

US Patent & Trademark Office

Patent Public Search | Text View

United States Patent	12394825
Kind Code	B2
Date of Patent	August 19, 2025
Inventor(s)	Seok; Hoon

Method of manufacturing all-solid-state battery using roll press process

Abstract

An embodiment method of manufacturing an all-solid-state battery includes forming a first electrode member by forming first active material layers on both surfaces of a first current collector, pressing the first electrode member to form a pressed first electrode member, forming a second electrode member by forming second active material layers on both surfaces of a second current collector and forming solid electrolyte layers on the second active material layers, pressing the second electrode member to form a pressed second electrode member, forming a laminated body by layering the pressed first electrode member and the pressed second electrode member, and pressing the laminated body by passing the laminated body between a pair of rollers to form a pressed laminated body.

Inventors: Seok; Hoon (Suwon-si, KR)

Applicant: Hyundai Motor Company (Seoul, KR); Kia Corporation (Seoul, KR)

Family ID: 1000008765474

Assignee: HYUNDAI MOTOR COMPANY (Seoul, KR); KIA CORPORATION (Seoul, KR)

Appl. No.: 18/789836

Filed: July 31, 2024

Prior Publication Data

Document Identifier	Publication Date
US 20240396091 A1	Nov. 28, 2024

Foreign Application Priority Data

KR	10-2020-0154426	Nov. 18, 2020
----	-----------------	---------------

Related U.S. Application Data

continuation parent-doc US 17504059 20211018 US 12080854 child-doc US 18789836

Publication Classification

Int. Cl.: H01M10/05 (20100101); H01M4/04 (20060101); H01M10/0525 (20100101); H01M10/056 (20100101); H01M10/058 (20100101); H01M10/0585 (20100101); B32B37/02 (20060101); H01M10/04 (20060101); H01M10/0562 (20100101); H01M10/0583 (20100101)

U.S. Cl.:

CPC H01M10/0585 (20130101); H01M4/0435 (20130101); H01M10/0525 (20130101); H01M10/056 (20130101); H01M10/058 (20130101); B32B37/02 (20130101); B32B2250/05 (20130101); B32B2457/10 (20130101); H01M10/0468 (20130101); H01M10/0562 (20130101); H01M10/0583 (20130101); Y10T156/1049 (20150115)

Field of Classification Search

CPC: H01M (10/0562); H01M (4/058); H01M (10/058); B32B (37/02)

References Cited

U.S. PATENT DOCUMENTS

Patent No.	Issued Date	Patentee Name	U.S. Cl.	CPC
5840087	12/1997	Gozdz et al.	N/A	N/A
12080854	12/2023	Seok	N/A	H01M 10/056
2004/0096733	12/2003	Shibamoto et al.	N/A	N/A
2018/0316042	12/2017	Kuhara	N/A	N/A
2020/0028156	12/2019	Zhang et al.	N/A	N/A

Primary Examiner: Dodds; Scott W

Attorney, Agent or Firm: SLATER MATSIL, LLP

Background/Summary

CROSS-REFERENCE TO RELATED APPLICATIONS (1) This application is a continuation application and claims the benefit of U.S. application Ser. No. 17/504,059, filed on Oct. 18, 2021, which application claims the benefit of Korean Application No. 10-2020-0154426, filed on Nov. 18, 2020, which applications are hereby incorporated herein by reference.

TECHNICAL FIELD

(1) The present disclosure relates to a method of manufacturing an all-solid-state battery using a roll press process.

BACKGROUND

(2) An all-solid-state battery includes a three-layered laminated body of a cathode active material

layer bonded to a cathode current collector, an anode active material layer bonded to an anode current collector, and a solid electrolyte layer disposed between the cathode active material layer and the anode active material layer.

(3) Because the all-solid-state battery includes an electrolyte layer in a solid state, an ultra-high-pressure pressing process is performed in order to improve the interfacial adhesive strength between the solid electrolyte layer and each active material layer and ionic conductivity during the manufacturing process thereof.

(4) However, when the ultra-high-pressure pressing process is performed, the following problems are very likely to occur. 1) The pressing causes physical damage to the laminated body, resulting in a short circuit and/or a sharp decline in cell performance. 2) Production costs are increased due to the decrease in processability caused by application of ultra-high pressure and due to the addition of equipment for the purpose of deformation control.

