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(54) Title: ACOUSTIC VALVE AND EAR PLUG FOR HEARING PROTECTION

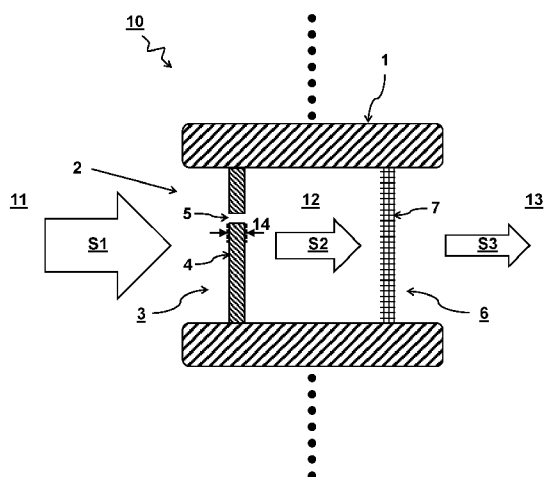


FIG 1

(57) Abstract: The present disclosure concerns an acoustic valve (10) for hearing protection. The valve (10) comprises a housing (1) that is placeable or integrated in an ear plug (100). The housing (1) comprises a sound passage (2) extending through the housing (1) for allowing at least partial transmission of sound from the external surroundings (11) into the auditory canal (13). The housing comprises an impulse filter (3) comprising a rigid plate (4). The rigid plate (4) forms an enclosed volume (12) within the sound passage (2) of the valve. The rigid plate (4) comprises at least one perforation (5) for passing part of the sound from the external surroundings (11) via the perforation (5) into the enclosed volume (12). The housing further comprises an acoustic filter (6) comprising a mesh (7) arranged in the sound passage (2) between the rigid plate (4) and the auditory canal (13).



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Title: ACOUSTIC VALVE AND EAR PLUG FOR HEARING
PROTECTION

TECHNICAL FIELD AND BACKGROUND

5 The present disclosure relates to an acoustic valve for hearing protection. The disclosure further relates to an ear plug for hearing protection comprising the acoustic valve.

 It is recognized that people can be exposed in their daily life to unwanted sounds and sound levels. Excessive sound levels may even cause
10 temporary or permanent damage to a person's hearing. To protect against unwanted or excessive sound, various devices exist that form a barrier or filter between the ear canal and the external surroundings. For example, an ear plug for hearing protection may comprise a universal or customized tip with an outer contour for sealingly fitting into an auditory canal of a user.
15 The earplug may provide a general blocking of all environmental sound. However, this may also prevent the user from hearing any other sound, e.g. speech, which can be undesired in some circumstance. For example, military or law enforcement officers may desire to have a good sense of hearing for regular environmental sound while at the same time being protected
20 against excessive sound levels, e.g. from gunshots. Accordingly, a non-linear filtering of different sound levels can be desired, wherein excessive sound levels are more attenuated than lower sound levels.

 U.S. Patent Number 6,068,079 describes an acoustic valve capable of selective and non-linear filtering of sound and placeable in a perforated
25 ear plug. The acoustic valve consists of a tube enclosing two rigid disks axially spaced opposite each other, each of the disks containing at least one perforation. The total perforated surface of at least one disk is between 0.03 and 0.5 mm² (square millimetre). It is appreciated that the prior art device may provide a simple design to protect against excessive (impulse) sound
30 levels while at the same time allowing at least a perception of regular sound

levels. However, it is found that the overall hearing perception of the environment can feel artificial to a user of the device.

Accordingly there is a desire for a simple design hearing protection device that provides a more natural hearing perception of the environment.

