Product Specifications

Type: Reflowable ML Lithium Rechargeable Battery

Model: ML414H IV01E

This is a "Standard Spec sheet " which is a general documentation for your evaluation.

Before we will start to supply this part to you, we would like you to ask us the formal version of this spec sheet.

We will issue the formal specification sheet for you.

(Basically the contents is the same as this one.)

We would like you to put your signature on it to state your approval of the specification, and send it back to us. It will be a kind of contract between you and us

Seller: Seiko Instruments Inc.

Electronic Components Business Unit

Micro-Energy Division

Sales Dep.

History of Revision

No.	Described by	Details of Change	Checked by	Issue Date
01	QA Dept R.Ito	Initial Release for Standard specifications	QA Dep H. Ishikawa	Nov.01.2007
		No.STDE-B-ML0414-0AGIV01E-0014-1		
02	QA Dept R.Ito	The pocket form of a emboss carrier tape is changed.	QA Dep H. Ishikawa	May.07.2008
		No. STDE-B-HB0414-0AGV01E-0014-2		

Manufacturer information

Company name: Seiko Instruments Inc.

Electronic Components Business Unit

Micro-Energy Division

Address: 45-1, Aza-Matsubara, Kami-ayashi, Aoba-ku, Sendai-shi,

Miyagi, Japan, postal code: 989-3124

Quality Assurance Department

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Appendix

Leakage Criteria

Construction of Battery

Battery drawing with tabs

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Reflow Profile

Drawing of Emboss Carrier Tape

Battery position in emboss tape

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Package specifications (Overseas)

Precautions for Your Safety

1. Application

This specification applies to the Reflowable ML Lithium Rechargeable Battery, which is manufactured and supplied by Seiko Instruments Inc. to the customer specified in the cover page of this document.

2. Model

Model described in cover.

3. Chemical System and Structure

Refer to the document "The construction of battery" attached.

4. Nominal Specifications

		Model				
No.	Characteristics	ML414H				
4-1	Range of temperature in which it can be operated	From -20°C to 60°C				
4-2	Recommended range of preservation temperature and humidity	From 10°C to 30°C 60%RH or less				
4-3	Nominal voltage	3V				
4-4	Charging voltage	From 2.7V to 3.1V				
4-5	Recommended Charging voltage	From 3.0V to 3.1V				
4-6	Nominal capacity: after charging(mAh)					
	From 3.1V to 2.0V	1.0				
4-7	Standard Discharge Current (mA)	0.005				
4-8	Nominal dimensions					
	Diameter (mm)	4.8				
	Height (mm)	1.4				
4-9	Standard mass (g)	0.07 (without tabs)				
4-10	Applicable Safety Standard	UL1642 (Not acquired)				

5. Characteristics

- * "Initial" means within one month after deliver.
- * Attached "Leakage Criteria" is used for the judgment of leakage.

5-1. Electric characteristics

		Model	Test	Measuring
No.	Characteristics	ML414H	Methods	Methods
1	Open Circuit Voltag	e (V) at delivery	-	6-4
	Maximum	2.8		
	Minimum	2.3		
2	Open Circuit Voltag	e (V) after charge	-	6-2 1) 2)
	Maximum	3.1		6-4
	Minimum	2.8		
3	Initial Capacity (mA	h)	7-2	6-2
	24°C	0.8 or more		
	-20°C	0.2 or more		
	60°C	0.8 or more		
4	Initial Internal Imped	dance (ohm)	7-2	6-3
	24°C	1500 or less		
	-20°C	5000 or less		
	60°C	1500 or less		