(5) Therefore, there is a need for a new manufacturing method to overcome the above-described limitations of the all-solid-state battery.

SUMMARY

(6) Therefore, embodiments of the present disclosure can solve problems encountered in the related art, and specific embodiments thereof are as follows.

(7) An embodiment of the present disclosure provides a method of manufacturing an all-solid-state battery having dimensional stability and cell performance equivalent or superior to those of the related art even without performing an ultra-high-pressure pressing process.

(8) The embodiments of the present disclosure are not limited to the foregoing, and will be able to be clearly understood through the following description and to be realized by the means described in the claims and combinations thereof.

(9) A method of manufacturing an all-solid-state battery according to an embodiment of the present disclosure includes forming first active material layers on both surfaces of a first current collector to obtain a first electrode member, pressing the first electrode member, forming second active material layers on both surfaces of a second current collector and forming solid electrolyte layers on the second active material layers to thus obtain a second electrode member, wherein the forming of the second electrode member occurs before any pressing of the second electrode member, pressing the second electrode member, layering the pressed first electrode member and the pressed second electrode member to obtain a laminated body, and pressing the laminated body by passing the laminated body between a pair of rollers.

(10) The pressing the first electrode member may include applying a pressure so that the pressed first electrode member has a thickness of 80 to 90% of a thickness before the pressing.

(11) The first electrode member may be pressed by being passed between the pair of rollers.

(12) The pressing the second electrode member may include applying a pressure so that the pressed second electrode member has a thickness of 80 to 90% of a thickness before the pressing.

(13) The second electrode member may be pressed by being passed between the pair of rollers.

(14) The pressing the laminated body may include applying a pressure so that the pressed laminated body has a thickness of 70 to 80% of a thickness before the pressing.

(15) The pressed laminated body may have a thickness of 100 to 300 μm .

(16) In the manufacturing method, each of the first electrode member and the second electrode member may be formed so as to have a length larger than a width, and the first electrode member and the second electrode member may be layered so that one longitudinal end of the second electrode member coincides with one longitudinal end of the first electrode member and so that a remaining longitudinal end of the second electrode member protrudes a predetermined length farther than a remaining longitudinal end of the first electrode member, thereby obtaining the laminated body.

(17) The predetermined length of the remaining protruding end of the second electrode member may be 1/20 to 1/40 of the total length of the second electrode member.

- (18) The manufacturing method may further include, after the laminated body is pressed, folding the second electrode member so that the remaining protruding end of the second electrode member surrounds the remaining end of the first electrode member.
- (19) The manufacturing method may further include consecutively folding the laminated body in the direction in which the remaining end of the second electrode member is folded.
- (20) According to embodiments of the present disclosure, it is possible to obtain an all-solid-state battery having dimensional stability and cell performance equivalent or superior to those of the related art even without performing an ultra-high-pressure pressing process.
- (21) The effects of embodiments of the present disclosure are not limited to the foregoing, and should be understood to include all effects that can be reasonably anticipated from the following description.
-

Description

BRIEF DESCRIPTION OF THE DRAWINGS

- (1) FIG. 1 is a flowchart showing a process of manufacturing an all-solid-state battery according to embodiments of the present disclosure;
- (2) FIG. 2 is a cross-sectional view showing a part of a first electrode member according to embodiments of the present disclosure;
- (3) FIG. 3 is a perspective view showing a part of the first electrode member according to embodiments of the present disclosure;
- (4) FIG. 4 is a cross-sectional view showing a part of a second electrode member according to embodiments of the present disclosure;
- (5) FIG. 5 schematically shows a laminated body according to embodiments of the present disclosure being passed between a pair of rollers so as to be pressed;
- (6) FIG. 6A is a reference view for explaining a process of layering a first electrode member and a second electrode member according to embodiments of the present disclosure;
- (7) FIG. 6B shows a state in which a remaining end of the second electrode member according to embodiments of the present disclosure is folded so as to surround the first electrode member;
- (8) FIG. 6C schematically shows a folding-type all-solid-state battery according to embodiments of the present disclosure;
- (9) FIG. 7A shows the result of analyzing the cross section of the all-solid-state battery according to a Comparative Example using a scanning electron microscope (SEM); and
- (10) FIG. 7B shows the result of analyzing the cross section of the all-solid-state battery according to an Example of the present disclosure using a scanning electron microscope (SEM).

DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

- (11) The above and other objectives, features and advantages of embodiments of the present disclosure will be more clearly understood from the following preferred embodiments taken in conjunction with the accompanying drawings. However, the present disclosure is not limited to the embodiments disclosed herein, and may be modified into different forms. These embodiments are provided to thoroughly explain the disclosure and to sufficiently transfer the spirit of the present disclosure to those skilled in the art.
- (12) Throughout the drawings, the same reference numerals will refer to the same or like elements. For the sake of clarity of the present disclosure, the dimensions of structures are depicted as being larger than the actual sizes thereof. It will be understood that, although terms such as “first”, “second”, etc. may be used herein to describe various elements, these elements are not to be limited by these terms. These terms are only used to distinguish one element from another element. For instance, a “first” element discussed below could be termed a “second” element without departing from the scope of the present disclosure. Similarly, the “second” element could also be termed a

“first” element. As used herein, the singular forms are intended to include the plural forms as well, unless the context clearly indicates otherwise.

(13) It will be further understood that the terms “comprise”, “include”, “have”, etc., when used in this specification, specify the presence of stated features, integers, steps, operations, elements, components, or combinations thereof, but do not preclude the presence or addition of one or more other features, integers, steps, operations, elements, components, or combinations thereof. Also, it will be understood that when an element such as a layer, film, area, or sheet is referred to as being “on” another element, it can be directly on the other element, or intervening elements may be present therebetween. Similarly, when an element such as a layer, film, area, or sheet is referred to as being “under” another element, it can be directly under the other element, or intervening elements may be present therebetween.

(14) Unless otherwise specified, all numbers, values, and/or representations that express the amounts of components, reaction conditions, polymer compositions, and mixtures used herein are to be taken as approximations including various uncertainties affecting measurement that inherently occur in obtaining these values, among others, and thus should be understood to be modified by the term “about” in all cases. Furthermore, when a numerical range is disclosed in this specification, the range is continuous, and includes all values from the minimum value of said range to the maximum value thereof, unless otherwise indicated. Moreover, when such a range pertains to integer values, all integers including the minimum value to the maximum value are included, unless otherwise indicated.

(15) FIG. 1 is a flowchart showing a method of manufacturing an all-solid-state battery according to embodiments of the present disclosure. Referring thereto, the manufacturing method includes forming first active material layers on both surfaces of a first current collector to obtain a first electrode member at step S1, pressing the first electrode member at step S2, forming second active material layers on both surfaces of a second current collector and forming solid electrolyte layers on the second active material layers to thus obtain a second electrode member at step S3, pressing the second electrode member at step S4, layering the pressed first electrode member and second electrode member to obtain a laminated body at step S5, and pressing the laminated body by passing the laminated body between a pair of rollers at step S6.

(16) FIG. 2 is a cross-sectional view showing a part of a first electrode member 10. Referring thereto, the first electrode member 10 may include a first current collector 11 and first active material layers 12 formed on both surfaces thereof. The polarity of the first electrode member 10 may be a positive or negative polarity.

(17) When the first electrode member 10 has a positive polarity, the first electrode member may include a cathode current collector and cathode active material layers formed on both surfaces thereof.

(18) The cathode current collector may be a piece of aluminum foil.

(19) The cathode active material layer may include a cathode active material, a solid electrolyte, a conductive material, and a binder.

(20) The cathode active material may be an oxide active material or a sulfide active material.

