery	Less than 1month	-20 ~ +60°C
	Less than 3months	-20 ~ +40°C
	Less than 1year	-20 ~ +20°C

※Percentage of recoverable capacity
= (discharging time after storage/Initial discharging time) × 100

Discharging time is measured by the discharge at 0.2CA to 2.75V end voltage after fully charged according to specification at approximately 25°C.

No.	Date	Remark	No.	Date	Remark
	6/Apr./'05	Issue(Tentative)	(b)		
(a)			(c)		

File No.	UR1865-968	Lithium-Ion Central Business Unit
----------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)		Page	2/12
4. Electrical Characteristics				
Item	Test Method		Criterion	
4.1 Charge Full Charge	The charger supply 1.75A constant current until battery voltage reaches 4.20V, then be changed at constant voltage of 4.20V while tapering the charge current. Charging time is 3.0 hours in all.			
4.2 Capacity	<p>① Within 1hour after fully charged, discharge at 0.2C(=0.5)A continuously down to 2.75V end voltage.</p> <p>② Within 1hour after fully charged, discharge at 1.0C(=2.5)A continuously down to 2.75V end voltage.</p>		<p>More than 300min.</p> <p>More than 54min.</p>	
4.3 Cycle Life	A battery unit shall be repeated 300 charge/discharge cycles, charged at CC-CV (1.75 A-4.20V) for 3.0hours, discharged at 2.5A to 2.75V end voltage. After 300cycles, discharging time is measured as specified in paragraph 4.2 ②.		More than 38min.	
4.4 Temperature	<p>① Within 1hour after fully charged at 20°C, a battery unit is stored at 0°C. Discharge time is measured by discharging at 1.0C(=2.5)A continuously down to 2.75V end voltage.</p> <p>② Within 1hour after fully charged at 20°C, a battery unit is stored at 60°C. Discharge time is measured by discharging at 1.0C(=2.5)A continuously down to 2.75V end voltage.</p>		<p>More than 35min.</p> <p>More than 50min.</p>	
4.5 Full Charged State Storage	<p>① After fully charged, stored for 10days at 60°C and rested at room temperature for 1hour. Discharge time is measured by discharging at 1.0C(=2.5)A continuously down to 2.75V end voltage.</p> <p>Then next discharge time is measured as specified in paragraph 4.2 ②.</p>		<p>More than 35min.</p> <p>More than 45min.</p>	
File No	UR1865-968	Lithium-Ion Central Business Unit		

Title	Specifications of Lithium Ion battery (Cylindrical Type)	page	3/12
	<p>②After fully charged, stored for 20days at 60°C and rested at room temperature for 1hour. Discharge time is measured by discharging at 1.0C(=2.5)A continuously down to 2.75V end voltage.</p>	more than 30min.	
4.6 Full Discharged State Storage	<p>Then next discharge time is measured as specified in paragraph 4.2 ②.</p> <p>After fully charged and discharged as specified in paragraph 4.2 ②, then store for 20days at 60°C and rest at room temperature for 1hour. Discharging time is measured as specified in paragraph 4.2 ②.</p>	more than 40min.	more than 50min.
4.7 Drop	The cell is freely dropped 6 times from a height of 1m onto a flat surface of hard wood.	No electrical charge.	

STANDARD TEST CONDITIONS:

The battery used for the test mentioned above should be new one delivered a week before at most. The test shall be performed at 20±2°C(Standard temperature of fifth grade adopted in *JIS Z 8703*(Standard Test Conditions)), 65±5%(Standard humidity of twentieth grade adopted in *JIS Z 8703*(Standard Test Conditions)). It is allowed however to test at 15~25°C, 45~85% humidity, as long as there is no big difference in test results. The battery used for the test without residual capacity indicator. The grade of voltmeter and ammeter used in the test shall be higher than class 0.5 adopted in *JIS C 1102*(Electric Indicator).

5. Design, Construction

A battery unit shall be of the design, construction and physical dimensions shown in the attached drawing. (Drawing No. NUR18650F-27101)

6. Appearance

There shall be no practical damage such as conspicuous liquid electrolyte leakage, flaw electrolyte leakage, flaw, rust, dirt, and deformation. The battery must have marketability.

7. Shipment

The battery shall be shipped in 40% charged state.

The battery shall be charged in 40% (2.5A×24minutes = 1000mAh) at SANYO.

It is not specified more than 40% capacity remain at AboCom Systems, Inc., because of self discharge.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	page	4/12
-------	--	------	------

8. Precautions on Design of Portable Media Player, Charger and Battery Pack

8-1. Precautions on Design of Portable Media Player and charger.