SUMMARY

According to one aspect, the present disclosure provides an acoustic valve for hearing protection, the valve comprising a housing placeable or integrated in an ear plug to form a seal between an auditory canal of an ear and an external surroundings, the housing comprising a sound passage extending through the housing for allowing at least partial transmission of sound from the external surroundings into the auditory canal; an impulse filter comprising a rigid plate forming an enclosed volume within the sound passage, wherein the rigid plate comprises at least one perforation for passing part of the sound from the external surroundings via the perforation into the enclosed volume; and an acoustic filter comprising a mesh arranged in the sound passage between the rigid plate and the auditory canal. According to another or further aspect, the present disclosure provides an ear plug for hearing protection comprising a tip with an outer contour for sealingly fitting into an auditory canal of a user, wherein the tip comprises a channel through the tip, and wherein an acoustic as described herein is arranged in the channel.

Without wishing to be bound by theory, it is appreciated that the synergetic combination of a rigid perforated plate or disc, a mesh, and an enclosed volume, can provide a more natural hearing perception in a simple hearing protection device. The mesh, which is typically woven, can provide an attenuation in particular at relatively low sound levels while the impulse filter, formed by the rigid perforated plate and the enclosed volume therein between, can provide attenuation in particular at relatively high sound

levels. The combined arrangement can provide a relatively flat acoustic transfer function, which is found to be associated with a more natural perception of environmental sound.

The inventors find that a single perforated rigid disc can be used
5 to form an enclosed volume in combination with the acoustic filter and
thereby used as an impulse filter. By forming the enclosed volume between
the rigid plate and the acoustic filter, in particular the mesh, a more
compact arrangement can be provided than e.g. by a combination of an
acoustic filter with two perforated discs. The compact arrangement can be of
10 particular benefit in an ear plug where spacing is limited.

To provide a barrier for impulse sound while at the same time
allowing transfer of naturally occurring sound levels, it is found
advantageous to provide a total perforated cross-section in the rigid plate
between 0.01 and 0.10 square millimetre, preferably between 0.025 and
15 0.035 square millimetre. Alternatively, or in addition, the impulse filter is
found to provide improved performance, i.e. sufficient protection while
allowing natural audio perception, when a specific size is provided for the
enclosed volume. Accordingly, the enclosed volume, e.g. between the rigid
plate and the mesh, is preferably selected in a range between 5 and 20 cubic
20 millimetre, more preferably between 10 and 15 cubic millimetre. Also a
thickness of the rigid plate at a position of the perforation is found to
influence the sound transfer function. To provide improved performance,
this thickness is preferably chosen in a range between 0.05 and 0.5
millimetre, more preferably between 0.1 and 0.3 millimetre.

25 By providing the rigid plate as an integral part of the housing,
production of the device can be simplified. For example, the housing and /or
perforated rigid plate can be made from plastic, e.g. by a moulding
technique. The rigid disc or plate may also comprise a metal part, e.g.
produced by an etch technique. The metal part may provide improved
30 rigidity to the plate which can be beneficial for blocking excessive sound. In

any case, the impulse filter is preferably arranged for attenuating impulse sound, e.g. above 130 dB, from the external surroundings into the auditory canal.

The mesh is preferably a woven mesh, e.g. precision woven. It is
5 found that the sound filtering characteristics of a mesh can be particularly beneficial for attenuating relatively low to midrange sound pressure levels, e.g. below 100 dB. The characteristics of the mesh can be determined e.g. by the many openings formed between a woven grid of the mesh. Typically, several hundred openings can be formed which however provide a relatively
10 low total cross-section. To provide adequate attenuation, the cross-section surface of the openings is preferably between 1 to 20 percent of the total cross-section surface of the mesh, more preferably between 12 and 15 percent.

As described above, the combination of the rigid disc and mesh
15 can provide a simple yet effective means for improving natural perception, in particular for a combination of relatively low and relatively high sound levels. The perception may be even further enhanced by the provision of further acoustic filtering elements. In this regard it is found that a flexible membrane can be provided between the perforated disc and the mesh to
20 enhance filtering of sounds traversing the perforation of the rigid plate. For example, the flexible membrane may flex towards the mesh at elevated sound pressure levels in the enclosed volume. By placing the flexible membrane relatively close to the mesh, e.g. closer than 0.15 millimetre in equilibrium (without sound), the flexible membrane may abutting against
25 the mesh at elevated sound pressure levels, e.g. at sound pressure levels in the enclosed volume above 120 dB. Overall, the flexible membrane may thus provide a further flattening effect on the acoustic transfer function and improve natural perception.

