



(86) Date de dépôt PCT/PCT Filing Date: 2016/01/11
(87) Date publication PCT/PCT Publication Date: 2016/08/18
(45) Date de délivrance/Issue Date: 2017/09/26
(85) Entrée phase nationale/National Entry: 2017/01/03
(86) N° demande PCT/PCT Application No.: IB 2016/000304
(87) N° publication PCT/PCT Publication No.: 2016/128837
(30) Priorité/Priority: 2015/02/09 (US62/113,788)

(51) Cl.Int./Int.Cl. *G01R 31/04* (2006.01),
H01M 2/20 (2006.01)

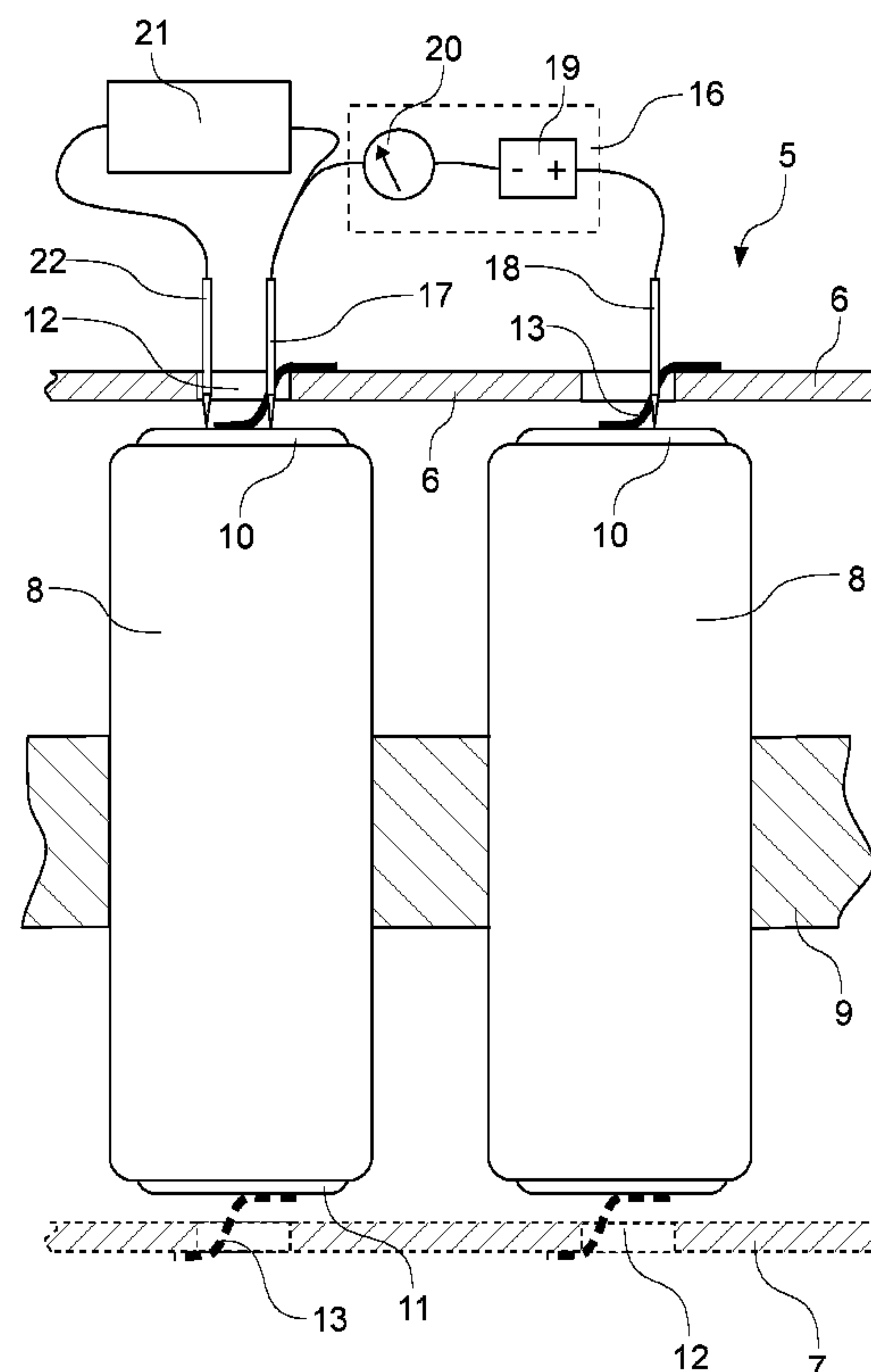
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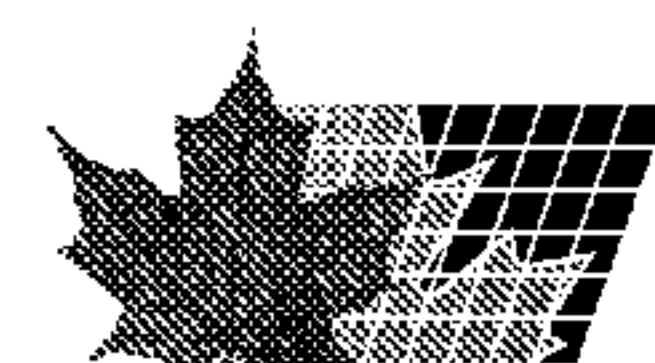
(54) Titre : PROCEDE ET DISPOSITIF PERMETTANT DE TESTER LES CONNEXIONS DE BATTERIES

(54) Title: METHOD AND DEVICE FOR TESTING THE CONNECTIONS OF BATTERIES

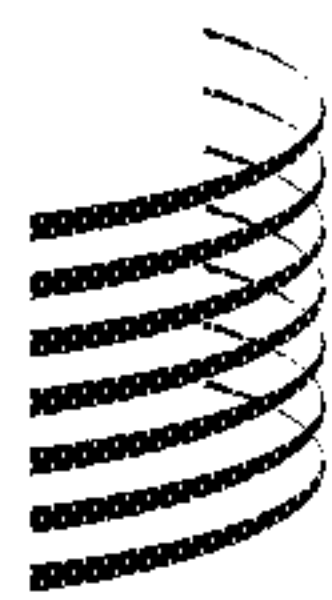


(57) Abrégé/Abstract:

For testing the connections (13) of batteries (8) that are connected in a battery module (5) to several bus bars (6, 7) that are electrically in parallel with their battery electrodes (10, 11) by a resistance measurer (16) comprising a pair of contact pins (17, 18), during a measurement a first battery electrode (10) is contacted by a first contact pin (17) and a point on the conductor arrangement (13, 6, 13, 10) connected to the first battery electrode (10) is contacted by the second contact pin.



