



Specification Approval Sheet

Name : Li-Ion cell

Model : AKYGA INR18650-22M

SPEC : 3.7V / 2200mAh

Specification Modification Records

Modification Time	Descriptions	Issued Date	Approved By
	Release 1	2024-01-22	

Content



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1 Scope

This specification is applied to the reference battery in this Specification and manufactured by Akyga battery.

2 Product Specification

Table 1

No.	Item	General Parameter		Remark
1	Rated Capacity	Nominal	2200mAh	Standard discharge (0.2C ₅ A) after Standard charge
		Minimum	2150mAh	
2	Nominal Voltage	3.7V		Mean Operation Voltage
3	Voltage at end of Discharge	2.75V		Discharge Cut-off Voltage
4	Charging Voltage	4.2V		Charge Cut-off Voltage
5	Internal Impedance	≤52mΩ		Internal resistance measured at AC 1KHz after 50% charge The measure must uses the new batteries that within one week after shipment and cycles less than 5 times
6	Standard charge	Constant Current 0.2C ₅ A Constant Voltage 4.2V 0.02 C ₅ A cut-off		Charge time : Approx 6.0h
7	Standard discharge	Constant current 0.2C ₅ A end voltage 2.75V		
8	Fast charge	Constant Current 0.5C ₅ A Constant Voltage 4.2V 0.02 C ₅ A cut-off		Charge time : Approx 3.0h



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Continuous the table 1

No.	Item	General Parameter	Remark
9	Fast discharge	Constant current 1.0C ₅ A end voltage 2.75V	
10	Maximum Continuous Charge Current	1.0C ₅ A	Charge time : Approx 1.5h
11	Maximum Continuous Discharge Current	1.0C ₅ A	Maximum instantaneous discharge current 2.0C ₅ A < 3S
12	Operation Temperature Range	Charge : 0~45°C	65 ±20%R.H. Bare Cell
		Discharge : -20~55°C	
13	Storage Temperature Range	Less than 1 year: -10~35°C	65 ±20%R.H. at the shipment state
		less than 3 months: -20~45°C	
14	Cell Dimension	Height: 65.0 ±0.3mm	Initial Dimension
		Diameter: 18.0 ±0.3mm	
15	Cell Weight	Approx 45.2g	

3 Performance And Test Conditions

3.1 Standard Test Conditions

Test should be conducted with new batteries within one week after shipment from our factory and the cells shall not be cycled more than five times before the test. Unless otherwise specified, test and measurement shall be done under temperature of $25 \pm 2^\circ\text{C}$ and relative humidity of 45~85%. If it is judged that the test results are not affected by such conditions, the tests may be conducted at temperature 15~30°C and humidity 25~85%RH.

3.2 Measuring Instrument or Apparatus

3.2.1 Dimension Measuring Instrument

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

3.2.2 Voltmeter

Standard class specified in the national standard or more sensitive class having inner impedance more than 10k Ω /V

3.2.3 Ammeter

Standard class specified in the national standard or more sensitive class. Total external resistance including ammeter and wire is less than 0.01 Ω .

3.2.4 Impedance Meter

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

3.3 Standard Charge\Discharge

3.3.1 Standard Charge : Test procedure and its criteria are referred as follows:

Charging shall consist of charging at a $0.2C_5A$ constant current rate until the cell reaches 4.2V. 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 $0.02C_5A$. Charge time : Approx 6.0h, The cell shall demonstrate no permanent degradation when charged between 0 °C and 45 °C.

3.3.2 Standard Discharge

$0.2C_5A$

Cells shall be discharged at a constant current of $0.2C_5A$ to 2.75V @ $25 \pm 2^\circ\text{C}$

3.3.3 If no otherwise specified, the rest time between Charge and Discharge amount to 30min.



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3.4 Appearance

There shall be no such defect as flaw, crack, rust, leakage, which may adversely affect commercial value of battery.