(21) The oxide active material may be a rock-salt-layer-type active material such as $\text{LiCoO}_{0.5}\text{O}_{1.5}$, $\text{LiMnO}_{0.5}\text{O}_{1.5}$, $\text{LiNiO}_{0.5}\text{O}_{1.5}$, $\text{LiVO}_{0.5}\text{O}_{1.5}$, or $\text{Li}_{1-x}\text{Ni}_x\text{O}_{1.5}$ ($0 < x < 1$), a spinel-type active material such as LiMn_2O_4 or $\text{Li}(\text{Ni}_{0.5}\text{Mn}_{1.5})\text{O}_4$, a reverse-spinel-type active material such as LiNiVO_4 or LiCoVO_4 , an olivine-type active material such as LiFePO_4 , LiMnPO_4 , LiCoPO_4 , or LiNiPO_4 , an active material containing silicon such as $\text{Li}_2\text{FeSiO}_4$ or $\text{Li}_2\text{MnSiO}_4$, a rock-salt-layer-type active material, such as $\text{LiNi}_{0.8}\text{CO}_{0.2}\text{Al}_x\text{O}_{1.2}$ ($0 < x < 0.2$), in which a part of a transition metal is replaced with a dissimilar metal, a spinel-type active material in which a part of a transition metal is replaced with a dissimilar metal, such as

$\text{Li}_{1-x}\text{Mn}_{2-x-y}\text{M}_y\text{O}_4$ (where M is at least one of Al, Mg, Co, Fe, Ni, and Zn

and $0 < x + y < 2$), or a lithium titanate such as $\text{Li.sub.2Ti.sub.5O.sub.12}$.

(22) The sulfide active material may be copper chevrel, iron sulfide, cobalt sulfide, or nickel sulfide.

(23) The solid electrolyte may be an oxide solid electrolyte or a sulfide solid electrolyte. However, it may be preferable to use a sulfide-based solid electrolyte having high lithium ionic conductivity. The sulfide-based solid electrolyte is not particularly limited, but may be Li.sub.2S — P.sub.2S.sub.5 , Li.sub.2S — P.sub.2S.sub.5 — LiI , Li.sub.2S — P.sub.2S.sub.5 — LiCl , Li.sub.2S — P.sub.2S.sub.5 — LiBr , Li.sub.2S — P.sub.2S.sub.5 — Li.sub.2O , Li.sub.2S — P.sub.2S.sub.5 — Li.sub.2O — LiI , Li.sub.2S — SiS.sub.2 , Li.sub.2S — SiS.sub.2 — LiI , Li.sub.2S — SiS.sub.2 — LiBr , Li.sub.2S — SiS.sub.2 — LiCl , Li.sub.2S — SiS.sub.2 — B.sub.2S.sub.3 — LiI , Li.sub.2S — SiS.sub.2 — P.sub.2S.sub.5LiI , Li.sub.2S — B.sub.2S.sub.3 , Li.sub.2S — P.sub.2S.sub.5 — Z.sub.mS.sub.n (where m and n are positive numbers and Z is any one of Ge , Zn , and Ga), Li.sub.2S — GeS.sub.2 , Li.sub.2S — SiS.sub.2 — Li.sub.3PO.sub.4 , Li.sub.2S — SiS.sub.2 — Li.sub.xMO.sub.y (where x and y are positive numbers, and M is any one of P , Si , Ge , B , Al , Ga , and In), or $\text{Li.sub.10GeP.sub.2S.sub.12}$.

(24) The conductive material may be carbon black, conductive graphite, ethylene black, or graphene.

(25) The binder may be BR (butadiene rubber), NBR (nitrile butadiene rubber), HNBR (hydrogenated nitrile butadiene rubber), PVDF (polyvinylidene difluoride), PTFE (polytetrafluoroethylene), or CMC (carboxymethylcellulose).

(26) In the step of obtaining the first electrode member **10** at step **S1**, the method of forming the first active material layers **12** on the first current collector **11** is not particularly limited. For example, a slurry containing the components of the first active material layers **12** may be applied on the first current collector **11**, or the first active material layers **12** may be transferred onto the first current collector **11**, thus obtaining the first electrode member **10**.

(27) FIG. **3** is a perspective view showing a part of the first electrode member **10**. Referring thereto, the first electrode member **10** may be formed so as to have a length L larger than a width W .

(28) In embodiments of the present disclosure, the first electrode member **10** and the second electrode member **20** are each pre-pressed prior to main pressing on the laminated body that includes the first electrode member **10** and the second electrode member **20** layered therein, thereby preventing deformation of the laminated body caused by the main pressing.

(29) Specifically, the step of pressing the first electrode member **10** at step **S2** may include applying a pressure so that the first electrode member **10** has a thickness of 80 to 90% of a thickness before the pressing. The pressure may be applied on the first electrode member **10** in a variety of ways. For example, the first electrode member **10** may be isostatically pressed, or may be passed between a pair of rollers so as to be roll-pressed.