(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property
Organization
International Bureau

WIPO | PCT

(10) International Publication Number
WO 2016/128837 A1(43) International Publication Date
18 August 2016 (18.08.2016)

(51) International Patent Classification:

G01R 31/04 (2006.01) *H01M 2/20* (2006.01)

(21) International Application Number:

PCT/IB2016/000304

(22) International Filing Date:

11 January 2016 (11.01.2016)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

62/113,788 9 February 2015 (09.02.2015) US

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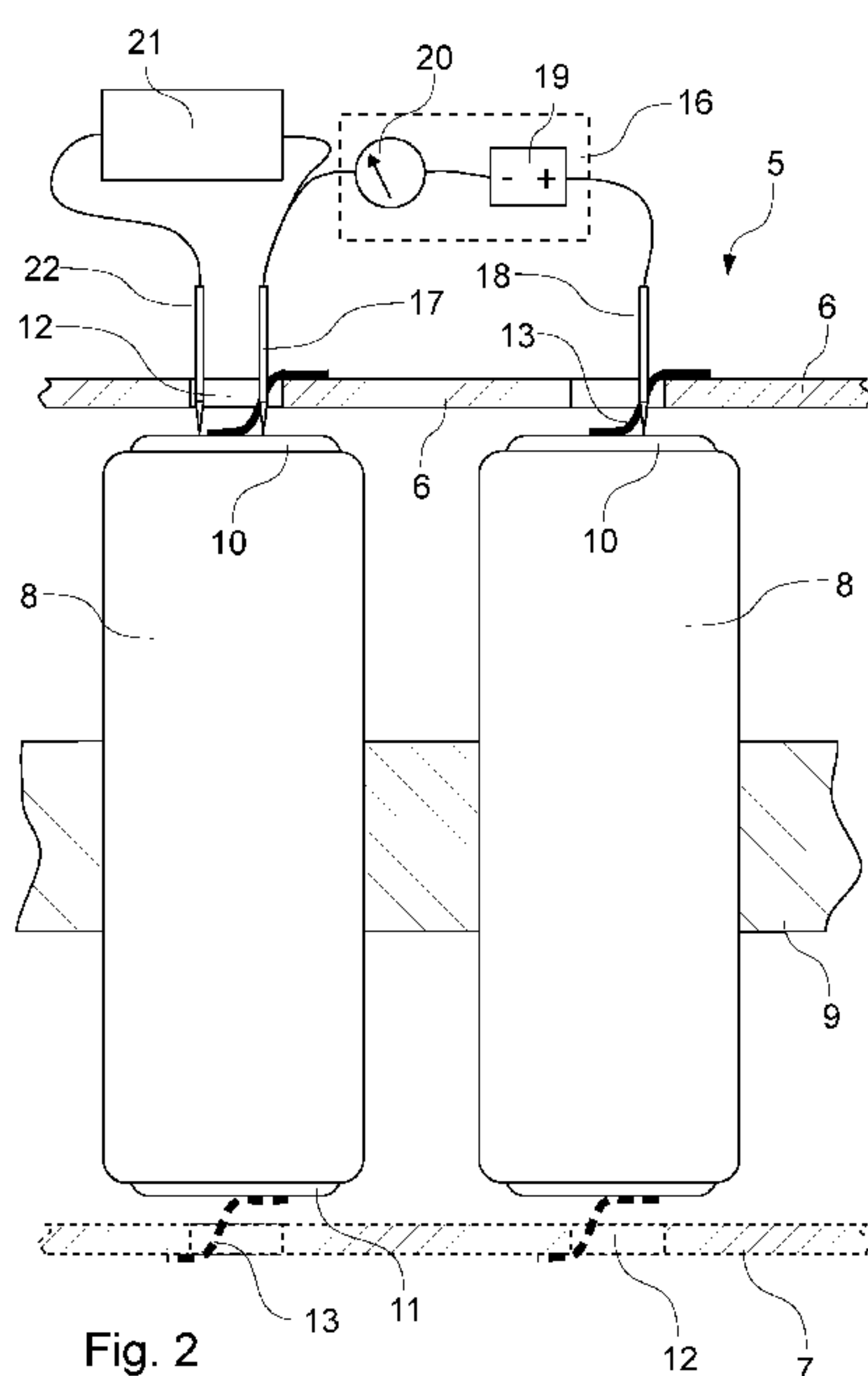
(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IR, IS, JP, KE, KG, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, ST, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Published:

- with international search report (Art. 21(3))
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments (Rule 48.2(h))

(54) Title: METHOD AND DEVICE FOR TESTING THE CONNECTIONS OF BATTERIES



(57) Abstract: For testing the connections (13) of batteries (8) that are connected in a battery module (5) to several bus bars (6, 7) that are electrically in parallel with their battery electrodes (10, 11) by a resistance measurer (16) comprising a pair of contact pins (17, 18), during a measurement a first battery electrode (10) is contacted by a first contact pin (17) and a point on the conductor arrangement (13, 6, 13, 10) connected to the first battery electrode (10) is contacted by the second contact pin.

METHOD AND DEVICE FOR TESTING THE CONNECTIONS OF BATTERIES

Technical Field

The invention relates to a method and a device for testing the connections of batteries, several of which in a battery module are connected, electrically in parallel, with their battery electrodes to bus bars.

Background

For example, battery modules for electric vehicles can be produced with this technology using commercial lithium ion batteries, for example, in the AA format, that have a parallel arrangement of, for example, 500 batteries. This concerns a parallel circuit of a very large number of batteries. This results in problems in the tests required after the production of the battery module.