5-2. Mechanical characteristics

		iccriamical criara	Model	Test	Measuring
No.	C	Characteristics	ML414H	Methods	Methods
1	Tal	Pulling Strength	n (N): With the terminal	-	6-8
		-	Refer to Battery Drawing with tabs attached		
2	Ext	ernal Appearanc	e		6-9
		Initial	No leakage	-	
			There must not be foreign body		
			adhesion (over level S2).		
			There is no significant deformation,		
			stain, stricken mark, rust and burr.		
		After Tests	There is no significant leakage (over	7-3	
			level C1), deformation, stain, stricken	7-4	
			mark, rust and burr.	7-5	
3		Free fall	Satisfy initial capacity and internal	7-9	6-2
			impedance. There is no significant		6-3
			leakage, deformation, stain, stricken		6-9
			mark, rust and burr, which effect battery		
1		Vibration	performance.	7.40	6.0
4		vibration	Satisfy initial capacity and internal	7-10	6-2
			impedance. There is no significant		6-3 6-9
			leakage, deformation, stain, stricken		0-9
			mark, rust and burr, which effect battery performance.		
<u> </u>			penomance.		

5-3. Reliability

	•	Model	Test	Measuring
No.	Characteristics	ML414H	Methods	Methods
1	High Temperature Storage	e Characteristics	7-3	
	Capacity (mAh)	0.68 or more		6-2
3	Low Temperature Storage	Characteristics	7-4	
	Capacity (mAh)	0.70 or more		6-2
3	Float Charge Characterist	ics	7-5	
	Capacity (mAh)	0.68 or more		6-2
	Internal Impedance			6-3
	(ohm)	3000 or more		
4	Over Discharge Character	ristics	7-6	
	Capacity (mAh)	0.68 or more		6-2
5	Charge / Discharge Cycle	Characteristics (Cycles)		6-2
	10% D.O.D.	300cycle or more	7-7	
6	Leakage Resistance	Level S3 (*1) or less	7-8	6-9
		(There is no significant leakage		
		which effect battery performance.)		

5-4. Table of Parameter for Test and Measuring

_		able of Farameter for 1	<u> </u>	1			
			Model	Test	Measuring		
No.		Characteristics	ML414H	Methods	Methods		
1	Ca	pacity		-	6-2		
		Vinit (V)	2.0				
		Vc (V)	3.1				
		Rp (kohm)	3				
		Tc (hrs)	72				
		Rd (kohm)	470				
		Voff (V)	Voff (V) 2.0				
2	Flo	at Charge Characterist	ics	7-5			
		Vc (V)	3.1				
		Rp (kohm)	3				
3	Ove	er Discharge Charactei	ristics	7-6			
		Rs (kohm)	33				
4	Cha	arge / Discharge Cycle		7-7			
		Vc (V)	3.1				
		Rp (kohm)	3				
		Tcs (hrs)	5				
		Rds (kohm)	100				
		Tds (hours)	4				

6. Measuring Methods

6-1. General Conditions

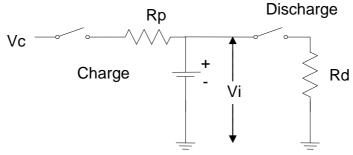
The measuring conditions are temperature of 24+/-2 °C, humidity of 65+/-20%Rh and within one month after delivering, if not specified.

6-2. Capacity

- 1) Charging: Apply specified voltage (Vc) through the protective resistance (Rp) for specified time (Tc).
- 2) Discharging: Discharging with load resistance (Rd) until the cell voltage reaches the cut off voltage (Voff), the cell voltage (Vi) and time (Ti) should be measured at intervals within one hour.
- 3) Calculation: The capacity value is calculated by the expression below.

Capacity =
$$\sum_{i} \left(\frac{(V_{i} + V_{i+1})}{2} \times \frac{1}{Rd} \times (T_{i+1} - T_{i}) \right)$$

4) General Circuit: The circuit, for charging and discharging, is shown as follows.



6-3. Internal Impedance

Measure by alternating current method using frequency of 1KHz.

6-4. Voltage

Use a direct current voltage meter, which has input impedance of 10Mohm or more and accuracy of +/-0.2% or less.

6-5. Current

Use an ammeter with accuracy of +/-0.2% or less.

6-6. Resistance

Resistance, which includes resistance of all external circuits, requires accuracy of 2.0% or less.

6-7. Size measurement

Use the size measurement instruments with accuracy of 0.01mm or 0.001mm if necessary.

6-8. Terminal pull strength: The direction of the pull is vertical.

