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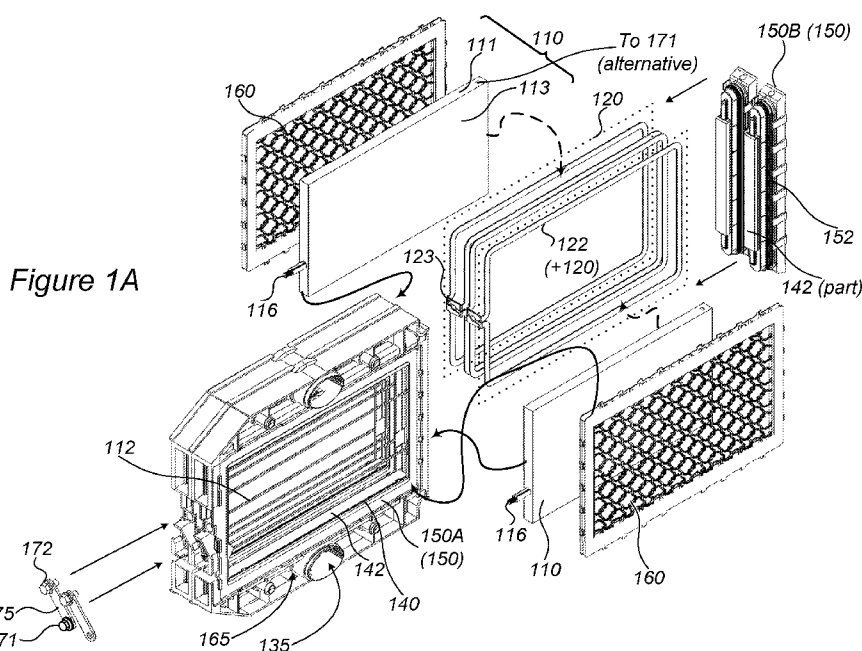
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(57) Abstract: Aluminum-air battery units and stacks are provided with frames configured to mechanically support the anode of each unit, within a housing configured to support the frame and the air cathode(s) mechanically, sealably hold the electrolyte within the housing and in fluid communication with openings in the housing - forming one or two sided electrochemical cell in each unit. The frame comprises a protective strap configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and also an external trapezoid shape that is configured to press the protective strap against the edges of the rectangular anode upon insertion of the frame with the anode into the housing. Various embodiments comprise, spacers between the anode and cathodes and grids supporting airways to the cathodes. In disclosed configurations, anode may be replaced after electrolyte evacuation while maintaining the stack sealed and quickly ready for renewed operation.

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ALUMINUM-AIR BATTERY UNITS AND STACKS

BACKGROUND OF THE INVENTION

1. TECHNICAL FIELD

[0001] The present invention relates to the field of energy storage, and more particularly, to construction of aluminum-air batteries.

2. DISCUSSION OF RELATED ART

[0002] Energy storage is a developing field with diverse solutions employing various electrochemical and structural configurations. One promising direction is aluminum-air batteries, in which aluminum anode material is consumed in the presence of alkaline electrolyte by an air cathode.

SUMMARY OF THE INVENTION

[0003] The following is a simplified summary providing an initial understanding of the invention. The summary does not necessarily identify key elements nor limit the scope of the invention, but merely serves as an introduction to the following description.

[0004] One aspect of the present invention provides an aluminum-air battery unit comprising: at least one aluminum-air electrochemical cell comprising a rectangular aluminum anode, at least one corresponding air cathode, and alkaline electrolyte, a frame configured to mechanically support the anode of the cell, and a housing configured to support mechanically the frame and the at least one air cathode and to sealably hold the electrolyte within the housing and in fluid communication with openings in the housing; wherein the frame comprises a protective strap configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and wherein the frame has an external trapezoid shape that is configured to press the protective strap against the edges of the rectangular anode upon insertion of the frame with the anode into the housing.

[0005] These, additional, and/or other aspects and/or advantages of the present invention are set forth in the detailed description which follows; possibly inferable from the detailed description; and/or learnable by practice of the present invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0006] For a better understanding of embodiments of the invention and to show how the same may be carried into effect, reference will now be made, purely by way of example, to the accompanying drawings in which like numerals designate corresponding elements or sections throughout.

[0007] In the accompanying drawings:

[0008] **Figures 1A-1F and 2A-2D** are high-level schematic illustrations of aluminum-air battery units, according to some embodiments of the invention.

[0009] **Figures 3A-3H** are high-level schematic illustrations of parts of aluminum-air battery units, according to some embodiments of the invention.

[0010] **Figures 4A-4E** are high-level schematic illustrations of various cathode side embodiments of aluminum-air battery units, according to some embodiments of the invention.

[0011] **Figure 5** is a high-level flowchart illustrating a method, according to some embodiments of the invention.

DETAILED DESCRIPTION OF THE INVENTION

[0012] In the following description, various aspects of the present invention are described. For purposes of explanation, specific configurations and details are set forth in order to provide a thorough understanding of the present invention. However, it will also be apparent to one skilled in the art that the present invention may be practiced without the specific details presented herein. Furthermore, well known features may have been omitted or simplified in order not to obscure the present invention. With specific reference to the drawings, it is stressed that the particulars shown are by way of example and for purposes of illustrative discussion of the present invention only, and are presented in the cause of providing what is believed to be the most useful and readily understood description of the principles and conceptual aspects of the invention. In this regard, no attempt is made to show structural details of the invention in more detail than is necessary for a fundamental understanding of the invention, the description taken with the drawings making apparent to those skilled in the art how the several forms of the invention may be embodied in practice.

[0013] Before at least one embodiment of the invention is explained in detail, it is to be understood that the invention is not limited in its application to the details of construction and the arrangement of the components set forth in the following description or illustrated in the drawings. The invention is applicable to other embodiments that may be practiced or carried out in various ways as well as

to combinations of the disclosed embodiments. Also, it is to be understood that the phraseology and terminology employed herein are for the purpose of description and should not be regarded as limiting.

Embodiments of the present invention provide efficient and economical methods and mechanisms for constructing and interconnecting aluminum-air battery units to form batteries and thereby provide improvements to the technological field of energy storage and supply. Aluminum-air battery units and stacks are provided with frames configured to mechanically support the anode of each unit, within a housing configured to support the frame and the air cathode(s) mechanically, sealably hold the electrolyte within the housing and in fluid communication with openings in the housing - forming one or two sided electrochemical cell in each unit. The frame comprises a protective strap configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and also an external trapezoid shape that is configured to press the protective strap against the edges of the rectangular anode upon insertion of the frame with the anode into the housing. Various embodiments comprise, spacers between the anode and cathodes and grids supporting airways to the cathodes. In disclosed configurations, anode may be replaced after electrolyte evacuation while maintaining the stack sealed and quickly ready for renewed operation.

[0014] Aluminum-air batteries (stacks) are typically composed of multiple units which are interconnected mechanically and electrically. The sealing between the units may be maintained along directions perpendicular to a plane of removed frame(s) and anode(s) to enable replacing anodes after depletion with new anodes while maintaining the configuration and sealing of the stack, allowing for quick reactivation of the stack without compromising its performance and further enabling simple maintenance of the stacks.

[0015] In the following figures, one or two battery units are shown to illustrate their spatial relation and connectivity.

[0016] **Figures 1A-1F** are high-level schematic illustrations of aluminum-air battery units **100**, according to some embodiments of the invention. **Figure 1A** is a schematic perspective partially exploded view, **Figure 1B** is a perspective detailed view, **Figures 1C and 1D** are highly schematic face views, **Figure 1E** is a highly schematic side view and **Figure 1F** is a highly schematic cross section of two units **100**.

[0017] Aluminum-air battery unit **100** comprises an aluminum-air electrochemical cell **105** comprising a rectangular aluminum anode **110**, at least one air cathode **120** and alkaline electrolyte **130** (see, e.g., a schematic notation of cell **105** in **Figure 1F**). Aluminum-air electrochemical cell **105** is configured to produce electricity from the electrochemical reaction of aluminum from anode **110** with oxygen (e.g., from the air) that is catalyzed by air cathode(s) **120** in association with alkaline electrolyte **130** (e.g., KOH or NaOH). In various configurations, anode **110** may be part of one cell **105** with one air cathode (see e.g., schematic **Figure 1E**) or part of two cells **105** (or cell compartments) with corresponding air cathodes **120** (see, e.g., schematic **Figure 1F**). Alternatively or complementarily, electrochemical cell **105** in each unit **100** may be considered one-sided when including anode **110** and one air cathode **120**, or two-sided when including anode **110** and two air cathodes **120** on either side thereof.

[0018] Battery unit **100** further comprises a frame **140** configured to mechanically support anode **110**, and a housing **150** configured to mechanically support frame **140** and cathode(s) **120**, and to sealably hold electrolyte **130** within housing **150** and in fluid communication with openings **135** in housing **150** through which electrolyte **130** is circulating through cell(s) **105** (delivered to and removed from the cell space holding electrolyte **130**).

[0019] Frame **140** comprises a protective strap **142** configured to protect edges **111** of rectangular anode **110** against corrosion by electrolyte **130**, particularly as a surface **113** is consumed during the operation of the aluminum air battery. Frame **140** has an external trapezoid shape **145**, that is configured to press protective strap **142** against edges **111** of rectangular anode **110** upon insertion of frame **140** with anode **110** into housing **150**. For example, the frame's trapezoid shape **145** may be configured to fit into a trapezoid cavity **155** in housing **150**, as shown in **Figures 1A-1E** and as illustrated schematically in **Figures 1C-E** by arrows **146**. It is noted that the trapezoid configuration may be implemented along a long side of anode **110** as illustrated e.g., in **Figures 1A-1D** and/or along a short side (thickness) of anode **110** as illustrated e.g., in **Figure 1E**. In certain embodiments, the former may be used to implement electrochemical cells **105** on both sides of anode **110**, with two corresponding air cathodes **120**, while the latter may be used to implement a single electrochemical cell **105** on one side of anode **110**, with one air cathode **120** and corresponding protection of the backside of anode **110** to prevent chemical and/or corrosion reactions thereof and operating cell **105** from one side of anode **110** facing air cathode **120**.

[0020] **Figure 1A** illustrates a partly exploded view of two attached units **100**, including frame **140** with protective straps positioned in housing **150A** (as part of housing **150**, together with part **150B**, see also **Figure 1D** for a schematic illustration) while anodes **110** are shown separately. Cathodes **120** are shown schematically (only two of four cathodes are indicated by point-dashed lines), and are represented by their respective current collectors **122**. Cathodes **120** are supported by grids **160** and attached to housing **150** (**150A**), as shown schematically by the curved arrows. The position of anodes **100** in frame **140** is indicated schematically by curved arrows and the relative position of anodes **110** with respect to cathodes **120** is shown by curved broken-line arrows, indicating two cathodes **120** per anode **110**, to form two cells **105** per unit **100**, as explained below. Sides **111** and surfaces **113** of anodes **110** are indicated, as well as an alternative option of attaching anode connector to triangular part **115** of anode **110** as in some embodiments presented below. Studs **116** are shown as being connected to anode connectors/fasteners **171** in the illustrated version, explained below in more details.

[0021] **Figure 1B** illustrates a partly exploded view showing the complementary structure of frame **140** to anode **110** according to some embodiments. Advantageously, the trapezoid shape of frame **140** may be configured to enable using rectangular anodes **110** which are easy to produce and do not waste anode material (with respect, e.g., to trapezoid anodes). Frame **140** may comprise joints or parts that endow some flexibility to frame **140** – for pressing frame **140** against sides **111** of anode **110** upon insertion of frame **140** into housing **150**. For example, as shown schematically in **Figure 1B**, frame **140** may comprise two disjunct parts which may each hold protective strap **142** and be pressed onto sides **111** of anode **110** upon insertion to housing **150** (e.g., closing of housing parts **150A** and **150B**).

[0022] **Figure 1B** further illustrates seal **117**, in some embodiments being part of housing **150** or housing part **150B**, which, upon insertion of frame **140** and anode **110** into housing **150** or housing part **150B**, is held against the edge of anode part **115** (e.g., by schematically illustrated tab or bar **117A**) and seals it off and protects part **115** from electrolyte **130** in cell **105**.

[0023] It is noted that in case of seal **117**, the distinction between sealing elements that prevent electrolyte from leaking outside of cell **105** and protective elements that protect anode sides from contact with electrolyte **130** (that may result in parasitic reactions) depend on the geometric configuration and the state of anode **110**, as explained below. Therefore, in the following discussion, the terms seal **117** and protective strap **117** are used interchangeably (as e.g., in **Figures**

3A-3C), and seal 117 is considered to include and/or function as both protective strap 117 and seal 152 in certain configurations (as e.g., in **Figures 3G and 3H**).

[0024] Schematic illustration **Figure 1F** shows in a generalized cross section of two units 100 with anodes 110 having two corresponding pairs of cathodes 120 which are arranged in a back-to-back configuration, creating spaces for electrolyte 130 (in fluid communication with openings 135) between anode 110 and cathode 120 and spaces (airways) 161 for air or other oxygen-containing gas (in fluid communication with openings 165) between cathodes 120. The chambers containing anode 110 and two cathodes 120 are sealed (by a seal 152 of cells 105 shown very schematically in **Figure 1F**, in which frame 140 and housing 150 are not shown, and see **Figure 1A** for part of seal 152 on housing part 150B) to prevent leakage of electrolyte 130. During operation, surfaces 113 of anodes 110 are consumed to deliver energy electrochemically (with respect to air cathodes 120 that consume oxygen). Sides 111 of anodes 110 may be protected by strap(s) 142 that prevent or reduce electrolyte contact with anode material and thereby prevent or reduce anode material consumption on sides 111 (which may result in parasitic reactions and development of hydrogen).

[0025] In certain embodiments, housing 150 may comprise two parts 150A, 150B (see, e.g., **Figures 1A, 1C and 1D**) which are sealably and/or snugly connected to each other to enclose frame 140. Advantageously, frame 140 protects and supports protective strap 142 during the enclosing thereof within housing 150 and provides a mechanically reliable interface between the external edge of frame 140 and the internal edge of housing 150. The enclosure of frame 140 within housing 150 (see arrows 146 in **Figure 1C**) may involve some pressure applied against flexible elements 144 (located at the external periphery of frame 140 and/or located at the internal periphery of housing 150) which are configured to compensate for possible deviations in the dimensions of anode 110, frame 140 and/or housing 150 and ensure close fitting of frame 140 in housing 150. In certain embodiments, elastic elements 144 may be configured to be pressed against housing 150 upon insertion 146 of frame 140 thereto, and enhance a contact of protective strap 142 to edges 111 of anode 110. In various embodiments, the enclosure of frame 140 within housing 150 also presses (see arrows 147 in **Figure 1C**) at least parts of protective strap 142 against anode edges 111 to ensure protection of the respective edges thereby. In certain embodiments, parts of protective strap 142 and/or additional protective straps (not shown) may be implemented on the receiving sides of parts of housing 150, in case frame 140 does not cover the full circumference (and all edges 111) of anode 110.

[0026] Protective strap 142 may comprise a circumferential strap or a combination of strap parts, some of which optionally attached to parts of housing 150, such as part 150B depicted schematically in Figure 1D.

[0027] In certain embodiments, housing 150 may be configured to receive frame 140 by a click connection to external trapezoid shape 145 of frame 140 which is configured to apply the pressure on protective strap 142 (or parts thereof) against edges 111 of rectangular anode 110. In some embodiments, as illustrated schematically in Figures 1B-1E by arrows 147, various ways may be implemented to press protective strap 142 to anode edges 111 without damaging protective strap 142, to maintain the protection and moreover to enable simple extraction of frame 140 with anode 110 from housing 150. For example, protrusion(s) 148 may be set in housing 150 to press onto frame 140 at final stage of its insertion into housing 150 and/or part 150A of housing 150 may be attached to frame 140 in a way that applies pressure 147 onto protective straps 142. In some embodiments, as illustrated schematically in Figures 1A and 1D, parts of protective strap 142 (and possibly of frame 140) may be attached to part 150B of housing, e.g., to yield pressure on all four edges 111 of rectangular anode 110 upon insertion of frame 140 with anode 110 into housing 150. In some embodiments, gap(s) or flexible spacers 149 may be formed in frame 140 (see e.g., Figure 1C and 1B, respectively) to allow for pressing 147A (see Figure 1C) of frame 140 to at least partly close gap(s) and/or spacer(s) 149 and thereby press protective strap 142 (or parts thereof) against edges 111 of rectangular anode 110.