BRIEF DESCRIPTION OF DRAWINGS

These and other features, aspects, and advantages of the apparatus, systems and methods of the present disclosure will become better understood from the following description, appended claims, and
5 accompanying drawing wherein:

FIG 1 shows a schematic cross section view of an embodiment of an acoustic valve;

FIG 2 shows a schematic cross section view of an embodiment of an acoustic valve comprising a flexible membrane;

10 FIG 3 shows a schematic cross section view of an embodiment of an acoustic valve wherein the rigid perforated plate is part of the housing;

FIG 4 shows a schematic cross section view of an embodiment of an acoustic valve comprising a switchable cap;

15 FIGs 5A-5D show schematic views of an acoustic valve design according to one embodiment;

FIG 6A shows schematic views of a perforated plate design according to one embodiment;

FIG 6B shows a graph with an example attenuation measurement of an earplug according to one embodiment;

20 FIG 7A shows a schematic cross section view of an embodiment of an earplug and how this can be inserted into an ear canal;

FIG 7B shows an exploded view of an embodiment of an earplug;

FIG 8A schematically shows a plan view of a woven mesh;

FIG 8B schematically shows a close-up view of mesh wires;

25 FIGs 9A and 9B show a graphs of acoustic transfer functions.

DESCRIPTION OF EMBODIMENTS

Unless otherwise defined, all terms (including technical and scientific terms) used herein have the same meaning as commonly
30 understood by one of ordinary skill in the art to which this invention belongs

as read in the context of the description and drawings. It will be further understood that terms, such as those defined in commonly used dictionaries, should be interpreted as having a meaning that is consistent with their meaning in the context of the relevant art and will not be interpreted in an idealized or overly formal sense unless expressly so defined herein. In some instances, detailed descriptions of well-known devices and methods may be omitted so as not to obscure the description of the present systems and methods. Terminology used for describing particular embodiments is not intended to be limiting of the invention. As used herein, the singular forms "a", "an" and "the" are intended to include the plural forms as well, unless the context clearly indicates otherwise. The term "and/or" includes any and all combinations of one or more of the associated listed items. It will be understood that the terms "comprises" and/or "comprising" specify the presence of stated features but do not preclude the presence or addition of one or more other features. It will be further understood that when a particular step of a method is referred to as subsequent to another step, it can directly follow said other step or one or more intermediate steps may be carried out before carrying out the particular step, unless specified otherwise. Likewise it will be understood that when a connection between structures or components is described, this connection may be established directly or through intermediate structures or components unless specified otherwise. All publications, patent applications, patents, and other references mentioned herein are incorporated by reference in their entirety. In case of conflict, the present specification, including definitions, will control.

The invention is described more fully hereinafter with reference to the accompanying drawings, in which embodiments of the invention are shown. This invention may, however, be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will be

thorough and complete, and will fully convey the scope of the invention to those skilled in the art. The description of the exemplary embodiments is intended to be read in connection with the accompanying drawings, which are to be considered part of the entire written description. In the drawings, the absolute and relative sizes of systems, components, layers, and regions may be exaggerated for clarity. Embodiments may be described with reference to schematic and/or cross-section illustrations of possibly idealized embodiments and intermediate structures of the invention. In the description and drawings, like numbers refer to like elements throughout. Relative terms as well as derivatives thereof should be construed to refer to the orientation as then described or as shown in the drawing under discussion. These relative terms are for convenience of description and do not require that the system be constructed or operated in a particular orientation unless stated otherwise.

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FIG 1 shows a schematic cross section view of an embodiment of an acoustic valve 10 that can be used for hearing protection.

In one embodiment, as shown, the valve 10 comprises a housing 1. The housing can be placeable or integrated in an ear plug 100. The combined ear plug with acoustic valve may form a seal or filter between an auditory canal 13 of an ear and an external surroundings 11. The housing 1 comprises a sound passage 2 extending through the housing 1. The sound passage 2 is arranged for allowing at least partial, e.g. filtered or ,damped, transmission of sound from the external surroundings 11 into the auditory canal 13 via the acoustic elements placed therein.