The batteries are connected with their battery electrodes to bus bars. The connections can be constructed in many ways, for example, as a direct contact or via connection connectors that are connected, for example, in the form of a wire to the battery electrode on the one hand and to the bus bar on the other hand. These connections must be tested.

The present invention therefore has the problem of creating a method and a device with which the connections of the batteries can be tested.

Summary

According to the invention the battery module is contacted by a pair of contact pins that are connected to a resistance measurer. Such test devices have proven themselves and can be readily adapted to different test situations, for example, with movable contact pins. The resistance of the connection, for example, of a spring contact or of a soldered or welded connection connector can be checked during the measuring in accordance with the invention with one contact pin on a battery electrode and with the second contact pin on a point on the conductor arrangement connected to the latter, which allows very precise statements about the

quality of the connection. A statement about the proper functioning of the battery module can be made in an uncomplicated manner with repeated or parallel measurements on all batteries of the battery module.

All connections can be individually tested with a method for testing connections in a battery module containing a plurality of batteries and a bus bar for connecting battery electrodes of said plurality of batteries electrically in parallel, the method comprising: contacting a first contact pin of a resistance measurer with an electrode of one of the plurality of batteries contained within the battery module; contacting a second contact pin of the resistance measurer with a point on a conductor arrangement, wherein said conductor arrangement includes the bus bar, the electrode of another of the plurality of batteries, optionally, a connector element extending between said bus bar and the electrode contacted by the first pin, and optionally, a connector element extending between said bus bar and the electrode of another of the plurality of batteries; and measuring electrical resistance between said first contact pin and said second contact pin using the resistance measurer.. For this, a contact pin can be placed, for example, for each battery on its battery electrode and the other contact pin can be placed on the bus bar. The measuring expense can preferably be cut in half if during the measuring the second contact pin is in contact with said electrode of another of the plurality of batteries. If during a measuring a contact pin is seated on the battery electrode of a battery and the other contact pin is seated on the battery electrode of another battery, then the complete connecting connection between a battery electrode, the bus bar and the other battery electrode can be determined in a measurement. Therefore, two batteries are included at the same time with practically the same measuring expense. Furthermore, during this type of measuring all contact pins contact identical contacting sites, namely, the battery electrodes, as a result of which the construction of the required test device can be simplified.

In another embodiment, during the measuring battery electrodes of adjacent batteries are advantageously contacted. As a result, the conductive connection path between the two contact points is shortened, which increases the measuring accuracy. Furthermore, the required test device can be made smaller since, for example, the required maximal distances between the contact pins are limited. Finally, the advantage of greater clarity and possibilities of simplification result in the control devices and control programs for the contact pins in comparison to a stochastic access method.

If, in a customary manner in each measurement only a pair of contact pins are used, this

results in the case of a battery module with several hundred batteries in a significant number of necessary measuring steps, which prolongs the total test time. Therefore, in another embodiment several pairs of contact pins can be advantageously contacted simultaneously. This means a significant saving of time since the travel times of the contact pins always require the greatest expenditure of time. On the other hand, the actual measuring time is usually negligible. If several pairs of contact pins are contacted simultaneously, they can, for example, also be moved simultaneously and the measurements can take place simultaneously, for example, by several resistance measurers operating in parallel or, for example, by a rapid switching of a resistance measurer onto the different pairs of contact pins.

According to yet another embodiment, in the case of a battery module in which the batteries are arranged in a fixed grid a test head that can be moved over the grid is advantageously provided that carries several contact pins suitably arranged relative to the grid. In particular in the case of battery modules with very many batteries, the testing can be accelerated in this manner. A testing head can travel from position to position and carry out several measurements in parallel. In the case of a high number of contact pins, the work can be carried out very rapidly in this manner.

According to another embodiment, a safety contact pin is provided in an advantageous manner parallel to a contact pin which safety contact pin contacts the same surface. The resistance between both contacting positions can be measured. This yields a statement about the quality of the contacting itself. If the contacting quality is also measured during each connection measurement, the measuring quality can be significantly increased.

A battery module can be advantageously tested according to another embodiment in which the bus bars are constructed as plates with holes arranged in a grid-like pattern under which the associated battery electrodes are arranged. Here the contact pins are arranged and constructed in such a manner that they reach through the holes for the contacting. This makes possible a simple but precise contacting of the battery electrodes from the free side of the plate-shaped bus bar.

According to another aspect, there is provided a method for testing connections in a battery module containing a plurality of batteries and a bus bar for connecting battery electrodes of said plurality of batteries electrically in parallel, the method comprising: moving a first and a second contact pin of a resistance measurer towards the battery module and/or moving

the battery module towards the first and the second contact pin of a resistance measurer and contacting the first contact pin with an electrode of one of the plurality of batteries contained within the battery module and contacting the second contact pin with a point on a conductor arrangement, wherein said conductor arrangement includes the bus bar, the electrode of another of the plurality of batteries; and measuring electrical resistance between said first contact pin and said second contact pin using the resistance measurer; and disconnecting the first and the second contact pin from the electrode and the conductor arrangement; and moving the first and the second contact pin away from the battery module and/or moving the battery module away from the first and the second contact pin.

Brief description of the drawings

The invention is shown by way of example and schematically in the drawings. In the

drawings: module with two test heads,

Fig. 1 shows a side view of a device for testing the connections of batteries of a battery module with two test heads,

Fig. 2 shows an enlarged section along line 2-2 in fig. 1 showing two batteries,

Fig. 3 shows a atop view onto a battery module along line 3 - 3 in fig. 1,

Fig. 4. shows a view of a test head along line 4-4 in fig. 1,

Fig. 5 shows another test head along line 5 - 5 in fig. 1,

Fig. 6 shows another test head.

Detailed Description

Fig. 1 shows a side view of a test device 1 with a frame 2 that connects a module carrier 3 to a head carrier 4 and is placed, for example, with the module earner 3 on a table or floor that is not shown. The module carrier 3 serves to receive the battery module 5 shown in fig. 1, which is to be subjected to a test.