(30) FIG. **4** is a cross-sectional view showing a part of the second electrode member **20**. Referring thereto, the second electrode member **20** may include a second current collector **21**, second active material layers **22** formed on both surfaces of the second current collector **21**, and solid electrolyte layers **23** formed on the second active material layers **22**. The polarity of the second electrode member **20** may be a negative or positive polarity, and may be a polarity opposite that of the first electrode member **10**.

(31) When the second electrode member **20** has a negative polarity, the second electrode member may include an anode current collector, anode active material layers formed on both surfaces thereof, and solid electrolyte layers on the anode active material layers.

(32) The anode current collector may be a metal thin film including at least one selected from the group consisting of copper (Cu), nickel (Ni), and a combination thereof.

(33) The anode active material layer may include an anode active material, a solid electrolyte, and a binder.

(34) The anode active material is not particularly limited, and may be, for example, a carbon active material or a metal active material.

(35) The carbon active material may be mesocarbon microbeads (MCMB), graphite such as highly oriented graphite (HOPG), or amorphous carbon such as hard carbon or soft carbon.

(36) The metal active material may be In, Al, Si, Sn, or an alloy containing at least one of these elements.

(37) The solid electrolyte may be an oxide solid electrolyte or a sulfide solid electrolyte. However, it may be preferable to use a sulfide-based solid electrolyte having high lithium ionic conductivity.

The sulfide-based solid electrolyte is not particularly limited, but may be Li.sub.2S —

P.sub.2S.sub.5 , $\text{Li.sub.2S—P.sub.2S.sub.5—LiI}$, $\text{Li.sub.2S—P.sub.2S.sub.5—LiCl}$, Li.sub.2S—

$\text{P.sub.2S.sub.5—LiBr}$, $\text{Li.sub.2S—P.sub.2S.sub.5—Li.sub.2O}$, $\text{Li.sub.2S—P.sub.2S.sub.5—}$

Li.sub.2O—LiI , $\text{Li.sub.2S—SiS.sub.2}$, $\text{Li.sub.2S—SiS.sub.2—LiI}$, $\text{Li.sub.2S—SiS.sub.2—LiBr}$,

$\text{Li.sub.2S—SiS.sub.2—LiCl}$, $\text{Li.sub.2S—SiS.sub.2—B.sub.2S.sub.3—LiI}$, $\text{Li.sub.2S—SiS.sub.2—}$

P.sub.2S.sub.5LiI , $\text{Li.sub.2S—B.sub.2S.sub.3}$, $\text{Li.sub.2S—P.sub.2S.sub.5—Z.sub.mS.sub.n}$ (where

m and n are positive numbers and Z is any one of Ge, Zn, and Ga), $\text{Li.sub.2S—GeS.sub.2}$,

$\text{Li.sub.2S—SiS.sub.2—Li.sub.3PO.sub.4}$, $\text{Li.sub.2S—SiS.sub.2—Li.sub.xMO.sub.y}$ (where x and

y are positive numbers, and M is any one of P, Si, Ge, B, Al, Ga, and In), or

$\text{Li.sub.10GeP.sub.2S.sub.12}$.

(38) The binder may be BR (butadiene rubber), NBR (nitrile butadiene rubber), HNBR

(hydrogenated nitrile butadiene rubber), PVDF (polyvinylidene difluoride), PTFE

(polytetrafluoroethylene), or CMC (carboxymethylcellulose).

(39) In a step of obtaining the second electrode member **20** at step **S3**, the method of forming the second active material layers **22** on the second current collector **21** and the method of forming the solid electrolyte layers **23** on the second active material layers **22** are not particularly limited. For example, a slurry containing the components of the second active material layers **22** may be applied on the second current collector **21**, or the second active material layers **22** may be transferred onto the second current collector **21**. Further, a slurry containing the components of the solid electrolyte layers **23** may be applied on the second active material layers **22**, or the solid electrolyte layers **23** may be transferred onto the second active material layers **22**.

(40) The second electrode member **20** may be formed so as to have a length L larger than a width W thereof, like the first electrode member **10**.

