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(54) Titre : SYSTEME DE REFROIDISSEMENT ELECTRIQUEMENT ISOLANT ET THERMOCONDUCTEUR EN
PARALLELE DES BATTERIES ET SYSTEME DE REGULATION DE TEMPERATURE

(54) Title: ELECTRICALLY INSULATIVE AND THERMALLY CONDUCTIVE PARALLEL BATTERY COOLING AND
TEMPERATURE CONTROL SYSTEM

(57) **Abrégé/Abstract:**

A battery is provided having heat transfer bars that directly transfer heat between the interior layers of a battery cell and the case that encloses the battery cell. The battery does not transfer significant heat from its interior layers to the posts of the battery that reside outside of the battery case. A temperature-controlled power system also is provided that uses multiple, active thermoelectric devices paired with multiple batteries to provide individual temperature control of the individual batteries forming the power system. The multiple, active thermoelectric devices preferably transfer heat to a single radiator on each side of the power system. A method of transferring heat from a battery interior using conductive, active, and convective heat transfer is also described.

ABSTRACT

A battery is provided having heat transfer bars that directly transfer heat between the interior layers of a battery cell and the case that encloses the battery cell. The battery does not transfer significant heat from its interior layers to the posts of the battery that reside outside of the
5 battery case. A temperature-controlled power system also is provided that uses multiple, active thermoelectric devices paired with multiple batteries to provide individual temperature control of the individual batteries forming the power system. The multiple, active thermoelectric
10 devices preferably transfer heat to a single radiator on each side of the power system. A method of transferring heat from a battery interior using conductive, active, and convective heat transfer is also described.

Electrically Insulative and Thermally Conductive Parallel Battery Cooling and Temperature Control System

REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of U.S. Provisional
5 Application No. 62/827,799 entitled "System and Method for Battery Thermal Management" filed April 1, 2019, which is incorporated by reference in its entirety.

BACKGROUND

[0002] Lithium ion and similar battery types generate significant
10 heat during charging and discharging, especially with rapid charging or discharging as common in automotive power applications. To manage heat removal in the automotive battery context, air and liquid flows have been used to remove heat from the batteries. Conduction of heat from the batteries into thermoelectric materials that then actively transfer the
15 heat to air or fluid flows also have been used to remove heat from the batteries.

[0003] Cells for automotive use batteries may be built up by rolling a continuous sheet having a cathode layer, an electrically insulative separator layer, and an anode layer sandwiched between electrically
20 insulating polymeric exterior layers. By rolling the continuous multi-layer sheet around an interior frame that is then removed to leave a central void, multiple layers of the polymeric exterior are in contact, resulting in a "jelly roll" battery cell. The bare, electrically conductive anode and cathode layers protrude at opposite ends of the jelly roll, as
25 the opposing ends of the continuous sheet lack the electrically insulative

polymeric exterior layers. Folding the polymeric exterior continuous sheet at fixed intervals back onto itself in a Z-pattern can provide a similar battery cell in the form of a flat stack as opposed to a roll – similarly to Post-It™ notes. Thus, the cell of the resulting battery can
5 have a central void if formed as a roll, or can be formed as a solid stack if folded onto itself.

[0004] A cooling method relying on heat transfer through the contacting electrically insulative polymeric exterior layers of the sheet of the roll or stack has the issue that the only way that heat from the
10 interior layers of the cell can reach the exterior of the cell is by passing through multiple layers of polymeric material, which in addition to being an electrical insulator, is a thermal insulator. This type of heat transfer may be thought of as serial heat transfer as heat must pass from an interior layer through additional interior layers to reach an exterior layer,
15 so the heat can be removed from the outermost polymeric exterior layer by the cooling system. Thus, the flat stack can transfer heat from the bottom and top flat, exterior surfaces and a roll can transfer heat to the exterior surfaces outside and inside the roll, but there is no way with either construction to directly transfer heat from the interior layers for
20 the roll or stack without the heat first having to transfer through additional interior layers to reach an exterior layer.

[0005] The only way to directly transfer heat from the interior layers of the cell is through the cathode and anode layers residing in each layer of the rolled or folded sheet. As the cathode and anode materials are
25 often electrically conductive metals, with aluminum forming the cathode (where reduction occurs) and copper forming the anode (where oxidation occurs) for example, a direct heat transfer pathway exists from the

interior layers of the cell out through the cathode and anode layers, which are not covered by the polymeric material. Transferring heat from these protruding electrically and thermally conductive surfaces may be referred to as parallel heat transfer as heat is being transferred directly from multiple interior layers simultaneously to the exterior surfaces that form the cathode and anode.

[0006] An issue with conventional parallel heat transfer techniques, which transfer heat from the interior cathode and anode layers of the cell, is that when the cell is turned into a battery the cathode and anode layers are electrically and thermally connected to relatively small surface area electrodes or “posts”. Thus, the interior cell heat transfers from the relatively large surface areas of the cathode and anode of the cell to the smaller surface area posts residing external to the cell of the battery. In this way the exposed posts of the battery serve as “cold fingers” in relation to the interior layers of the battery cell. Conventionally, bus bars and other thermally conductive components are then attached to the battery posts residing external to the battery, which provide the surface area from which the heat is removed. However, the contact area establishing electrical conductivity between the battery posts and the cathode and anode of the cell limits the rate at which heat may be transferred from the interior layers of the battery to the bus bars and/or other thermally conductive components residing external to the battery.

[0007] Conventional parallel heat removal techniques also exist where a thermally conductive tube is clamped to the cathode and/or anode of the cell where an aqueous liquid is passed through the tube to remove the heat from the cathode and/or anode. This design does not limit heat transfer from the interior layers of the battery with the

connection between the cathode and anode electrode posts being a choke point as the previously discussed “post only” conventional designs. However, these “internal liquid” designs suffer from being difficult to manufacture as the tube must be made from a thermally but not
5 electrically conductive material to prevent shorting between the cathode and/or anode and the circulating liquid. Furthermore, especially in automotive applications, as the liquid is in close proximity to the battery cell, such designs have a high probability of the aqueous liquid coming in contact with the cathode, anode, and/or cell materials and causing
10 extreme heating and fire if the battery is damaged in an accident.

[0008] As can be seen from the above description, there is an ongoing need for simple and efficient designs and materials to cool batteries during charging and discharging, especially in the context of lithium ion batteries used in automotive power applications. The
15 designs, devices, and materials of present invention overcome at least one of the disadvantages associated with conventional devices.

SUMMARY

[0009] The present design provides a battery with or without active cooling provided by thermoelectric devices and/or a heat transfer fluid
20 that makes possible high battery charge and discharge rates, thus extreme fast charging and discharging, without overheating the cell of the battery. The design enables longer and thicker cells to be used in constructing the battery, significantly improved cell life, and ease of manufacture and assembly.

25 **[0010]** The present design of a temperature-controlled power system provides many benefits, including nearly silent operation, high capacity

cooling and heating in one unit, lower parasitic heat loads in relation to conventional systems, reduced temperature gradients between batteries, and the ability to simultaneously heat and cool different batteries.

[0011] In one aspect, the invention provides a battery including a
5 parallel heat transfer system, where the battery includes a case
comprising a can attached to a lid; a cell having first and second
electrodes exposed from an exterior layer of polymeric material of the cell,
the at least two electrodes comprising an anode electrode and a cathode
electrode, where the case encloses the cell; at least two posts exposed
10 from the case; at least two contacts enclosed by the case, where a first of
the at least two posts is in electrical communication with a first of the at
least two contacts and a second of the at least two posts is in electrical
communication with a second of the at least two contacts; and at least a
first heat transfer bar in electrical and thermal communication with the
15 first electrode and the first of the at least two contacts, where the first
heat transfer bar comprises a first side that is thermally and electrically
conductive and a second side that is thermally but not electrically
conductive. The battery may include a second heat transfer bar
configured similarly to the first.

20 **[0012]** In another aspect of the invention, there is a temperature-
controlled power system, the temperature-controlled power system
includes batteries; and a thermal transfer system, where the thermal
transfer system includes at least one circuit board; control circuitry in
electrical or wireless communication with the at least one circuit board;
25 at least two active thermoelectric devices held by the at least one circuit
board, where each of the at least two active thermoelectric devices
contacts and is in thermal communication with a different battery; and

at least one radiator in conductive heat transfer with the at least two active thermoelectric devices. The power system may include additional active thermoelectric devices in a second circuit board that contact a second radiator on the opposite side of the batteries.