① Charge

- A battery must be charged with constant current-constant voltage.
- In case of UR18650F, charge current must be below 2.5A/cell.
- Charging voltage must be set 4.20V/cell.
Concerning charge voltage tolerance of charger, charging voltage must be set below 4.23V/cell. Even if the charge could be out of order, charge voltage of charger should not be above 4.35V/cell.
- Have pre-charge system in charger.
In case of a battery voltage is below 3.0V, a battery should be charged with pre-charge that current is below 0.25A. Then a battery voltage reach over 3.0V, standard charge starts. And if a battery voltage never reach to 3.0V in specified period (timer), charger stop charging.
- Have full charge detection in charger.
By timer, current detection and open circuit voltage detection, charger detects full charge. When charger detect full charge, charger stop charging.
- Do not use the continuous charging (trickle charging) method.
- Charger should start charging at temperature range 0~40°C.

② Discharge

- Discharge current must be below 5.0A/cell.
- Discharge temperature range should be -20~60°C.
- Discharge end voltage must be over 2.75V/cell.

③ Over-discharge

- Do not over-discharge a battery below 2.0V/cell.

④ Battery position in Portable Media Player and charger.

- To avoid degradation of battery performance by heat, a battery should set the place apart from heat generating electronic parts inside Portable Media Player and charger.

8-2. Precautions on Battery Pack Design.

① Battery pack Shape, Mechanism and Material

- Do not make the shape which easy connect to other chargers exclusive of charger.
- Do not make the shape and mechanism which easy use another equipment exclusive of Portable Media Player and charger.
- Do not make the terminal shape which easy cause short circuit by metal object such as necklaces, hairpins, etc. And further, have over current protection function to prevent outer short circuit.
- Do not make the terminal shape and mechanism which connect reverse to equipment.
- Do not make the shape and mechanism which static electricity and water easy go through the battery pack inside.
- Make the shape and mechanism which can inspect protection circuit function (specified paragraph 8-2②) before the battery pack makes completely.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)		Page	5/12
<ul style="list-style-type: none"> · Fix cells with mold case by rib, tape, glue etc., but do not make damage cells (especially sealing part) by rib or sharp part of mold case. In case of the battery pack is struck by hard shock or vibration, the battery pack has possibility to cause leakage, smoke, explosion. · Weld mold case by glue. Not weld mold case by ultra sonic welding. <p>② Protection Circuit</p> <p>Have protection circuit function which is described below inside battery pack, to insure safety of battery in case of misuse.</p> <ul style="list-style-type: none"> · Overcharge Protection At the voltage range 4.24~4.35V/cell by charge, overcharge protection should work. Then charge current shall be shut down. · Over discharge Protection At the voltage range 2.2~2.4V/cell, over discharge protection should work. Then discharge current shall be shut down and consumption current is below 1μA. · Over discharge Current Protection When discharge current exceed about 5.0A, over discharge current protection should work. Then over discharge current shall be shut down. <p>③ Electric circuit</p> <ul style="list-style-type: none"> · To avoid to discharge during storage, design the low consumption current electronic circuit(e.g. Protection circuit, fuel gauge, etc) inside battery pack. <p>④ Battery connection</p> <ul style="list-style-type: none"> · Do not solder onto a battery in order to avoid a damage on the battery. Weld spot welding lead plate onto battery, and solder lead wire or lead plate. <p>⑤ Precautions on label</p> <ul style="list-style-type: none"> · Write maker's name, trade mark, maker's nation, model number and precautions on label. Precautions are based on chapter 14. Write the precaution manual based on chapter 14. <p>9. Storage Condition</p> <p>9-1 Storage Temperature and Humidity</p> <ul style="list-style-type: none"> · Store the battery at temperature range -20~+35°C, low humidity and no corrosive gas atmosphere. · No condensation on the battery. <p>* Lithium ion battery is not suitable for a back up usage or a long term storage usage. (Emergency Light, Uninterruptible power supply, Memory back up, etc.)</p>				
File No	UR1865-968	Lithium-Ion Central Business Unit		

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	6/12
-------	--	------	------

9-2 Long Period Storage

- In case of long period storage (more than 3 months), store the battery at temperature range -20~+20°C, low humidity, no corrosive gas atmosphere.
And in this case, charge condition of the battery is Sanyo shipment charge state or discharge state.
- No condensation on the battery.

10. Precautions on Handling Lithium Ion Cells

In term of shipping and assembling the battery pack, this chapter describes precautions on handling Sanyo lithium ion cells, which are assembled for Portable Media Player's battery packs by AboCom Systems, Inc.. This battery pack consists of UR18650F.

