










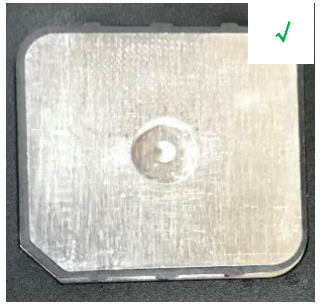




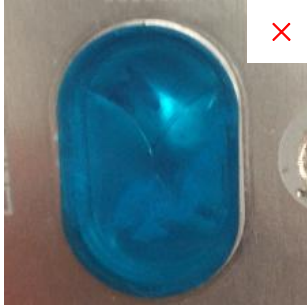


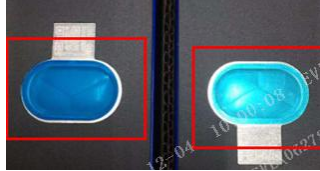

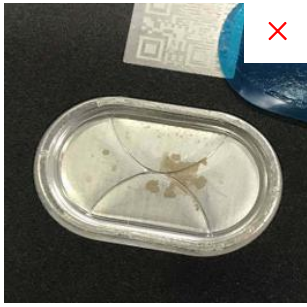
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Items	Defect Name	Acceptance Criteria	Defect Image	Standards
1	QR Code			<p>Accept: Scratches, dirt etc. on the QR code do not prevent the QR code from being recognized by the scanning gun/device.</p> <p>Reject: QR code cannot be recognized by scanning gun/device due to the scratches, dirt etc. on the QR code.</p>
2	Scratches on the terminal			<p>Accept: Scratch length\leq4.5mm, scratch depth\leq0.2mm, the scratch qty\leq1strip, the scratch can be polished with sandpaper of 1000 or above mesh</p> <p>Reject: Scratch still cannot meet above acceptance criteria after being polished.</p>
3	Pits on the terminal			<p>Accept: Within 3mm with the positioning hole as a center: indentation radius\leq0.2mm, and indentation depth\leq0.2mm acceptable; Beyond 3mm away from the positioning hole: ①indentation depth\leq0.1mm acceptable; ②depth between 0.1~0.2mm and length\leq0.2mm, qty\leq3 acceptable; ③depth$>$0.2mm not acceptable. The indentation of the volumetric probe is acceptable</p> <p>Reject: Pits can still not meet above acceptance criteria after being polished.</p>
4	Dirt and pollution on the terminal			<p>Accept: Wipable dirt is not allowed on the surface of the terminal, the non-wipable pollution can be polished by the sandpaper of 1000 or above mesh, however, the powder dirt and touchable particle pits are not allowed on the polished terminals.</p> <p>Reject: Still cannot meet above standard after treatment.</p>





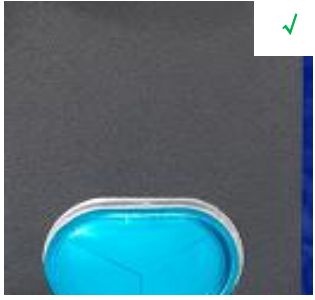





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5	Incomplete of the terminal			<p>Accept: From terminal edge to center, notch length\leq2mm, width\leq1.5mm, qty\leq1 acceptable.</p> <p>Reject: The notch exceeds above acceptance standards.</p>
6	Incomplete on terminal rubber ring			<p>Accept: Length$<$5mm perimeter and no continuous damage on ceramic/metal is exposed, qty\leq1 acceptable; length\leq1mm, depth\leq1.3mm, and no continuous damage on ceramic/metal is exposed, qty\leq5 acceptable.</p> <p>Reject: The rubber ring notch exceeds above acceptance standards.</p>
7	Dirt and pollution on the terminal rubber ring			<p>Accept: No any electrolyte contamination is allowed on the terminal rubber ring.</p> <p>Reject: The above requirement is not met.</p>
8	Terminal corrosion (e.g. green, whitish, rust)		<p align="center">Corrosion rating$>$3 degree</p>	<p>Accept: 3 degree standard: surface stain residual and erasable dirt are not allowed; Non-erasable dirt area is less than 1/4 of the terminal area is acceptable, the corrosion can be sanded.</p> <p>Reject: The corrosion area is more than 1/4 of the terminal area and cannot be sanded.</p>
9	Sanding of the terminal			<p>Accept: The terminal can be polished with sandpaper of 1000 or above mesh, after sanding, there is no visible particle residue on the surface.</p> <p>Reject: The above requirement cannot be met after sanding.</p>