Fig. 2 shows a section from the battery module 5 showing a plate-like upper bus bar 6 and a lower bus bar 7 arranged parallel to it. The bus bars 6 and 7 can be constructed to be congruent and identical. A plurality of batteries 8 is arranged between them that are held standing in parallel in a uniform grid. The carrier structure 9 can serve for holding them and secures the position of all batteries among themselves and with the bus bars 6, 7.

The two batteries 8 shown are of the same type, for example, a commercial AA format. They have a longitudinally extended, cylindrical housing on whose ends battery electrodes 10 and 11 are centrally seated.

The battery electrodes 10 and 11 can be constructed to be mechanically identical, as is also shown in fig. 2, They have a different polarity + and - and are all electrically connected in parallel. To this end the battery electrodes 10 lying toward the upper bus bar 6 and fig. 2 and which are, for example, the + electrodes, are connected to the upper bus bar 6 and the lower battery electrodes 11 are all connected to the lower bus bar 7. in order to simplify the drawing, in fig. 2 the electrode connections to the bus bars are only shown for the upper bus bar 6.

The upper bus bar 6 is provided with holes at the locations where the upper battery's

electrodes 10 are seated. Corresponding holes 12 are also formed in the lower bus bar 7.

Electrically conductive connectors 13 formed, for example, in the shape of wires or bands, are connected by one end to an upper battery electrode 10 and by the other to the upper bus bar 6. The connectors 13 can be constructed here, for example, as a wire that is soldered at its ends to the surfaces of the battery electrode 10 or is connected by spot welding.

The connectors 13 are also to be arranged in a corresponding manner between the lower battery electrodes 11 and the lower bus bar 7. They can have a relatively small cross section since they only have to carry the current of a single battery 8. The bus bars 6 and 7 must also consist of conductive material but require a greater cross section since the current of several batteries flows through them.

Fig. 3 shows a top view onto the battery module 5, the upper bus bar 6 and the holes 12 arranged in them. The holes 12 are arranged in the exemplary embodiment shown in the regular grid shown, in which the batteries 8 and the battery electrodes also stand. Two thick conductor cables 14 and 15 connect the upper bus bar 6 and the lower bus bar 7 to a consumer, for example, a vehicle engine or to control electronics connected in front of the latter.

After the mounting of the battery module 5 it must be tested for manufacturing errors. If it is assumed that the individual batteries 8 were previously tested, then the possibility of errors in the manufacture of the battery module 5 is to be found substantially in the positioning of the connectors 13,

The connectors 13 run in an 8 shape between the surface of the particular battery electrode 10 and the surface of the upper bus bar 6. Electrically conductive connections must be produced at both ends, for example, by spot welding,

Breaks can occur in a connector 13 or a lacking contact on one of its ends if, for example, a soldering or welding took place in an incomplete manner.

Such errors must be checked for with a test and as rapidly as possible in the case of very many connecting connections, for example, 1,000 connectors in the case of a battery module with 500 batteries.

The good conductivity of the connections between the batteries 8 and the bus bars 6, 7 is important here. A resistance measuring is carried out in order to check them. A resistance

measurer is 16 is used for this that is connected by a pair of contact pins 17, 18 to the lines shown in fig. 2.

The resistance measurer 16 comprises a current source 19 and a current measuring device 20 in a customary construction. Given a known voltage of the current source 19, the display of the current measuring device 20 can be unambiguously re-calculated into the measured resistance value. As fig. 2 shows, in the exemplary embodiment the resistance is measured on short connections that conduct well. The resistance measurer 16 should therefore be designed in particular especially for the low-ohmic range.

In order to determine whether a connector 13 is whole and correctly connected at both ends, measurements could be carried out, for example, between the two ends of a connector in order to check it for an interruption. Then, a contacting could be made on the connecting conductor and on the other hand on the bus bar in order to test the correct connection of the connecting conductor on the bus bar.

That would mean several measurements for a connector. In addition, there is the fact that the connecting conductor 13 is sensitive and should not be touched if possible. Therefore, the measuring is carried out in such a manner as is shown in fig. 2, namely, between two battery electrodes of different batteries connected to the same bus bar. In the example of fig. 2 shown, that is the upper bus bar 6.

As Fig. 2 shows, two batteries 8 are measured on which the upper battery electrodes 10 are contacted by the contact pins 17 and 18. Therefore, a current flow is generated that runs from the one battery electrode through its connector 13, then through the upper bus bar 6 and then through the other connector to the battery electrode 10 of the other battery 8. Therefore, two complete battery connections are measured in series. This cuts the number of measurements and therefore the measuring time in half and optimizes the significance of the measuring.

A poor contacting of one of the contact pins 17, 18 could result in a false measurement. In order to check the reliability of the contacting, a safety measuring is carried out. For this, a safety resistance measurer 21 is provided that can have basically the same construction as the resistance measurer 16. It is connected by the two shown conductors to the contact pin 17 on the one hand and to a safety contact pin 22 on the other hand. It can be determined with this safety arrangement if both contact pins 22 and 17 are set on the same conductive surface of the battery electrode 10 whether the contact pins 17 makes a good contact with the battery's

electrode 10. If the measured resistance is above a set value, then the contacting of the contact pins 17 is probably insufficient and must be checked,

A. corresponding safety circuit with a safety contact pin can also be provided on the contact pin 18 in order to be able to guarantee complete contact safety.

As fig. 2 shows, the batteries 8 are connected on the bottom to the lower bus bar 7 in an identical manner. Therefore, the tests can take place here in the same manner.

The test device 1 shown in fig. 1 serves for the testing. It carries the battery module 5 on the module carrier 3. The head carrier 4 carries two head drives 23 and 24 that for their part each carry a test head 25, 26 and can move it in the x, y and z directions in the desired manner.

The test heads 25 and 26 have different sizes and carry a number of contact pins 17, 18.

Resistance measurers are connected to the contact pins in a manner that is not shown and are able to determine the resistance between two contact pins. In another embodiment it is also possible to operate all pairs of contact pins with only one resistance measurer that is constructed so that it can be switched between the pairs for this purpose.