5 **[0013]** In another aspect of the invention, method of transferring heat from a battery cell to surrounding air includes generating heat from the interior layers of a cell by flowing current into or out of the cell; conductively transferring the heat from cathode and anode layers of the interior layers of the cell to an exterior cathode electrode of the cell and
10 to an exterior anode electrode of the cell; conductively transferring the heat from at least one of the electrodes to a heat transfer bar contacting the at least one of the electrodes; conductively transferring the heat from the heat transfer bar through a thermally conductive and electrically insulative material into an interfacing face of the heat transfer bar;
15 conductively transferring the heat from the interfacing face into a can of the battery; conductively transferring the heat from the can of the battery to a cold side of an active thermoelectric device, where the active thermoelectric device transfers the heat from the cold side to a hot side; conductively transferring the heat from the hot side of the thermoelectric
20 device to a radiator, where the radiator convectively transfers the heat to surrounding air. The radiator may conductively transfer the heat to a heat transfer fluid that convectively transfers the heat to the surrounding air after the heat transfer fluid leaves the radiator.

[0014] Other systems, methods, features and advantages of the
25 invention will be, or will become, apparent to one with skill in the art upon examination of the following figures and detailed description. It is intended that all such additional systems, methods, features, and

advantages be included within this description, be within the scope of the invention, and be protected by the claims that follow. The scope of the present invention is defined solely by the appended claims and is not affected by the statements within this summary.

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BRIEF DESCRIPTION OF THE FIGURES

[0015] The invention can be better understood with reference to the following drawings and description. The components in the figures are not necessarily to scale, emphasis instead being placed upon illustrating the principles of the invention.

10 **[0016]** FIG. 1 represents a battery cell and a pair of heat transfer bars.

[0017] FIG. 2 represents a battery including a case that encloses a cell in thermal and electrical communication with heat transfer bars.

15 **[0018]** FIG. 3 represents a temperature-controlled power system including a thermal transfer system and multiple assembled batteries.

[0019] FIG. 4A represents a close-up and thus more detailed view of the temperature-controlled power system as previously represented in FIG. 3.

20 **[0020]** FIG. 4B represents a close-up and thus more detailed view of the TEDs held in the circuit board by the slots.

[0021] FIG. 4C represents an additional circuit board design where two TEDs reside on the same side at each battery position.

[0022] FIG. 5A represents one implementation of a radiator showing a cut-away of the interior.

[0023] FIG. 5B provides a representation of a compression plate including holes.

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DETAILED DESCRIPTION

[0024] A battery is provided having heat transfer bars that directly transfer heat between the interior layers of a battery cell and the case enclosing the battery cell. The battery does not transfer significant heat from its interior layers to the posts of the battery that reside outside of
10 the battery case. A temperature-controlled power system also is provided that uses multiple, active thermoelectric devices paired with multiple batteries to provide individual temperature control of the individual batteries forming the power system. The multiple, active thermoelectric devices preferably transfer heat to a radiator on each side of the power
15 system. While the application is written mostly in the context of cooling a battery or batteries, the battery or batteries could likewise be heated by supplying heat to the thermal transfer system from an exterior source.

[0025] FIG. 1 represents a battery cell **105** and a pair of heat transfer bars **150**. The cell **105** includes an exterior layer **110** of the
20 polymeric material that forms the outside layers of the continuous sheet that also forms interior layers **120** of the cell **105**. The polymeric material forming the exterior layer **110** is electrically insulative and a relatively poor thermal conductor. The cell **105** includes electrodes **130** formed from the anode and cathode layers that are continuous through
25 the sheet and are separated by an electrically insulating spacer layer that also is continuous through the sheet. The electrodes **130** are made from

an electrically and thermally conductive material, preferably a conductive metal such as copper, aluminum, and the like. The electrodes **130** extend outside of the exterior layer **110** of the polymeric material.

[0026] The heat transfer bars **150** are formed from an electrically and thermally conductive material, preferably a conductive metal such as copper, aluminum, steel, iron, and the like. Preferably, the heat transfer bars **150** are solid conductive metal. The heat transfer bars **150** hold through contact, such as ultrasonic welding or interference fit, with the electrodes **130**. The heat transfer bars **150** may be force fit to the electrodes **130**, may be heated and contacted with the electrodes to achieve an interference fit upon cooling to the temperature of the electrodes **130**, or may be welded together, such as ultrasonically, and the like. While two heat transfer bars **150** are represented, one may be used on either of the two electrodes **130**.

[0027] The heat transfer bars **150** are in close or direct contact with the electrodes **130** and thus preferably do not include a space where a liquid can readily flow between the electrodes **130** and the heat transfer bars **150**. Thus, the heat transfer bars **150** preferably lack interior passages capable of transporting a liquid.

[0028] The heat transfer bars **150** contact at least 60% of a longitudinal length of the electrodes **130**, preferably at least 80% of the longitudinal length of the electrodes **130**. Preferably the heat transfer bars **150** are in contact with at least 70% of a lateral width of the exposed electrodes **130**, more preferably at least 90% of a lateral width of the exposed electrodes **130**. While the cell **105** is represented with rectangular shaped electrodes and thus corresponding rectangular

shaped channels in the heat transfer bars **150**, other geometric shapes may be used for the electrodes **130** and the heat transfer bars **150** that provide the desired contact between the two. For example, cross-sectionally circular or dove-tail shaped electrodes would have circular cross-section or dove-tail shaped heat transfer bars respectively, as shown in the figure inset.

[0029] The heat transfer bars **150** have a surface opposite where the electrodes **130** clamp that is coated with a thermally conductive and electrically insulative material. Thus, the heat transfer bars **150** have a first or inner side that is a thermally and electrically conductive side **170** contacting the electrode **130** and a second or outer side that is a thermally but not electrically conductive side **180** contacting an interior side of the battery case (not shown). The outer side **180** preferably includes a geometric pattern that forms an interfacing face **185**.

[0030] The thermally conductive but electrically insulative material of the outer side **180** of the heat transfer bars **150** is preferably a dielectric material, such as anodizing, a non-electrically conductive paint, or a plasma electrolytic oxidation (PEO) coating. Preferably, the thermally conductive but electrically insulative material is a PEO material, such as available from Keronite, Greenwood IN or from IBC Group, Lebanon IN under the tradename Ceratough™.

[0031] FIG. 2 represents a battery **200** including a case **290** that encloses a cell **205** in thermal and electrical communication with heat transfer bars **250**. The battery **200** may be used individually or multiples of the battery **200** may be electrically combined to provide increased voltage and/or amperage. The case **290** includes a can **292**

and a lid **295**, where the lid **295** forms a seal (not shown) with the can **292**. The case **290** is made from a thermally conductive material that may or may not be electrically conductive. Preferably, the case **290** is made from a metal, such as aluminum, steel, copper, magnesium, or the like. Preferably the seal between the can **292** and the lid **295** substantially excludes moisture from the cell **205**, and more preferably substantially excludes moisture and air from the cell **205**. The seal may be provided through laser welding, by metal edges that do or do not distort on compression, a gasket, an adhesive, combinations thereof, and the like and may or may not provide thermal conduction between the can **292** and the lid **295**. Preferably, the seal is formed from laser welding the can **292** to the lid **295**.

[0032] The can **292** provides the primary path for heat transfer, whether through convection or conduction, from the cell **205** and thus the battery **200**. Substantially all the heat drawn from the interior layers of the cell **205** is passively transferred to the exterior surfaces of the can **292**. Furthermore, at least 70% of the heat drawn from the cell **205** is passively transferred to exterior surfaces of the can **292**, preferably at least 90% of the heat drawn from the cell **205** is passively transferred to the exterior surfaces of the can **292**. While not shown in the figure, the case **290** may include one or more temperature sensors that sense the temperature of the can **292** and/or case **290**, the cell **205**, the electrodes **230**, and/or heat transfer bars **250**.

[0033] The can **292** preferably includes a receiving geometric pattern **287** on opposing interior sides that receives interfacing face **285** of the heat transfer bars **250**. In this context “interfacing” preferably means that once joined, the heat transfer bars **250** and the receiving

geometric pattern **287** on the interior of the can **292** limit movement of the heat transfer bars **250** in at least one dimension. While the figure represents the battery **200** as having two of the heat transfer bars **250** on opposite sides of the cell **205** and two of the receiving geometric
5 patterns **287** on the opposite interior sides of the can **292**, if less cooling is desired for the cell **205**, a single heat transfer bar may be interfaced with a single receiving geometric pattern on the interior of the can **292**.