[0028] Housing 150 further comprise openings 135 for delivery of electrolyte 130 into and out of the space between anodes 110 and cathodes 120 defined for operating the electrochemical reactions of the battery, and openings 165 for delivery of air (or other gas) into and out of the space between cathodes 120 defined for provision of air to cathodes 120, as described in additional details below and as illustrated schematically in Figure 1F. For example, electrolyte 130 and/or air may be delivered from below upwards into cells 105 and airways 161, respectively, to enable gas and heat release from these corresponding chambers. Cathodes 120 may be supported by grid 160 (shown schematically in Figure 1F), discussed in further details below.

[0029] Cathodes 120 may be air cathodes, e.g., as taught by U.S. Patents Nos. 8,142,938 and 9,941,516, incorporated herein by reference in their entirety, comprising a catalyst attached to a PTFE (Polytetrafluoroethylene) skin on a network to which a current collector is attached. Anodes

110 may be made of solid metal (e.g., aluminum) and/or alloys thereof. Alkaline electrolyte **130** may comprise KOH and/or NaOH, as non-limiting examples.

[0030] Frame **140** may be configured to be replaceable, with associate anode **110** and cathodes **120**, within housing **150** and/or unit **100** (housing **150** with frame **140**) may be replaceable within the assembled battery.

[0031] **Figure 1A** further illustrates fasteners **171** of the anode contacts, and fasteners **172** of the cathode contacts, which are interconnected by tabs **175** for serial connection of consecutive cells. Fasteners **171** and **172** may comprise nuts, screws, spring loaded connectors, or other types of fastener. It is noted that the anode and cathode contacts may comprise parts thereof (e.g., part **115** of anode), separate elements such as cathode holder **123** (e.g., tab, segment or spring) shown e.g., in **Figures 1A** and **2B**, and/or attached elements such as stud **116** or other connecting elements to anode **110**, illustrated below. In various configurations, certain elements may function both as connectors and fasteners, and therefore electrode connectors and fasteners may be implemented by a single element.

[0032] In certain embodiments, battery unit **100** may further comprise at least one spacer **112** attached to housing **150** (or possibly to frame **140** or any other unit element) and configured to mechanically prevent contact between anode **110** and cathode **120** in case of negative pressure occurring upon emptying electrolyte **130** from unit **100** (e.g., by gravity or by pumping). Spacer(s) **112** may be configured in various ways, such as one or more thin rods, along one direction, two orthogonal directions or multiple directions in a plane between the surfaces of anode **110** and cathode **120**, diagonal rods, serrated rods etc., to support electrolyte flow out of the cells during emptying, and prevent electrolyte retention after evacuation thereof from the cell. It is noted that spacer(s) **112** have a mechanical function and do not form any barrier to chemical species in electrolyte **130** such as anions and/or cations.

[0033] **Figures 2A-2D** are high-level schematic illustrations of aluminum-air battery units **100**, according to some embodiments of the invention. **Figure 2A** is a side view of housing **150** with spacers **112** and a current collector **122** of cathode **120** (the cathode itself is not shown), **Figure 2B** is a perspective view of cathode **120** with current collector **122** attached thereto, **Figure 2C** is a perspective view of housing **150** with spacers **112** and electric connectors/fasteners **171**, **172** of anode **110** and cathode **120**, respectively, and **Figure 2D** is an enlarged perspective view of the contacts region. It is noted that different illustrations relate to different embodiments, elements of

which can be combined in various ways to yield additional embodiments, and the illustration of features in certain embodiments does not limit the implementation of these features in other embodiments.

[0034] In various embodiments, current collector **122** of cathodes **120** may be a rectangular planar sideways-bent strap, rather than prior art cut-out made from a corresponding metal sheet. In certain embodiments, as illustrated in **Figures 2A** and **2B**, rectangular planar sideways-bent strap current collector **122** may connect to cathode contact/fastener **172** at a central position **125** on a side of battery unit **100**, which advantageously enables production of symmetric cathodes **120**, requiring namely production of one instead of two cathode geometries. It is noted that cathode **120** itself is not shown explicitly in **Figure 2A**, as it covers illustrated current collector **122**, and is illustrated schematically as a surface in **Figure 2B**.

[0035] **Figures 2A** and **2C** provide further illustration of spacers **112**, as well as of electrolyte delivery openings **135** and air delivery openings **165**. **Figure 2B** further illustrates a holder **123**, such as a tab, segment or spring, configured to fixate rectangular planar sideways-bent strap current collector **122** and stabilize its shape – to maintain its conformity within housing **150**. **Figure 2D** schematically illustrates details of the contacts region, showing cathode contact/fastener **172**, anode contacts/fastener **171** and connecting tabs **175** in certain embodiments. As disclosed below, certain embodiments comprise multiple battery units **100** attached to each other with corresponding electrochemical cells **105** electrically serially connected and electrolyte openings **135** sealably attached to each other. **Figure 2C** schematically illustrates such attachment of two units **100** and **Figure 2D** illustrates details of their electrical connections, presenting two cathode connectors/fasteners **172** of two units **100**, two studs **116** as anode extensions (see below) to which corresponding anode connectors/fasteners **171** are connected (one shown in **Figures 2C** and **2D**) and tabs **175** providing the serial connection from cathode(s) **120** of one unit to anode **110** of the next unit.

[0036] **Figures 3A-3H** are high-level schematic illustrations of parts of aluminum-air battery units **100**, according to some embodiments of the invention. **Figure 3A** is a partial side view of anode **110** with frame **140**, with **Figures 3B** and **3C** present a schematic and a detailed enlarged view, respectively of certain embodiments of an anode part **115** to which anode connector/fastener **171** may be connected, with anode part **115** protected by seal **152** and protective strap **117**, **Figures 3D** and **3E** are a perspective view and a cross section, respectively, of anode part **115** and seal **117**

according to different embodiments of battery units **100**, and **Figures 3F-3H** are highly schematic cross section views of anode material consumption during operation of the battery and various connection and sealing means, as explained below. As discussed above, the terms seal **117** and protective strap **117** may be replaceable, depending on the geometric configuration and state of anode **110**, and may comprise combinations of protective strap **142** and seal **117**, as explained below.

[0037] In certain embodiments, part **115** of anode **110** may extend outside frame **140**, be sealed from contact with electrolyte **130** and be connected to anode connector/fastener **171**. It is noted that anode part **115** may be seen as an anode connector (which is physically part of the anode plate but does not take part in the electrochemical processes) and/or as an element to which an anode connector (e.g., a screw, a sleeve, a clasp, a stud etc., note attachment point in **Figure 1A**) is attached. For example, anode part **115** may be a triangular corner of rectangular anode **110**, as illustrated e.g., in **Figures 3A-3C**, and frame **140** may comprises a seal **117**/protective strap **142** in combination with seal **152** - configured to prevent electrolyte penetration to anode part **115** during consumption of anode material in operation (see also **Figure 3G**). It is noted that as the anode material is consumed, gaps may form between seal/protective strap **117** and the anode surface, which may allow electrolyte to penetrate the anode material and advance toward anode part **115**. In order to prevent such gaps to reach anode part **115** and leak and/or damage the conductivity, seal/protective strap **117** may be configured to be at least as wide as half the thickness of anode **110** (for cells **105** on both sides of anode **110**), as explained schematically in **Figures 3G** and **3H**, below.

[0038] In certain embodiments, battery unit **100** may comprise a stud **116** attached to anode **110** and used as anode connector/fastener **171** or connected thereto, as illustrated e.g., in **Figures 2C**, **3D** and **3E**. For example, stud **116** may be attached externally to a side of anode **110**, e.g., by arc stud welding at a specified position which corresponds to an opening in housing **150**. In certain embodiments, frame **140** may further comprise seal/protective strap **117** (the side of which, illustrated in **Figure 3D**, functions as protective strap **142** while the center of which, illustrated in **Figure 3E** functions as a seal, and see **Figure 3H** for a schematic illustration) configured to prevent electrolyte penetration to stud **116** (which can be seen as an extension of anode **110** and/or as an anode connector to anode **110**) during consumption of anode material in operation. As explained above, seal/protective strap **117** may be configured to be at least as wide as half the thickness of

anode **110** (for cells **105** on both sides of anode **110**), and/or as the length of the shortest path between the exposed anode surface and the stud connection point.

[0039] **Figure 3F** illustrates schematically anode material consumption **90** during operation of the battery. Any anode material which is exposed to electrolyte **130** is being consumed during operation of the battery, thinning out anode **110**. Protection straps **142** may be configured to prevent electrolyte contact with anode material along sides **111**, as long as protection straps **142** contact anode sides **111** snugly. As soon as gaps between protection straps **142** contact anode sides **111** occur (e.g., due to deviant measures of any of the components), electrolyte **130** may enter the gaps and consumption (corrosion) of adjacent anode material commences and broadens the initial gaps.

[0040] **Figures 3G** and **3H** illustrate schematically two configurations of electric contact configuration between anodes **110** and anode connector/fastener **171** (not shown), **Figure 3G** illustrating anode part **115** extending outside frame **140** and sealed from contact with electrolyte **130** by seal/protective strap **117** (see e.g., **Figures 1B** and **3A-3D**) and **Figure 3H** illustrating stud **116** attached to anode **110** and used as the anode connector or connected thereto (onto which fastener **171** is applied, see e.g., **Figures 1A**, **2A-2D** and **3D-3E**).

[0041] **Figure 3G** illustrates schematically that seal **152** and protective strap **117** and both prevents direct leakage of electrolyte **130** and protect a portion **119** of the anode surface from contacting electrolyte **130**, respectively. However, as the anode material is consumed during operation, gaps **118** may start to form due to the receding anode surface and electrolyte **130** may enter gaps **118** and consume anode material in a direction approaching anode part **115** – posing a risk of electrolyte leakage and damage to the electric contact between anode **110** and the anode connector which may comprise anode part **115** and/or connector/fastener **171**. To counter such risk, seal/protective strap **117** may be configured to be at least as wide as half the thickness of anode **110** (for cells **105** on both sides of anode **110**, as anode **110** is consumed from both its surfaces facing opposite cathodes **120**). In certain embodiments, seal/protective strap **117** may be wider, to increase the safety margins in case of seal misplacement or other inaccuracy in assembling units **100**, or possibly narrower if complemented by other straps or seals in unit **100**, or if more anode sacrificial material is present which can be corroded without electrolyte leakage.

[0042] **Figure 3H** illustrates schematically seal/protective element **117** as being adjacent to protective strap **142** and increasing the length of anode material that has to be consumed before electrolyte **130** reaches stud **116** (a case which may result in electrolyte leakage and damage to stud

116 and/or to the electric contact between anode 110 and connector/fastener 171). Seal/protective strap 117 both prevents direct leakage of electrolyte 130 through the edge of anode 110 and protects portion 119 of the anode surface from contacting electrolyte 130. As the anode material is consumed during operation, gaps 118 may start to form due to the receding anode surface and electrolyte 130 may enter gaps 118 and consume anode material in a direction approaching stud 116. To counter the risk of electrolyte 130 reaching stud 116, seal/protective strap 117 may be configured to be at least as wide as half the thickness of anode 110, anode 110 is thick. In certain embodiments, seal/protective strap 117 may be wider or narrower, depending on the geometric configuration and the presence of other sealing/protective elements that increase the distance between the closest point of contact of electrolyte with the anode surface to stud 116 etc. For example, it is noted that when stud 116 is pulled, e.g., by fastener 171, protective strap 142 may function as a seal that prevents electrolyte leakage out of the cell. In certain embodiments, seal/protective strap 117 may be wider, to increase the safety margins in case of seal and/or stud and/or protective strap misplacement or other inaccuracy in assembling units 100.

[0043] In certain embodiments, stud 116 may be tightly secured to housing 150 (e.g., forming the connection to anode connector/fastener 171), to yield a force (see arrows 147 in Figures 1B and 1C) pressing anode 110 against adjacent protective strap 142 (see arrow 116A in Figure 3D, 3E and 3H). For example, stud 116 may comprise an outer winding and be fastened by a nut (possibly also providing the electrical connection, e.g., fastener 171) to apply force 116A. Stud 116 may be tightly secured to housing 150 and/or to tab(s) 175, to further secure an electrical connection thereof to anode 110 and/or to anode connector/fastener 171 and to reduce resistance at the connection thereof.

[0044] In certain embodiments, battery unit 100 may further comprise a grid 160 adjacent to cathode 120 (and/or between adjacent cathodes 120) and configured to support airways 161 to cathode 120, as illustrated schematically in Figure 1F, and in more detail below.

[0045] Figures 4A-4E are high-level schematic illustrations of various cathode side embodiments of aluminum-air battery units 100, according to some embodiments of the invention. Figure 4A is a side view, Figure 4B is highly schematic illustrations of grid construction principles, at cross section and top view, Figure 4C is a perspective view with details of another grid configuration, and Figures 4D and 4E illustrate yet another grid configuration, in perspective and cross section views, respectively. It is noted that different illustrations relate to different embodiments, elements

of which can be combined in various ways to yield additional embodiments, and the illustration of features in certain embodiments does not limit the implementation of these features in other embodiments.

[0046] In various embodiments, grids **160** are configured to mechanically support an adjacent one of air cathode(s) **120** of units **100** and support airways **161** thereto. While in certain embodiments grids **160** may be made of strong material such as metal, allowing grids **160** to be made very thin and avoid much obstruction to air flowing through airways **161**, in some embodiments grids **160** may be made of plastic material (e.g., polypropylene) which is weaker, and therefore requires larger material volume to provide the required mechanical support. In various embodiments disclosed below, the geometrical configuration of grid **160** is optimized to minimize resistance to air flow through airways **161** while maintaining a required level of support of air cathodes **120**. In embodiments disclosed below, grid **160** may comprise pairs of complementary grids **160**, each supporting one cathode **120** of one unit, each pair complementing the support of adjacent cathodes **120** on both sides of airway **161**. In various embodiments, grid **160** may comprise two complementary grids **160** or two complementary grids **160** may be merged into single grid **160** filling airway **161** (see e.g., schematic **Figure 1F**).

[0047] Any of the disclosed embodiments further comprise aluminum-air battery stacks (not fully shown, represented by pairs of interconnected units **100** as, e.g., in **Figures 1A, 1F, 2D, 3C-3E** and **4E**) comprising a plurality of aluminum-air battery units **100**, with pairs of air cathodes **120** placed on both sides of each respective anode **110** in each cell **105** and with single grid **160** and or pair of complementary grids **160** configured to mechanically support two adjacent air cathode **120** of corresponding two adjacent units **100** of the stack and support airways **161** thereto.

[0048] Multiple non-limiting alternatives or complementary solutions are presented for supporting airways **161** to air cathodes **120** and designing airways **161** to be as broad as possible, while providing stable mechanical structures.

[0049] In certain embodiments, illustrated e.g., in **Figures 4A** and **4B**, grid **160** may comprise pairs of complementary networks having nodal spacers **162**, one associated with each of air cathodes **120**, and each comprising a network of rectangles **161** (or other shapes) with knobs **162** as spacers at some or all of the network's nodes. Grids **160** of this type provide a high level of cathode protection and stability and a relatively small obstruction (by spacers **162**) to the air flow through airways **161**. Nodal spacers **162** of each grid **160** may contact adjacent grid **160** of adjacent battery

unit **100** (not shown, illustrated schematically in **Figure 4B**) to form rectangular supports to cathodes **120** and rectangular supports to airways **161**, as shown schematically in **Figure 4B** in top and side views, respectively.

[0050] In other examples, **Figure 4C** illustrates schematically constructing grid **160** from complementary structures **168A**, **168B** one associated with each of air cathodes **120**, and each comprising a partial undulating network, which in combination form a network (in face view) supporting both cathodes **120**. Such grids **160** are advantageous in that they provide structures associated with each cathode **120**, yet reduce the amount of obstruction to the air flow through airways **161**, as a smaller part of airway **161** is obstructed thereby, as shown schematically by comparison of **Figure 4C** and **Figure 4B**. Undulating strip networks **168A**, **168B** of each grid **160** in each direction may complement each other with corresponding undulating strips **168A**, **168B** of adjacent grid **160** of adjacent battery unit **100** to form rectangular supports to cathodes **120** and L-shaped supports to airways **161** (see the complementary structures in **Figure 4C**).

[0051] In certain embodiments, adjacent anode and cathode connectors/fasteners **171**, **172** advantageously enable implementing control circuits of the battery stack along a single straight PCB (printed circuit board) **174**, simplifying construction and control.