The test heads 25 and 26 have different sizes, as figures 1, 4 and 5 show, in the exemplary embodiment the test head 25 carries eight contact pins and the test head 26 carries four contact pins.

Fig. 6 shows a test head 27 with a different pin arrangement. However, the pin arrangements of all heads 25, 26 and 27 shown obviously fit the grid arrangement of the holes 12 of the battery module 5, as is shown in fig. 3.

Fig. 1 shows the test head 25 in raised position, that is, not contacting, and shows the test head 26 in lowered position, in which the contact pins contact battery electrodes 10 of the battery module 5.

When the top of the battery module 5 has been completely tested, the battery module can be turned around in order to now test the bottom in the same manner.

In the case of a very large battery module 5, test heads 25 with very many pins, for example, the eight pins of the test head 25 shown, can be used. Of course, even much greater test heads can be used in order to further accelerate the testing process.

A test head, for example, the test head 25, can obviously be seen on the surface of the battery

module 5 successively in several adjacent positions with contacting of all its contact pins, which makes it possible to achieve a complete engagement of all holes 12. As fig. 1 show's even test heads 25 and 26 with different sizes can be used. For example, narrow' ranges can be tested with the smaller test head 26 that are too narrow for the large test head 25.

in the case that safety contact pins 22 are used, they' are to be additionally provided on a test head, which can double the number of contact pins on a test head.

Fig. 2 shows the geometry' of the connectors 13 that are arranged in such a manner that they pass through a hole 12 of the bus bar 6. They are sensitive to touch in this area and should not be touched by the contact pins 17, 18. The contact pins 17, 18 and optionally also 22 must therefore be positioned through the hole 12 and adjacent to the connectors 13, that is, in a very narrow area range. The position control of the head drives 23 and 24 is to be constructed in an appropriately precise manner.

LIST OF REFERENCE NUMERALS:

1	Test device	15	Conductor cable
9	Frame	16	Resistance measurer
	Module carrier	17	Contact pin
4	Head carrier	18	Contact pin
5	Battery module	19	Current source
6	Upper bus bar	20	Current measuring device
7	Lower bus bar	21	Safety resistance measurer
8	Battery	22	Safety contact pin
9	Carrier structure	23	Head drive
10	Battery electrode	24	Head drive
11	Battery electrode	25	Test head
12	Hole	26	Test head
13	Connector	27	Test head
14	Conductor cable		

CLAIMS

1. A method for testing connections in a battery module containing a plurality of batteries and a bus bar for connecting battery electrodes of said plurality of batteries electrically in parallel, the method comprising:

moving a first and a second contact pin of a resistance measurer towards the battery module and/or moving the battery module towards the first and the second contact pin of a resistance measurer and contacting the first contact pin with an electrode of one of the plurality of batteries contained within the battery module and contacting the second contact pin with a point on a conductor arrangement, wherein said conductor arrangement includes the bus bar, the electrode of another of the plurality of batteries; and

measuring electrical resistance between said first contact pin and said second contact pin using the resistance measurer; and

disconnecting the first and the second contact pin from the electrode and the conductor arrangement; and moving the first and the second contact pin away from the battery module and/or moving the battery module away from the first and the second contact pin.
2. The method according to claim 1 wherein said conductor arrangement includes a connector element extending between said bus bar and the electrode contacted by the first pin.
3. The method according claim 1 or 2 wherein said conductor arrangement includes a connector element extending between said bus bar and the electrode of another of the plurality of batteries.
4. The method according to any one of claims 1 to 3, wherein during the measuring the second contact pin is in contact with said electrode of another of the plurality of batteries.
5. The method according to claim 4, wherein during the measuring battery electrodes of adjacent batteries in the battery module are contacted by other contact pins of the resistance measurer.
6. The method according to claim 4 or 5, wherein during the measuring several pairs of first contact pins and second contact pins of the resistance measurer contact battery electrodes and points on conductor arrangements, respectively, of other batteries contained in the battery

module at the same time.

7. A device for carrying out the method according to any one of claims 1 to 6 on a battery module in which the plurality of batteries are arranged in a fixed grid, the device comprising a test head configured to move over the grid, said test head carrying a plurality of contact pins arranged to fit the grid.
8. A device according to claim 7, wherein a safety contact pin is connected by a safety resistance measurer to a contact pin of the resistance measurer, and wherein the contact pin and the safety contact pin are configured to simultaneously contact a same contactable surface.
9. A device according to claim 7 or 8, wherein the contact pins are arranged and constructed on the test head such that they are extendable through holes in at least one of the bus bars of the battery module that is in the form of a plate to contact battery electrodes in the battery module under the holes.