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In one embodiment, the sound passage 2 comprises an impulse filter 3. The impulse filter 3 comprises a rigid plate 4 forming an enclosed volume 12 within the sound passage 2. The rigid plate 4 comprises at least one perforation 5 for passing part of the sound from the external surroundings 11 via the perforation 5 into the enclosed volume 12. The

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rigidity of the plate 4 is preferably such as to provide minimal or no transmission of sound waves via the plate structure 4 itself, and substantially exclusively via the perforation 5.

In one embodiment, the sound passage 2 comprises an acoustic
5 filter 6. The acoustic filter 6 comprises a mesh 7. In the embodiment shown, the mesh 7 is arranged in the sound passage 2 between the rigid plate 4 and the auditory canal 13. This arrangement provides an advantageous sequence of filtering the relatively loud noises before passing the sound to the mesh. Overall, the combination of the rigid plate 4 and mesh 7 can
10 provide a relatively flat and/or smooth acoustic transfer function compared e.g. to a combination of perforated rigid plates.

In use, sound S1 from the external surroundings 11 enters the sound passage 2 of the valve 10. The sound S2 that passes the rigid plate 4 via perforation 5, enters into the enclosed volume 12. The sound S3 that
15 passes the acoustic filter 6, in this case mesh 7, enters into the auditory canal 13 of a user.

In one embodiment, a cross-section of the perforation 5 in the rigid plate 4 is between 0.01 and 0.10 square millimetre. In one embodiment, a plurality of perforations is provided having a total perforated
20 cross-section within the said range. For example, two, three, or more perforations can be provided in the rigid plate 4. However, an increased number of perforations can affect the acoustic transfer function.

Accordingly, it is found desirable to keep the number of perforations in the rigid disc at fifty or below, preferably at twenty or below, more preferably at
25 ten or below, most preferable at five or below. The less the number of perforations in the rigid disc, the higher can be the individual cross section of the perforations. A higher cross-section of a perforation, may be associated with a lower capillary resistance, which may affect the acoustic transfer function. Similarly, a lower thickness 14 of the rigid plate 4 may be
30 associated with a lower capillary resistance. For example, in one

embodiment, a thickness 14 of the rigid plate 4 at the at least one perforation 5 is between 0.05 and 0.5 millimetre.

In one embodiment, the enclosed or at least substantially enclosed volume 12 is formed between the rigid plate 4 and the acoustic filter 6. In the embodiment shown, the enclosed volume 12 is formed or defined between the rigid plate 4, the mesh 7 and the inner walls of the housing 1. The enclosed volume 12 may act as a buffer to receive sound waves traversing the perforation 5. Together with the rigid plate 4, the enclosed volume 12 may act as an impulse filter 3. In one embodiment, the enclosed volume 12 is between 5 and 20 cubic millimetre. In one embodiment, the impulse filter 3 is arranged for attenuating impulse sound above 130 dB from the external surroundings 11 into the auditory canal 13.

It is noted that the mesh 7 is substantially different from the rigid plate 4 in structure and function. In one embodiment, the mesh 7 comprises a woven structure. For example, a plastic mesh may be extruded, oriented, expanded, woven or tubular. In one embodiment, it comprises a wire mesh. In one embodiment, the mesh 7 comprises a grid forming a plurality of openings through the grid, wherein a cross-section surface of the openings is between 1 to 20 percent of the total cross-section surface of the mesh 7. The structure of the mesh typically provides a relatively low rigidity.

In the embodiment shown, the acoustic filter 6 is formed by the mesh 7. In one embodiment, the acoustic filter 6, e.g. mesh 7, is arranged for flattening an acoustic transfer function of sound from the external surroundings 11 into the auditory canal 13.