[0052] Yet additional examples for the construction of grid **160** presented in **Figure 4D** and **4E** illustrate complementary structures, each comprising a set of longitudinal strips **164** (e.g., along the direction of airways **161**) which are interconnected by connecting elements **166** (e.g., curved or undulating elements **166**) that support strips **164** as well as support opposite cathode **120**, as illustrated schematically in the cross section view in **Figure 4E**, mechanically, reducing the obstruction posed thereby to the air flow through airways **161**. Connecting elements **166** of each grid **160** may contact adjacent air cathode **120** of adjacent battery unit **100** (shown in cross section **Figure 4E**) to form rectangular supports to cathodes **120** and U-shaped supports to airways **161** (as seen in perspective view in **Figure 4D**).

[0053] Certain embodiments comprise splitting such grids **160** to be composed of two partial grids (e.g., having some of strips **164** in each part), each of which may be associated and assembled with corresponding cathode **120** (not shown). Elements from different designs may be combined to yield additional designs of grids **160**, and grid designs may be varied according to technical considerations, without departing from the scope of the invention.

[0054] In any of the configurations, housings 150 of units 100 may comprise sealed and/or protected air passages 165 in fluid communication with airways 161 supported by grids 160 to provide a closed (or substantially closed) air system delivering air or other oxygen containing gas to cathodes 120 and removing used air therefrom. The aluminum-air battery stack made of attached units 100 may have air filtered and pumped into air passages 165, 161, or, alternatively, the aluminum-air battery stack may have an open air system, with airways 161 open to the surrounding atmosphere and passively aerated. The aluminum-air battery stack may be made of multiple units 100 attached to each other with corresponding electrochemical cells 105 electrically serially connected and electrolyte openings 135 sealably attached to each other. Moreover, the aluminum-air battery stack may further be configured to maintain the sealed attachment of electrolyte openings 135 and of aluminum-air battery units 100 upon removal of one or more frame(s) 140 with corresponding anode(s) 100 from corresponding housing(s) 150 of corresponding unit(s) 100. For example, the sealing may be maintained along directions perpendicular to a plane of removed frame(s) 140 and anode(s) 110. Advantageously, disclosed units 100 and stacks enable replacing anodes after depletion with new anodes while maintaining the configuration and sealing of the stack, allowing for quick reactivation of the stack without compromising its performance and further enabling simple maintenance of the stacks.

[0055] Any of the disclosed embodiments, as well as combinations and/or variations thereof, may be configured to support airways 161 from air passages 165 (which are in fluid communication therewith) and cathodes 120. Grid 160 may be optimized for maximizing air throughput by increasing the free cross-section to air passage while reducing structural barriers to the air flow, simplifying units' assembly, providing mechanical protection of cathodes 120 during assemble, minimizing production costs, etc.

[0056] In various embodiments, electrolyte 130 and/or air may be actively pumped through opening 135 and 165, respectively. Grid 160 may be configured to support cathodes 120 with respect to internal fluid pressure of electrolyte 130 and with respect to pressure differences between electrolyte 130 and actively pumped air or other O₂-containing gas to cathodes 120. Additional air filters may be provided in to pumping system (and/or possibly in air openings 165) to ensure clean air supply to cathodes 120.

[0057] Elements from **Figures 1A-4E** may be combined in any operable combination, and the illustration of certain elements in certain figures and not in others merely serves an explanatory purpose and is non-limiting.

[0058] **Figure 5** is a high-level flowchart illustrating a method **200**, according to some embodiments of the invention. The method stages may be carried out with respect to units **100** described above, which may optionally be configured to implement method **200**. Method **200** may comprise the following stages, irrespective of their order.

[0059] Method **200** comprises configuring an aluminum-air battery unit, comprising an aluminum-air electrochemical cell comprising a rectangular aluminum anode, at least one air cathode and alkaline electrolyte, to have a frame mechanically supporting the anode of the cell (stage **210**), supporting, mechanically, the frame and the air cathode(s) in a housing configured to sealably hold the electrolyte therewithin in fluid communication with openings in the for receiving delivered electrolyte (stage **220**), placing a protective strap between an inner perimeter of the frame and an outer perimeter of the anode (stage **230**), configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and forming the frame to have an external trapezoid shape that is configured to press the protective strap against the edges the rectangular anode upon insertion of the frame with the anode into the housing (stage **240**), e.g., to fit into a trapezoid cavity in the housing and/or to be pressed by a click connection between the frame and the housing. In certain embodiments, method **200** may comprise configuring the housing and the frame to press the protective strap against all four edges of the rectangular anode upon insertion of the frame with the anode into the housing (stage **245**).

[0060] Method **200** may further comprise shaping a current collector of the air cathode(s) as a rectangular planar sideways-bent strap (stage **250**).

[0061] In certain embodiments, method **200** may comprise sealing a part of the rectangular anode from contact with the electrolyte in the cell and connecting the sealed part to an anode connector or using it as anode connector (stage **270**). For example, method **200** may comprise selecting the sealed part as a triangular corner of the rectangular anode, and preventing electrolyte penetration to the anode part during consumption of anode material in operation.

[0062] In certain embodiments, method **200** may comprise attaching a stud to the anode, using the stud as an anode connector (or connecting it thereto) and sealing a surrounding of the stud to prevent electrolyte penetration to the stud during consumption of anode material in operation (stage

280) and optionally tightly securing the stud to the housing, to yield a force pressing the anode against the protective strap (stage 285), provide additional protection and sealing and to secure an electrical connection thereof to the anode and/or to the anode connector.

[0063] Method 200 may further comprise enhancing a contact of the protective strap to the edges of the anode by pressing a plurality of elastic elements against the housing upon insertion of the frame thereto (stage 290).

[0064] In certain embodiments, method 200 may comprise mechanically preventing contact between the anode and the air cathode(s) upon emptying the electrolyte from the unit (stage 300).

[0065] In certain embodiments, method 200 may comprise mechanically supporting the air cathode(s) by a grid that further supports airways to the air cathode(s), which are in fluid communication with air passages in the housing, adjacent to the cathode to support airways thereto (stage 310). In various embodiments, the grid may be constructed as any of: complementary networks having nodal spacers and/or a plurality of strips in one direction that are interconnected by undulating strips and/or connecting elements in another direction and/or a pair of complementary structures that together form the grid; as well as combined configurations of the complementary grids.

[0066] In certain embodiments, method 200 may further comprise assembling multiple aluminum-air battery units to form an aluminum-air battery stack having the corresponding electrochemical cells electrically serially connected and the electrolyte openings sealably attached to each other (stage 320).

[0067] In certain embodiments, method 200 may further comprise assembling multiple aluminum-air battery units to form an aluminum-air battery stack having the corresponding electrochemical cells electrically serially connected and the electrolyte openings sealably attached to each other, wherein each cell comprises two air cathodes on either side of the respective anode, and optimizing a geometrical configuration of the grid, set between adjacent air cathodes of adjacent cells (stage 330), to minimize resistance to air flow through the airways while maintaining a required level of support of the air cathodes.

[0068] Certain embodiments comprise a shut-down procedure which includes introducing a stopping liquid (e.g., acidic liquid in an alkaline metal air cell) into unit 100 when the operation of the cell is ceased, in order to prevent further corrosion of anode 110, or other unwanted reactions. In order to stop operation of the metal air battery, it may be required to introduce a stopping material

into the cell. For example, when stopping an alkaline aluminum air cell, electrolyte **130** may be drained out of unit **110**, in order to prevent further corrosion of anode **110**. Furthermore, acidic material may be added into the cell in order to neutralize the remains of the alkaline electrolyte in the cell or on the surface of the anode. Certain embodiments comprise introducing an acidic solution through openings **135**, after draining electrolyte **130** from housing **150**. Spray nozzles may be used to spray the acidic material into the gap between anode **110** and cathode **120**, and onto surface **113** of anode **110**. The stopping liquid inlet cell may include a one-way valve for preventing electrolyte **130** from flowing out of the cell through the stopping liquid inlet.

[0069] Advantageously, disclosed battery units **100** are replaceable, and disclosed frames **140** holding anode **110** and cathode **120** is replaceable within housing **150** as well. Moreover, disclosed battery units **100** protect parts of anodes **110** which are used to provide the electrical contact from dissolving due to electrolyte contact, preventing electrical and mechanical difficulties due to inconsistencies in the physical dimensions of the battery elements. Disclosed battery units **100** also provide sufficient protection and sealing around the metal anode, while avoiding the creation of friction upon frame insertion into housing **150**, e.g., by the complementary trapezoidal shapes and use of smooth plastic-to-plastic between frame **140** and housing **150**. Finally, disclosed battery units **100** optimize the use of the anode material in production and therefore the efficiency and power provided by the battery. Additional advantages of disclosed units **100** and methods **200** comprise enabling a relatively cheap production process, easy maintenance (e.g., simple insertion and extraction of anode **110** to and from housing **150** using frame **140** while providing good sealing against electrolyte leakage) and improved mechanical and electrical connection to the anodes throughout its entire lifetime without experiencing degradation as the anode is consumed.

[0070] In the above description, an embodiment is an example or implementation of the invention. The various appearances of "one embodiment", "an embodiment", "certain embodiments" or "some embodiments" do not necessarily all refer to the same embodiments. Although various features of the invention may be described in the context of a single embodiment, the features may also be provided separately or in any suitable combination. Conversely, although the invention may be described herein in the context of separate embodiments for clarity, the invention may also be implemented in a single embodiment. Certain embodiments of the invention may include features from different embodiments disclosed above, and certain embodiments may incorporate elements from other embodiments disclosed above. The disclosure of elements of the invention in the context

of a specific embodiment is not to be taken as limiting their use in the specific embodiment alone. Furthermore, it is to be understood that the invention can be carried out or practiced in various ways and that the invention can be implemented in certain embodiments other than the ones outlined in the description above.

[0071] The invention is not limited to those diagrams or to the corresponding descriptions. For example, flow need not move through each illustrated box or state, or in exactly the same order as illustrated and described. Meanings of technical and scientific terms used herein are to be commonly understood as by one of ordinary skill in the art to which the invention belongs, unless otherwise defined. While the invention has been described with respect to a limited number of embodiments, these should not be construed as limitations on the scope of the invention, but rather as exemplifications of some of the preferred embodiments. Other possible variations, modifications, and applications are also within the scope of the invention. Accordingly, the scope of the invention should not be limited by what has thus far been described, but by the appended claims and their legal equivalents.

CLAIMS

What is claimed is:

1. An aluminum-air battery unit comprising:
 - at least one aluminum-air electrochemical cell comprising a rectangular aluminum anode, at least one corresponding air cathode, and alkaline electrolyte,
 - a frame configured to mechanically support the anode of the cell, and
 - a housing configured to support mechanically the frame and the at least one air cathode and to sealably hold the electrolyte within the housing and in fluid communication with openings in the housing;
 - wherein the frame comprises a protective strap configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and
 - wherein the frame has an external trapezoid shape that is configured to press the protective strap against the edges of the rectangular anode upon insertion of the frame with the anode into the housing.
2. The aluminum-air battery unit of claim 1, wherein the external trapezoid shape of the frame is configured to fit into a trapezoid cavity in the housing.
3. The aluminum-air battery unit of claim 1, wherein the housing is configured to receive the frame by a click connection to the external trapezoid shape of the frame which is configured to apply the pressure on the protective strap against the edges of the rectangular anode.
4. The aluminum-air battery unit of any one of claims 1-3, wherein the housing comprises at least two parts configured to enclose the frame snugly.
5. The aluminum-air battery unit of any one of claims 1-4, wherein the housing and the frame are configured to press the protective strap against all four edges of the rectangular anode upon insertion of the frame with the anode into the housing.
6. The aluminum-air battery unit of any one of claims 1-5, wherein the at least one air cathode comprises a current collector that is a rectangular planar sideways-bent strap.
7. The aluminum-air battery unit of claim 6, wherein the rectangular planar sideways-bent strap is fixated at a contact region of the respective cathode.
8. The aluminum-air battery unit of claim 7, wherein the contact region is central with respect to a side of the respective cathode and the cathode is symmetric along a central axis thereof.

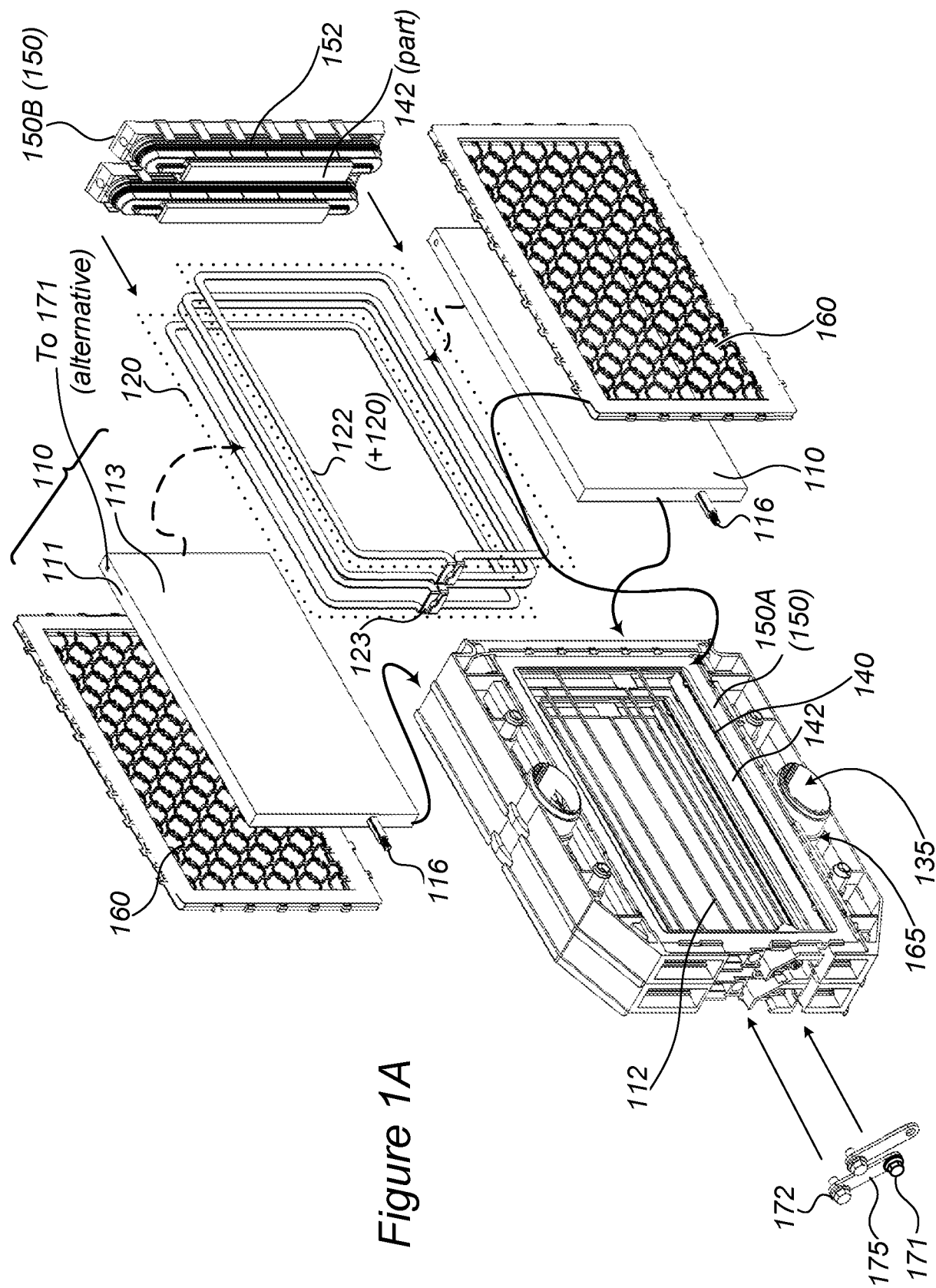
9. The aluminum-air battery unit of any one of claims 1-8, further comprising at least one spacer configured to mechanically prevent contact between the anode and cathode upon emptying the electrolyte from the unit.
10. The aluminum-air battery unit of claim 9, wherein the comprising at least one spacer comprises at least one rod connected to the housing in a plane between the anode and the at least one cathode.
11. The aluminum-air battery unit of any one of claims 1-10, wherein a part of the anode extends outside the frame, is sealed from contact with the electrolyte in the cell, and is used as an anode connector.
12. The aluminum-air battery unit of claim 11, wherein the part of the anode extending outside the frame is a triangular corner of the rectangular anode, and the frame comprises a seal configured to prevent electrolyte penetration to the anode part during consumption of anode material in operation.
13. The aluminum-air battery unit of claim 12, wherein the seal has a width which is at least half a thickness of the anode.
14. The aluminum-air battery unit of any one of claims 1-10, further comprising a stud attached to the anode and is used as an anode connector.
15. The aluminum-air battery unit of claim 14, wherein the frame further comprises a seal configured to prevent electrolyte penetration to the stud during consumption of anode material in operation.
16. The aluminum-air battery unit of claim 15, wherein the seal has a width which is at least half a thickness of the anode.
17. The aluminum-air battery unit of any one of claims 14-16, wherein the stud is tightly secured to the housing, to yield a force pressing the anode against the protective strap.
18. The aluminum-air battery unit of any one of claims 14-17, wherein the stud is tightly secured to the housing, to further secure an electrical connection thereof to the anode.
19. The aluminum-air battery unit of any one of claims 1-18, wherein the frame further comprises a plurality of elastic elements configured to be pressed against the housing upon insertion of the frame thereto, and enhance a contact of the protective strap to the edges of the anode.

