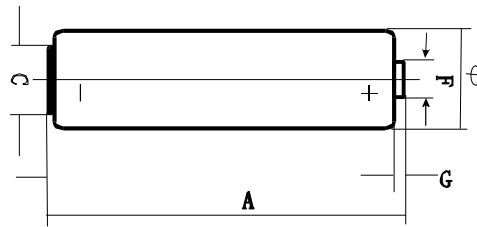


1. Product drawing

/	min	max
Φ	33.0	34.0
A	59.6	61.0
C	26.0	27.0
F	8.0	9.0
G	2.5	3.0



2. Scope:

This specification is applicable to ULTRA alkaline cell, LR20 distributed under brandname RAVER.

3. Law & Regulation Compliances:

This product complies with EU's battery directive (2006/66/EC).

Packaging materials comply with EU's directive on packaging materials and waste (94/62/EC)

4. General:

4.1 Type designation

IEC/ JIS LR20

ANSI 13A

Common D

4.2 Chemical system: Zn/KOH-H₂O/MnO₂

4.3 Nominal voltage: 1.5 V

4.4 Weight: Approximate 140 g

4.5 Dimension: The dimensions shall be in accordance with the below figures both prior to and after service output test. Measuring equipment shall be with an accuracy ±0.05mm at least.

4.6 Capacity: Approximate 18000mAh (25mA, 24h/d, 20±2°C, e.v.= 0.8V)

4.7 Operation temperature : -20°C ~ 60°C

Recommend storage temperature : Not exceed 30°C

5. Appearance

The battery visually inspected by unaided eye 30cm away from battery. The battery shall be free from dents, scratch, rust and extruded internal compounds, such as sealing compounds and etc, and serious displacement of artwork. Appearance defects shall not be observed that may adversely affect actual use or performance of batteries.

6. Electrical Characteristics

Unless otherwise stated, all measurements are to be performed at a Standard Environment of 20 ± 2°C; 55 ± 20% RH.

All samples are normalized for 8 hours at least at the above environment prior to measurement.

The digital voltmeter (DCM) is with the precision of 1mV (internal resistance not less than 1 Megohm). The load resistance of the total circuit is accurate within ±0.5% of the specified value.



6.1 Open circuit voltage and closed circuit voltage (Load resistance 1.0Ω, 0.3S)

		OCV(V)	CCV(V)	S.C.(A) (reference)
Initial	Min	1.57	1.30	7.5
	Normal	1.60	1.38	12.0
Stored 1 year	Min	1.55	1.20	5.5
	Normal	1.57	1.30	9.0

6.2 Service output

Load	2.2Ω	600mA	1.5Ω	2.2Ω	10Ω
Test mode	24h/d	2h/d	4m/15m,8h/d	1h/d	4h/d
End voltage	0.9V	0.9V	0.9V	0.8V	0.9V
Unit	h	h	h	h	h
Applications	Reference	Portable stereo	Portable lighting	Toy	Radio
Initial	MAD	17.5	14.5	12.5	22.0
	Normal	19.0	16.0	14.0	24.5
Stored 1 year	MAD	17.0	13.5	11.5	20.0
	Normal	18.0	15.5	13.5	23.0

m: minute h: hour d: day

Remark:

- 1) The initial discharge test shall commence within 30 days of manufacture. During stored period, the cells shall be stored under room temperature conditions.
- 2) Lot release service output test is conducted by 2.2Ω continuous discharging to 0.9volts
- The batteries shall not leak during the service life test before the end voltage reached.

7. Leakage Resistance

7.1 Over discharge leakage test

Test conditions: 20±2°C & RH 60±15%, 2.2Ω continuous discharge 48h.

Number of test samples: 9 batteries

Requirement: No visible leakage; No explosion.

7.2 High temperature leakage test

Test conditions: store 20 days under 60±2°C, then store 4~24h under standard environment.

Number of test samples: 24 batteries

Requirement: No visible leakage; No explosion.



8. Security Characteristics

8.1 User Drop Test

This test simulates the situation when a battery is accidentally dropped.

Test conditions: Undischarged test batteries shall be dropped from a height of 1 m onto a concrete surface. Each test battery shall be dropped six times, twice in each of the three axes. The test batteries shall be stored for 1 h afterwards.

Number of test sets: 5 batteries

Requirement: No fire, No explosion or leakage after 1hour OCV maintenance rate is 95% over

8.2 Short-circuit explosion-proof characteristics

This test simulates an external short circuit of a battery during daily handling of batteries.

Test conditions: Positive and negative terminals of an undischarged battery shall be connected directly. The circuit shall be completed for 24 h or until the battery case temperature has returned to ambient. The resistance of the inter-connecting circuitry shall not exceed 0,1 Ω .

Number of test samples: 5 batteries

Requirement: No fire or explosion; Leakage is allowable.

8.3 Incorrect installation

This test simulates incorrect installation of a battery in a series application.

Test conditions: 4 undischarged batteries are used per test. 3 batteries are placed correctly in series; the 4th battery is reversed with respect to polarity. The circuit is maintained until venting occurs or the reversed battery temperature has returned to ambient.

Number of test sets: 5 (20 batteries)

Requirement: No fire or explosion; Leakage is allowable.

9. Expiry Date Marking:

9.1 Unless otherwise specified, each battery will carry a manufacturing date code followed by month and year of expiry for export.

9.2 Expiry date is 7 years from the date of manufacture and is stated on the battery jacket/packing..

10. Packaging Requirements

10.1 The total of heavy metal lead, cadmium, mercury, and hexavalent chromium concentration shall not exceed 100 ppm in Packaging materials and printing inks. Ozone depleting substances (ODS) shall not be used in the manufacturing of any packaging.

The printing on each cell label is legible and permanent. Label defects, if any, shall conform to mutually agreed upon limit samples.

10.2 It is recommended that packaging for shipment and sales according to following packaging specification: 2pcs cells in a blister, 12 blisters in a display box, 4 display boxes in a final outer carton.

10.3 Otherwise packaging for shipment and sales shall conform to the mutually agreed to packaging specification of the designated customers.



11. Component / Information of Ingredients

Chemical Nature: Alkaline zinc-manganese dioxide batteries

MATERIALS	APPROXIMATE PERCENT OF TOTAL WEIGHT (%)	CAS NO.	MATERIALS	APPROXIMATE PERCENT OF TOTAL WEIGHT (%)	CAS NO.
Manganese Dioxide (MnO ₂)	~41.5	1313-13-9	Brass	~1.3	12597-71-6
Zinc Powder (Zn)	~16.5	7440-66-6	Fe	~15.0	7439-89-6
Water (H ₂ O)	~11.5	7732-18-5	Ni-plating	~0.18	7440-02-0
Potassium Hydroxide (KOH)	~7.2	1310-58-3	Bi	<0.005	7440-69-9
Carbon	~2.5	7782-42-5	In	<0.005	7440-74-6

Chart 1. Discharge diagram