[0034] The interfacing face **285** preferably contacts at least 60% of an interior length of the can **292**, thus the can **292** preferably includes
10 the receiving geometric pattern **287** along at least 60% of an interior length. The interior length may be a shorter or longer interior side of the can **292**. More preferably, the interfacing face **285** contacts at least 80% of the interior length of the can **292**, with the can **292** including the receiving geometric pattern **287** along at least 80% of the interior length.
15 The contact between the electrodes **230** and the heat transfer bars **250** provides a primary thermal transfer path from the cell **205** to the exterior surfaces of the case **290** through conduction. With regard to the interfacing face **285**, contact includes the circumstances where dielectric grease and other such materials are used to provide or enhance the
20 contact, thus enhancing thermal conductivity in relation to having thermal insulation arising from an air-gap, and exclude contaminants.

[0035] In addition to the receiving geometric pattern **287**, the can **292** preferably also includes one or more interior surfaces making contact with exterior layer **210** of the cell **205**. More preferably, the can
25 **292** includes two opposing interior surfaces making contact with the exterior layer **210** of the cell **205**. The contact between the interior surface of the can **292** and the exterior layer **210** of the cell **205** provides

a secondary thermal transfer path from the cell **205** to the exterior surfaces of the case **290** through conduction. However, as the primary thermal transfer path is from the electrodes **230** through the heat transfer bars **250** and into the case **290**, the secondary thermal transfer
5 between the exterior layer **210** and the case **290** may serve to heat the exterior layer **210**, thus providing the benefit of a reduced temperature gradient across the exterior and interior layers of the cell **205**.

Additionally, if the can **292** is thermally insulated from the lid **295** by the seal, the temperature of the can **292** will be significantly higher than
10 the temperature of the lid **295**, as the lid **295** is thermally insulated from the can **292**, which receives primary heat transfer from the heat transfer bars **250** and secondary heat transfer from the exterior layer **210**.

[0036] The lid **295** includes electrode contacts **240** that establish electrical communication between electrodes **230** and battery posts **245**.
15 The contacts **240** reside in the interior of the case **290**, while the posts **245** extend to the exterior of the case **290** to provide electricity to the load. The posts **245** are electrically insulated from the lid **295**. While the lid **295** is preferably made from the same thermally conductive material as the can **292** for ease of manufacture, as the lid **295** may be
20 formed from a relatively poor thermally conductive material in relation to the can **292**. The lid **295** may be made from a polymeric and/or composite material that is thermally and/or electrically insulative. Thus, while preferable that the exterior surfaces of the case **290** are efficient thermal transmitters, thermal transfer from the cell **205** may be
25 substantially limited to the can **292**.

[0037] The contacts **240** are made from an electrically conductive material that also may be thermally conductive, such as copper,

aluminum, steel, magnesium, and the like; however, the contacts **240** do not have to be thermally conductive. The posts **245** are made from an electrically conductive material that also may be thermally conductive, such as copper, lead, aluminum, and the like; however, the posts **245** do not have to be a good thermal conductor. Thus, unlike the can **292**, the posts **245** do not have to be thermally conductive.

[0038] The contacts **240** engage with electrically and thermally conductive side **270** of the heat transfer bars **250** to establish electrical communication between the electrodes **230** and the posts **245**, thus providing electrical communication between the “inside” and the “outside” of the battery **200**. This engagement may be purely mechanical, such as when spring force holds the contacts **240** against the thermally conductive side **270** of the heat transfer bars **250** after the contacts **240** are forced onto the heat transfer bars **250**. Engagement between the contacts **240** and the thermally conductive side **270** of the heat transfer bars **250** also may be permanent, such as when the contacts **240** and the thermally conductive side **270** of the heat transfer bars **250** are welded together. Ultrasonic welding is preferred.

[0039] Unlike the heat transfer bars **250** that engage at least 60% of the longitudinal length of the electrodes **230** to provide primary thermal transfer from the cell **205**, the contacts **240** can engage a relatively small surface area of the conductive side **270** of the heat transfer bars **250** as efficient electrical communication and not thermal communication with the electrodes **230** is required. Preferably the relatively small surface area of the conductive side **270** of the heat transfer bars **250**, is less than 30% of the longitudinal length of the first side of the heat transfer bars **250**.

[0040] The posts **245** may provide a relatively minor third path of thermal transfer from the cell **205**, but as the posts **245** are electrically insulated from the lid **295**, and likewise substantially thermally insulated from the lid **295**, heat does not effectively conductively transfer
5 from the contacts **240** to the exterior surfaces of the case **290**. This is very different that conventional designs requiring significant contact between the posts and the electrodes for cooling when both electrical and primary heat transfer from the cell is shared through the posts.

[0041] FIG. 3 represents a temperature-controlled power system
10 **302** including a thermal transfer system **301** and multiple assembled batteries **300**. The thermal transfer system **301** includes at least one radiator **320**, and preferably includes at least one circuit board **358** and at least two active thermoelectric devices **352**.

[0042] The batteries **300** of the temperature-controlled power
15 system **302** may be conductively cooled by active thermoelectric devices **352** that are convectively cooled by the surrounding air. The batteries **300** may be conductively cooled by the one or more radiator **320** that transfers heat to the surrounding air and/or into a heat transfer fluid (not shown). The batteries **300** may be conductively cooled by active
20 thermoelectric devices **352** that are conductively cooled by one or more radiator **320** that convectively transfers heat to the surrounding air or preferably transfers heat into a heat transfer fluid.

[0043] The heat originating from the multiple batteries **300** may be directly convectively transferred to the surrounding air, or conductively
25 transferred to active thermoelectric devices that are then directly convectively cooled by the surrounding air. However, in either instance,

the “surrounding air” may be replaced by one or more radiators **320** that adsorb the heat for transfer into the surrounding air and/or into a heat transfer fluid passing through the one or more of the radiators **320**.

[0044] The temperature-controlled power system **302** includes
5 battery carrier **304** that carries the batteries **300**, optional circuit board **358** and TEDs **352**, and optional radiator **320**. As previously discussed, when the batteries are directly cooled by convection, the circuit board **358**, TEDs **352**, and radiator **320** are omitted. When the radiator **320** is in the form of a convective heat sink that conductively adsorbs heat from
10 the batteries **300** and convectively radiates the heat to the surrounding air, the circuit board **358** and TEDs **352** may be omitted. When the TED’s directly radiate heat to the surrounding air convectively, the radiator **320** may be omitted. Preferably, the temperature-controlled power system **302** includes the circuit board **358**, the TEDs **352**, and
15 the radiator **320**, thus having ability to conductively transfer heat from the batteries to the TEDs and then conductively transfer heat from the TEDs to the radiator, where the radiator transfers the adsorbed heat to a circulating heat transfer fluid – thus permitting the heat to be convectively lost at a location distanced from the temperature-controlled
20 power system **302**.

[0045] The battery carrier **304** preferably provides a base **303** on which the batteries **300** reside. The battery carrier **304** also preferably provides one or more divider and ends **306**, **308** that separate the batteries **300** and that retain the vertical positioning of the batteries
25 **300**, respectively. While not shown in the image, the battery carrier **304** may omit the dividers **306** when thermal conductivity between the batteries **300** is desired. When the battery carrier **304** includes the

dividers **306**, the thermal insulation between the batteries **300** provided by the dividers **306** permits thermal control of each of the batteries **300** individually when individual active thermoelectric devices are used for cooling of the batteries **300**. Thus, it is possible to heat a first subset of the batteries **300** while simultaneously cooling a second subset of the batteries **300**. The ability to monitor and control the temperature of the batteries **300** individually is advantageous when multiple of the batteries **300** are electrically connected in series to increase voltage over that of a single battery or are electrically connected in parallel to increase current over that of a single battery. In either instance the batteries **300** on the “ends” of the battery carrier **304** have a tendency to heat at a slower rate than the batteries **300** at the “middle” of the battery carrier **304**. Thus, individual battery temperature monitoring and control advantageously provides the benefit of a reduced temperature gradient across the batteries **300** when at least three of the batteries **300** are present.

[0046] The battery carrier **304** is preferably made from an electrically insulating and thermally insulative material, preferably a polymer composite, such as glass filled nylon, polypropylene, ABS, and the like. While a single material is represented in the figure, multiple insulative materials may be used to form the battery carrier **304**. The battery carrier **304** may be formed from a single or from multiple parts, for example, when the divider and ends **306**, **308** are separate parts that are attached to the base **303** of the battery carrier **304**. The battery carrier **304** may include mounting points such as studs (not shown) and/or threaded inserts **325**.

[0047] The circuit board **358** holds the active thermoelectric devices (TEDs) **352**. The TEDs **352** have slots **353** on opposing longitudinal

sides that permit the TEDs to slide into the circuit board **358** and be movement constrained in the dimensions perpendicular to the circuit board **358**. The circuit board **358** includes cut-outs **355** to receive and hold the TEDs **352** and to prevent substantial side to side movement of the TEDs **352** in the plane of the circuit board **358**. Thus, the TEDs **352** can move up and down in the plane of the circuit board **358**, but the slots **353** prevent perpendicular movement in and out of the plane of the circuit board **358**. The circuit board **358** preferably includes holes **322** that may be used to affix the circuit board **358** including the TEDs **352** to the battery carrier **304**, thus creating contact between the TEDs **352** and the batteries **300**.