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FIG 2 shows a schematic cross section view of an embodiment of an acoustic valve 10, similar to FIG 1, but additionally comprising a flexible membrane 8. In one embodiment, as shown the flexible membrane 8 is arranged between the rigid plate 4 and the mesh 7. In one embodiment, the flexible membrane 8 is arranged for flexing towards the mesh 7 at elevated

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sound pressure levels in the enclosed volume 12. In one embodiment, the flexible membrane 8 is arranged for abutting the mesh at elevated sound pressure levels in the enclosed volume 12, e.g. above 120 dB. In one embodiment, the flexible membrane 8 is relatively close to the mesh 7. For
5 example, in one embodiment, a distance 18 between the flexible membrane 8 and the mesh 7 (at equilibrium, not flexed) is less than 0.1 millimetre.

The flexible membrane 8 may be considered part of the acoustic filter 6, together with the mesh 7. Together, they may provide a desired acoustic transfer function, in particular for low to mid range sound levels,
10 e.g. up to 120 dB. In combination with the impulse filter 3, an overall relatively flat or smooth transfer function may be obtained. It may be considered that the enclosed volume 12 in one embodiment, is formed between the rigid plate 4 and flexible membrane 8, which may be considered part of the acoustic filter 6. Preferably, the rigid plate 4, flexible membrane
15 8, and/or mesh 7 are arranged in series and with their respective surfaces transverse to a length of the sound passage 2.

In one embodiment (not shown), the flexible membrane is disposed between a first mesh and a second mesh. In a further embodiment, the flexible membrane is configured for abutting the first mesh at an
20 elevated pressure of the environment relative to the auditory canal, and configured for abutting the second mesh at a lowered pressure of the environment relative to the auditory canal. It will be appreciated that an impulse sound wave may comprise an oscillating pressure level, wherein the flexible membrane configured between two meshes can filter both the over
25 pressure and under pressure regions of the sound wave. In this way, even further improvement to the acoustic transfer function may be obtained.

FIG 3 shows a schematic cross section view of an embodiment of an acoustic valve similar to FIG 1, except wherein the rigid perforated plate
30 2 is part of the housing 1, i.e. an integral part of the housing 1. For example,

the housing 1 and rigid plate 4 may be produced by a single moulding step, e.g. injection moulding. The perforation 5 may be produced at the time of moulding or applied later.

5 FIG 4 shows a schematic cross section view of an embodiment of an acoustic valve similar to FIG 1, but further comprising a switchable cap 9. The cap 9 may be used for fully or partially closing an entrance to the sound passage 2. Accordingly, the cap 9 may act as an additional filter, in case a user wants to further block any sounds from the environment.

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FIGs 5A-5D show schematic views of a design for an acoustic valve 10 according to one embodiment. FIG 5A shows a cross section view of section A-A, as viewed along the arrows A, indicated in the top view of FIG 5C. FIG 5B shows a perspective view of the embodiment and FIG 5B shows
15 a side view of the embodiment.

In the embodiment shown, the mesh 7 is spanned by a washer or ring 7r that is placed in the housing 1. Alternatively, the mesh may also be attached directly to the housing. The rigid plate 4 in the embodiment is placed with its perforation 5 in line with an opening in the housing 1, e.g. a decorative figure or logo cut from the housing 1. The shown measures are
20 given in millimetres, and may vary for different designs. In the embodiment shown, the valve 10, in particular, the housing 1 has an overall round shape. This may advantageously fit to a typical ear plug. However, also other shapes may be used.

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FIG 6A shows a schematic top and side view of a design according to one embodiment of a rigid plate 4 with perforation 5. Also shown are example measurements for the plate 4, in this case a round disc having a diameter of 4.50 millimetre. The perforation 5, in this example, has a

diameter of 0.20 millimetres. The thickness (not indicated here) is for example 0.15 millimetres. Also other measure and shapes are possible.

FIG 6B show an example graph of a measurements for an earplugs having an impulse filter as described herein. In the graph, the attenuation “F” (in decibels, “dB”) is plotted as a function of a provided
5 sound pressure level “SPL” at an entrance of the respective ear plug. The SPL indicates an integrated value over a range of frequencies.