3.5 Initial Performance Test

Table 2

Item	Test Method and Condition	Requirements
Open-Circuit Voltage	The open-circuit voltage shall be measured within 24 hours after standard charge.	$\geq 4.1V$
Internal impedance	Internal resistance measured at AC 1KHz after 50% charge.	$\leq 52m\Omega$
Minimal Rated Capacity	The capacity on $0.2C_5A$ discharge till the voltage tapered to 2.75V shall be measured after rested for 30min then finish standard charge.	Discharge Capacity $\geq 2150mAh$

3.6 Temperature Dependence of discharge capacity

Cells shall be charged per 3.3.1 and discharged @ $0.2C_5A$ to 2.75V. Except to be discharged at temperatures per Table 3. Cells shall be stored for 3 hours at the test temperature prior to discharging and then shall be discharged at the test temperature. The capacity of a cell at each temperature shall be compared to the capacity achieved at 25 °C and the percentage shall be calculated. Each cell shall meet or exceed the requirements of Table 3.

Table 3

Discharge Temperature	-20°C	0°C	25°C	55°C
Discharge Capacity ($0.2C_5A$)	60%	90%	100%	95%

3.7 Cycle Life and Leakage-Proof

Table 4

No.	Item	Criteria	Test Conditions
1	Cycle Life	Higher than 80% of the Initial Capacities of the Cells (80%)	Carry out 300cycle Charging/Discharging in the below condition. ◆ Charge:0.2C ₅ A Charge, per 3.3.1 ◆ Discharge:0.5C ₅ A to 3.0 V ◆ Rest Time between charge/discharge:30min. ◆ Temperature:25±2℃
2	Leakage-Proof	No leakage (visual inspection)	After full charge with standard charge, store at 60±3℃, 60±10%RH for 1 month.

4. Mechanical characteristics and Safety Test

Table 5

(Mechanical characteristics)

No.	Items	Test Method and Condition	Criteria
1	Vibration Test	After standard charging, fixed the cell to vibration table and subjected to vibration cycling that the frequency is to be varied at the rate of 1Hz per minute between 10Hz an 55Hz, the excursion of the vibration is 1.6mm. The cell shall be vibrated for 30 minutes per axis of XYZ axes.	No leakage No fire
2	Drop Test	The cell is to be dropped from a height of 1 meter twice onto concrete ground.	No explosion, No fire, no leakage.

Table 6

(Safety Test)

No.	Items	Test Method	Requirements
1	Short Circuit	Each test sample battery, in turn, is to be short-circuited by connecting the (+) and (-) terminals of the battery with a Cu wire having a maximum resistance load of 0.1Ω. Tests are to be conducted at room temperature(20±2°C).	No explosion, No fire The Temperature of the surface of the Cells are lower than 150°C
2	Short Circuit	Each test sample battery, in turn, is to be short-circuited by connecting the (+) and (-) terminals of the battery with a Cu wire having a maximum resistance load of 0.1Ω. Tests are to be conducted at temperature(60±2°C).	No explosion, No fire The Temperature of the surface of the Cells are lower than 150°C
3	Over charge	Battery charged at 1C rate to 5.0V and kept the voltage constant until the current detection to 0.02C cut-off	No explosion, No fire
4	Over discharge	Battery Discharge at 1C till the voltage reaches to 0V, at room temperature(25±2°C)	No explosion, No fire

5. Handling of Cells

5.1 Prohibition short circuit

Never make short circuit cell. It generates very high current which causes heating of the cells and may cause electrolyte leakage, gassing or explosion that are very dangerous. The Li tabs may be easily short-circuited by putting them on conductive surface. Such outer short circuit may lead to heat generation and damage of the cell. An appropriate circuitry with PCM shall be employed to protect accidental short circuit of the battery pack.



6. Notice for Designing Battery Pack

6.1 Pack toughness

Battery pack should have sufficient strength and the Li cell inside should be protected from mechanical shocks.