10-1 Precautions on series connection of cell

- When the cells are connected in series, use same rank cells, use same lot number cells and use same charging date cells. These date show label for carton on the master carton. Further, the cell's voltage has to be checked and confirm the voltage to be within 20mV voltage difference.
- * Lot number (= shipping week) on carton label.

10-2 Precautions on terminals of cell

- Do not over-stress or rotate at positive terminal plate and negative cap.
By over-stress, it has possibility to remove the welding point and cause leakage or short circuit.

10-3 Inspection Before Shipment of The Battery pack

- About all battery pack, inspect voltage, internal impedance and function of protection circuit before shipment.

10-4 Packing and shipping cells

- When cells are re-shipped to assembling factory, make enough attention the packing to avoid stress by shipping.
Sanyo recommends the same package shipped from Sanyo when re-shipping.
Even if after open package, when re-shipping, use the same parts and materials from Sanyo for re-packing.

10-5 Abnormal cell

- Do not use abnormal cell which has damages by shipping stress, drop, short or something else, and which gives off electrolyte odor.

11. Exemption from Warrantee

- Sanyo will not be responsible for trouble occurred by handling outside of the precautions in this specification.
- Sanyo will not be responsible for trouble occurred by matching electric circuit, battery pack, Portable Media Player and charger.
- Sanyo will be exempt from warrantee any defect cells during assembling after acceptance.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	7/12
-------	--	------	------

12. Other Remarks

- If there are problems in this specification, Sanyo can consider to change specification after discussion.
- About the things not covered by this specification, Sanyo will have discussion.
- Do not use this cell for other models or equipment.

13. Standard Charging Method

- (1) The battery voltage fall to about 0V by storage. If the battery is rapidly charged at this state, FET of a protection circuit may generate heat. The charger must have the pre-charge system.
- (2) Pre-charge current of charger should be approximately 0.1C(=0.25)A. When the battery voltage becomes 3.0V, standard charge should be started. When the battery voltage is less than 3.0V even after the set period of timer, charging should be stopped.
- (3) Rapid charge is 1.75A-4.20V (Constant current-constant voltage).
Charging should be suspended when the time, OCV or current is certain value.
- (4) Charge current of charger must not exceed 2.5A.
- (5) The battery could be swelled or worked the current interrupt device by continuous charging, especially under the high temperature atmosphere.
Therefore, do NOT use the continuous charging (trickle charging) method or the short term re-charging (supplementary charging) method.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	8/12
-------	--	------	------

14. Safety Instruction

Prohibition Points on Handle

The battery pack includes the flammable objects such as the organic solvent. If the handling is missed there will be possibility that the battery rupture flames or hot, or it will cause the deterioration or damage of battery. Please observe the following prohibitive matters. And also, add the protection device the equipment for fear that the trouble would affect the battery by the abnormality of equipment. In addition, mention the following matters as "Prohibition Points on Handle" in the instruction manual of the equipment.

I D a n g e r

1. Disassemble and Reconstruction

"Do not disassemble or reconstruct battery"

The battery pack has safety function and protection circuit to avoid the danger. If they have serious damage, it will cause the generating heat, smoke, rupture or flame.

2. Short-circuit

"Do not short-circuit battery"

Do not connect the + and - terminals with metals (such as wire). Do not carry or store the battery with metal objects (such as wire, necklace or hairpins). If the battery is short-circuited, excessive large current will flow and then the generating heat, smoke, rupture or flame will occur. And also, it causes generating heat at metals.

3. Incineration and Heating

"Do not incinerate or heat the battery"

These occur the melting of insulator, damage of gas release vent or safety function, or ignition on electrolyte. Above mentioned matters cause the generating heat, smoke, rupture or flame.

4. Use nearby Heated Place

"Do not use or leave battery nearby fire, stove or heated place(more than 80°C)"

In case that separator made of polymer is melted by high temperature, the internal short-circuit occurs in individual cells and then it causes the generating heat, smoke, rupture or flame. In addition, do not use the battery under the heated place (more than 80°C) for same reason.

5. Immersion

"Do not immerse the battery in water or sea water, or get it wet"

If the protection circuit included in the battery is broken, the battery will be charged at extreme current or voltage and the abnormal chemical reaction occurs in it. And then it causes the generating heat, smoke, rupture or flame.