20. The aluminum-air battery unit of any one of claims 1-19, further comprising at least one grid configured to mechanically support an adjacent one of the at least one air cathode of the unit and support airways thereto.
21. An aluminum-air battery stack comprising a plurality of the aluminum-air battery units of claim 20, wherein the at least one air cathode comprises two air cathodes placed on both sides of the respective anode in each cell and wherein each battery unit comprises a single grid configured to mechanically support two adjacent air cathodes of corresponding two adjacent units of the stack and support airways thereto
22. The aluminum-air battery unit of any one of claims 1-19, wherein the at least one air cathode comprises two air cathodes placed on both sides of the respective anode in each cell.
23. The aluminum-air battery unit of claim 22, further comprising two grids adjacent to and configured to mechanically support the corresponding two air cathodes and support airways thereto.
24. The aluminum-air battery unit of claim 23, wherein each grid comprises a network having nodal spacers.
25. An aluminum-air battery stack comprising a plurality of the aluminum-air battery units of claim 24, wherein the nodal spacers of each grid contact an adjacent grid of an adjacent battery unit to form rectangular supports to the cathodes and rectangular supports to the airways.
26. The aluminum-air battery unit of claim 23, wherein each grid comprises a plurality of strips in a direction of the airways, and wherein the strips are interconnected by a plurality of connecting elements.
27. An aluminum-air battery stack comprising a plurality of the aluminum-air battery units of claim 26, wherein the connecting elements of each grid contact an adjacent air cathode of an adjacent battery unit to form rectangular supports to the cathodes and U-shaped supports to the airways.
28. The aluminum-air battery unit of claim 23, wherein each grid comprises a plurality of undulating strips in a direction of the airways and in a direction perpendicular thereto.
29. An aluminum-air battery stack comprising a plurality of the aluminum-air battery units of claim 28, wherein the undulating strips of each grid in each direction complement each other with the corresponding undulating strips of an adjacent grid of an adjacent battery unit to form rectangular supports to the cathodes and L-shaped supports to the airways.

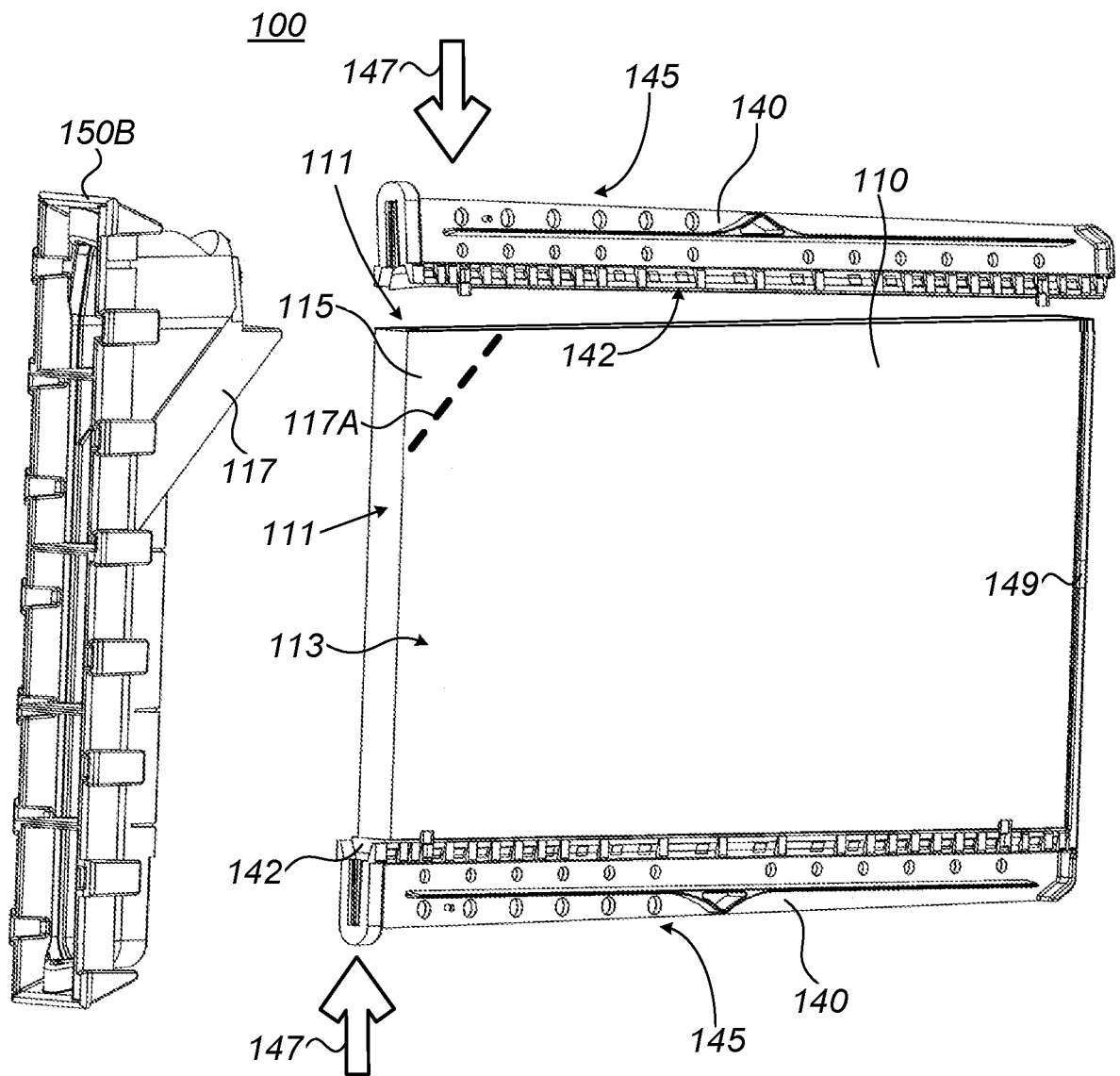
30. The aluminum-air battery unit of any one of claims 20, 22-24, 26 and 28, wherein the housing further comprises air passages in fluid communication with the airways supported by the respective at least one grid.
31. An aluminum-air battery stack of any one of claims 21, 25 and 27, wherein the unit housings further comprise sealed air passages in fluid communication with the airways supported by the grids.
32. An aluminum-air battery stack comprising a plurality of the aluminum-air battery units of any one of claims 1-20, 22-24, 26, 28 and 30, attached to each other with the corresponding electrochemical cells electrically serially connected and the electrolyte openings sealably attached to each other.
33. The aluminum-air battery stack of any one of claims 21, 25, 27 and 31, further configured to maintain the sealed attachment of the electrolyte openings and of the aluminum-air battery units upon removal of at least one frame with the corresponding anode from at least one corresponding housing of a corresponding one of the units.
34. The aluminum-air battery stack of claim 32 or 33, wherein the sealing is maintained along directions perpendicular to a plane of the at least one removed frame and anode.
35. A method comprising:
 - configuring an aluminum-air battery unit, comprising an aluminum-air electrochemical cell comprising a rectangular aluminum anode, at least one air cathode and alkaline electrolyte, to have a frame mechanically supporting the anode of the cell,
 - supporting mechanically the frame and the at least one air cathode in a housing configured to sealably hold the electrolyte therewithin in fluid communication with openings in the housing for receiving delivered electrolyte,
 - placing a protective strap between an inner perimeter of the frame and an outer perimeter of the anode, configured to protect edges of the rectangular anode against corrosion by the electrolyte during operation, and
 - forming the frame to have an external trapezoid shape, that is configured to press the protective strap against the edges of the rectangular anode upon insertion of the frame with the anode into the housing.

36. The method of claim 35, further comprising configuring the housing and the frame to press the protective strap against all four edges of the rectangular anode upon insertion of the frame with the anode into the housing
37. The method of claim 35 or 36, further comprising shaping a current collector of the at least one air cathode as a rectangular planar sideways-bent strap.
38. The method of any one of claims 35-37, further comprising sealing a part of the rectangular anode from contact with the electrolyte in the cell and connecting the sealed part to an anode connector.
39. The method of claim 38, further comprising selecting the sealed part of the rectangular anode as a triangular corner of the rectangular anode, and preventing electrolyte penetration to the anode part during consumption of anode material in operation.
40. The method of any one of claims 35-37, further comprising attaching a stud to the anode, using the stud as an anode connector and sealing a portion surrounding the stud to prevent electrolyte penetration to the stud during consumption of anode material in operation.
41. The aluminum-air battery unit of claim 40, further comprising tightly securing the stud to the housing, to yield a force pressing the anode against the protective strap and to secure an electrical connection thereof to the anode.
42. The method of any one of claims 35-41, further comprising enhancing a contact of the protective strap to the edges of the anode by pressing a plurality of elastic elements against the housing upon insertion of the frame thereto.
43. The method of any one of claims 35-42, further comprising mechanically preventing contact between the anode and the at least one air cathode upon emptying the electrolyte from the unit.
44. The method of any one of claims 35-43, further comprising mechanically supporting the at least one air cathode by a grid which further supports airways to the at least one air cathode, which are in fluid communication with air passages in the housing.
45. The method of any one of claims 35-43, further comprising assembling multiple aluminum-air battery units to form an aluminum-air battery stack having the corresponding electrochemical cells electrically serially connected and the electrolyte openings sealably attached to each other.
46. The method of claim 44, further comprising assembling multiple aluminum-air battery units to form an aluminum-air battery stack having the corresponding electrochemical cells electrically serially connected and the electrolyte openings sealably attached to each other, wherein each

cell comprises two air cathodes on either side of the respective anode, and optimizing a geometrical configuration of the grid, set between adjacent air cathodes of adjacent cells, to minimize resistance to air flow through the airways while maintaining a required level of support of the air cathodes.



2/19

*Figure 1B*

3/19

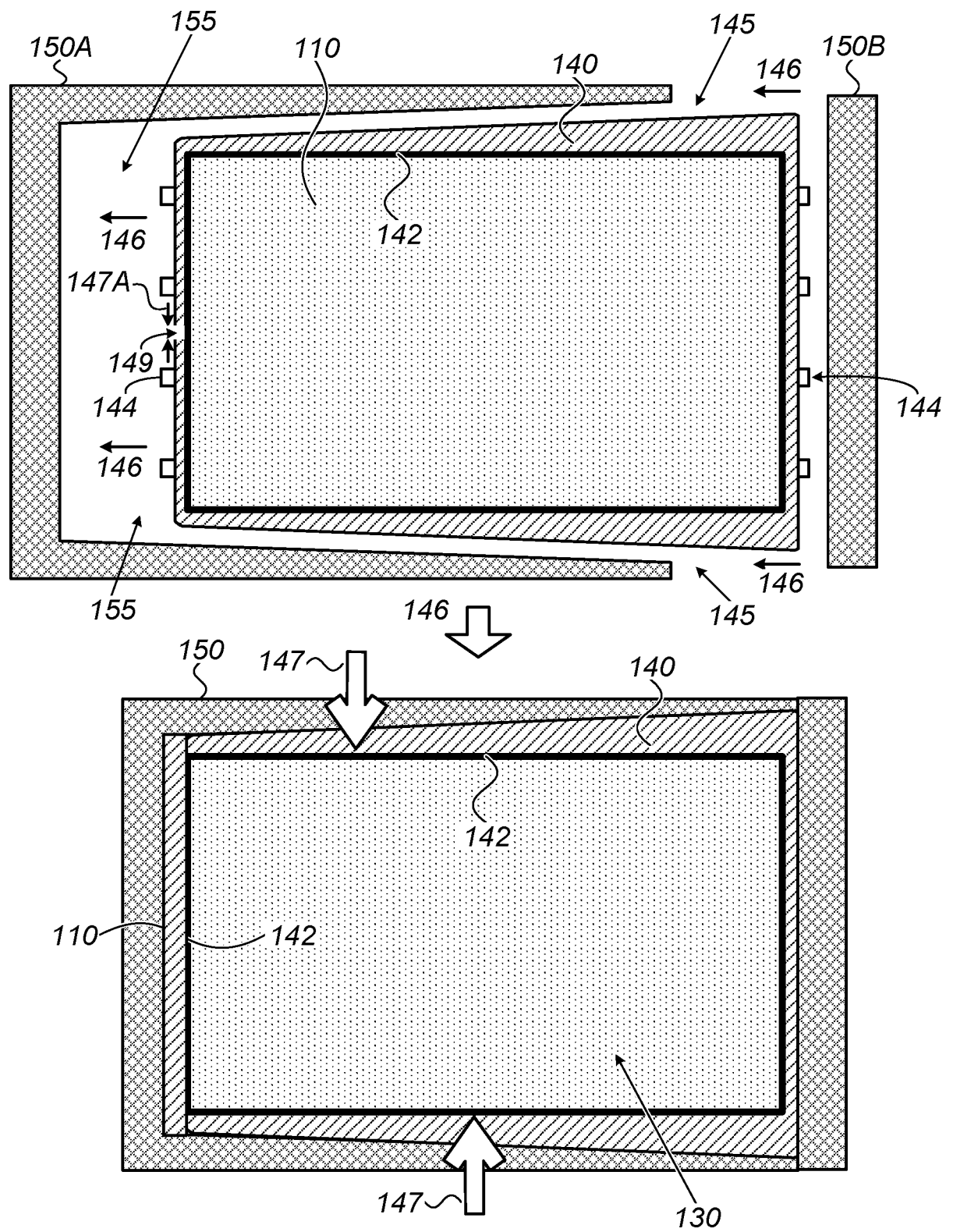


Figure 1C

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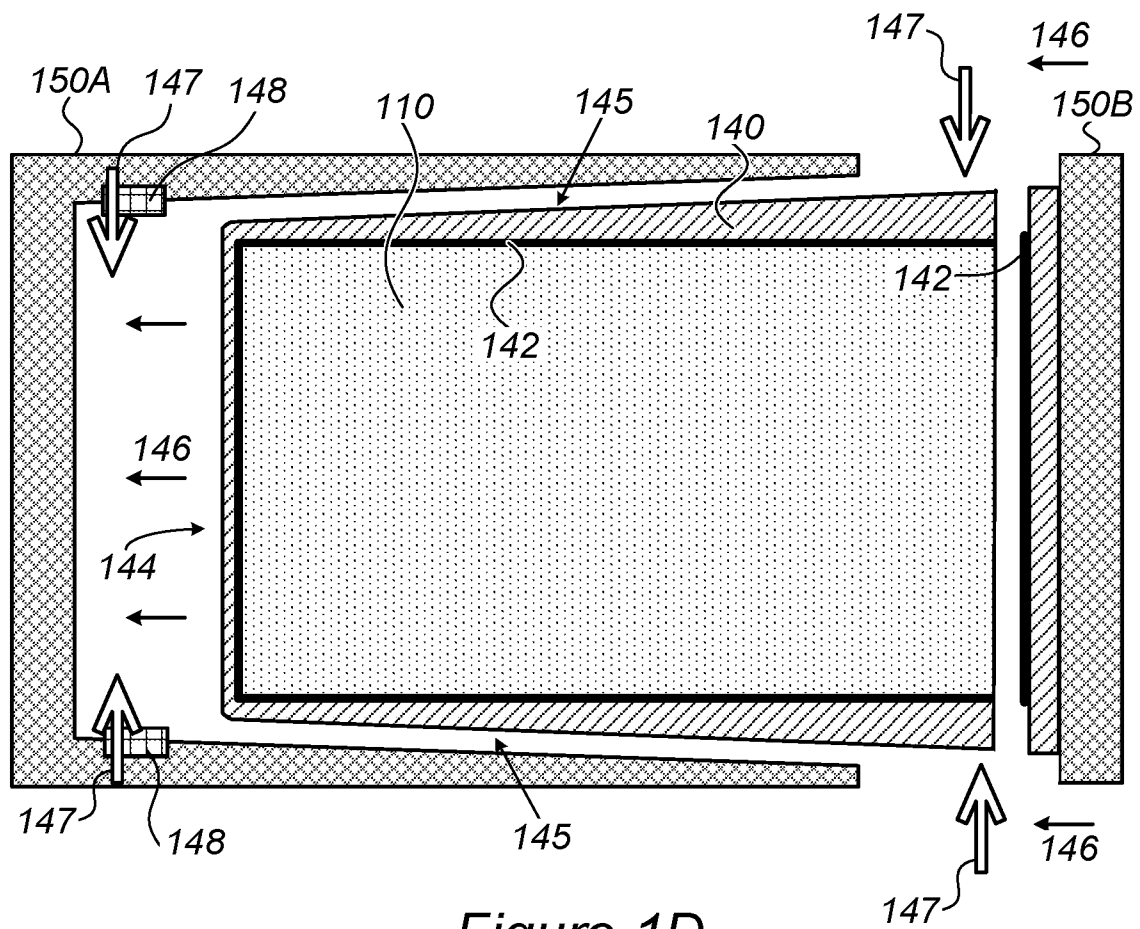


