

# Chapter 4

## Batteries with Terminals and Soldering Lithium Batteries



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# Batteries with Terminals

## Highly Reliable Terminal Welding

### (1) Terminal welding by laser

Panasonic adopted the laser welding method to solder battery terminal onto the printed circuit board.

In the comparison of 20φ series battery, while the tensile strength of conventional resistance welding method was 20-50N (about 2 to 5 kgf), laser welding method was 100N (about 10kgf) and the variations was compressed to 1/2.

By using the laser welding method, terminal welding on a thin battery (1.4mm in thickness) is able to perform. Since strengthening the welding etc. became unnecessary, battery could be widely used to many applications.

obviating eliminating the need for reinforcement or other such means.

### (2) Execution of pre-soldering

The tips of the terminals are pre-soldered in order to enhance the reliability of the soldering.



## Complete Line-up

Panasonic offers a full range of batteries with terminals for PCB mounting. Since the terminals come in a variety of types, please contact Panasonic for further details. A more limited selection of simple battery holders to support the batteries is also available.

# Soldering

### (1) Using a soldering iron

Do not allow the soldering iron to make direct contact with the bodies of the batteries. Proceed with the soldering quickly within 5 seconds while maintaining the iron tip temperature at about 350°C, and do not allow the temperature of the battery bodies to exceed 85°C. (Heat resistance BR type is 125°C)

### (2) Automatic dip-soldering bath

Soldering with a dip-soldering bath can be used by condition but do not allow the temperature of the battery bodies exceed 85°C. It is important to note, depending on the temperature conditions inside the dipping device, that the battery body temperature may rise after dipping due to the residual heat retained. When a post-dipping temperature rise is observed, review the temperature conditions and consider a dipping time reduction or a way of forcibly cooling the batteries after dipping.

#### Basic conditions

Solder dipping bath temperature	Not exceed 260°C
Dipping duration	Within 5 sec.
Number of dipping	Within 2 times



## Never Use Reflow Soldering

Please do not carry out re-flow welding except for the re-flow corresponding batteries (ML-R and NBL-R). Never use reflow soldering since doing so directly heats the battery surface to high temperatures, causing electrolyte leakage, deterioration of battery characteristics and risking bursting or ignition.

## Cautions

Example where the terminals were soldered straight onto a coin-type lithium battery, the terminals were connected to a PC board or other electronic components, and the heat generated by the soldering adversely affected the battery, resulting in a deterioration of the battery characteristics:

The heat generated when terminals are mounted using solder causes lithium to melt.

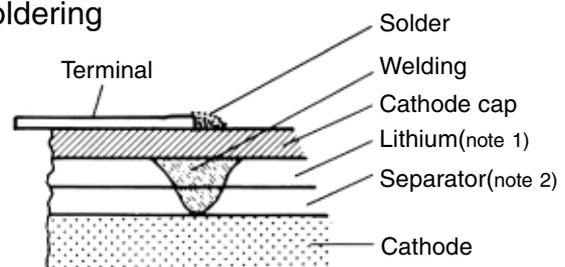
The separator melts and becomes perforated.

The positive and negative poles are welded together, causing "internal shorting."

In terms of the battery characteristics, the open-circuit voltage and electrical capacity are both reduced.

The battery loses its functions or it bursts in rare cases.

## Soldering



(note 1) Metal whose melting point is about 180°C

(note 2) Non woven cloth of polypropylene whose melting point is about 165°C