In one embodiment, the impulse filter is configured to attenuate impulse sound with an SPL between 140 and 160 dB at the entrance of the
10 earplug to an output SPL below 140 dB at the other end of the earplug. Preferably the sound is attenuated below 130 dB. For example, in the graph, an input SPL of 150 dB is attenuated by 30 dB, to provide an output SPL of 120 dB. An input SPL of 165 dB is attenuated by 35 dB, to provide an output SPL of 130 dB. Accordingly, it is demonstrated that the ear plug can
15 provide an increased attenuation for increased sound pressure levels.

FIG 7 shows two embodiments for an earplug 100 for hearing protection comprising an acoustic valve 10, as described herein. The ear plug 100 comprises a tip 101 with an outer contour for sealingly fitting into
20 an auditory canal 13 of a user. FIG 7A shows a cross section view of an embodiment for an earplug 100 with a user customized tip 101 (e.g. otoplastics) while FIG 7B shows an exploded view of an embodiment with a more universal tip 101, e.g. comprising ridges. The tip 101 comprises a channel 102 through the tip 101. The acoustic valve 10 can be arranged in
25 the channel 102. The channel 102 with the valve 10 arranged therein may in use form an acoustic passage between the external surroundings 11 and the auditory canal 13. For example, in FIG 7A, right side, the earplug 100 is shown inserted into an ear 23 of a user. As shown in FIG 7B, the earplug 100 and/or valve 10 may comprise an optional cap (formed in this case by
30 hinging parts 9a, 9b) to manually close off the ear plug passage

It is noted that hearing protection can be defined for example in accordance with a minimum attenuation provided by an ear plug or acoustic valve. In one embodiment, when tested in accordance with EN 13819-2:2002, 4.2, the values (Mf - sf) of the ear-plugs are not less than the values
 5 given in Table 1 of this standard (reproduced below), wherein Mf are the mean attenuation data and sf the standard deviations as measured in accordance with EN 13819-2:2002, 4.2. Alternatively, or in addition, also other definitions of hearing protection can be used.

Frequency in Hz	125	250	500	1000	2000	4000	8000
(Mf - sf) in dB	5	8	10	12	12	12	12

10 The sound pressure level (SPL) typically refers to a logarithmic measure of the effective sound pressure of a sound relative to a reference value. It may be measured e.g. in decibels (dB) above a standard reference level, e.g. 20 μ Pa root mean square in air or 1 μ Pa under water. These and other reference levels may be defined e.g. in a standard such as ANSI S1.1-
 15 1994. For example, a measurement can be done directly in front of and/or directly behind the ear plug. Measurements can be compared to determine a attenuation level of the ear plug, e.g. expressed as the relative sound pressure levels in decibels. It is noted that the amount of attenuation can be vary as a function of the sound pressure level and/or as function of sound
 20 frequency. In some measurements, the sound pressure level and/or the amount of attenuation can be integrated, e.g. over a range of frequencies. The individual or total sound pressure level can also be weighted depending on a typical sensitivity curve of human hearing.

25 FIG 8A schematically shows a plan view of a woven mesh 6 comprising mesh wires 6w forming mesh openings or holes 6h there between. The dash-dotted square “U” in the figure indicates one unit cell that may be considered as a repeating pattern within the mesh 6.

FIG 8B schematically shows a close-up view of four mesh wires 6w defining a mesh opening 6h there between. The cross-sections surface area of the wires 6w within the unit cell "U" is indicated as the area "Aw". The cross-sections surface area of the opening 6h within the unit cell "U" is indicated as the area "Ah". As described herein it is found advantageous that the mesh 7 comprises a grid forming a plurality of openings through the grid, wherein a cross-section surface of the openings is between 0.5 to 20 percent of the total cross-section surface of the mesh 7. This may be the case for example for a mesh as depicted wherein $0.005 \leq Ah / (Ah + Aw) \leq 0.2$.