(41) Further, the step of pressing the second electrode member **20** at step **S4** may include applying a pressure so that the second electrode member **20** has a thickness of 80 to 90% of a thickness before the pressing. The pressure may be applied on the second electrode member **20** in a variety of ways. For example, the second electrode member **20** may be isostatically pressed, or may be passed between a pair of rollers so as to be roll-pressed.

(42) Thereafter, the pressed first electrode member **10** and second electrode member **20** may be layered to obtain a laminated body at step **S5**, and the laminated body may be passed between a pair of rollers R as shown in FIG. 5 so as to be pressed at step **S6**.

(43) As described above, in the manufacture of a conventional all-solid-state battery, an ultra-high-pressure pressing process is performed for the purpose of realizing bonding strength between the solid electrolyte layer and the active material layer and ionic conductivity. Isostatic pressing is mainly performed, which not only damages the laminated body but is also unsuitable for mass production of all-solid-state batteries.

(44) In embodiments of the present disclosure, the electrode members are pre-pressed prior to main pressing on the laminated body, and the pressed electrode members are layered and pressed using a roll press, thereby ensuring dimensional stability equivalent or superior to that of the related art and also significantly improving productivity.

(45) The step of pressing the laminated body at step **S6** may include adjusting an interval between a pair of rollers R so that the pressed laminated body has a thickness of 70 to 80% of a thickness

before the pressing, thereby pressing the laminated body. For example, the thickness of the pressed laminated body may be 100 to 300 μm , but is not limited thereto.

(46) Another embodiment of the present disclosure relates to a method of manufacturing a folding-type all-solid-state battery.

(47) First, after the first electrode member **10** and the second electrode member **20** are prepared as described above, as shown in FIG. 6A, the first electrode member **10** and the second electrode member **20** may be layered so that one longitudinal end B1 of the second electrode member **20** coincides with one longitudinal end A1 of the first electrode member **10** and so that a remaining longitudinal end B2 of the second electrode member **20** protrudes a predetermined length x farther than a remaining longitudinal end A2 of the first electrode member **10**, thereby obtaining the laminated body.

(48) The predetermined length x that the remaining end B2 of the second electrode member **20** protrudes may be 1/20 to 1/40 of the total length of the second electrode member **20**.

(49) Thereafter, the laminated body may be passed between a pair of rollers R as shown in FIG. 5 so as to be pressed, and the second electrode member **20** may then be folded so that the remaining protruding end B2 of the second electrode member **20** surrounds the remaining end A2 of the first electrode member **10** as shown in FIG. 6B.

(50) Finally, the laminated body may be consecutively folded in the direction in which the remaining end B2 of the second electrode member **20** is folded, thus obtaining the folding-type all-solid-state battery shown in FIG. 6C.

(51) Hereinafter, embodiments of the present disclosure will be described in more detail with reference to specific Examples and Experimental Examples. However, these Examples and Experimental Examples are for illustrative purposes only, and the scope of the present disclosure is not limited thereto.

EXAMPLE AND COMPARATIVE EXAMPLE

(52) The Example is an all-solid-state battery obtained by pressing a laminated body, which includes a cathode, including a cathode current collector and a cathode active material layer, an anode active material layer including an anode current collector and an anode active material layer, and a solid electrolyte layer positioned between the cathode active material layer and the anode active material layer, using a roll press as in embodiments of the present disclosure.

(53) The Comparative Example is an all-solid-state battery obtained by forming a cathode, an anode, and a solid electrolyte layer with the same compositions as in the Example and by applying pressure through isostatic pressing, as in the prior art.

(54) The thickness of each component of the laminated bodies according to the Example and the Comparative Example is shown in the following Table 1.

(55) TABLE-US-00001

	TABLE 1	Thickness of cathode	Thickness of anode	Thickness of electrolyte layer	Classification
Comparative	64.3 μm	72.2 μm	33.3 μm	Example	60.3 μm
Example	69.1 μm	32.5 μm		Experimental Example 1	

(56) Scanning electron microscope (SEM) analysis was performed on the cross sections of the all-solid-state batteries according to the Example and the Comparative Example.