Use a digital force gauge, which has accuracy of +/-1.0% or less.

6-9. Appearance

After Test : Microscope, which has magnification of 10 times.

At delivery : Naked eye

7. Test Methods

7-1. General conditions

If not specified, the test conditions are temperature of 24+/-2 °C, humidity of 65+/-20%Rh and The test should be started within one month after delivering.

7-2. Temperature Characteristics Test

Measure electrical characteristics after exposing battery to each temperature atmosphere for 2 hours.

Temperature: -20+/-2 °C, +24+/-2 °C, +60+/-2 °C

7-3. High Temperature Storage

After Charging at voltage of Vc through protective resistance of Rp for Tc hours, store battery at temperature 60+/-2 °C for 20days.

7-4. Low Temperature Storage

After Charging at voltage of Vc through protective resistance of Rp for Tc hours, store battery at temperature of -40+/-2 °C for 96 hours.

7-5. Float Charge Characteristics Test

Charge battery at voltage of Vc through protective resistance of Rp at temperature of 24+/-2 °C for 30days.

7-6. Over Discharge Characteristics Test

Discharge the battery by discharge resistance of Rs for 30 days.

7-7. Charge / Discharge Cycle Characteristics Test

Charge : Apply specified voltage (Vc) through protective resistance (Rp) for

specified period (Tcs).

Discharge: With load resistance (Rds) for specified period (Tds).

The battery is repeated in the above condition. Its closed circuit voltage is 2.00V or more.

7-8. Leakage Resistance (Thermal Shock Test: Air to Air)

Hold battery at -10+/-2 °C for 1 hour then hold it at 60+/-2 °C for 1 hour.

Repeat 100 cycles between above conditions. (Chamber) Not humidity controlled.

7-9. Free Fall Test

Drop the battery ten times in an arbitrary direction on the board of the oak of 3cm in thickness from the height of 75cm. The tabs of battery should be cut before test.

7-10. Vibration Test

Vibrate the battery in the direction of 3(x, y, z) for 30 minutes by 1000 cycles per minute with amplitude of 2mm. The tabs of battery should be cut before test.

8. Mounting Conditions

8-1. Battery with tabs

1) For soldering iron

Use the conditions as follows

	Model
	ML414H
Temperature	260°C or less
Soldering time	Within five seconds

Within above conditions, do not heat battery over 100°C.

Do not solder directly to the battery.

2) Dip soldering

It is possible to apply. Do not heat the battery over 100°C

3) Reflow soldering

It is possible to apply.

Refer to "Reflow Profile" attached.

8-2. Battery without tabs

Use the spring terminal, which meets the specification as follows.

Surface treatment: Nickel plating or Gold plating

Contact force: 0.5N or more

9. Indications (Markings)

9-1. Dies

Following items are indicated on battery.

Below items can be omitted except item (2).

(1) Model code

(2) Cathode polarity (+)

(3) Manufacturer's name or monogram

(4) Country of origin

9-2. Date of Manufacturing

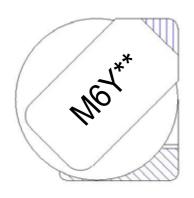
Date of Manufacturing is marked on the negative tab or the battery (if possible) and label of each package as.

(Example) M51...manufactured in January 2005

M6Y...manufactured in November 2006

 $\underline{M70}$...manufactured in $\underline{October}$ 200 $\underline{7}$

Abbreviation of month: Jan. (1), Feb. (2).... Sep. (9), Oct. (0), Nov. (Y), Dec. (Z)



**is our own number, and might be omitted.

Method of marking of manufacturing date is laser

type.

Inspection (Outgoing and Incoming)

10-1. Lot composition

Lot must be composed within the same manufacturing conditions.

10-2. Outgoing Inspection

Seiko Instruments Inc. shall do outgoing inspection before shipping. The inspection items are as below table. The inspection results shall be submitted by the customer request.