6. Charge nearby heated place

"Do not charge battery nearby the fire or under the blazing sun"

If the protection circuit to avoid the danger works under high temperature or it is broken, the battery will be charged at abnormal current (or voltage) and abnormal chemical reaction will occur. It causes the generating heat, smoke, rupture or flame.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	9/12
-------	--	------	------

7. Charger and Charge Condition

"Do not use the specified charger and observe charging requirement"

If the battery is charged with unspecified condition (under high temperature over the regulated value, excessive high voltage or current over regulated value, or remodeled charger), there are cases that it will be overcharged or the abnormal chemical reaction will occur in cells. It causes the generating heat, smoke, rupture or flame.

8. Penetration

"Do not drive a nail into the battery, strike it by hammer, or tread it"

As the battery might be broken or deformed and then it will be short-circuited, it causes the generating heat, smoke, rupture or flame.

9. Impact

"Do not give battery impact or throw it"

The impact might cause leakage, heat, smoke, rupture, and/or fire of cell in the battery. And also if the protection circuit in the battery is broken, the battery will be charged at abnormal voltage or current, and abnormal chemical reaction might occur. It might cause leakage, heat, smoke, rupture, and/or fire.

10. Deformation

"Do not use the battery with conspicuous damage or deformation"

It causes the generating heat, smoke, rupture or flame.

11. Soldering

"Do not make the direct soldering on battery"

As the insulator is melted by heat or the gas release vent (or safety function) is broken, it causes the generating heat, smoke, rupture or flame.

12. Reverse Charge and Overdischarge

"Do not reverse polarity (and terminals)"

On charging, the battery is reverse-charged and abnormal chemical reaction occurs. And also, there may be case that unexpected large current flows on discharging. These cause the generating heat, smoke, rupture or flame.

13. Reversed Polarity Use

"Do not reverse-charge or reverse-connect"

The battery has polarity. In case the battery is not connected with charger or equipment smoothly, do not force them to connect and do check polarity of battery. If the battery is connected to opposite polarity with charger, it will be reverse-charged and abnormal chemical reaction will occur. It causes the generating heat, smoke, rupture or flame.

14. Connect Battery To the Plug

"Do not connect battery to the plug socket or car-cigarette-plug"

Added high voltage to the battery, the excessive current will flow in it and then it will cause the generating heat, smoke, rupture or flame.

15. Inappropriate Use For Other Equipment

"Do not use battery for other equipment"

If the battery is used for unspecified equipment, it will deteriorate its performance and cycle-life. At worst, abnormal current will flow or battery may generate heat, smoke, rupture or flame.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	10/12
-------	--	------	-------

16. Leakage

"Do not touch a leaked battery directly"

In case the leaked electrolyte gets into eyes, wash them with fresh water as soon as possible without rubbing eyes. And then, see a doctor immediately.

If leave damaged eyes undone, it will cause eye-trouble.

! W a r n i n g

1. Mixed Use

"Do not use Lithium ion battery in mixture"

Do not use Lithium ion battery with the primary batteries or secondary batteries whose capacity or kinds or maker is different. If do that, the battery will be discharged or charged excessively in use. And it may cause the generating heat, smoke,rupture or flame because of the abnormal chemical reaction in cells.

2. Ingestion

"Keep the battery away from babies"

Keep the little battery out of the reach of babies in order to avoid troubles by Swallowing. In case of swallowing the battery, see a doctor immediately.

3. Charging Time

"Do not continue to charge battery over specified time"

If the battery is not finished charging over regulated time, let it stop charging. There is possibility that the battery might generate heat, smoke, rupture or flame.

4. Store

"Do not get into a microwave or a high pressure container"

It causes the generating heat, smoke, rapture or flame because of a sudden heat or damage of sealing condition of battery.

5. Leakage

"Do not use a leaked battery nearby fire"

If the liquid leaks from the battery (or the battery gives out bad smell), let the battery leave from flammable objects immediately. Unless do that, the electrolyte leaked from battery will catch fire and it will cause the smoke, flame or rupture of it.

6. Rust, Changing color and Deformation

"Do not use an abnormal battery"

In case the battery has bad smell or is generated its changing color or deformation or causes something wrong in using (includes charging and storage), let it take out from equipment or charger and do not use it. If an abnormal battery is used, it will generate heat, smoke, rupture or flame.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	11/12
-------	--	------	-------

! C a u t i o n

1. Use under strong sunshine

Do not use or leave the battery under the blazing sun(or in heated car by sunshine).
The battery may generate heat, smoke or flame. And also, it might cause the deterioration of battery's characteristics or cycle life.

2. Static Electricity

The battery pack has the protection circuit to avoid the danger. Do not use nearby the place where generates static electricity (more than 100V) which gives damage to the protection circuit. If the protection circuit were broken, the battery would generate smoke, rupture or flame.