[0048] The TEDs **352** slide into the cut-outs **355** of the circuit board **358** until electrical contacts **354** electrically and mechanically engage with the circuit board **358** connectors **356**. Once the contacts **354** engage the connectors **356** through interference fit, the TEDs **352** can no longer freely move up and down in the plane of the circuit board **358**. The sizing of the openings in the circuit board **358** correspond with the slots **353** in the TEDs **352**. The sizing of the TEDs **352** preferably corresponds to the width and height of the exposed sides of the batteries **300**. Thus, the TEDs **352** directly contact and conductively transfer heat from the individual cases of the batteries **300**, preferably with an individual TED **352** or two for each battery **300**, thus allowing individual batteries **300** to be heated or cooled.

[0049] The TEDs **352** do not directly contact or transfer heat from the battery posts **345** or associated bus bars and related structures (not shown) that may be used to carry the primary current to and from the batteries **300**. Thus, the hot and cold sides of the TEDs **352** are not in

contact with the primary current carrying components of the system,
which facilitates manufacturing.

[0050] Preferably, at least 30% of the area of the side of each battery contacts and is thus in conductive thermal communication with a side of
5 the corresponding TED **352**, more preferably at least 60% of the area of the side of each battery is in contact and thus conductive thermal communication with a side of the corresponding TED **352**. When the temperature-controlled power system **302** includes TEDs **352** on opposite sides of the batteries **300**, as represented in the figure, each of
10 the batteries **300** is in contact with two TEDs **352**, one contacting each of the two opposing sides not contacting the battery carrier **304**. Preferably, the TEDs **352** are not in contact with the top of the batteries **300**, thus not in contact with the battery lids.

[0051] The radiator **320** may not include a heat transfer fluid, thus
15 being a heatsink that directly transfers heat to the surrounding air through fins and the like. Preferably, the radiator **320** includes a heat transfer fluid which circulates through internal passageways in the radiator **320** to transfer heat from the TEDs **352** to the heat transfer fluid.

[0052] While one side of the temperature-controlled power system
20 **302** is represented as a cut-away in this figure, thus showing one outer partial side of the batteries **300**, a partial outer face of a first circuit board, a partial inner face of a second circuit board that is not obscured by the batteries **300**, and a portion of a single radiator opposite the cut-
25 away side not obscured by the circuit board, the temperature-controlled power system **302** may be similarly configured with a circuit board,

TEDs, and radiator on one or more sides, preferably the two opposing longitudinal sides as represented in the figure.

[0053] FIG. 4A represents a close-up and thus more detailed view of the temperature-controlled power system as previously represented in FIG. 3. Opposing, longitudinal slots **453** of the TEDs **452** are seen holding opposing longitudinal sides of the TEDs **452** in the plane of circuit board **458**. The figure also represents that the width of the TED **452** approximately corresponds to the width of the battery **400**, as is preferred. The TED **452** has a cold side in contact with the side of the battery **400**, and a hot side in contact with radiator **420** when actively cooling the battery **400**.

[0054] FIG. 4B represents a close-up and thus more detailed view of the TEDs **452** held in the circuit board **458** by the slots **453**. Control circuitry **459** including at least one processor and memory storage is also represented on the circuit board **458** that can monitor temperature sensors (not shown), which may be placed inside or outside the case of the battery **400** to adjust the voltage and/or polarity of the potential applied to the TEDs **452** in response to temperature readings obtained from the sensors. The control circuitry **459** also may monitor temperature sensors (not shown) incorporated with the radiator **420** or a heat transfer fluid to further alter the voltage and/or polarity of the potential applied to the TEDs **452**. By reversing the polarity between a first and a second opposite polarity input to the TEDs, the system can switch between cooling or heating the batteries **400**, respectively.

[0055] The temperature sensors may be thermocouples or like physical devices, or other parameters of the batteries may be monitored,

and these parameters turned into temperature readings of the batteries via an algorithm. Additionally, the side of one or more of the TEDs **452** contacting a battery may be used as a temperature sensor by measuring the Seebeck voltage across the TED. Other methods of obtaining
5 temperature information may be used. While the figure represents the control circuitry **459** being incorporated into the circuit board **458**, the control circuitry **459** may be remotely located and in electrical or wireless communication with the circuit board **458**.

[0056] In view of the available temperature information, battery
10 load, and the like, the control circuitry **459** also may alter the rate of heat transfer fluid flow through the radiator **420** by adjusting the operation of a circulating pump or similar fluid flow device (not shown). The control circuitry **459** preferably includes the ability to independently adjust the TED **452** or pair of TEDs **452** that cool or heat a single battery
15 **400**. In addition to adjusting the input to the TEDs **452** in response to the temperature sensors, the control circuitry **459** also may adjust the current outflow or inflow to individual batteries **400** or to all the batteries **400** to prevent damage to the batteries **400** under extreme load or charging conditions. Thus, the control circuitry **459** also may manage
20 charging and/or discharging of the batteries **400** to optimize performance and/or longevity of the batteries **400**.

[0057] FIG. 4C represents an additional circuit board **458** design where two TEDs **452** reside on the same side at each battery location. As with the circuit board **458** design of FIG. 3, the TEDs **452** incorporate
25 slots that slide into the circuit board **458** to constrain perpendicular movement of the TEDs **452** and engage a “bottom” connector to constrain planar movement while held in the circuit board **458**. In this

implementation, at each battery position the circuit board **458** includes two connectors **456** which engage a first TED **452** from the “top” and a second TED **452** from the “bottom”. Thus, there are corresponding “top” and “bottom” connectors **456** that prevent the TEDs **452** from sliding out
5 of the circuit board **458**. The circuit board **458** includes the control circuitry **459** and holes **422** that may used to affix the circuit board **458** to the battery carrier, thus brining the TEDs **452** in contact with the batteries. In this implementation, the control circuitry **459** has the additional ability to independently control the temperature of each
10 battery, as a single circuit board may have two individually controllable TEDs **452** at each battery location.

[0058] FIG. 5A represents one implementation of a radiator **520** showing a cut-away of the interior. The radiator **520** may have a “plate and fin” design as represented in the figure where there are fins **521**
15 positioned within the interior between the two outer plates **524**. Preferably, the fluid passages in the plates **524** are sized and configured so that fluid flow is substantially equalized through the fins **521**. As represented in the figure, on the fluid inlet side the upper longitudinal portion of the plate starts at a larger diameter than where it ends, while
20 the lower longitudinal fluid plate diameter is larger near the fluid exit. In this way larger inlet diameters to the fins are paired with smaller exit diameters from the fins so fluid flow is equalized through the multiple sets of the fins **521**.

[0059] Heat is removed from the radiator **520** by a heat transfer
25 fluid (not shown) flowing through the radiator **520**. The heat transfer fluid includes fluids that transfer heat primarily through a phase change.

[0060] The radiator **520** may include attachment spacers **523** that contact the battery carrier and that include holes **522** that may be used to affix the radiator **520** to the TEDs, and then to the battery carrier. The spacers **523** provide a solid surface for the holes **522** and assist in preventing the fins **521** from being damaged when the radiator **520** is tightly affixed.

[0061] The fins **521** are preferably positioned where the TEDs are located in the circuit board to enhance cooling within the radiator **520** at these locations and to assist in providing structural integrity to the radiator **520** when the radiator is tightly affixed. While a specific plate and fin implementation is represented in the figure, other implementations may be used that provide the desired contact with the TEDs.

[0062] FIG. 5B provides a representation of a compression plate **580** including holes **523**. The compression plate **580** may be placed on the outside face of the radiator **520** to provide a clamping force that holds the radiator **520** to the TEDs of the circuit board and then the TEDs to the batteries. Studs (not shown) may be provided in the battery carrier that extend through the holes in the circuit board, the holes **522** in the radiator **520**, and through the holes **523** in the compression plate **580**. Nuts (not shown) may then be threaded onto the studs to apply compression force to the compression plate **580**, thus applying relatively even compression force to hold the radiator and the circuit board to the batteries and the battery carrier. Alternatively, bolts (not shown) may be passed through the holes **523** that thread into threaded inserts (not shown) in the battery carrier to provide a similar compression force to the compression plate **580**. Alternatively, if the battery carrier lacks

thermal spacers between the batteries, thus placing the battery cases in contact, the sides of the battery cases may be equipped with studs for attachment of the compression plate **580**.