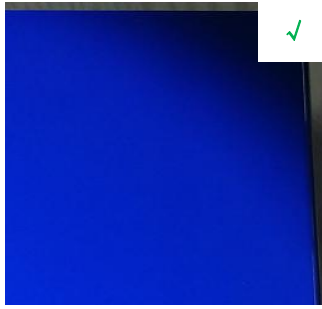

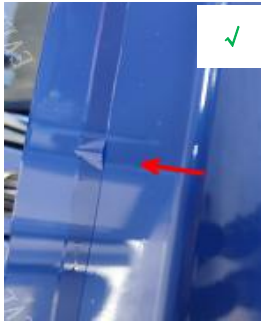
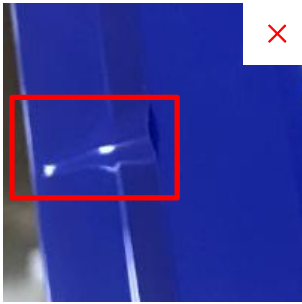
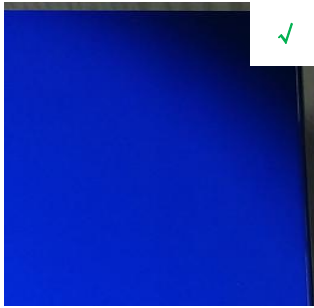



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10	Black prints and grinding on the surface of terminal			<p>Accept: The black print length\leq5mm, qty\leq2 marks, the dirty black marks can be erased or sanded.</p> <p>Reject: The above requirement cannot be met after sanding.</p>
11	Damage and deform of the explosion-proof valve			<p>Accept: Explosion-proof valve damage and irregular deformation is not allowed.</p> <p>Reject: The above requirement cannot be met.</p>
12	Bulge of the explosion-proof valve			<p>Accept: Explosion-proof valve bumps are not allowed.</p> <p>Reject: The above requirement cannot be met.</p>
13	PET film abnormal of the explosion-proof valve			<p>Accept: No any missing, damage, dirty are allowed, the PET film can be replaced with new one if any abnormal exists.</p> <p>Reject: The above requirement cannot be met.</p>
14	Color difference of the explosion-proof valve		NA	<p>Accept: Color difference of the explosion-proof valve for cells in one batch is acceptable.</p> <p>Reject: Need to be discussed.</p>
15	Dirt and electrolyte pollution on the explosion-proof valve			<p>Accept: Glue residue is allowed, residual liquid and oil $\phi\leq$3mm is acceptable.</p> <p>Reject: Residual liquid and oil \geq3mm.</p>








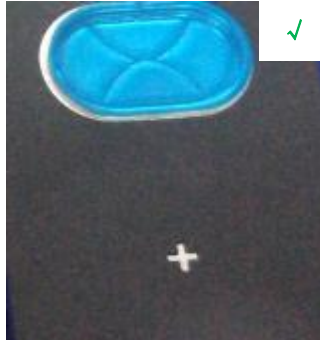

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16	Rubber ring cracks and welding wires on the terminal			<p>Accept: Cracks are not allowed on the rubber ring, the welding wires are acceptable.</p> <p>Reject: The above requirement cannot be met.</p>
17	Protrusion of the blue film from the edge of the terminal			<p>Accept: The protrusion of the blue film from the edge of the terminal is not allowed</p> <p>Reject: The blue film is exposed out of the edge of the terminal.</p>
18	Seal nails warp issue			<p>Accept: Seal nails warp $\leq 0.2\text{mm}$</p> <p>Reject: Seal nails warp $> 0.2\text{mm}$</p>
19	Damage of the wrapping film			<p>Accept: Blue wrapping film no damage, no aluminum shell is exposed, damage $\leq 3\text{mm}$ can be patched, patch size $20*20\text{mm}$, qty ≤ 1 place</p> <p>Reject: The above requirement cannot be met.</p>
20	Foreign material under the wrapping film			<p>Accept: Soft foreign material is allowed, hard foreign material is forbidden. Judging criteria on main surface: with clamp force 300Kgf, if the blue film in the corresponding position of the foreign material is not whitish, it can be determined as a soft foreign material, and if it is whitish, it is a hard foreign material.</p> <p>Judging criteria on side surface: press by hand, if the blue film is</p>