No	Characteristics	Inspection levels	Frequency				
1	Open circuit voltage	n=6, c=0	per lot				
2	Internal Impedance	n=6, c=0	per lot				
3	Discharge capacity	n=6, c=0	per month				
4	Leakage resistance	n=10, c=0	per lot				

10-3. Incoming Inspection

The customer should do incoming inspection within 30 days from receiving day. If defective products are find out at incoming inspection, the customer immediately should notify to Seiko Instruments Inc. in writing with the defective products for replacement request. When there was no contact from you within 30 days, we shall judge that those were accepted.

11. Package Specifications

Examples of the tray or the Emboss tape for wrapping, wrapping specification, and packing specification are shown in the following as our standard.

11-1. Wrapping

Refer to "Drawing of Emboss Carrier Tape", "Battery position in emboss tape" and "Taping specifications".

11-2. Wrapping and packing

Refer to "Package specifications (Overseas)" attached.

12. In case of quality trouble

The warranties set forth herein are the only warranties on the products.

The liabilities of Seiko Instruments Inc. in connection with the products under these specifications are expressly limited to the replacement of defective products.

13. Operation of this Specification

13-1. Agreement

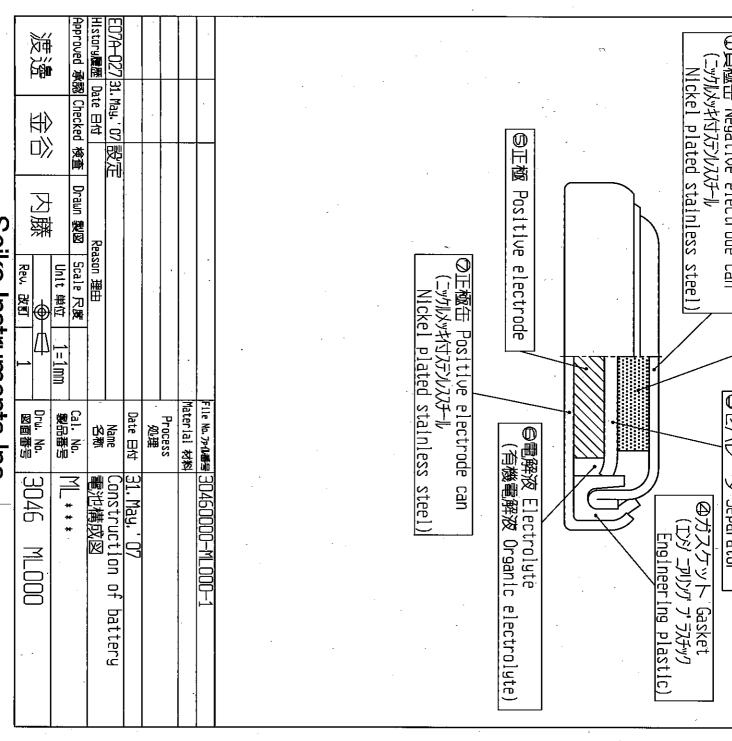
Before these specifications being revised, the agreement, of the customer, seller and manufacturer, is required.

13-2. Negotiation

If some accident not specified on these specifications occurs, the customer, seller and manufacturer must negotiate in order to solve the problem faithfully.

Leakage Criteria

		Criteria
Grade	Diagram	Definition
S1	Leakage	The leakage can not be seen by naked eyes, but can be seen by microscope, which have magnification of 10 to 15.
S2	Leakage	The leakage can be seen by naked eyes. The area of leakage is within half of the round and reaching to neither the flat area of the negative can nor the straight area of the positive can. The leakage is not bridged between the negative can and the positive can.
S3	Leakage	The area of leakage is from half to all of the round and reaching to neither the flat area of the negative can nor the straight area of the positive can. The leakage is not bridged between the negative can and the positive can.
C1	Leakage Bridge Leakage	The area of leakage is reaching to either the flat area of the negative can or the straight area of the positive can. The leakage is bridged between the negative can and the positive can.



Seiko Instruments Inc.