[0063] To provide a clear and more consistent understanding of the specification and claims of this application, the following definitions are provided.

[0064] Conduction is the transfer of heat through contact with a solid.

[0065] Convection is the transfer of heat through the movement of a contacted fluid.

[0066] Thermoelectric devices (TEDs) are solid-state devices that provide a cold side and a hot side in response to an electrical input. Thus, when an electric potential is applied to a thermoelectric device, the device moves heat from the cold side of the device to the hot side of the device. Reversing the applied potential results in heat traveling through the device in the opposite direction, thus reversing the hot and cold sides of the device. Devices of this type are often referred to as Peltier coolers.

[0067] Surrounding air in most instances will be the ambient atmosphere able to convectively absorb heat from a heated surface contacting the air. However, it is possible to replace the surrounding air with a device and/or fluids other than air that continue to move the heat for final transfer to the air, earth, and the like.

[0068] Note that spatially relative terms, such as “up,” “down,” “right,” “left,” “beneath,” “below,” “lower,” “above,” “upper”, “top”, “bottom”, and the like, may be used for ease of description to describe

one element or feature's relationship to another element(s) or feature(s) as illustrated in the figures. Spatially relative terms are intended to encompass different orientations of the device in use or operation in addition to the orientation depicted in the figures. For example, if the
5 device in the figures is turned over or rotated, elements described as "below", or "beneath" other elements or features would then be oriented "above" the other elements or features. Thus, the exemplary term "below" can encompass both an orientation of above and below in relation to another element or feature. The device may be otherwise
10 oriented (rotated 90 degrees or at other orientations) and the spatially relative descriptors used herein interpreted accordingly.

[0069] The simplified diagrams and drawings do not illustrate all the various connections and assemblies of the various components, however, those skilled in the art will understand how to implement such
15 connections and assemblies, based on the illustrated components, figures, and descriptions provided herein, using sound engineering judgment.

[0070] While various aspects of the invention are described, it will be apparent to those of ordinary skill in the art that other embodiments and
20 implementations are possible within the scope of the invention. Accordingly, the invention is not to be restricted except in light of the attached claims and their equivalents.

CLAIMS

1. A battery including a parallel heat transfer system, the battery comprising:

a case comprising a can attached to a lid;

5 a cell having first and second electrodes exposed from an exterior layer of polymeric material of the cell, the at least two electrodes comprising an anode electrode and a cathode electrode, where the case encloses the cell;

at least two posts exposed from the case;

10 at least two contacts enclosed by the case,

where a first of the at least two posts is in electrical communication with a first of the at least two contacts and a second of the at least two posts is in electrical communication with a second of the at least two contacts; and

15 at least a first heat transfer bar in electrical and thermal communication with the first electrode and the first of the at least two contacts, where

the first heat transfer bar comprises a first side that is thermally and electrically conductive and a second side that is thermally but not electrically conductive.

20

2. The battery of claim 1, the first heat transfer bar comprising a conductive metal.

3. The battery of claim 2 the conductive metal chosen from copper, aluminum, steel, and iron.
4. The battery of claim 1, where the first heat transfer bar is a solid conductive metal.
- 5 5. The battery of claim 1, where the first side of the first heat transfer bar contacts the first electrode through ultrasonic welding or with an interference fit.
6. The battery of claim 1, where the first heat transfer bar contacts at least 60% of a longitudinal length of the first electrode.
- 10 7. The battery of claim 1, where the first heat transfer bar contacts at least 70% of a lateral width of the first electrode.
8. The battery of claim 1, where a second side of the first heat transfer bar comprises a thermally conductive but electrically insulative material and contacts at least one inner side of the can.
- 15 9. The battery of claim 8, where the second side of the first heat transfer bar includes a geometric pattern providing a first interfacing face that interfaces with the at least one inner side of the can.
10. The battery of claim 9, where the first interfacing face contacts at least 60% of an interior longitudinal length of the at least one inner side
20 of the can.

11. The battery of claim 8, where the thermally conductive but electrically insulative material is a dielectric material.
12. The battery of claim 11, where the dielectric material is chosen from anodizing and a plasma electrolytic oxidation material.
- 5 13. The battery of claim 1, further comprising a seal between the can and the lid.
14. The battery of claim 13, where the seal substantially excludes moisture from reaching the cell enclosed by case.
15. The battery of claim 13, where the seal is chosen from laser
10 welding, interlocking metal that does or does not distort on compression, a gasket, an adhesive, or any combination thereof.
16. The battery of claim 13, where the seal impedes thermal communication between the can and the lid.
17. The battery of claim 1, where the can comprises a thermally
15 conductive material that is not electrically conductive.
18. The battery of claim 1, where the can comprises a metal chosen from aluminum, steel, copper, magnesium, and combinations thereof.
19. The battery of claim 1, where the can provides a primary path for heat transfer from the cell.
- 20 20. The battery of claim 1, where at least 70% of the heat transferred from the cell is passively transferred to exterior surfaces of the can.

21. The battery of claim 1, where the case comprises at least one temperature sensor.
22. The battery of claim 1, where an interior surface of the can contacts the exterior layer of polymeric material of the cell to provide a secondary thermal transfer path from the cell to exterior surfaces of the can.
23. The battery of claim 1, where the posts are electrically insulated from the lid.
24. The battery of claim 1, where the lid comprises a relatively poor thermally conductive material in relation to the can.
25. The battery of claim 1, where the first of the at least two contacts engages less than 30% of a longitudinal length of the first side of the first heat transfer bar.
26. The battery of claim 1, further comprising a second heat transfer bar in electrical and thermal communication with the second electrode and the second of the at least two contacts.
27. The battery of claim 26, where the first side of the second heat transfer bar contacts the second electrode through ultrasonic welding or with an interference fit.
28. The battery of claim 26, where the second heat transfer bar contacts at least 60% of a longitudinal length of the second electrode.

29. The battery of claim 26, where the second heat transfer bar contacts at least 70% of a lateral width of the second electrode.

30. The battery of claim 26, where a second side of the second heat transfer bar comprises a thermally conductive but electrically insulative material and contacts at least one inner side of the can.

31. The battery of claim 30, where the second side of the second heat transfer bar includes a geometric pattern providing a second interfacing face that interlocks with the at least one inner side of the can.

32. The battery of claim 31, where the second interfacing face contacts at least 60% of an interior longitudinal length of the at least one inner side of the can.

33. The battery of claim 26, where the second of the at least two contacts engages less than 30% of a longitudinal length of the first side of the second heat transfer bar.

15

34. A temperature-controlled power system, the temperature-controlled power system comprising:

batteries; and

a thermal transfer system, where the thermal transfer system
5 comprises:

at least one circuit board;

control circuitry in electrical or wireless communication with
the at least one circuit board;

at least two active thermoelectric devices held by the at least
10 one circuit board, where

each of the at least two active thermoelectric devices
contacts and is in thermal communication with a different
battery; and

at least one radiator in conductive heat transfer with the at
15 least two active thermoelectric devices.

35. The power system of claim 34, further comprising a battery carrier that carries the batteries.

36. The power system of claim 34, the battery carrier comprising a base on which the batteries reside.

20 37. The power system of claim 36, the battery carrier further comprising one or more divider between the batteries and opposing ends of the batteries.

38. The power system of claim 35, where the battery carrier comprises a thermally insulative material.

39. The power system of claim 35, where the battery carrier further comprises mounting points chosen from studs and threaded inserts.

5 40. The power system of claim 35, the at least one radiator comprising fins contacting the at least two active thermoelectric devices and attachment spacers contacting the battery carrier.

41. The power system of claim 34, the at least one circuit board comprising cut-outs to receive and hold the at least two active
10 thermoelectric devices.

42. The power system of claim 41, the at least two active thermoelectric devices comprising slots on opposing sides to mechanically engage the cut-outs of the at least one circuit board.

43. The power system of claim 34, the at least two active thermoelectric
15 devices comprising contacts that mechanically engage and establish electrical communication with connectors of the at least one circuit board.

44. The power system of claim 34, where at least 30% of the area of at least one side of each of the batteries contacts and is in thermal
20 communication with the at least two active thermoelectric devices.

45. The power system of claim 34, where each of the batteries contacts a pair of the at least two active thermoelectric devices on opposing sides.

46. The power system of claim 34, where the batteries have opposing sides, each opposing side in contact with at least one of the at least two active thermoelectric devices.

47. The power system of claim 34, where a side of one of the batteries
5 contacts at least two of the active thermoelectric devices.

48. The power system of claim 34, the control circuitry configured to monitor temperature sensors inside or outside the batteries.

49. The power system of claim 34, the control circuitry configured to adjust a voltage applied to the at least two active thermoelectric devices.