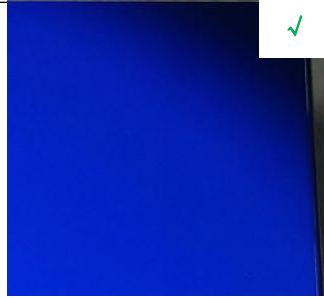
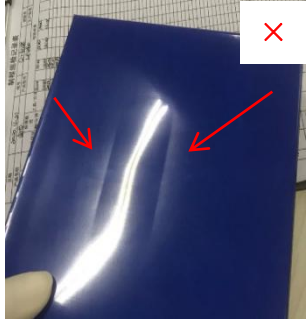
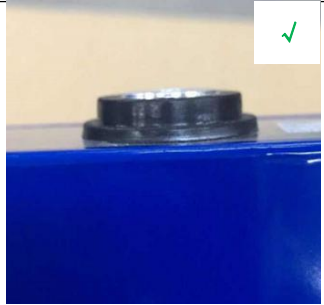
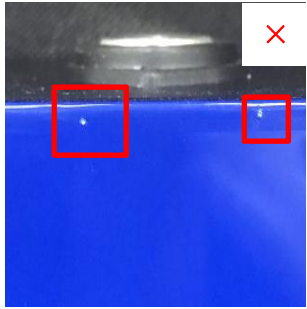
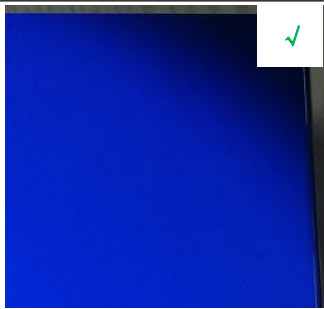

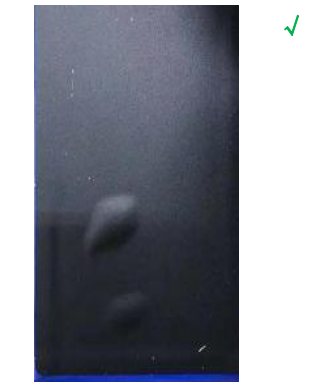

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				<p>not whitish in the corresponding position, it can be determined as a soft foreign material, and if it is whitish, it is a hard foreign material.</p> <p>Reject: Hard foreign material exists.</p>
21	Pleats of the wrapping film			<p>Accept: The individual pleat width\leq2mm, and pleat length\leq10mm, and qty\leq2 pleats.</p> <p>Reject: The above requirement cannot be met.</p>
22	Warping of the wrapping film			<p>Accept: The warping between the blue films(coincident edge) at the end side of the cell should not exceed the edge side of the cell, and the warping qty\leq1.</p> <p>Reject: The above requirement cannot be met.</p>
23	Wrapping Bubbles			<p>Accept: Bubble diameter\geq10mm is not allowed; 8mm<bubble diameter\leq10mm, 1bubble allowed; 4mm<bubble diameter\leq8mm, bubble qty\leq5 allowed; 2mm<bubble diameter\leq4mm, bubble qty\leq10 allowed for each side; bubble diameter\leq2mm is acceptable. Patch is allowed, patch size \leq20*20mm, qty\leq1 patch.</p> <p>Reject: The above requirement cannot be met.</p>
24	Scratch on wrapping film			<p>Accept: The scratches are acceptable when they don't damage the blue wrapping epidermis and exposure the aluminum shell, at the same time the insulation test can be passed.</p> <p>Reject: The above requirement cannot be met.</p>

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25	Pits on the blue wrapping film			<p>Accept: Pit diameter\leq10mm, and depth\leq0.3mm, and qty\leq3 pits. Reject: The above requirement cannot be met.</p>
26	Color difference on the blue wrapping film		NA	<p>Accept: Wrapping film color difference is not allowed for the cells in the same group. Reject: The above requirement cannot be met.</p>
27	Crook of insulation sheet			<p>Accept: The insulation sheet is not allowed to exceed the edge of the battery cell, and should not cover the terminals, QR code and explosion-proof valve. Reject: The above requirement cannot be met.</p>
28	Warping of the insulation sheet			<p>Accept: The coating insulation sheet is not allowed to warp except for the 4 corners. The warp height of the 4 corners should be less than 4mm (shown as the picture) Reject: The above requirement cannot be met.</p>
29	Pleats on the insulation sheet			<p>Accept: No Pleats and damage on the insulation sheet. Reject: The above requirement cannot be met.</p>

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30	Crease on the main sides			<p>Accept: Crease length\leq50mm, and the qty*width\leq2*2mm. Reject: The above requirement cannot be met.</p>
31	Top white on the blue wrapping film			<p>Accept: Top white on the blue wrapping film is not allowed. Reject: Top white on the blue wrapping film occurs.</p>
32	Dirt and pollution on the blue wrapping film			<p>Accept: No any dirt and pollution on the blue wrapping film. Reject: There is any dirt and electrolyte pollution on the blue wrapping film.</p>
33	Foreign material, crook, bubble on the insulation sheet at the cell bottom			<p>Accept: The bottom insulation sheet is not damaged, does not exceed the edge of the battery cell. The bottom bubble is acceptable Reject: The bottom insulation sheet exceeds the edge of the battery cell, and any hard foreign material exists.</p>

Customer signature:

Bitner

EVE signature:

Juping

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