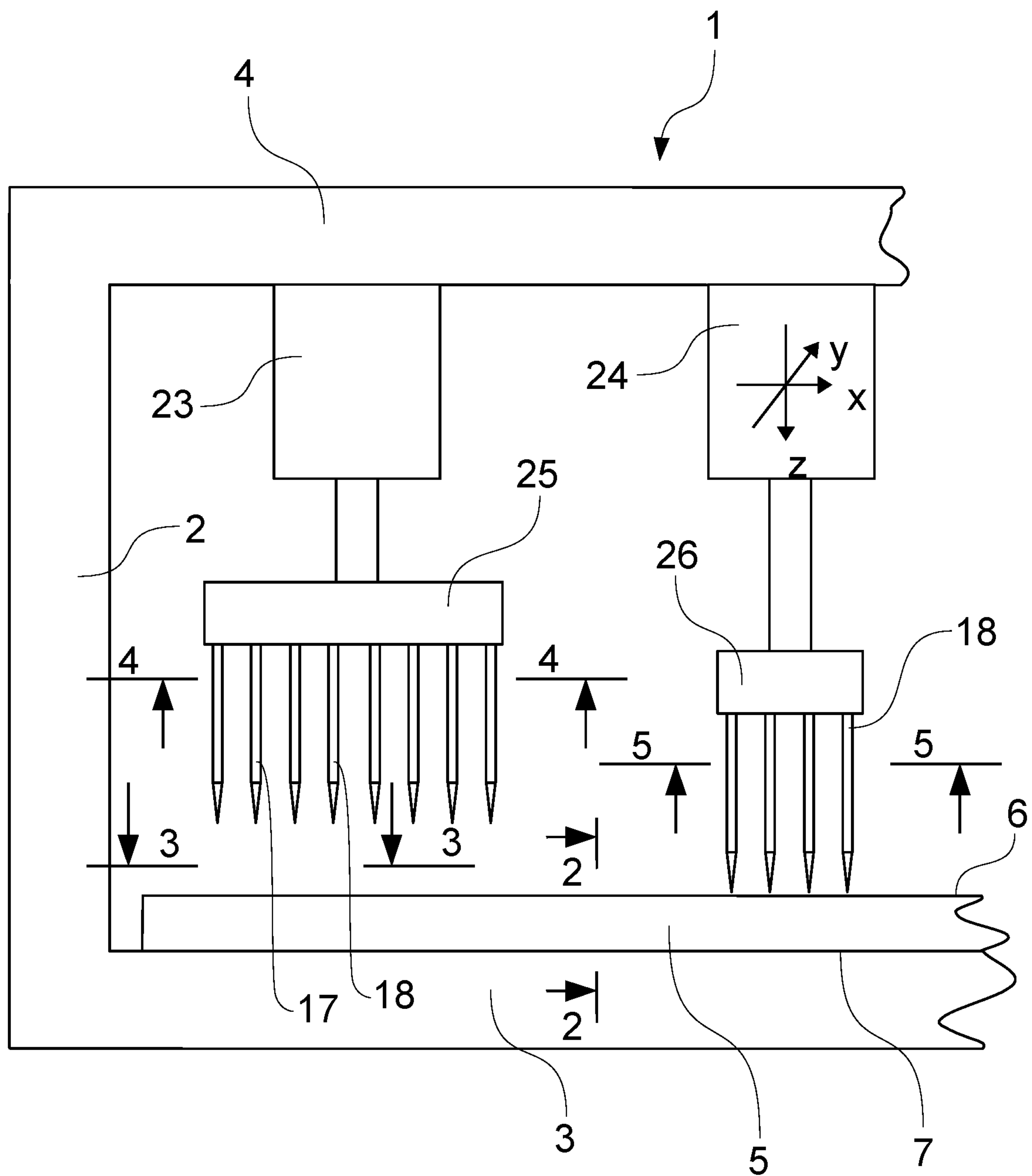
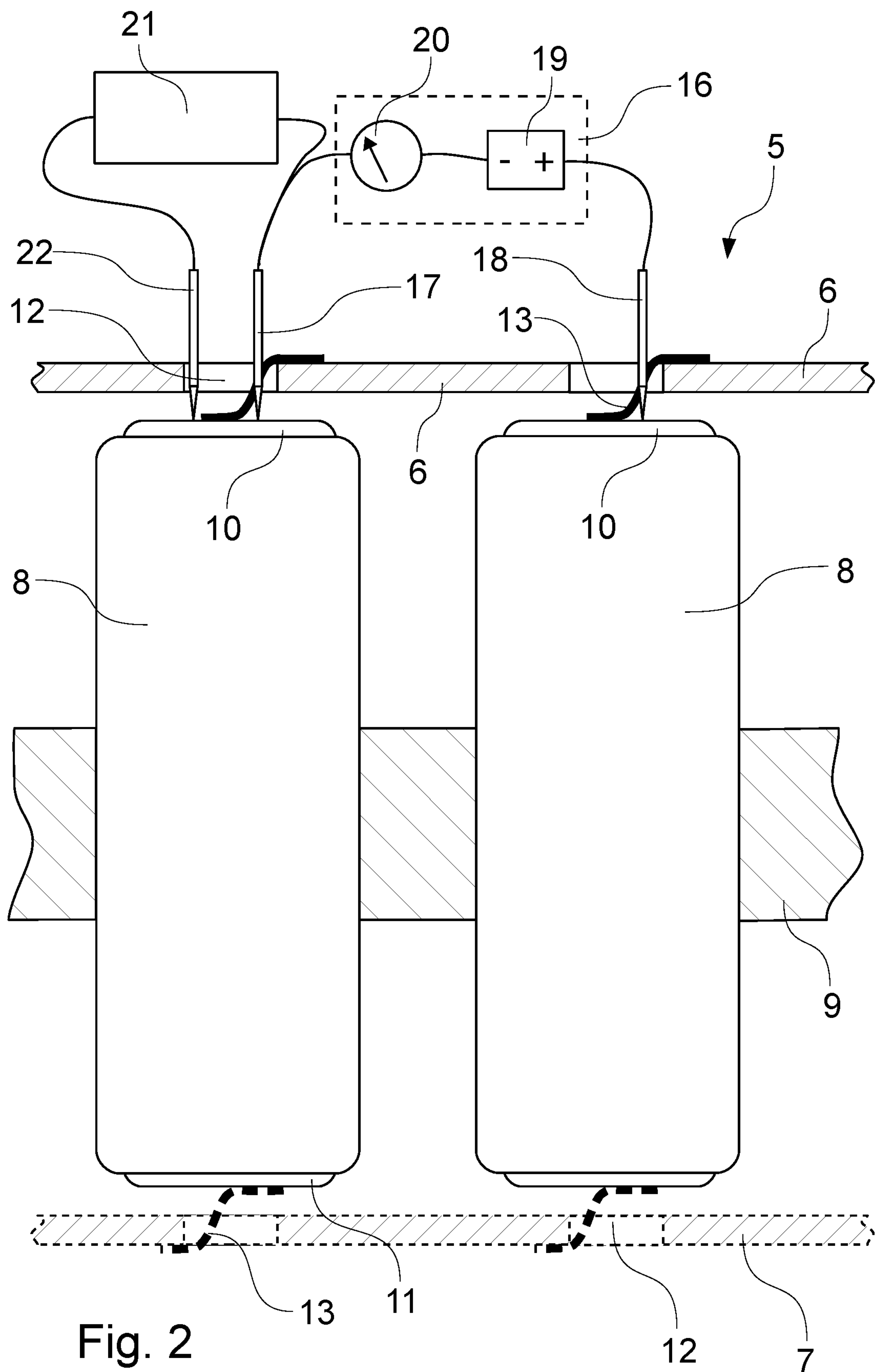