10 50. The power system of claim 34, the control circuitry configured to adjust a voltage flowing from or into the batteries.

51. The power system of claim 34, the control circuitry configured to estimate a temperature of the batteries in response to a voltage obtained from the at least two active thermoelectric devices.

15 52. The power system of claim 34, the at least one radiator comprising a heat transfer fluid.

53. The power system of claim 52, the control circuitry configured to alter a flow rate of the heat transfer fluid through the at least one radiator.

20 54. The power system of claim 34, the at least one radiator comprising a solid heat sink lacking a heat transfer fluid.

55. The power system of claim 52, the at least one radiator comprising a plate and fin design.

56. The power system of claim 55, where the plates are configured to match larger diameter fin entrances with smaller diameter fin exits and
5 to match smaller diameter fin entrances with larger diameter fin exits.

57. The power system of claim 34, further comprising a compression plate configured to apply a clamping force against the at least one radiator.

58. The power system of claim 34, where
10 the at least two active thermoelectric devices comprise at least four active thermoelectric devices,
the at least one circuit board comprises at least two circuit boards,
where each of the at least two circuit boards hold at least two of the at least four active thermoelectric devices, and
15 the at least one radiator comprises at least two radiators,
where each of the at least two radiators contacts at least two of the at least four active thermoelectric devices.

59. A method of transferring heat from a battery cell to surrounding air, the method comprising:

generating heat from the interior layers of a cell by flowing current into or out of the cell;

5 conductively transferring the heat from cathode and anode layers of the interior layers of the cell to an exterior cathode electrode of the cell and to an exterior anode electrode of the cell;

conductively transferring the heat from at least one of the electrodes to a heat transfer bar contacting the at least one of the
10 electrodes;

conductively transferring the heat from the heat transfer bar through a thermally conductive and electrically insulative material into an interfacing face of the heat transfer bar;

conductively transferring the heat from the interfacing face into a
15 can of the battery;

conductively transferring the heat from the can of the battery to a cold side of an active thermoelectric device, where the active thermoelectric device transfers the heat from the cold side to a hot side;

conductively transferring the heat from the hot side of the
20 thermoelectric device to a radiator, where the radiator convectively transfers the heat to surrounding air.

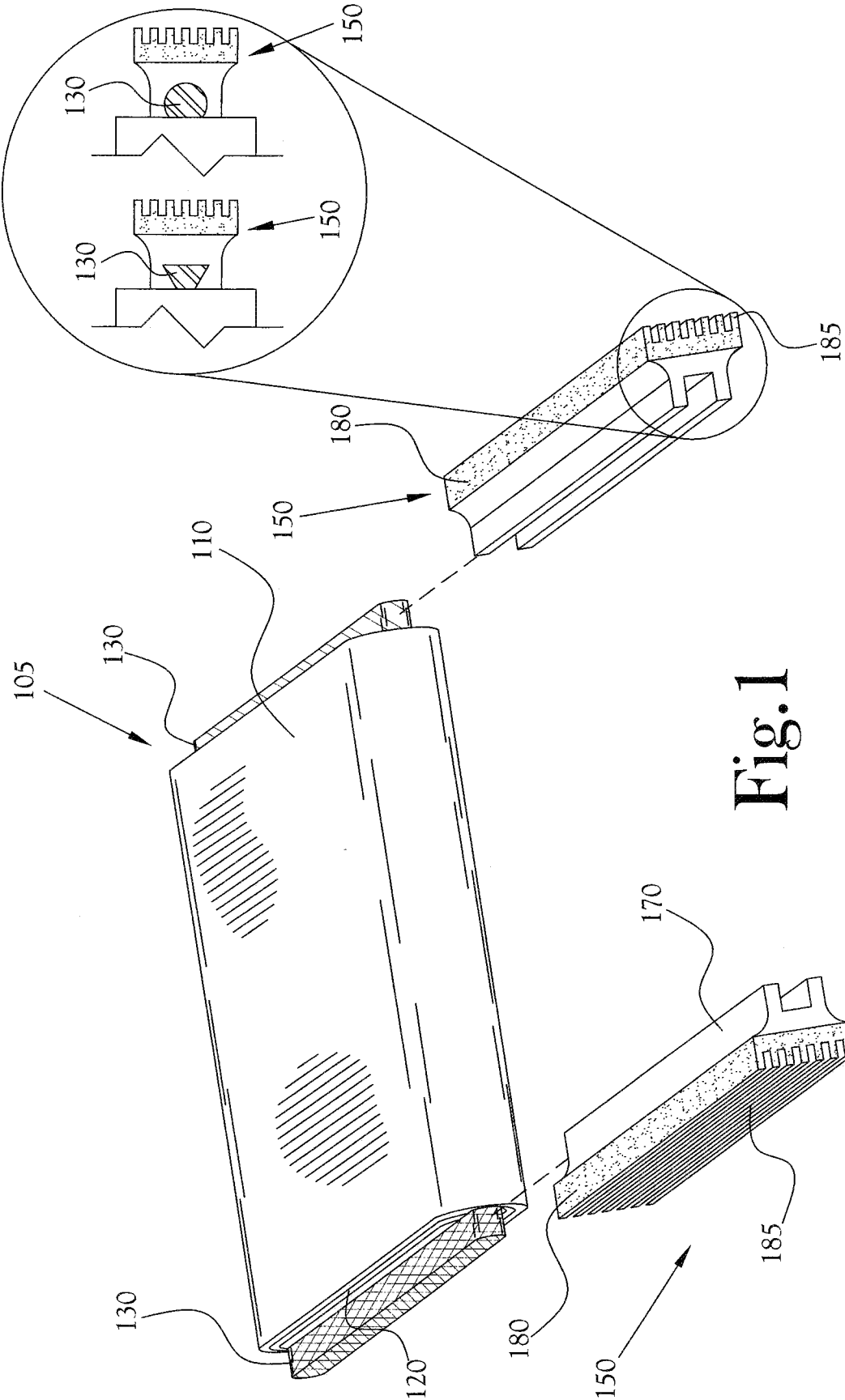
60. The method of claim 59, further comprising where the radiator conductively transfers the heat to a heat transfer fluid and the heat

transfer fluid convectively transfers the heat to the surround air after the heat transfer fluid leaves the radiator.

61. The method of claim 59, where electricity flows between the electrodes and an electrically and thermally conductive side of the heat
5 transfer bars, contacts, and posts.

62. The method of claim 60, where in response to a potential measured across the active thermoelectric device, control circuitry regulates the flow of the heat transfer fluid.

63. The method of claim 60, where in response to a temperature
10 reading from a temperature sensor, control circuitry regulates the flow of the heat transfer fluid.



