

4. Visual Inspection

There shall be no such defects as remarkable scratches, cracks, bolts, cup cancers, deformations, swelling, leakage.

5. Detailed Specification

5.1 Electrical specification

Items	Test conditions	Results
5.1.1 Full charge <standard charge>	Under $20\pm 5^{\circ}\text{C}$, $65\pm 5\%\text{RH}$, it can be charged to 4.2V with constant current of $0.2 C_5\text{mA}$, and then, charged continuously with constant voltage of 4.2V until the charged current is less than $0.02 C_5\text{mA}$.	Remark: it is standard charge method
5.1.2 Rated capacity	Under $20\pm 5^{\circ}\text{C}$, charge the cell according to above charging method, then, keep it for 0.5-1hrs. Discharge the cell with constant current $0.2C_5\text{mA}$ to 2.75V, the discharging time is not less than 5 hours.	$\geq 4500\text{mAh}$
5.1.3 Cycle life	Discharge the cell with constant current $0.2C_5\text{mA}$ to 2.75V firstly, then, charged it for 2.5hrs by quick charging, keep it for 30mins. Discharge it with current $1C_5\text{mA}$ to 2.75V, this is one cycle. To do the cycle test for 300^{\dagger} times.	Capacity \geq at least 80% of the rated capacity
5.1.4 Internal impedance	At 1kHz AC with fully charge state	Initial battery pack $\leq 180\text{m}\Omega$
5.1.5 Temperature performance	Hi-temperature: At $20\pm 5^{\circ}\text{C}$, charge the cell according to standard charge, then, keep it in the oven of $55\pm 2^{\circ}\text{C}$ for 2hrs. Discharge the cell with constant current of $0.5 C_5\text{mA}$ to 2.75V, the discharging time should be not less than 51 minutes.	
	Low temperature: At $20\pm 5^{\circ}\text{C}$, charge the cell according to standard charge, then, keep it in the oven of $-20\pm 2^{\circ}\text{C}$ for 16 ~ 24 hrs. Discharge the cell with constant current $0.2 C_5\text{mA}$, the discharge time should be not less than 3hrs.	
	Constant temperature & humidity: At $20\pm 5^{\circ}\text{C}$, charge the cell according to standard charge, then, keep it in $40\pm 2^{\circ}\text{C}$ & $90\sim 95\%\text{RH}$ for 48hrs, after this, keep the cell in $20\pm 5^{\circ}\text{C}$ for 2hrs. Discharge the cell with constant current of $0.5 C_5\text{mA}$ to 2.75V, the discharge time should be not less than 36mins.	
5.1.6 Storage	Storage for 28 days at 25°C .	Capacity $\geq 80\%$
	Storage for 7 days at 60°C .	Capacity $\geq 85\%$

5.1.7 Open circuit voltage	As of shipment	3.7 – 4.0V
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6.1 Mechanical specification

Items	Test conditions
6.2.1 Vibration test	At 20±5°C & normal atmospheric pressure, charge the cell according to standard charge. Then, vibrated it 10 times in each direction of X, Y, Z with changing frequency of 10~55HZ and amplitude of 0.35mm, the rate of scan frequency is from 10~55HZ per min. After above test, to keep the battery at 20±5°C for 30mins, the battery cannot be break, scratch, distortion, contamination and leakage, and the Voltage is not less than 3.6V.
6.2.2 Free fall testing	At 20±5°C, charge the cell by standard charging, then drop it freely for six times in each direction of X, Y, Z from the height of 1000mm onto the hard board with the thickness of 20mm. After above testing, to keep the cell at (20±5)°C for 1-2hrs, the cell cannot be break, scratch, distortion, contamination and leakage. Discharge the cell to 2.75V with constant current 0.2 C ₅ mA, it should be discharged and the discharge time should be not less than 51 minutes.

6.3Secure Specification

Items	Test conditions
6.3.1 Impact Testing	At 20±5°C, full charge the cell by standard charge, then, place the cell on the impact flat, a 10kgs weight dropped from 1m height onto cell, distortion is allowed. After above testing, to keep the battery at 20±5°C for 1-2hrs, the cell should be not exploded or catch fire.
6.3.2 Heat impact testing	Put the cell into a air oven, the temperature in the oven should rise at the rate of speed of (5±2°C)/min to be 130°C±2°C, keeping the temperature for 30 min, the cell should be not explosion, fire or fume.
6.3.3 Short-circuit test	At 20±5°C, full charged the cell by standard charge firstly, short-circuited it by max resistance of 50mΩ by connecting the positive and negative terminals of cell with copper wire, Monitor its temperature while testing, finish the test when the cell case temperature was 10°C lower than the peak temperature. The cell should be not explosion, fire.
6.3.4 Over-charged test	Connect the cell with a CC/CV power, then, charge the cell to 4.6V with constant 3A current, and last for 2hrs. The cell shall be not explode and fire.
6.3.5 Over-discharged test	At 20±5°C, charged the cell by standard charge firstly, then, discharge it with constant current 0.2 C ₅ mA to 2.75V. Connected with external load of 30Ω for 24hrs. The cell shall be not explode or fire.

7. Test Conditions