6.2 Cell fixing

The cell should be fixed to the battery pack by its large surface area.

No cell movement in the battery pack should be allowed.

6.3 Inside design

No sharp edge components should be inside the pack containing the Li cell.

6.4 Tab connection

Ultrasonic welding or spot welding is recommended for Li tab connection method.

Battery pack should be designed that shear force are not applied to the Li tabs.

If apply manual solder method to connect tab with PCM, below notice is very important to ensure battery performance:

- The solder iron should be temperature controlled and ESD safe;
- 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;
- Directly heat cell body is strictly prohibited, Battery may be damaged by heat above approx. 90 °C

6.5 For mishaps

Battery pack should be designed not to generate heat even when leakage occurs due to mishaps.

- 1) Isolate PCM (Protection Circuit Module) from leaked electrolyte as perfectly as possible.
- 2) Avoid narrow spacing between bare circuit patterns with different voltage.
(Including around connector)
- 3) Li battery should not have liquid from electrolyte, but in case If leaked electrolyte touch bare circuit patterns, higher potential terminal material may dissolve and precipitate at the lower potential terminal, and may cause short circuit. The design of the PCM must have this covered.

7. Others

7.1.Cell connection

- 1) Direct soldering of wire leads or devices to the cell is strictly prohibited.
- 2) Lead tabs with pro-soldered wiring shall be spot welded to the cells.Direct soldering may cause damage of components, such as separator and insulator, by heat generation.

7.2.Prevention of short circuit within a battery pack

Enough insulation layers between wiring and the cells shall be used to maintain extra safety protection.The battery pack shall be structured with no short circuit within the battery pack, which may cause generation of smoke or firing.

7.3.Prohibition of disassemble

- 1) Never disassemble the cells.
The disassembling may generate internal short circuit in the cell, which may cause gassing, firing, explosion, or other problems.
- 2) Electrolyte is harmful.
Li battery should not have liquid from electrolyte flowing, but in case the electrolyte come into contact with the skin, or eyes, physicians shall flush the electrolyte immediately with fresh water and medical advice is to be sought.

7.4.Prohibition of dumping of cells into fire

Never incinerate nor dispose the cells in fire. These may cause explosion of the cells, which is very dangerous and is prohibited.

7.5.Prohibition of cells immersion into liquid such as water

The cells shall never be soaked with liquids such as water, seawater, drinks such as soft drinks, juices, coffee or others.



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7.6. Battery cells replacement

The battery replacement shall be done only by either cells supplier or device supplier and never be done by the user.

7.7. Prohibition of use of damaged cells

The cells might be damaged during shipping by shock. If any abnormal features of the cells are found such as damages in a plastic envelop of the cell, deformation of the cell package, smelling of an electrolyte, an electrolyte leakage and others, the cells shall never be used any more.

The Cells with a smell of the electrolyte or a leakage shall be placed away from fire to avoid firing or explosion.

8. Storing the Batteries

The batteries should be stored at room temperature, charged to about 30% to 50% of capacity.

We recommend that batteries be charged about once per half a year to prevent over discharge.