3. Charging Temperature Range

Charging temperature range is regulated between 0°C and 40°C. Do not charge the battery out of recommended temperature range. Charging out of recommended range might cause the generating heat or serious damage of battery. And also, it might cause the deterioration of battery's characteristics and cycle life.

4. Manual

Please read the manual before using the battery and let it keep after reading.
And also, please reread if necessary.

5. Charging Method

Please read the manual of specified charger about charging method.

6. First time use

When the battery has rust, bad smell or something abnormal at first-time-using, do not use the equipment and go to bring the battery to the shop which it was bought.

7. Used by children

In case younger children use the battery, their parents teach how to use batteries according to the manual with care. And also, when children are using the batteries, pay attention to use it according to that or not.

8. Keep Battery away from children

Keep the battery out of the reach of younger children. And also, using the battery, pay attention to be taken out it from the charger or equipment by little children.

9. Leakage

If the skin or cloth is smeared with liquid from the battery, wash with fresh water.
It may cause the skin inflammation.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

Title	Specifications of Lithium Ion battery (Cylindrical Type)	Page	12/12
-------	--	------	-------

15. Warranty Period of Battery

The warranty period of a battery is for one year after shipment. However, even if a battery is unusual within this period, SANYO will replace a new battery for free as long as it is clear that the problem is the failure of battery manufacturing process and the battery isn't used at the abnormal usage.

16. Requirement for Safety Assurance

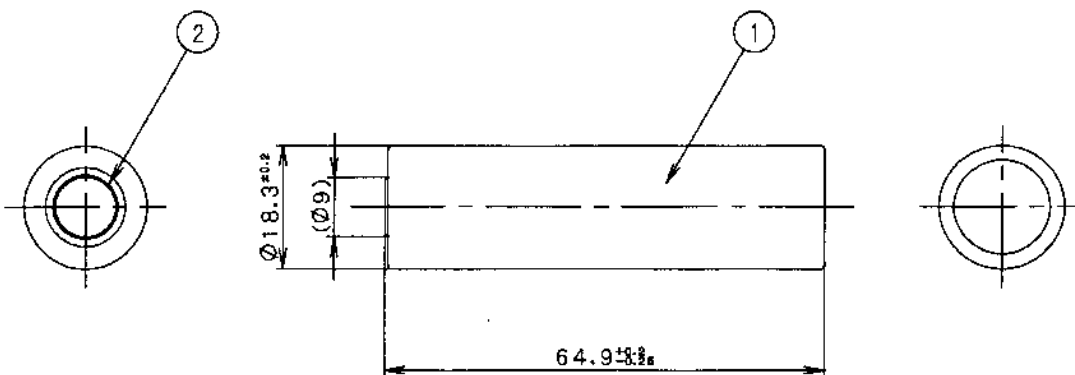
For the sake of safety assurance, please discuss the equipment design, its system and protection circuit of Lithium ion battery with SANYO in advance. And also, consult SANYO about the high rate current, rapid charge and special application such as extreme condition and / or environment.

17. Effectiveness of This Specification

- ① This specification has effectiveness for 6 months.
- ② In case of AboCom Systems, Inc. receives permanent specification, please abrogate or send back this specification to SANYO.
- ③ The standardized figure stated in this specification is tentative value.

File No	UR1865-968	Lithium-Ion Central Business Unit
---------	------------	-----------------------------------

NO.	PART NAME	APPLICATION PART CODE	QTY.	MATERIAL SPECIFICATION	NOTE
	BATTERY		1	UR18650F	SHIPPING WITH CHARGE
1	TUBE		1	PO 0.12t	RED
2	INSULATION RING		1	PAPER 0.25t	LIGHT BLUE



NOTE.

1. STAMP LOT NO. ON THE TUBE.

XXXX
 ↑ CHANGED CAREER (A, B, C, Z)
 ↑ WEEK (01, 02, ... 48, 49, ... 53)
 ↑ YEAR ('96=A, '97=B, ... '05=J, '06=K, ...)
 EX.) APR.-5.2005.....J15A

DRAWING NOT TO SCALE

DATE		REMARK		△		
APR.-5.2005				△		
DR	Y. Akagasi	MODEL:UR18650F-ABW		SYM	DATE	DESCRIPTION
CHK	Y. Iketani	CUSTOMER CODE:ABW				
CHK		TOLERANCE	WEIGHT			
		25<L	±5			
ENG		<L	±			
		50<L	±4			
APP	K. Nakata	100<L	±3			
		L	±2			
		QTY	SCALE	UNIT	製品名	完成電池
		1	1/1	mm	PART NAME	BATTERY PACK(finish goods)
					PART CODE	
					DRAWING NO	NUR18650F-27101
					Rev.	