Figure 1D

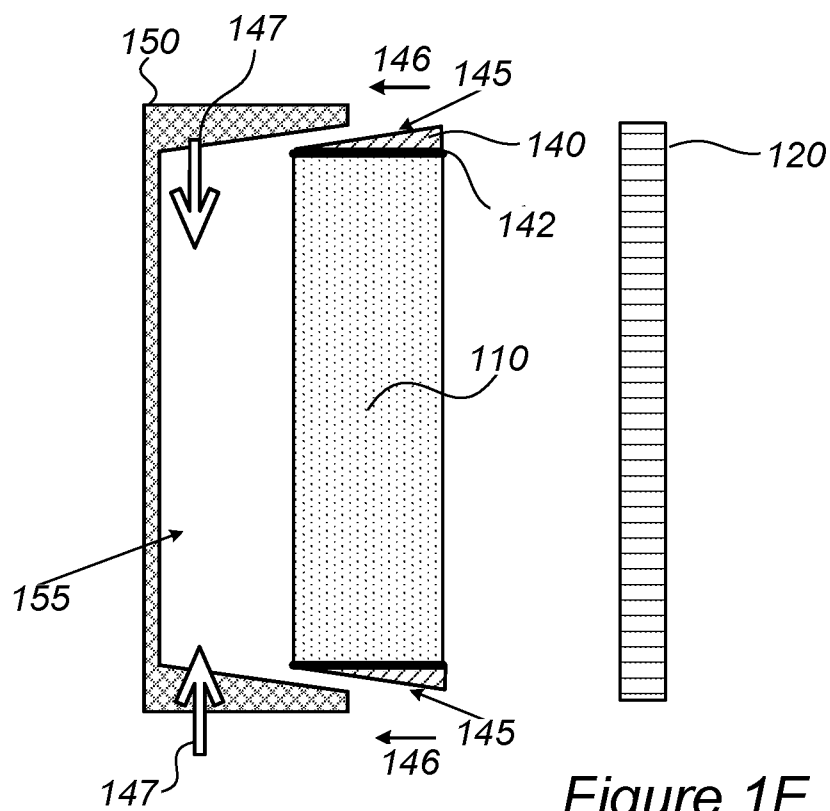


Figure 1E

5/19

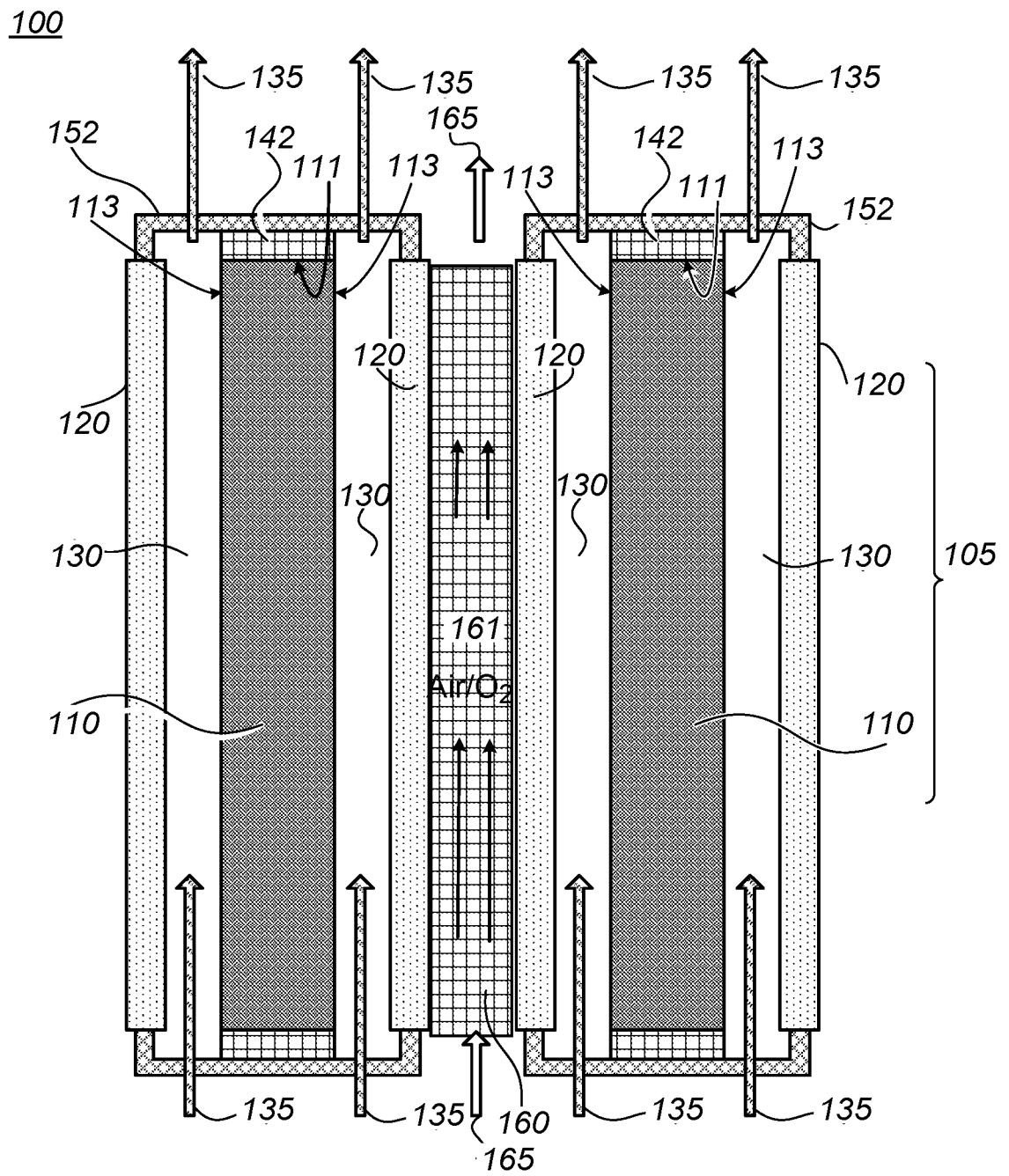


Figure 1F

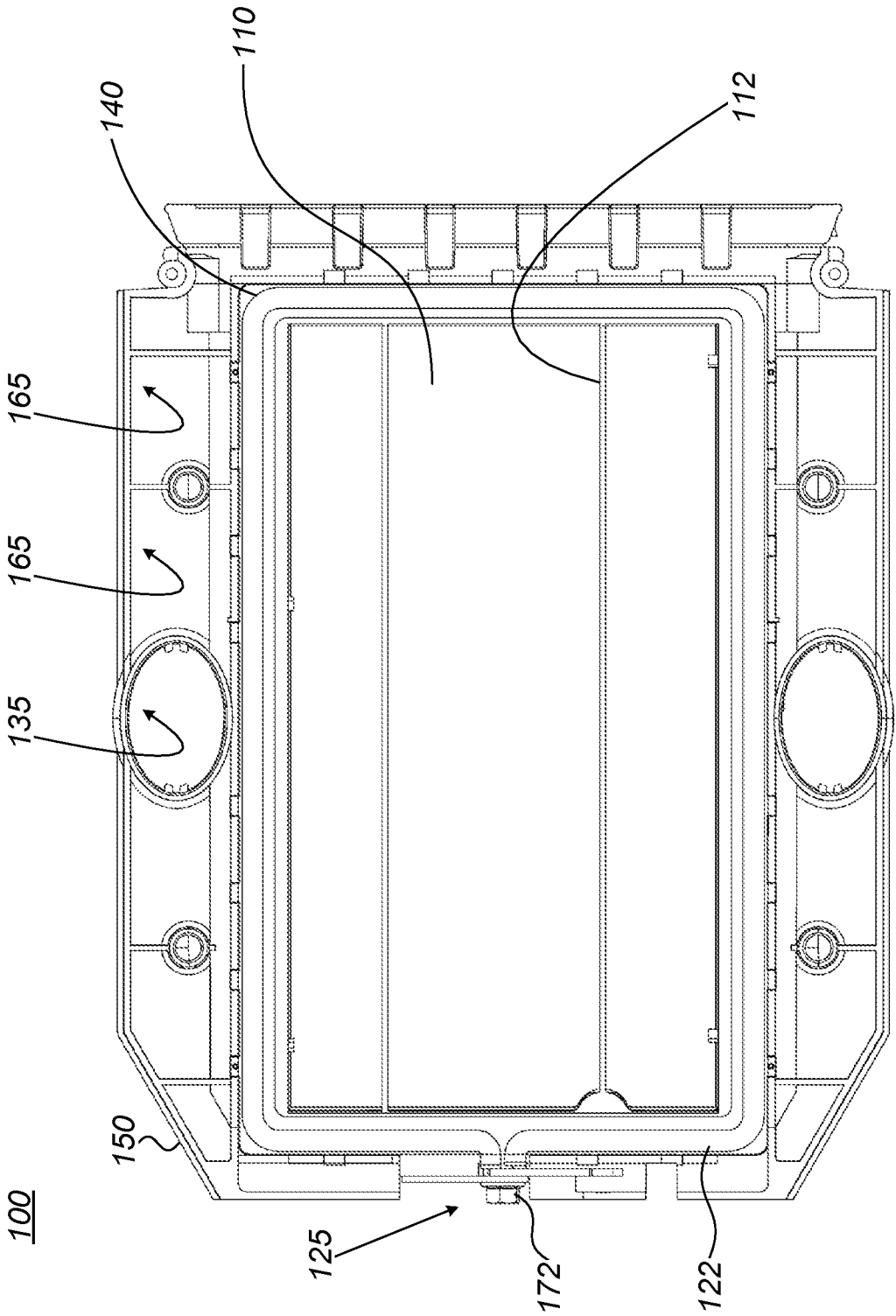
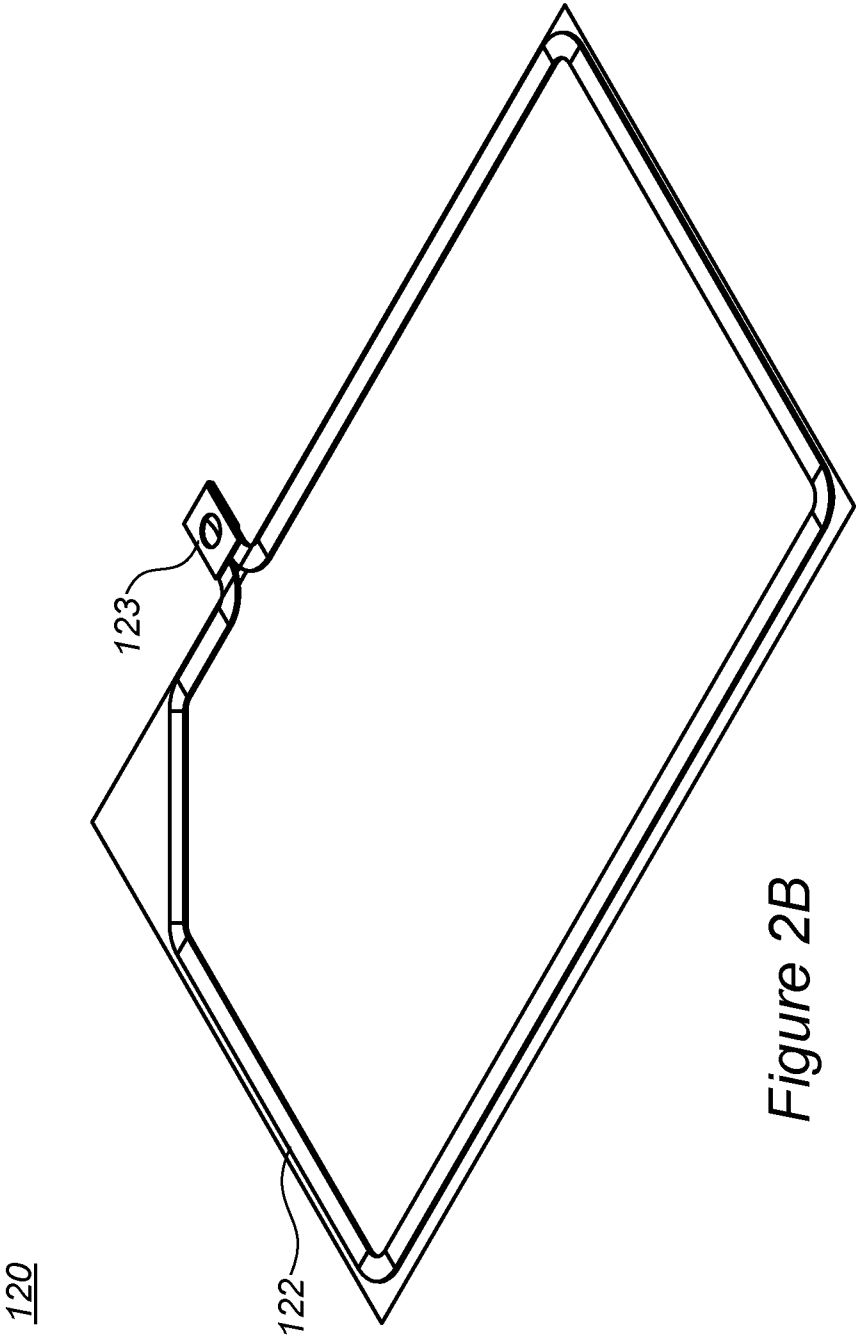