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FIG 9A shows a graph of acoustic transfer functions of the sound magnitude M (in decibel) for three different measurements in a frequency range F between 100 and 4000 Hz (corresponding to speech). Reference numeral 71 indicates the response for an open artificial ear, i.e. without ear plug. Reference numeral 72 indicates the response for an impulse protector based on a mesh and perforated disc as described herein. Reference numeral 73 indicates the response for an impulse protector based on two perforated discs. It will be appreciated that the graph 72 of the impulse protector based on a mesh and perforated disc has an acoustic transfer functions that is considerably more flat than the graph of the impulse protector based on two perforated discs 73. The graph 72 thus more closely resembles the graph 71 of the open artificial ear and therefore corresponds to a more natural hearing experience e.g. with less occlusion effect.

FIG 9B show further graphs of acoustic transfer functions for different measurements of impulse filters. Reference numerals 71 indicates the response for an open artificial ear. Reference numerals 73 indicates the response for a 200 μ m diameter hole. Reference numerals 72a and 72b indicate the respective responses for a first mesh with 20 μ m holes (total diameter of the mesh 1.6 mm) and a second mesh with 6 μ m holes (total diameter 4 mm). These graphs again illustrate that the mesh provides an

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improved (flatter) acoustic transfer function, more similar to the open ear than the plate with a single hole.

Without being bound by theory, to improve understanding of
 5 different impulse filters and as guidance for optimal parametrization, the following observations are made with regards to the acoustic properties of a densely woven mesh. In general, sound attenuation in order to protect the ear can be realised by blocking (part of) the ear canal. This could e.g. be done by only allowing sound to enter through a small hole, a pipe or a bunch
 10 of small holes. In all those options, the acoustic properties of the openings can be described by two parameters: the acoustic mass m_a and the acoustic resistance R_a . (Both have their equivalent in electricity as inductance and resistance.) The acoustic resistance R_a of a circular opening with a radius of “ a ” can be calculated as follows with “ η ” the viscosity of air and “ L ”, the
 15 depth of the opening in the sound direction:

$$(1) \quad R_a = 8\eta L / (\pi a^4)$$

The acoustic mass of a circular opening can be calculated as follows with “ ρ ” the density of air:

$$20 \quad (2) \quad M_a = 4\rho L / (3\pi a^2)$$

Formulas (1) and (2) combined give for the ratio of m_a and R_a :

$$(3) \quad M_a / R_a = (\rho / 6\eta) \cdot a^2$$

This ratio can be important for the acoustic performance of the
 25 sound attenuator. For most application it is considered to be beneficial to have acoustic transfer function that has an equal attenuation over the frequency range of speech. (100 Hz – 4000 Hz). However, when using openings as described above, the attenuation is higher for higher frequencies. If the acoustic mass term M_a is relatively high, compared to the
 30 resistive term R_a , the higher frequencies are even more attenuated. Hence it

is found desirable to make the ratio as low as possible. If we look at formula (3), this means that the radius a of the holes should be as small as possible. In other words, for a required attenuation of e.g. 10 dB at 500 Hz, it would be preferred to have more smaller holes over less bigger holes.

5 Precision woven meshes made for filtration and use in acoustic applications are in general made of a specific pattern made from two or more layers of plastic wires woven together. This will result in very many, very small holes. From the discussion above it is clear that for use in a hearing protector, it would be preferred to have a mesh like this over a
10 single hole, since the single hole will lead to a less attractive response.

In the table below, the ratio is calculated for two different mesh types and a hole with a similar resistance R_a as mesh Type A. It is clear that the ratio of M_a/R_a is higher for the hole.