History**慶歴**| Date 日付 Approved 承認 Checked 検査 07A-024|10. May. ' 07| 設定 敷製 1. 41-{ (Solder Plating Area) (バンダ 火水部) 金谷 Drawn 製図 内藤 2.4±0.2 , 5±0.1 Seiko Instruments Inc. 4±0.2 Reason 理由 Scale 尺度 Unit 単位 Rev. 改訂 2.4^{±0.2} 4^{±0.2} 0. 2^{+0.1} Material 材料 File No.774篇号|30461090—IV01E— Drw. No. 図面番号 Cal. No. 製品番号 Process 妈猫 Date 日付 SE ACC <u>0</u>±0.1 Battery drawing with tabs 端子付電池図面 109 IV01E ML414H IV01E May. 153U4-N1 -P H/2 :Solder plating <u>0.1</u>±0.02 Tolerances of angular dimensions 角度寸法公差 100%) <u>0.8±0.5</u> (Solder Plating Area) (ルダ 火料部) ±0.50 1129 女本 ± 0.20

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Reflow Profile

< Reflow Soldering Conditions >

Reflow Soldering Profile: As per shown in Fig.-1.

The times of repeated reflow soldering must be **two times or less**.

The temperature must be measured at top of the cell.

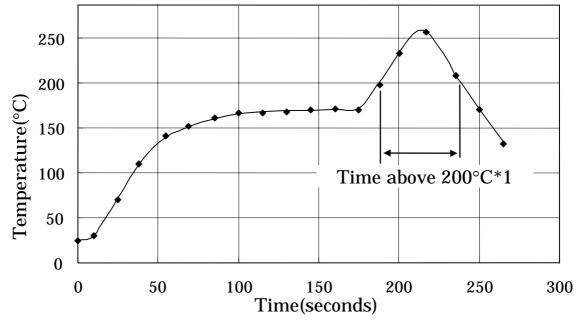


Fig.-1: Reflow soldering profile (for reference only)

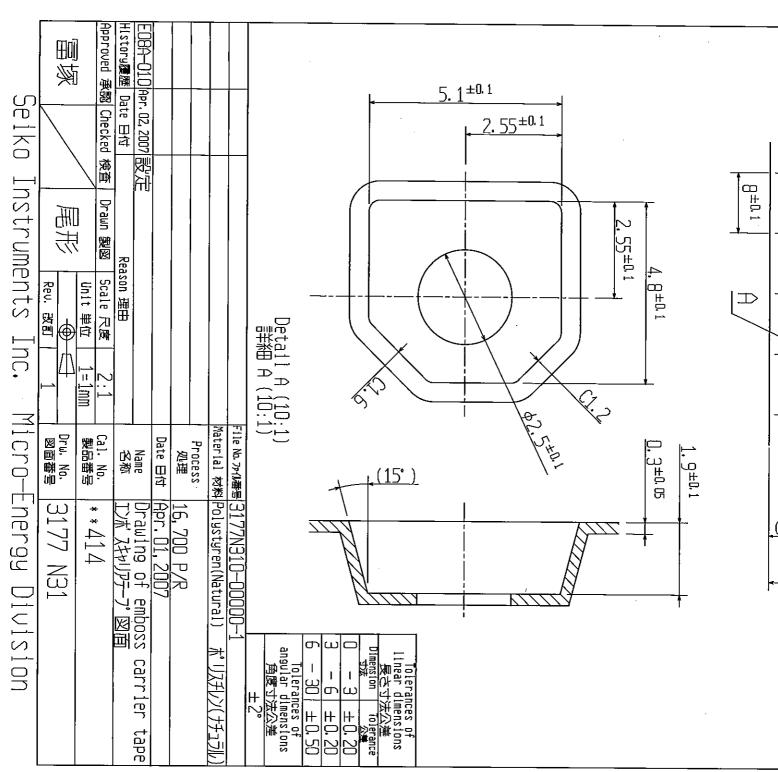
*1: Time above 200°C must be max. 80seconds.

Total length of profile must be max. 300seconds.