Figure 2A



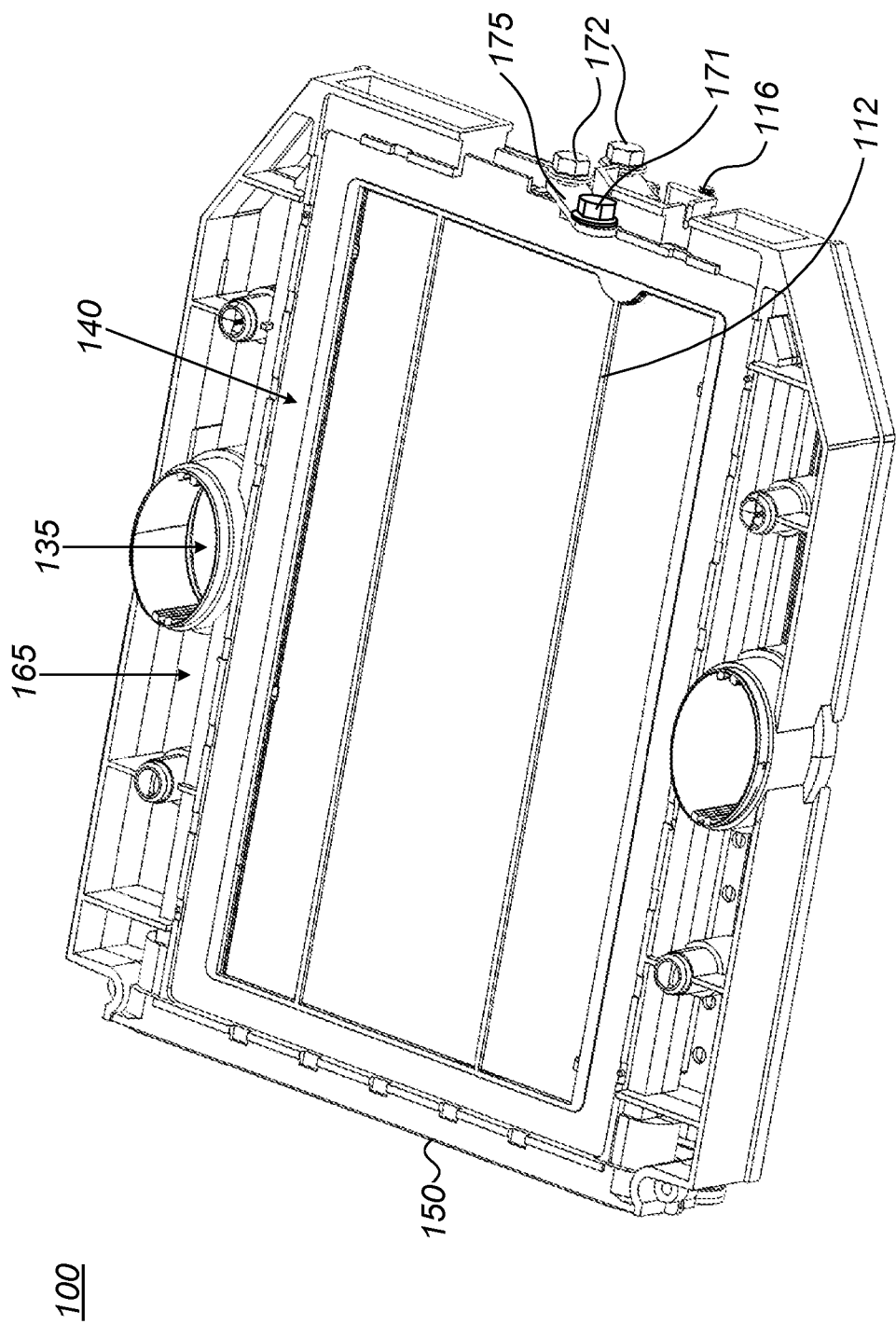


Figure 2C

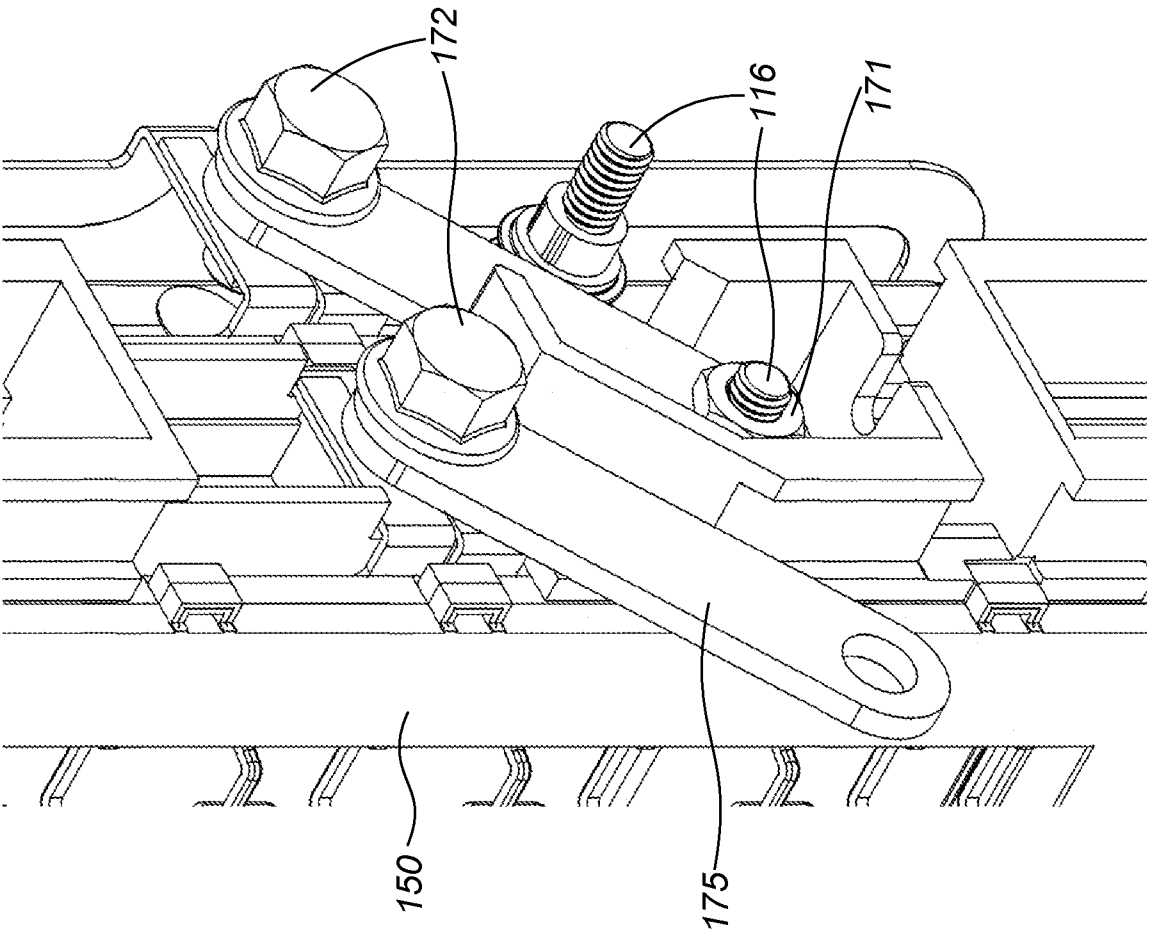


Figure 2D

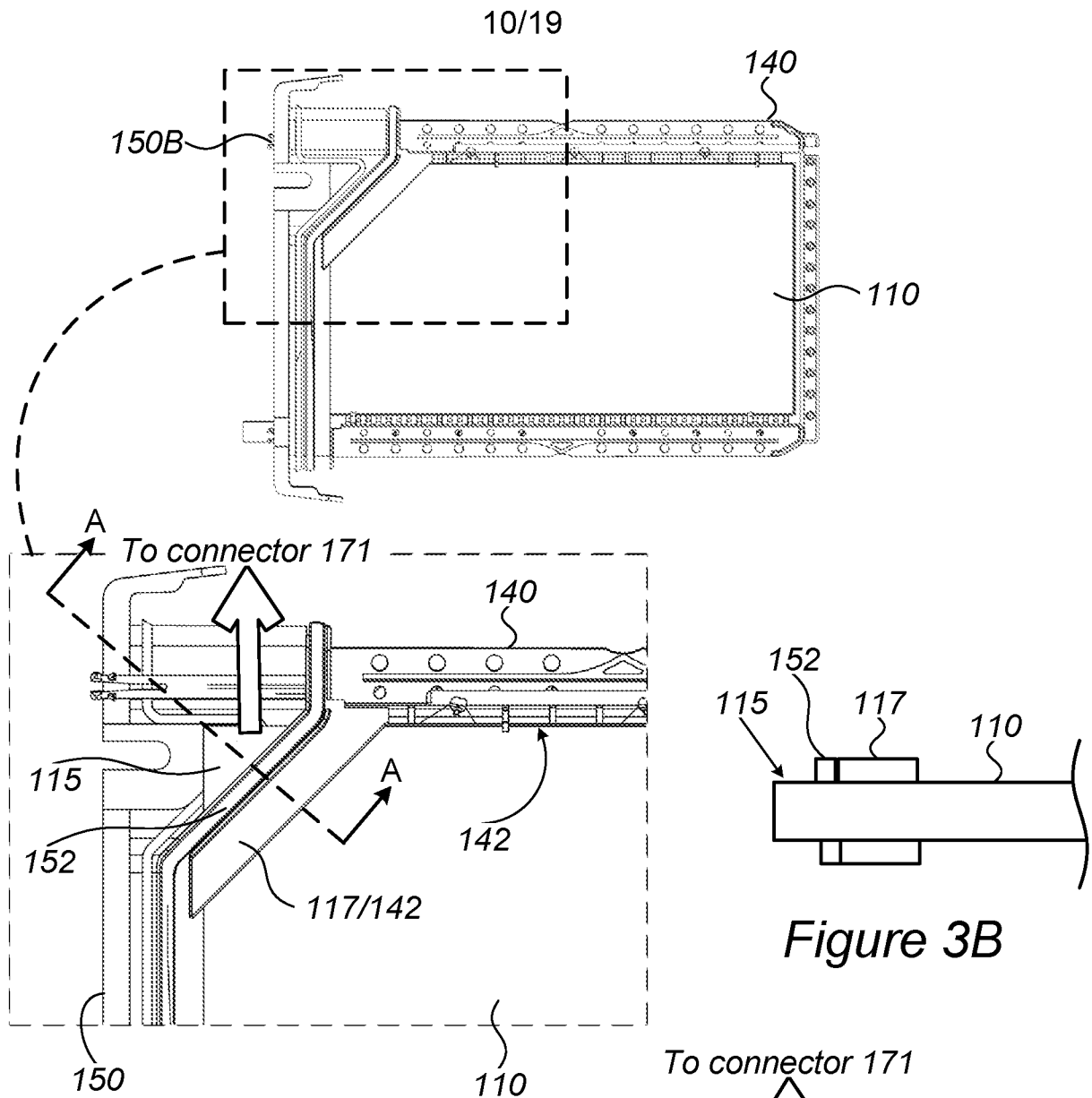
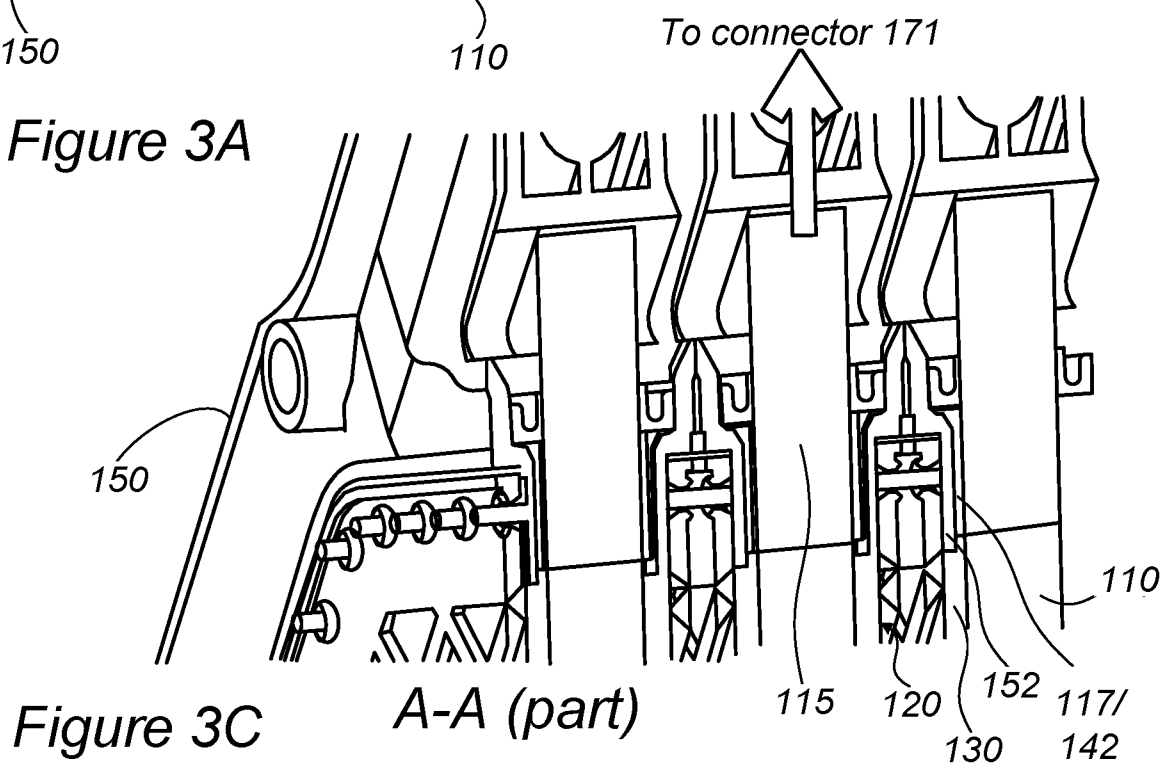


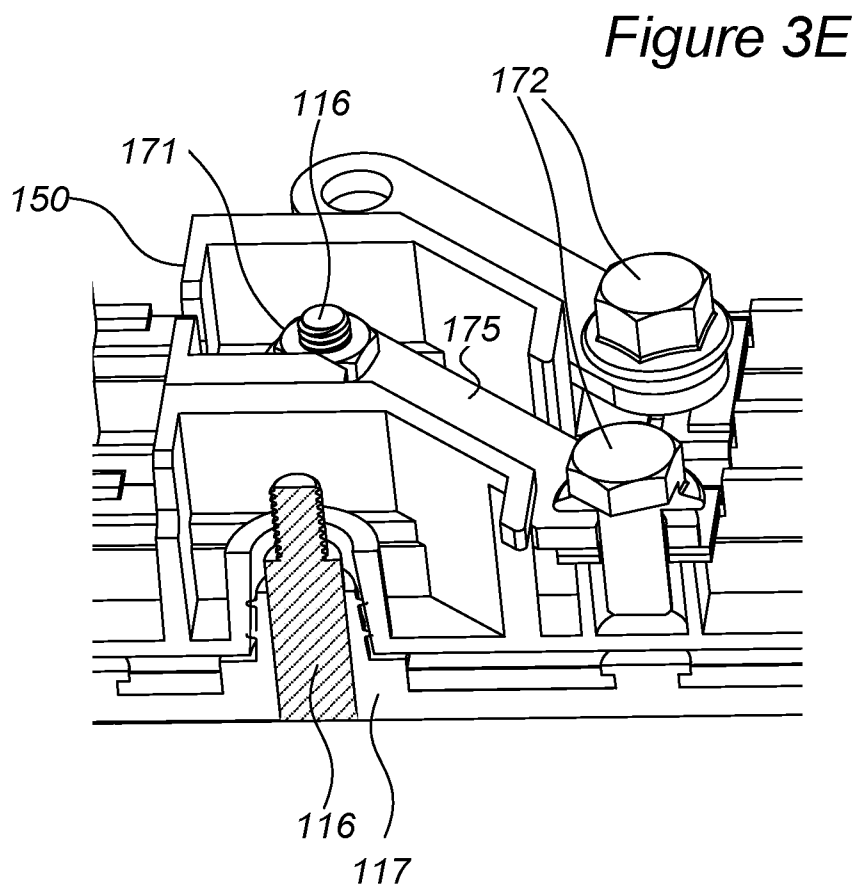
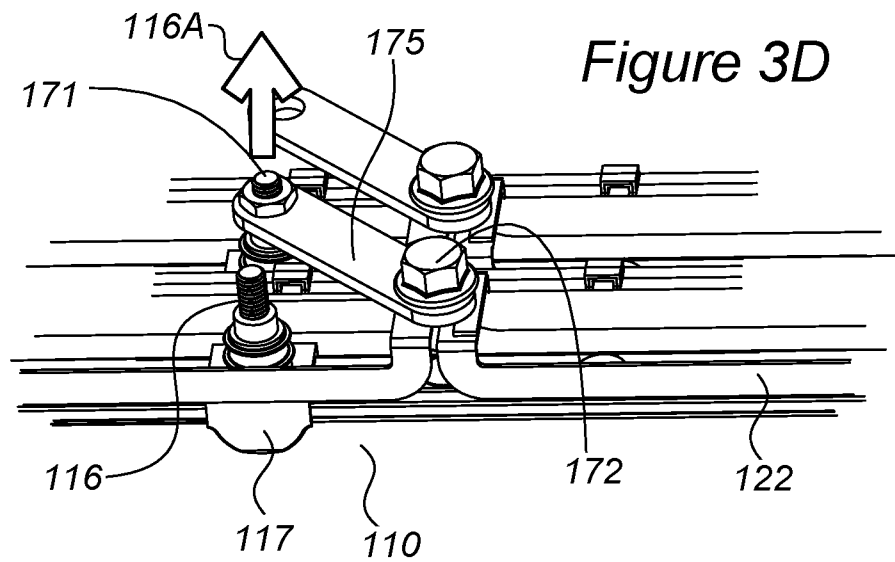
Figure 3B

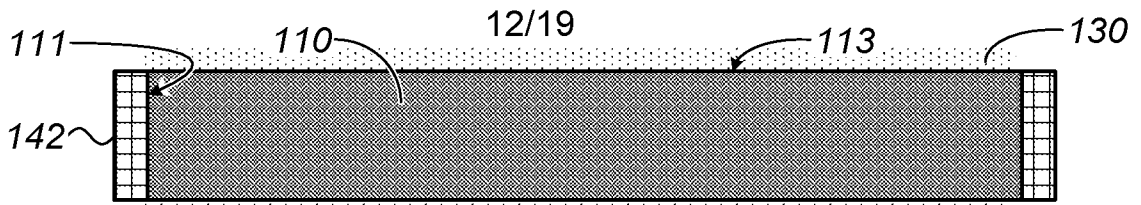
Figure 3A



A-A (part)