(57) FIG. 7A shows the result of the Comparative Example, and FIG. 7B shows the result of the Example. Referring thereto, it can be seen that the all-solid-state battery manufactured using the roll press as in the Example includes components densely formed therein, like the all-solid-state battery manufactured by performing isostatic pressing at an ultra-high pressure, as in the prior art.

Experimental Example 2

(58) Charging/discharging capacity and Coulomb efficiency for the all-solid-state batteries according to the Example and the Comparative Example were measured. The results are shown in the following Table 2.

(59) TABLE-US-00002

	TABLE 2	Charging capacity [mAh]	Discharging capacity [mAh]	Coulomb efficiency [%]	Classification
Example					
Comparative Example					

capacity [mAh] efficiency [%] Comparative 43.9 31.1 70.8 Example Example 43.0 30.2 70.2 (60) Referring thereto, it can be seen that the all-solid-state batteries according to the Example and the Comparative Example have the same level of charge/discharge capacity and Coulomb efficiency.

(61) According to embodiments of the present disclosure, as described above, it is possible to obtain an all-solid-state battery having performance equivalent or superior to those of the related art. Further, since a roll press is used in the method of manufacturing the all-solid-state battery according to embodiments of the present disclosure, this method is more suitable for mass production than an ultra-high-pressure isostatic pressing process.

(62) The test examples and examples of embodiments of the present disclosure have been described in detail above, but the scope of the present invention is not limited to the test examples and examples described above. Various modifications and improvements capable of being devised by those skilled in the art using the basic concept of the present disclosure defined in the following claims are also incorporated in the scope of the present disclosure.

Claims

1. A method of manufacturing an all-solid-state battery, the method comprising: forming a first electrode member by forming first active material layers on both surfaces of a first current collector; pressing the first electrode member to form a pressed first electrode member; forming a second electrode member by forming second active material layers on both surfaces of a second current collector and forming solid electrolyte layers on the second active material layers, wherein the forming of the second electrode member occurs before any pressing of the second electrode member; pressing the second electrode member to form a pressed second electrode member; forming a laminated body by layering the pressed first electrode member and the pressed second electrode member; and pressing the laminated body by passing the laminated body between a pair of rollers to form a pressed laminated body.
2. The method of claim 1, wherein pressing the first electrode member comprises applying a pressure so that the pressed first electrode member has a thickness of 80 to 90% of a thickness of the first electrode member before the pressing.
3. The method of claim 1, wherein pressing the first electrode member comprises passing the first electrode member between the pair of rollers.
4. The method of claim 1, wherein pressing the second electrode member comprises applying a pressure so that the pressed second electrode member has a thickness of 80 to 90% of a thickness of the second electrode member before the pressing.
5. The method of claim 1, wherein pressing the second electrode member comprises passing the second electrode member between the pair of rollers.
6. The method of claim 1, wherein the pressed laminated body has a thickness of 100 to 300 μm .
7. The method of claim 1, wherein the first electrode member has a larger length than width.
8. The method of claim 1, wherein the second electrode member has a larger length than width.
9. The method of claim 1, wherein a first longitudinal end of the pressed second electrode member coincides with a first longitudinal end of the pressed first electrode member and a second longitudinal end of the pressed second electrode member protrudes a predetermined distance farther than a second longitudinal end of the pressed first electrode member.
10. A method of manufacturing an all-solid-state battery, the method comprising: forming a first electrode member by forming first active material layers on both surfaces of a first current collector; pressing the first electrode member to form a pressed first electrode member, wherein the pressed first electrode member has a thickness of 80 to 90% of a thickness of the first electrode member before the pressing; forming a second electrode member by forming second active material layers on both surfaces of a second current collector and forming solid electrolyte layers

on the second active material layers, wherein the forming of the second electrode member occurs before any pressing of the second electrode member; pressing the second electrode member to form a pressed second electrode member, wherein the pressed second electrode member has a thickness of 80 to 90% of a thickness of the second electrode member before the pressing; forming a laminated body by layering the pressed first electrode member and the pressed second electrode member; and pressing the laminated body by passing the laminated body between a pair of rollers to form a pressed laminated body.

11. The method of claim 10, wherein: pressing the first electrode member comprises passing the first electrode member between the pair of rollers; and pressing the second electrode member comprises passing the second electrode member between the pair of rollers.