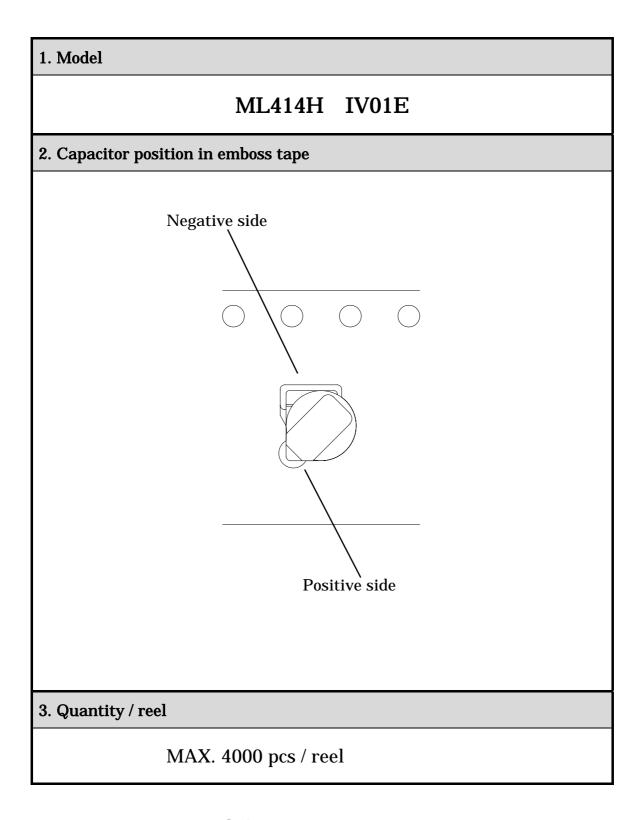
	Model
Peak Temperature	ML414H
Max.260°C	Applicable (within 5 seconds)

< Underfilling Conditions >

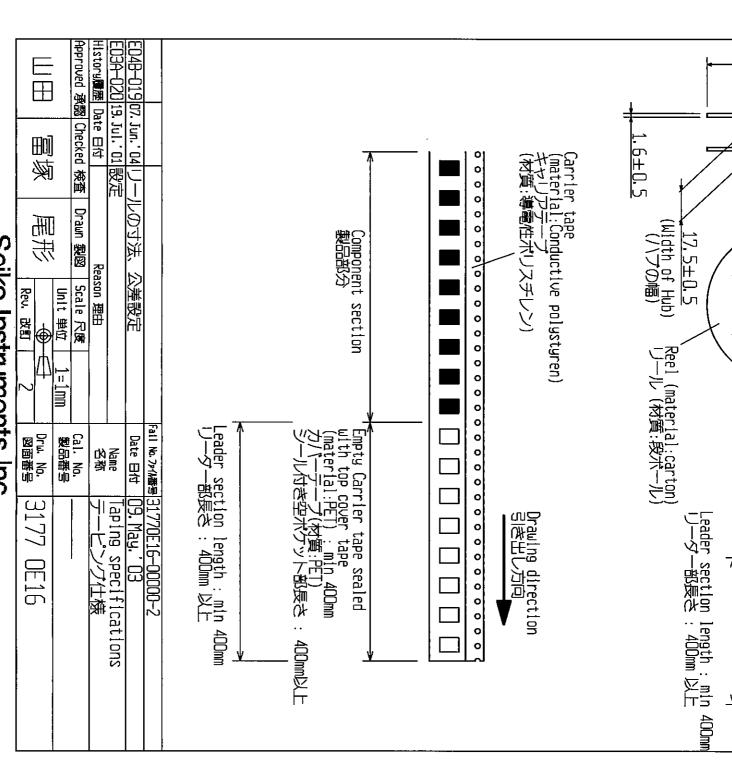
Temperature: Max.160°C, Time: Max.10 minutes.