11/19





Operation

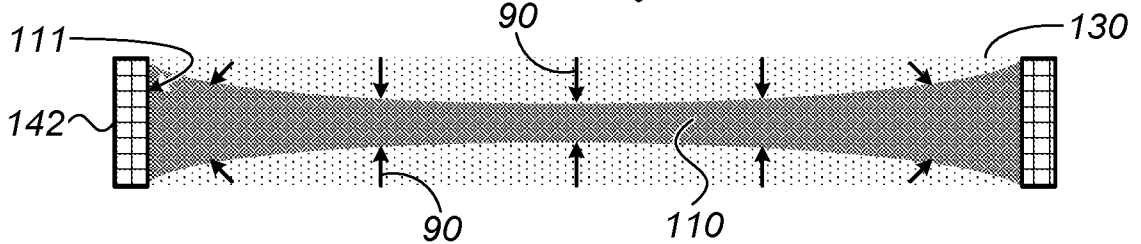
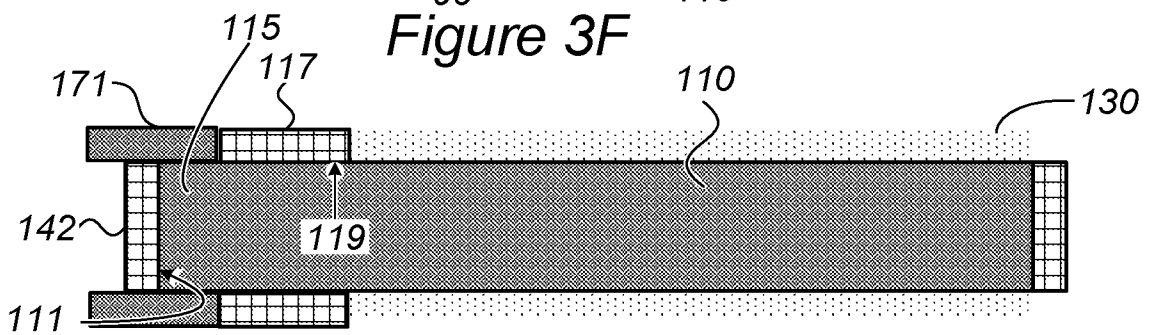


Figure 3F



Operation

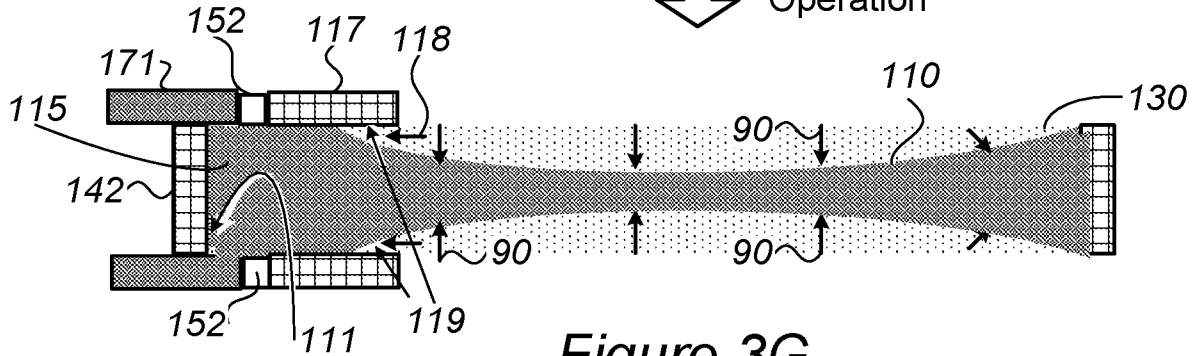
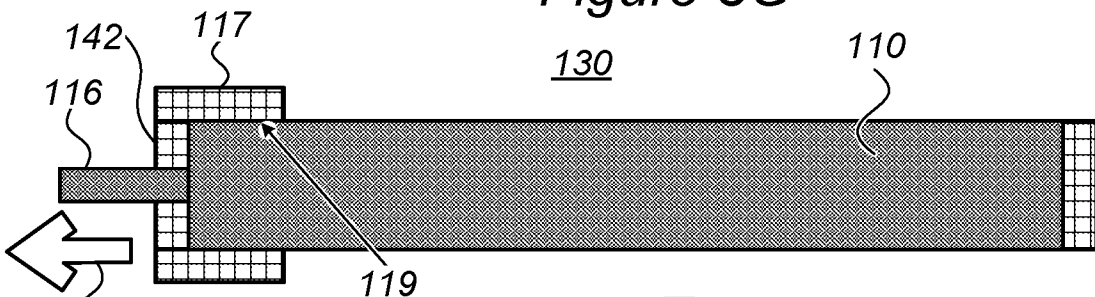