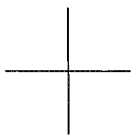


Fig. 2

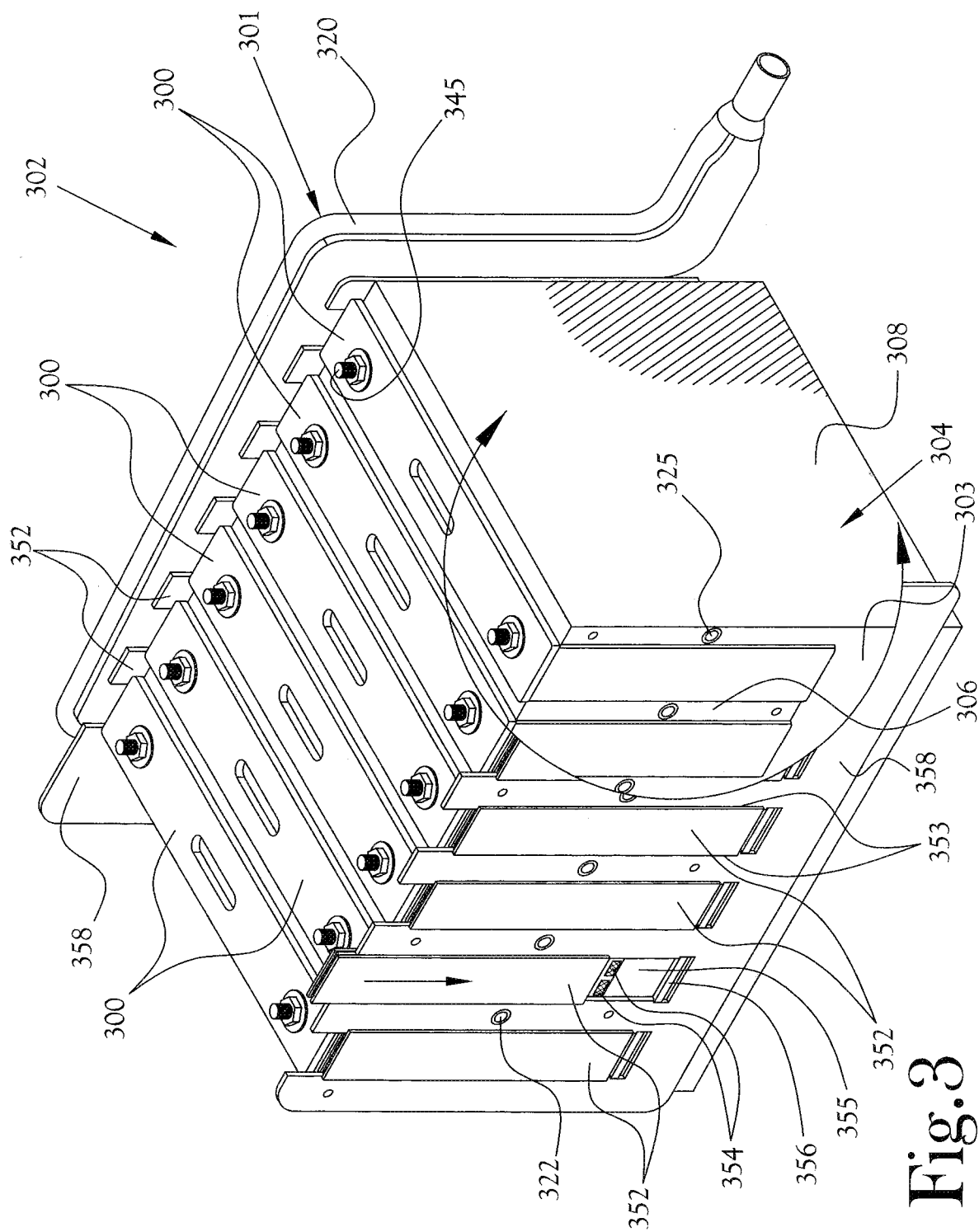


Fig. 3

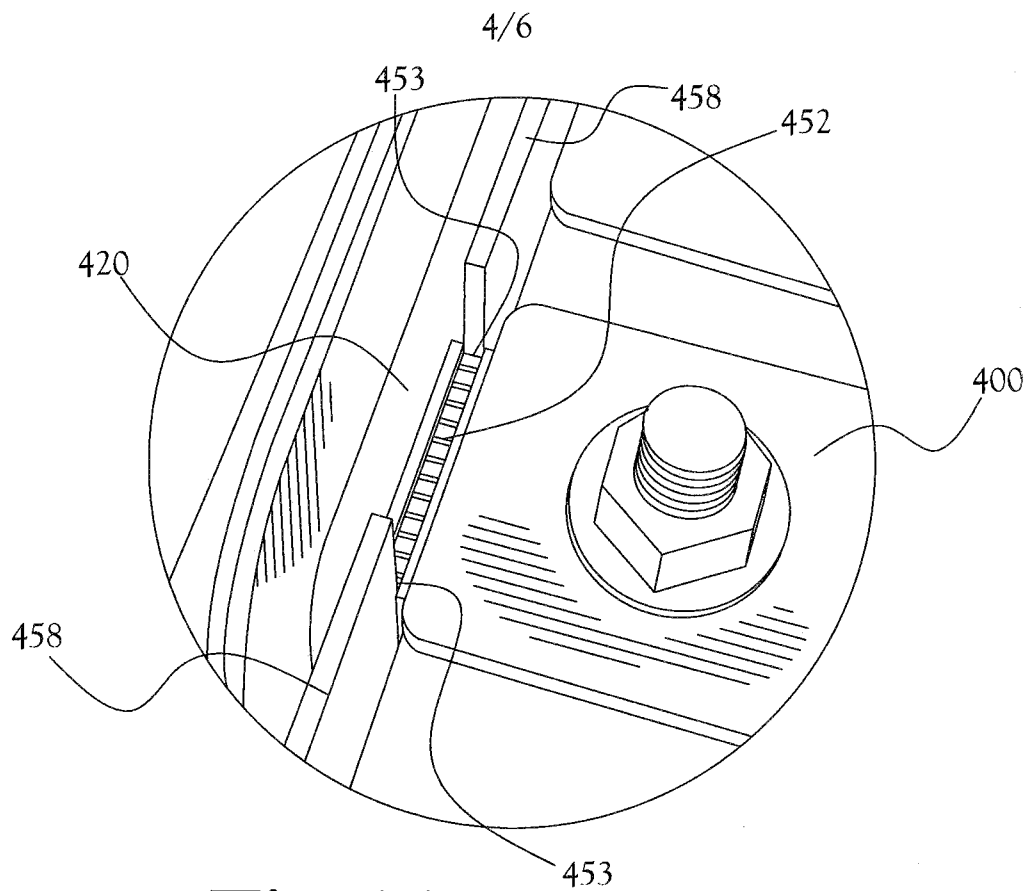


Fig. 4A

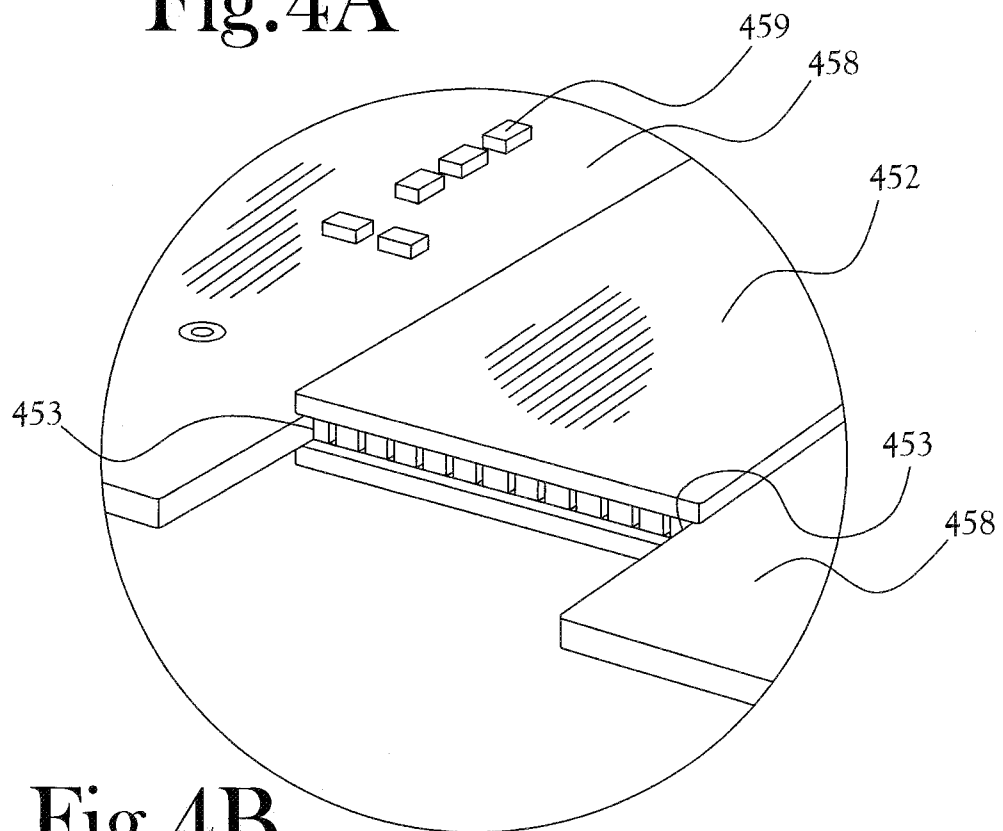


Fig. 4B