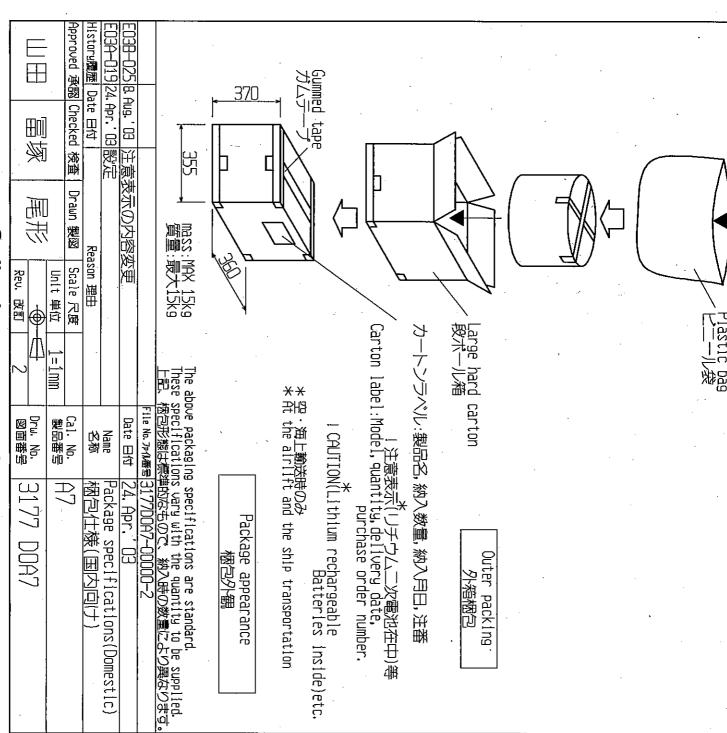
Battery position in emboss tape



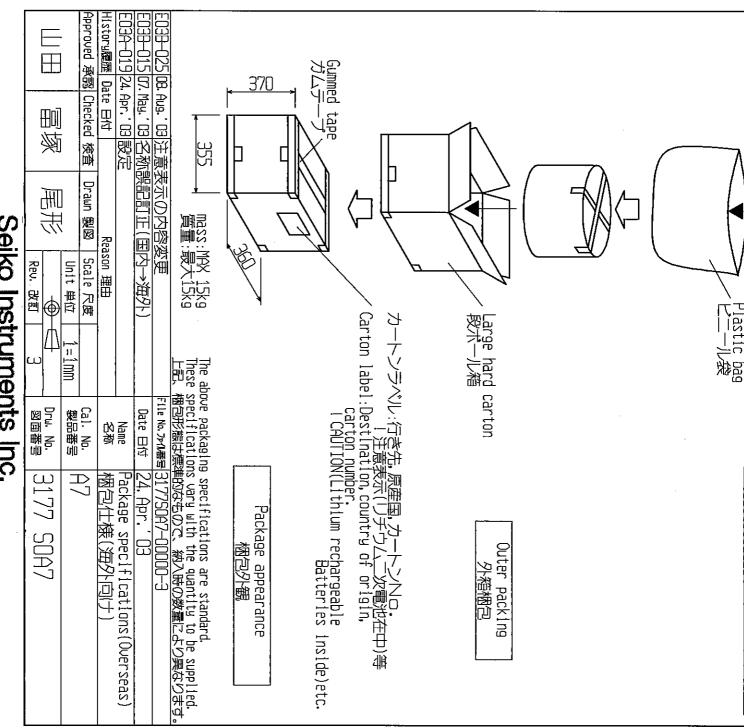
Seiko Instruments Inc.



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Seiko Instruments Inc.

Precautions for Your Safety

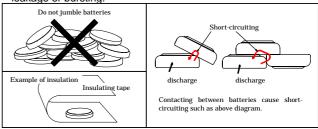
SII Lithium rechargeable batteries (ML, MS, HB, TS) contain flammable organic solvents. For your safety, please follow following prohibitions.

! WARNING!

- Do not charge by high current or high voltage.
 Doing so may generate gas inside the battery, resulting swelling, catching fire, and heat generation or bursting.
- Do not heat, disassemble nor dispose of in fire Doing so damages the insulation materials and may cause catching fire, heat generation, leakage or bursting.
- Do not solder directly to the battery
 If soldering is performed directly to the battery, the battery is
 heated up, consequently cause leakage, explosion or fire due to
 overheating from internal short-circuiting.
- 4. Do not short.
 - If the (+) and (-) come into contact with metal materials, short-circuiting occurs. As a result, catching fire, heat generation, leakage or bursting.
- Keep batteries out of children's reach.
 If leaked liquid is ingested or a battery is swallowed, consult a physician immediately.
- 6. Do not reverse placement of (+) and (-) If the (+) and (-) side of the battery is reverse inserted, it may cause a short-circuiting or over discharge of the battery on some equipment and it may induce overheating, explosion or fire.