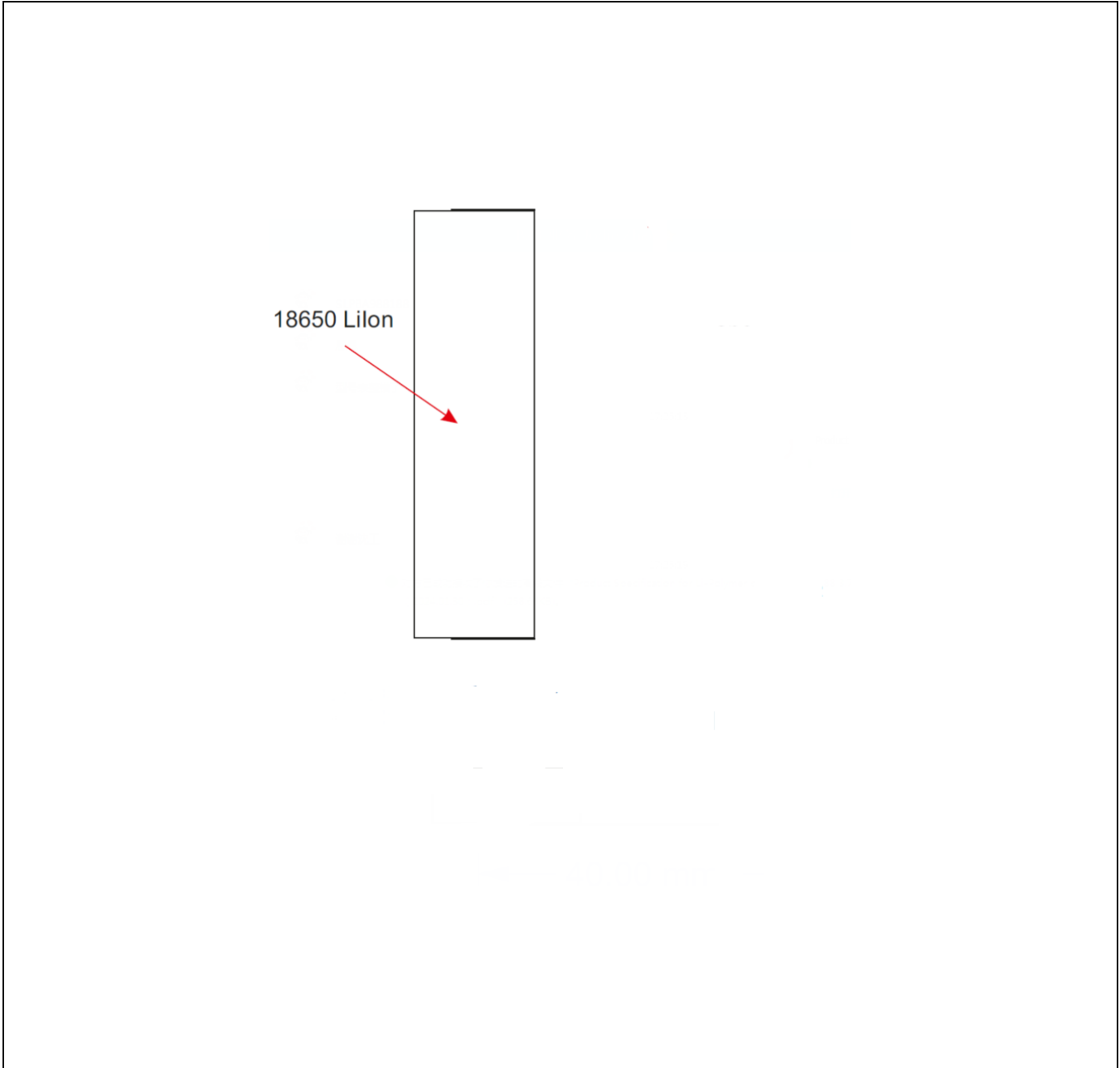
9. Other The Chemical Reaction

Because batteries utilize a chemical reaction, battery performance will deteriorate over time even if stored for a long period of time without being used. In addition, if the various usage conditions such as charge, discharge, ambient temperature, etc. are not maintained within the specified ranges the life expectancy of the battery may be shortened or the device in which the battery is used may be damaged by electrolyte leakage. If the batteries cannot maintain a charge for long periods of time, even when they are charged correctly, this may indicate it is time to change the battery.

10. Note:


Any other items which are not covered in this specification shall be agreed by customer and Akyga battery.

11. Battery Dimensions/



18650 Lilon



	18.5±0.3mm		
Height	65.0±0.3mm		
	ICR18650-22M3.7V 2200mAh		
	BATTERY DRAWING		
Drawing ID			