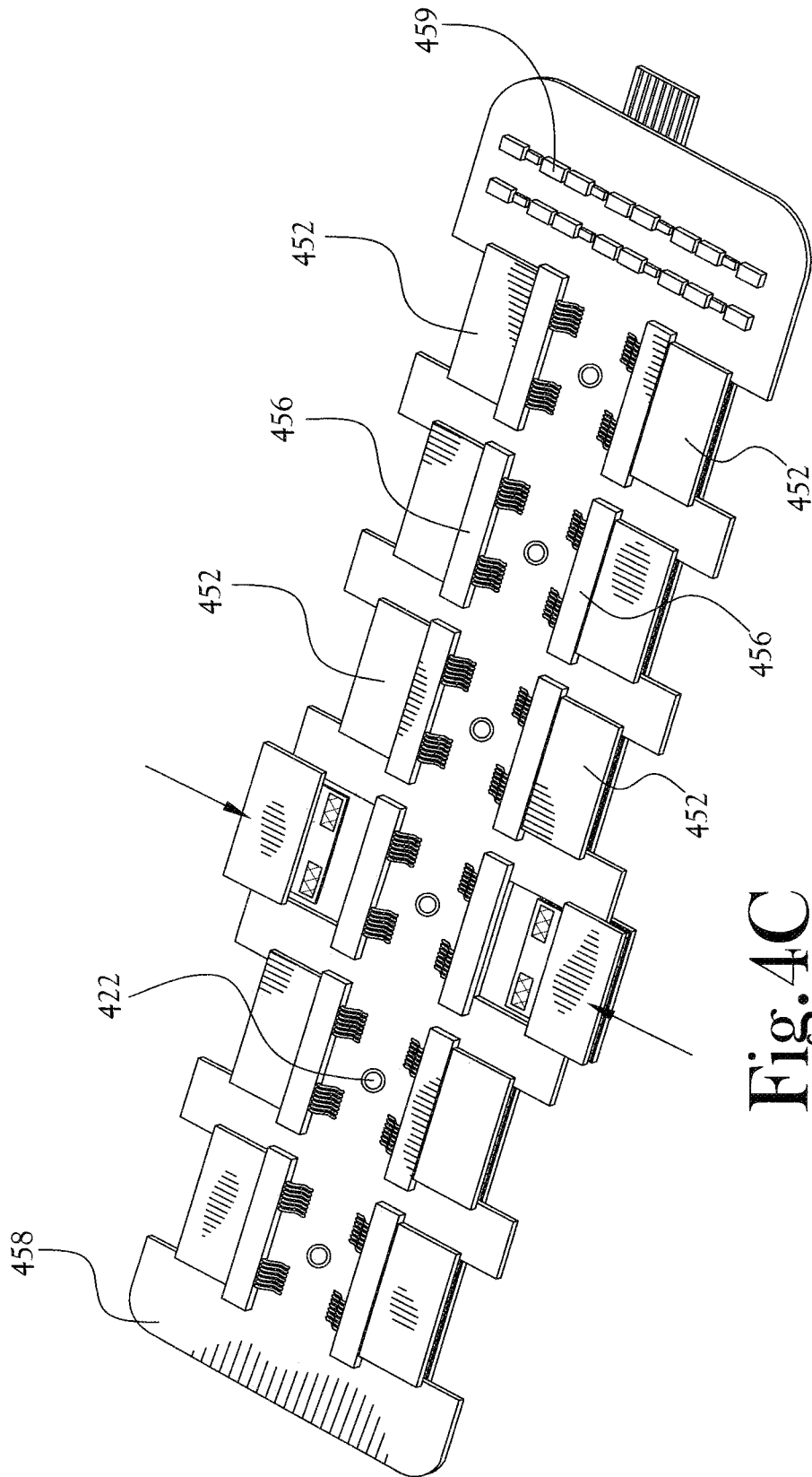


Fig. 4C

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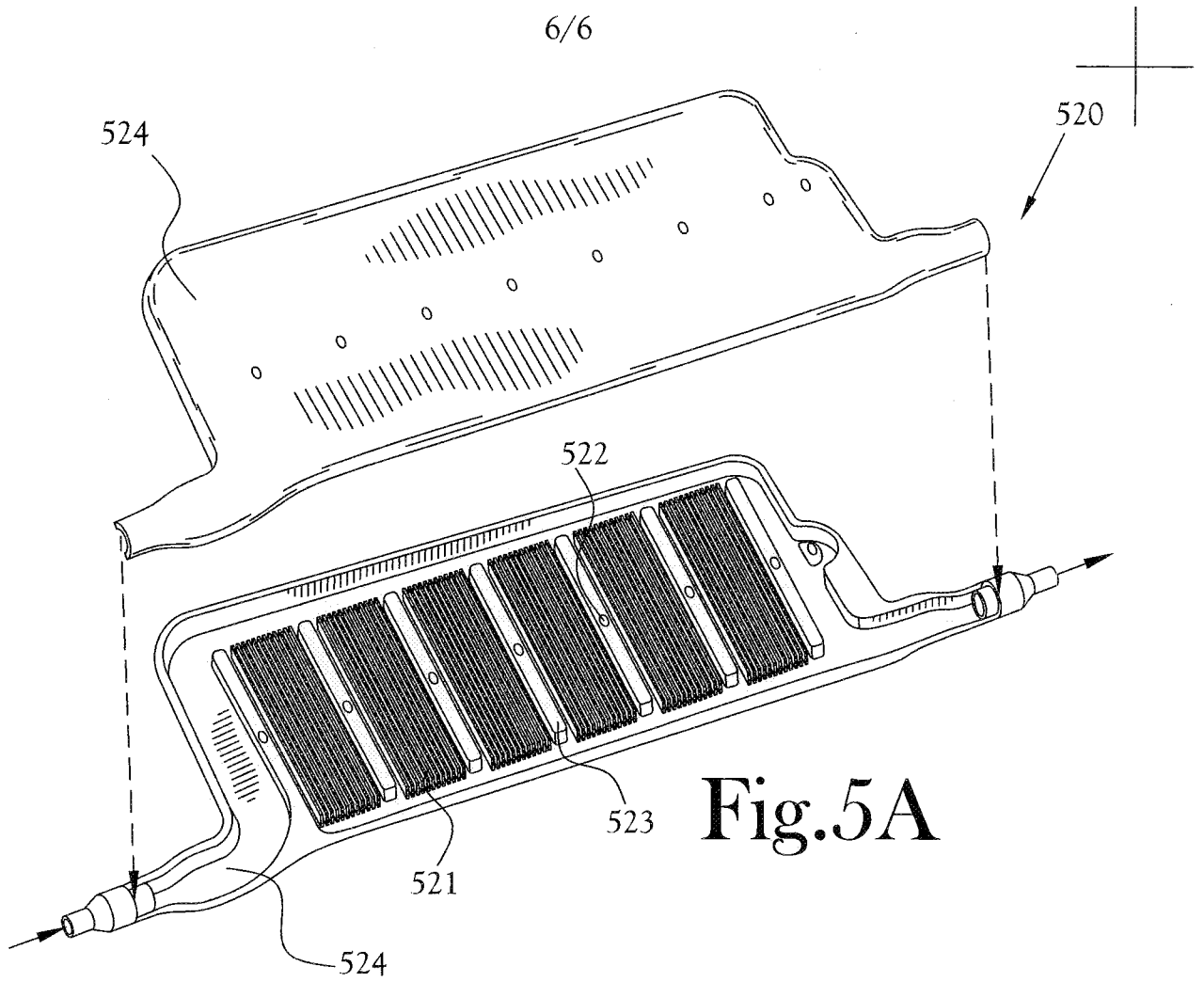


Fig. 5A

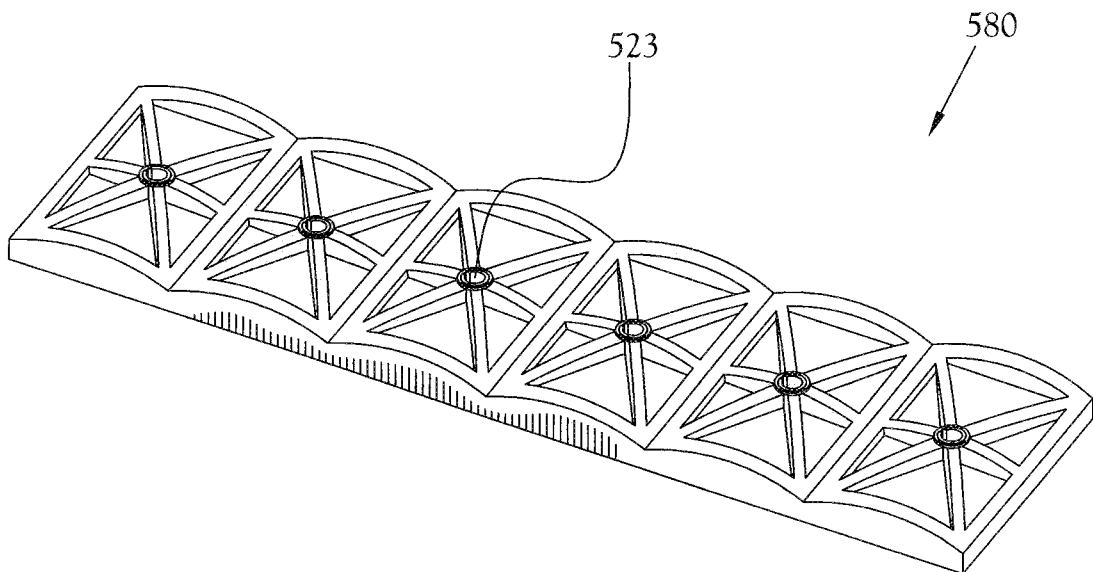


Fig. 5B