- 7. Do not discharge by force
 - If the battery is discharged by direct connection to an external power supply etc., voltage of the battery will decline lower than 0 volts (electrical reversal) and will cause the battery case to expand, overheat, leak, explode or burn.
- 8. Incase of leakage or a strange-smell; keep away from fire to prevent ignition of any leaked electrolyte.
- 9. In case of disposal, insulate between (+) and (-) of battery by an insulating

Jumbling batteries or with other metal materials cause short-circuiting. As a result, catching fire, heat generation, leakage or bursting.





CAUTION!

- 1. If leaked liquids gets in the eyes, wash them with clean water and consult a physician immediately.
- 2. Do not use new and used batteries together. Do not use different types of batteries together. It may cause catching fire, heat generation, leakage or bursting.
- 3. If you connect two or more batteries in series or parallel, please consult us in advance.
 - It may cause bursting or catching fire due to unbalanced load or voltage.
- 4. Do not use nor leave the batteries in direct sunlight

- nor in high-temperature areas.
- It may cause catching fire, heat generation, leakage or bursting.
- 5. Do not apply strong pressure to the batteries nor handle roughly.
 - It may cause catching fire, heat generation, leakage or bursting.
- 6. Avoid contact with water.
 - It may cause heat generation.
- Keep batteries away from direct sunlight, high temperature and humidity. It may cause heat generation.

For prevention the performance of battery

- Pay attention to mat or sheet for ESD
 Battery with tabs or battery on PCB may short circuit on the mat for ESD. As a result the voltage of cell drops down.
- 2. Pay attention to soldering by tips
 - Do no touch the battery by solder chips, in case of soldering another components after equipping battery.
 - In basically, keep any high temperature process away from battery.
- 3. Pay attention to material of jig for pick and place
 Use nonconductive material of jig for pick and place of batteries,
 for short-circuit protect. If short circuit of battery is occurred, the
 voltage of battery drops down quickly but raise gradually.
- Pay attention to washing and drying Some detergent or high temperature drying cause deteriorates of battery. If wash batteries, consult us.

International Transportation and Disposal

International Air / Marine / Ground Transportation

Regarding the transport of Lithium battery and Lithium-ion battery, organizations like IATA, ICAO, IMO, DOT have determined transport regulations, based on the United Nations Regulations. The SII Lithium rechargeable batteries can be transported being not subject to the provisions of dangerous goods, if they meet the following requirements.

- (a) <Lithium content>The Lithium content is not more than 1g.
- (b) **<Safety Certification>**Each battery is of a type proved to meet the requirements of each test in the UN Manual of Tests and Criteria, Part 3, sub-section38.3.
- (c) **<Strong packaging>**Batteries are separated so as to prevent short circuits and are packed in strong packaging.
- (d) <Caution Label>Each package must be marked indicating that it contains lithium batteries and that special procedures should be followed in the event that the package is damaged.
- (e) <Not Restricted Declaration>Each shipment must be accompanied with a document indicating that the packages contain lithium batteries and that special procedures should be

- followed in the event that a package is damaged.
- (f) <Package Drop Test>Each packages is capable of withstanding a 1.2 m drop test in any orientation without damage to batteries contained.
- (g) **<Weight Limit>**Except in the case of packed with equipment, packages may not exceed 30 kg gross mass.
- (h) <Transport to U.S.A.>When you transport to U.S.A., emergency contact information must be indicated on the required documents.

For further information, please consult with us.

Disposal

Recent environmental protection concerns have increased globally and waste and recycling are regulated in the world. The current regulations differ in each country, state and local municipality. Please consult local regulations and authorities for recommended disposal of batteries. If you are in question of application or safety of our batteries, please consult your local authorities.

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