Fig. 1



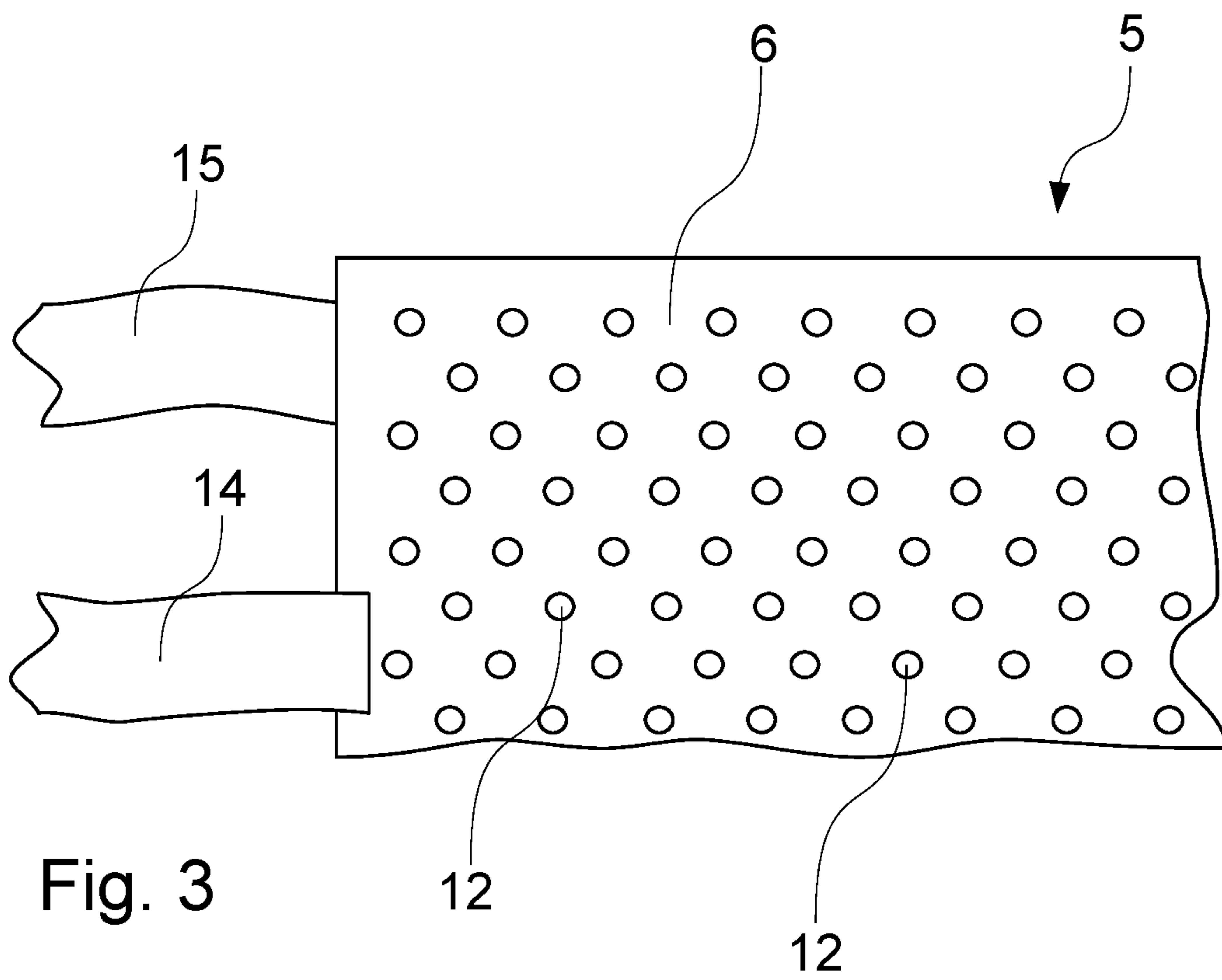


Fig. 4

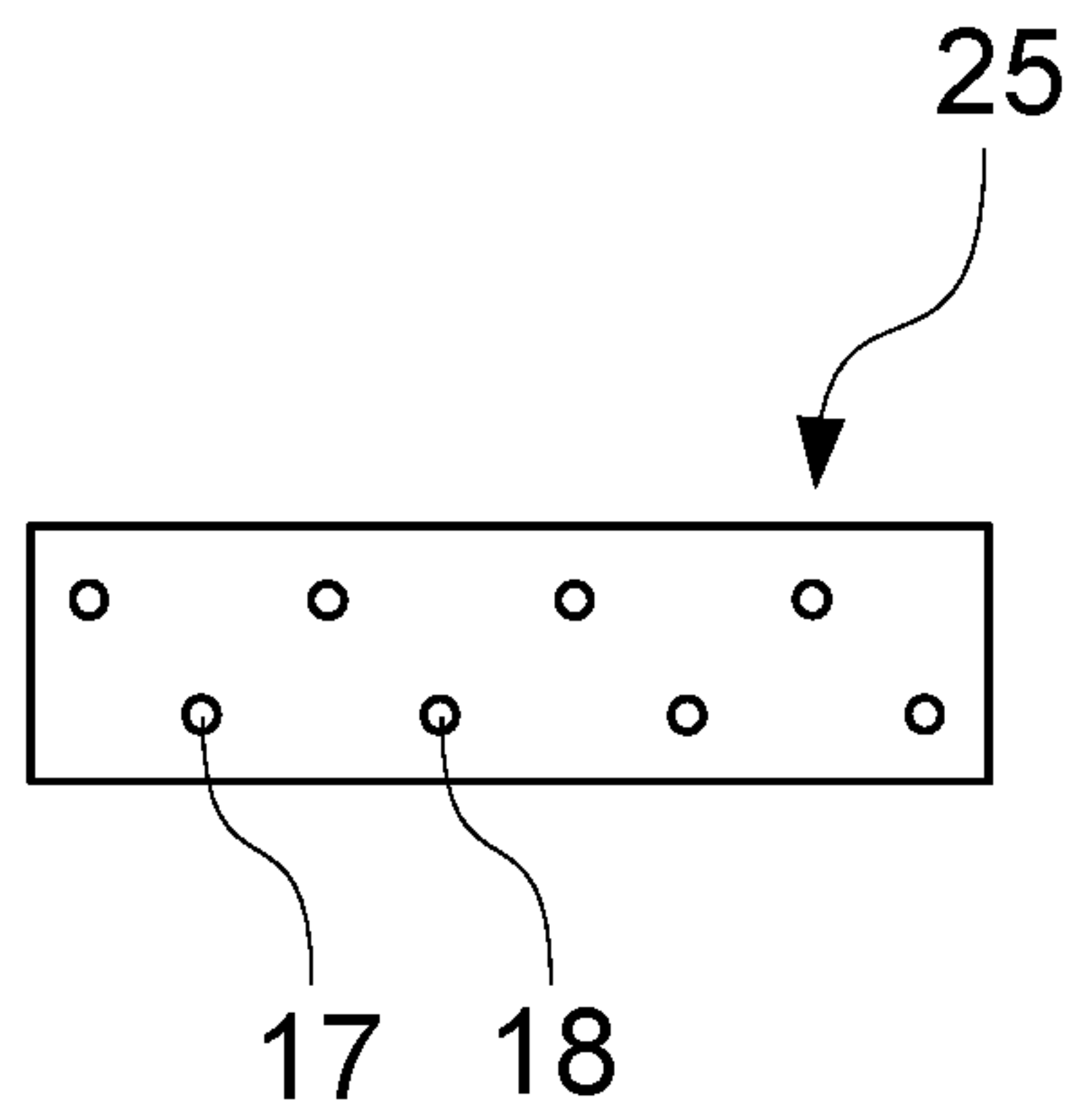