Figure 3G



Operation

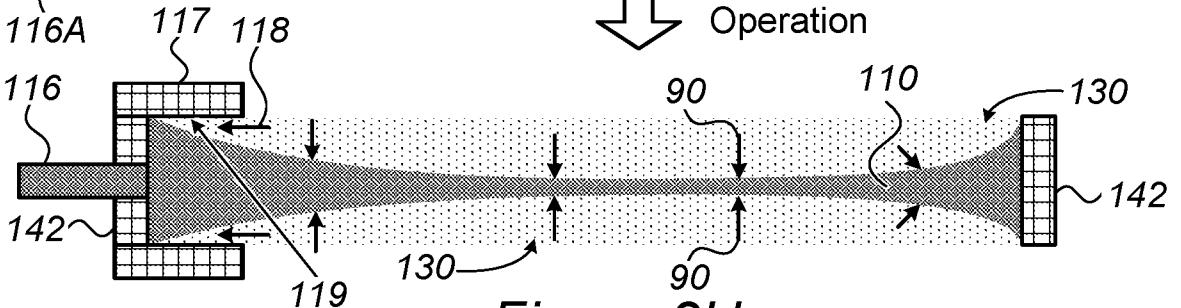


Figure 3H

13/19

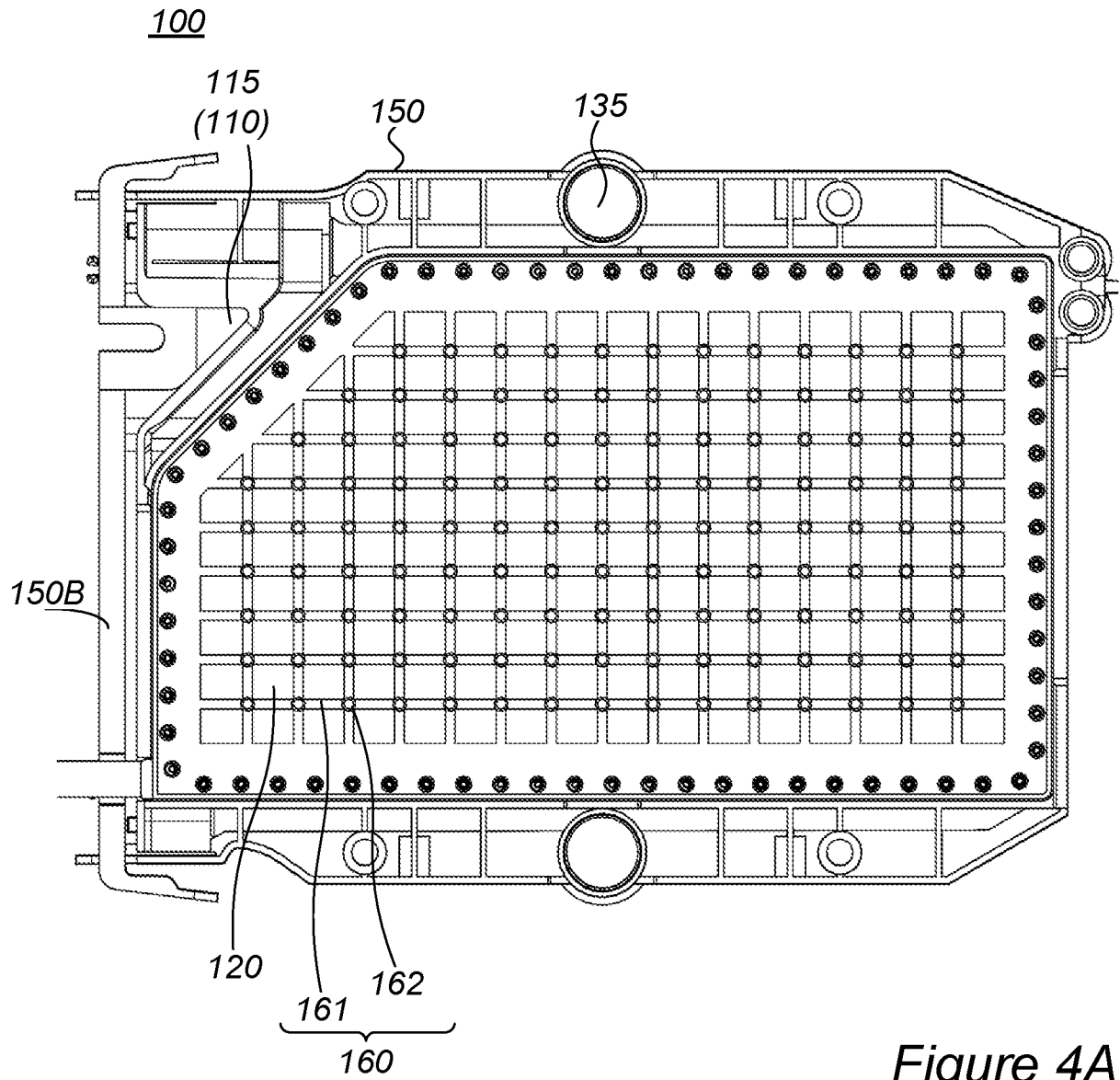


Figure 4A

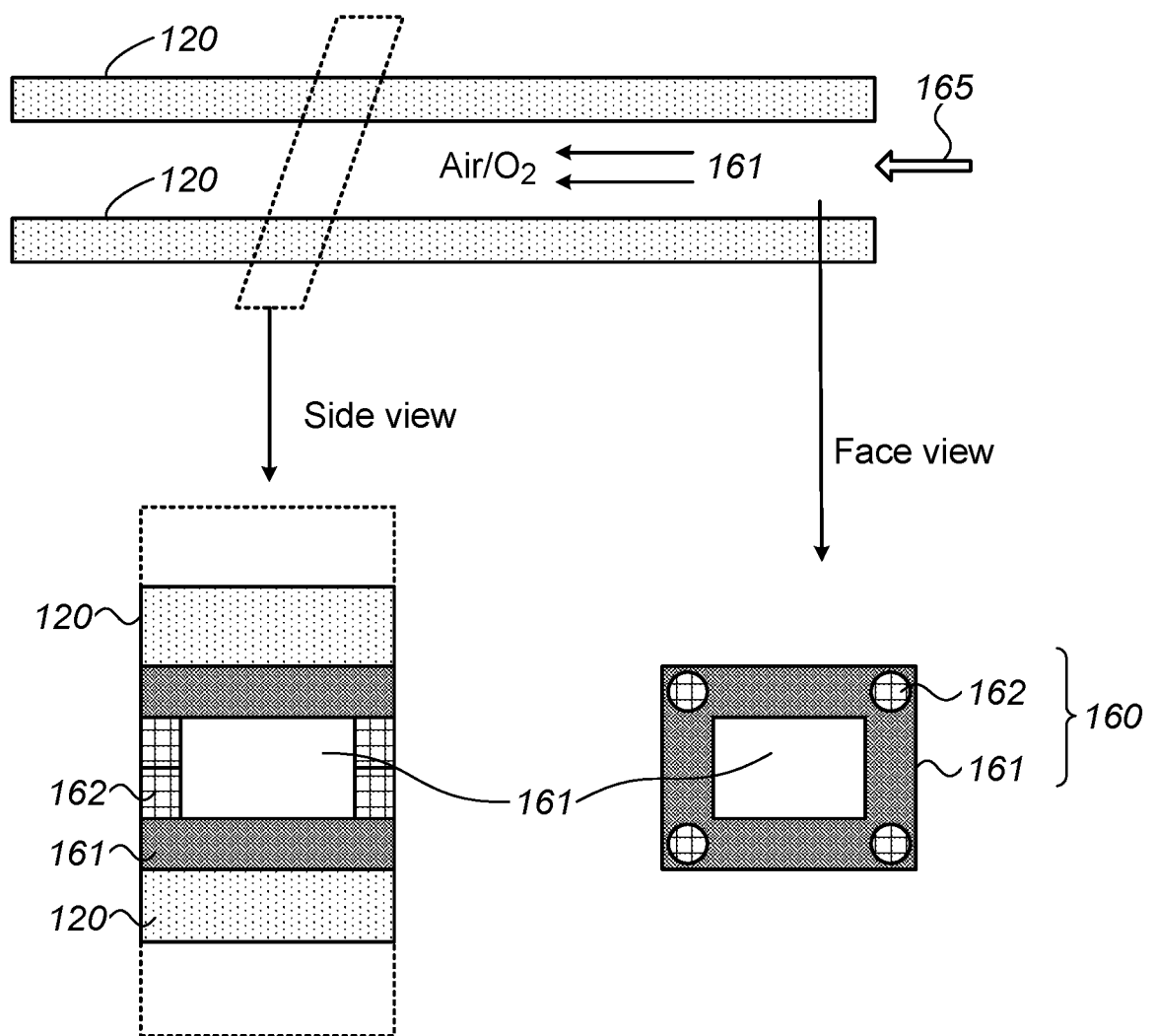


Figure 4B

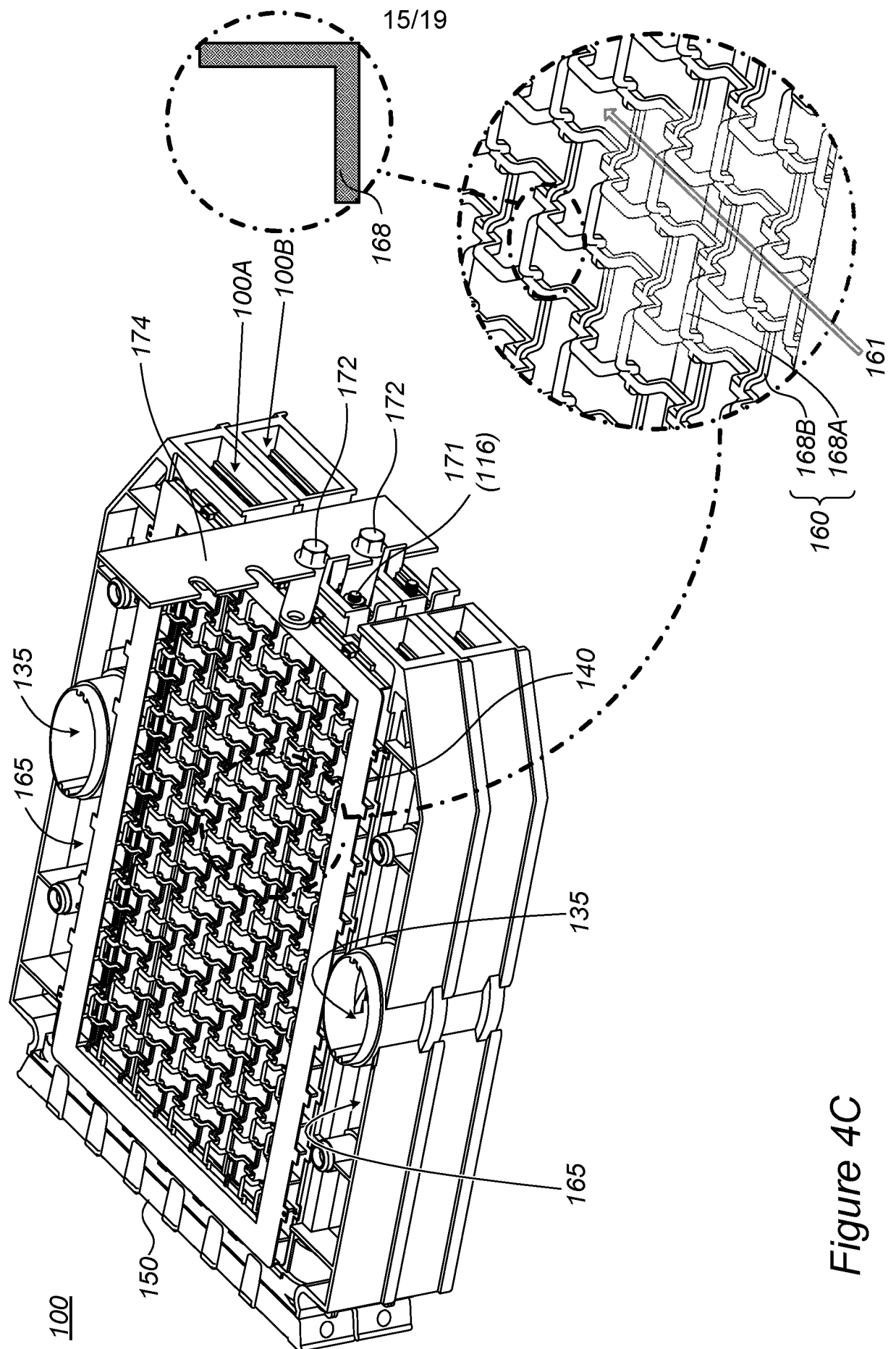


Figure 4C

16/19

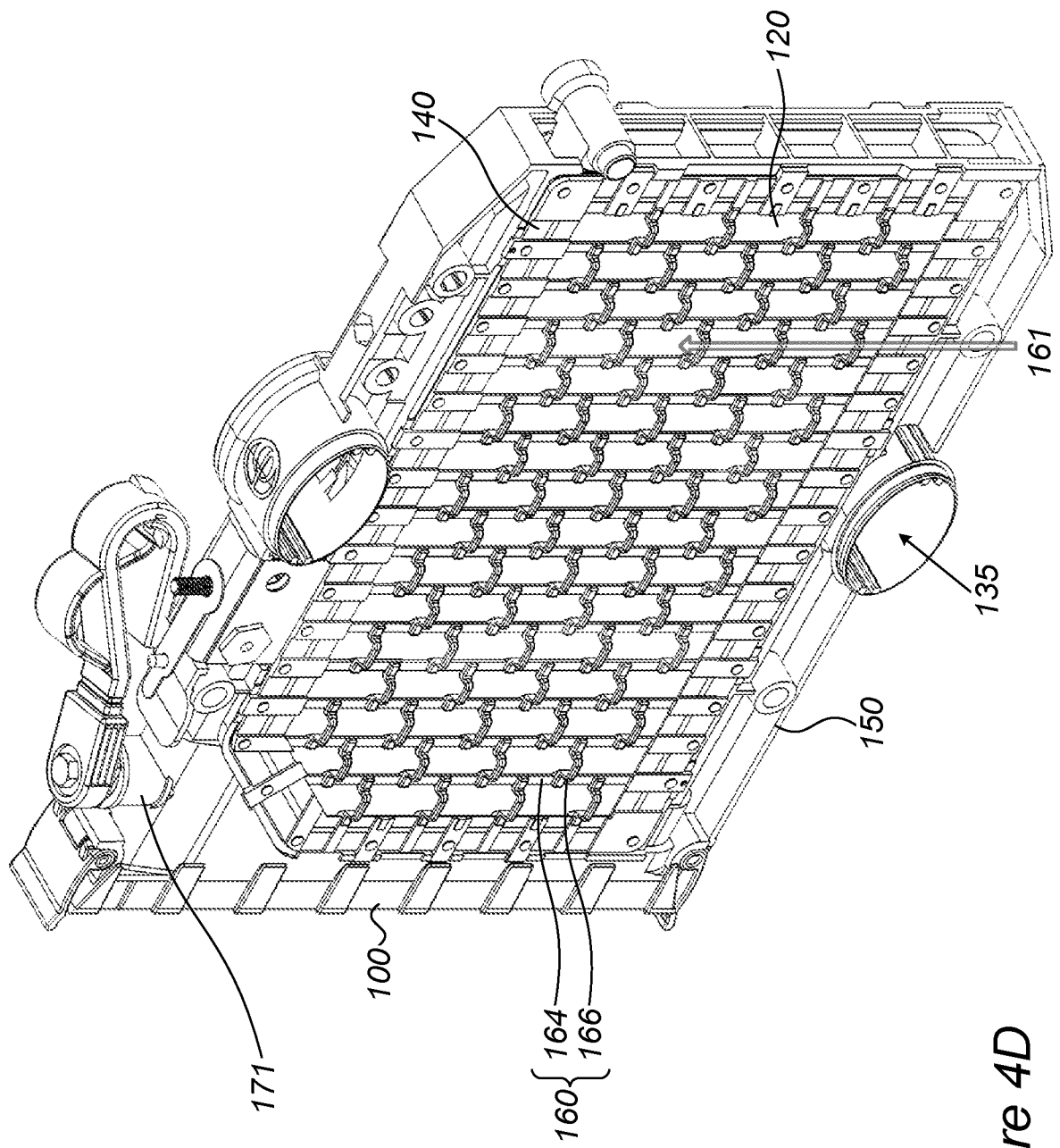


Figure 4D

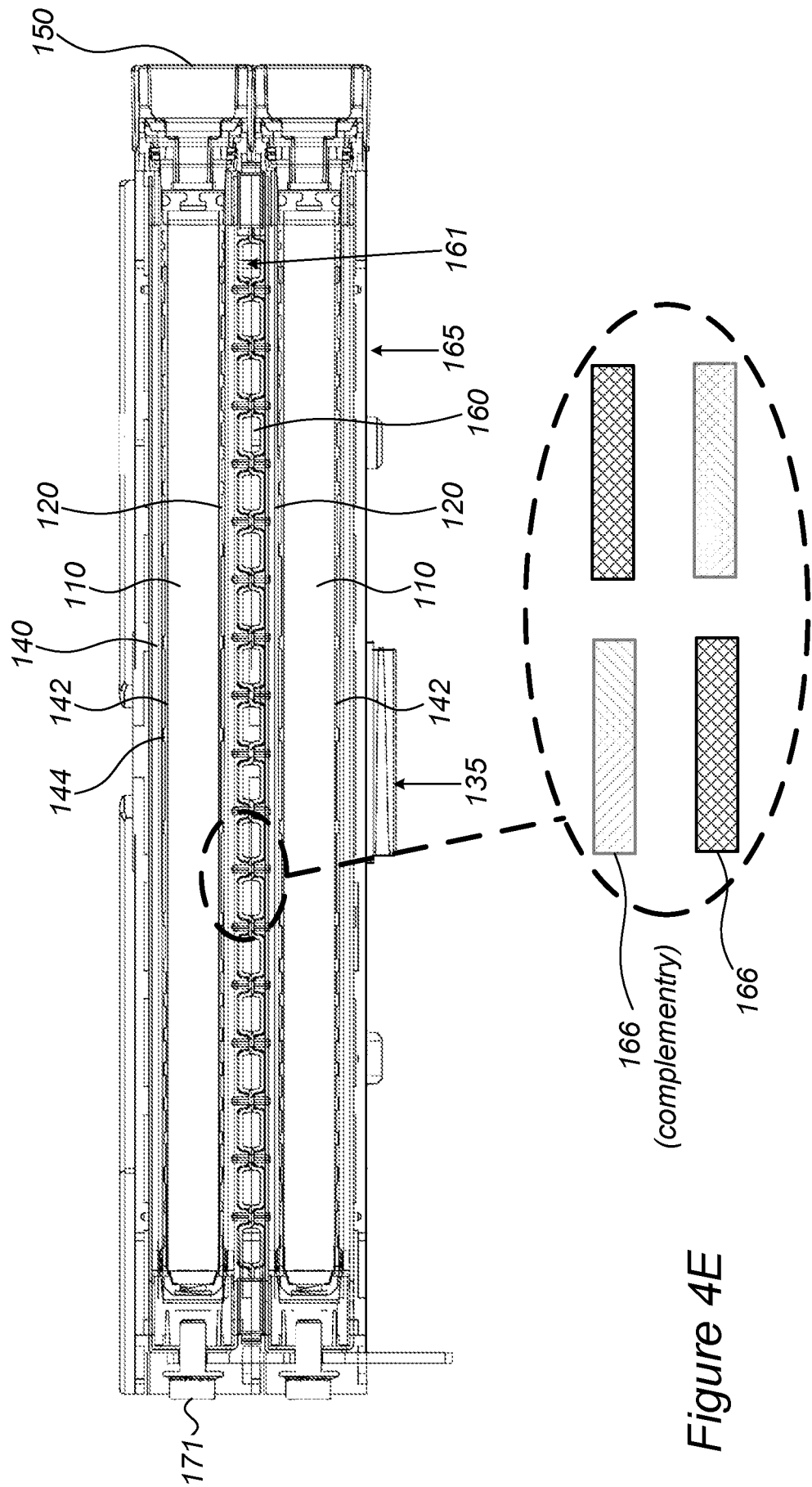
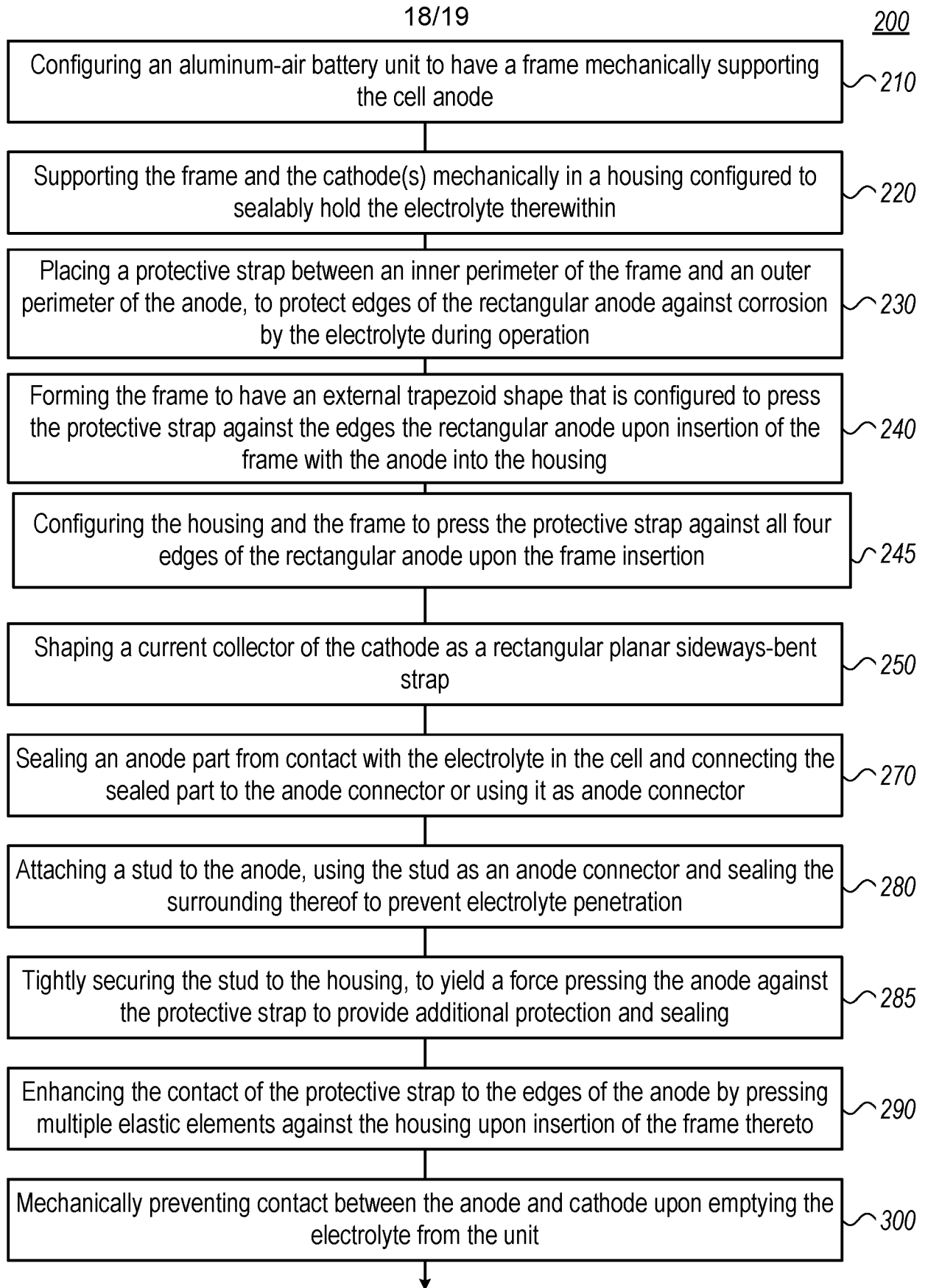
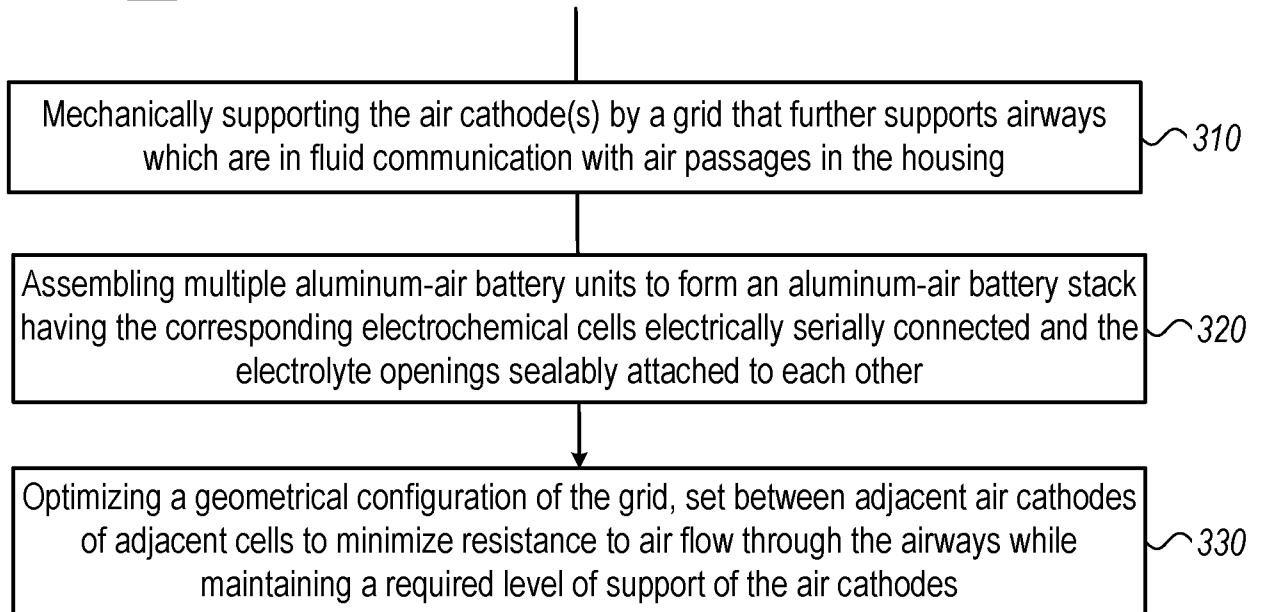


Figure 4E

*Figure 5*

19/19

200*Figure 5 (continued)*

INTERNATIONAL SEARCH REPORT

International application No.

PCT/IL2018/051224

A. CLASSIFICATION OF SUBJECT MATTER

IPC (2019.01) H01M 12/06, H01M 4/46, H01M 6/50

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC (2019.01) H01M 12/06, H01M 4/46, H01M 6/50

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

Databases consulted: Esp@cenet, Google Patents, Google Scholar, PatBase

Search terms used: trapezoid; aluminum-air; battery; protective; strap

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 2016013529 A1 PHINERGY LTD [IL] 14 Jan 2016 (2016/01/14) the whole document	1-46
Y	WO 2012012558 A2 EOS ENERGY STORAGE LLC [US]; AMENDOLA STEVEN [US]; JOHNSON LOIS [US]; BINDER MICHAEL [US]; KUNZ MICHAEL [US]; BLACK PHILLIP J [US]; OSTER MICHAEL [US]; SHARP-GOLDMAN STEFANIE [US]; CHCIUK TESIA [US]; JOHNSON REGAN [US] 26 Jan 2012 (2012/01/26) the whole document	1-46
Y	US 2010143807 A1 KHASIN ERNST; ZABAN ARIE; BAR ILAN UNIVERSITY 10 Jun 2010 (2010/06/10) the whole document	1-46



Further documents are listed in the continuation of Box C.



See patent family annex.

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Date of the actual completion of the international search

26 Feb 2019

Date of mailing of the international search report

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Name and mailing address of the ISA:

Israel Patent Office

Technology Park, Bldg.5, Malcha, Jerusalem, 9695101, Israel

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INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.
PCT/IL2018/051224

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Information on patent family members

International application No.
PCT/IL2018/051224

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