Fig. 5

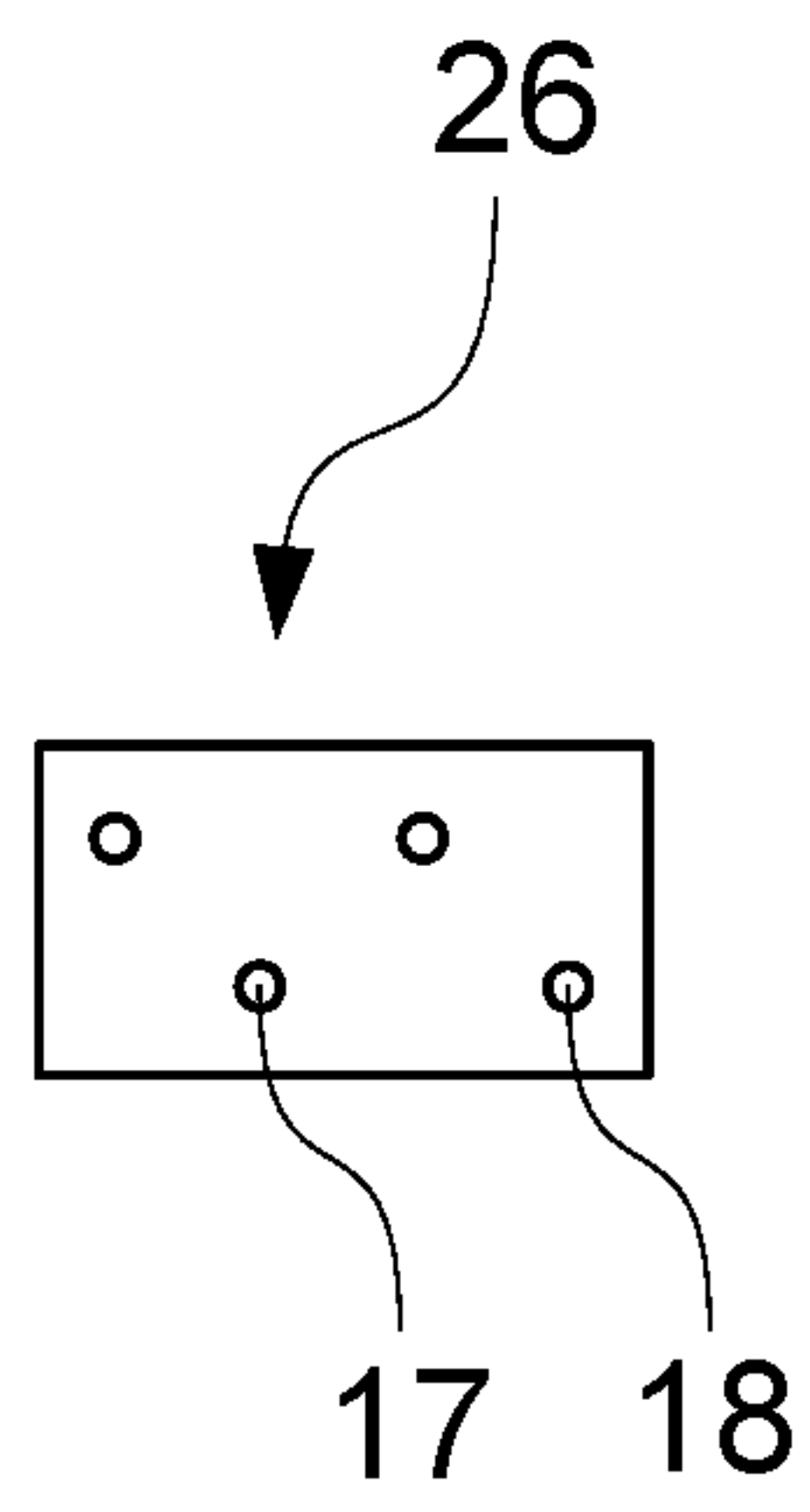


Fig. 6