	R_a	M_a	M_a/R_a
Type a (13 % mesh openings)	$1.0 \cdot 10^7$	50	$5.0 \cdot 10^{-6}$
Type b (5 % mesh openings)	$6.0 \cdot 10^7$	125	$2.1 \cdot 10^{-6}$
Hole ($a = 0,24$ mm, $L = 1$ mm)	$1.0 \cdot 10^7$	8846	$8.9 \cdot 10^{-4}$

15 In view of these and other considerations, the inventors find that an optimal combination of sufficient hearing protection and a relatively flat acoustic transfer function can be obtained by providing an acoustic valve 10 with impulse filter as described herein having a combination of a perforated rigid plate 4 and a mesh 7, wherein the openings 7h of the mesh have a
20 cross-section diameter D_x between 0.1 and 70 micrometre, preferably between 1 and 40 micrometre, more preferably between 5 and 30 micrometre. For example, as indicated in FIG 8B, for a square or rectangular hole 7h, the cross-section diameter may correspond to a length and/or width dimension of the hole, indicated by “ D_x ” and “ D_y ”. For
25 example, for round openings (not shown) it is preferably to have a radius “ a ”

(half the diameter) between 0.05 and 35 micrometre.

For the purpose of clarity and a concise description, features are described herein as part of the same or separate embodiments, however, it will be appreciated that the scope of the invention may include 5 embodiments having combinations of all or some of the features described. In one aspect, the present disclosure provides a passive acoustic filter with in series a single disc. The single disc consists of a thin element positioned in series with another acoustic element providing a desired acoustic 10 characteristic at sound levels below 130 dBA, in particular in combination with universal tip or custom mould. The disc provides a strong increase in attenuation for higher sound levels as a result of a small hole. This hole can be tuned to provide more or less non-linear behaviour having limited effect on the attenuation at lower sound-levels. For example, while embodiments 15 were shown for acoustic valves comprising passive elements, also alternative ways may be envisaged by those skilled in the art having the benefit of the present disclosure for achieving a similar function and result. For example, alternative sequences of the rigid plate, flexible membrane and/or mesh may provide alternative or additional advantages.

20 Acoustic elements may be combined or split up into one or more alternative components. For example, variable passive filters and/or active elements such as one or more controllable valves may be combined with the rigid disc in addition to, or instead of, the mesh and/or flexible membrane. The various elements of the embodiments as discussed and shown offer 25 certain advantages, such as providing a simple design hearing protection providing a more natural sensation of the environment. Of course, it is to be appreciated that any one of the above embodiments or processes may be combined with one or more other embodiments or processes to provide even further improvements in finding and matching designs and advantages. It is 30 appreciated that this disclosure offers particular advantages to hearing

protection and in general can be applied for any application wherein it is desired to improve an acoustic transfer function of a hearing device.

While the present systems and methods have been described in particular detail with reference to specific exemplary embodiments thereof, it should also be appreciated that numerous modifications and alternative
5 embodiments may be devised by those having ordinary skill in the art without departing from the scope of the present disclosure. For example, embodiments wherein devices or systems are disclosed to be arranged and/or constructed for performing a specified method or function inherently
10 disclose the method or function as such and/or in combination with other disclosed embodiments of methods or systems. Furthermore, embodiments of methods are considered to inherently disclose their implementation in respective hardware, where possible, in combination with other disclosed embodiments of methods or systems. Furthermore, methods that can be
15 embodied as program instructions, e.g. on a non-transient computer-readable storage medium, are considered inherently disclosed as such embodiment.

Finally, the above-discussion is intended to be merely illustrative of the present systems and/or methods and should not be construed as
20 limiting the appended claims to any particular embodiment or group of embodiments. The specification and drawings are accordingly to be regarded in an illustrative manner and are not intended to limit the scope of the appended claims. In interpreting the appended claims, it should be understood that the word "comprising" does not exclude the presence of
25 other elements or acts than those listed in a given claim; the word "a" or "an" preceding an element does not exclude the presence of a plurality of such elements; any reference signs in the claims do not limit their scope; several "means" may be represented by the same or different item(s) or implemented structure or function; any of the disclosed devices or portions
30 thereof may be combined together or separated into further portions unless

specifically stated otherwise. The mere fact that certain measures are recited in mutually different claims does not indicate that a combination of these measures cannot be used to advantage. In particular, all working combinations of the claims are considered inherently disclosed.

CLAIMS

1. Acoustic valve (10) for hearing protection, the valve (10) comprising a housing (1) placeable or integrated in an ear plug (100) to form a seal between an auditory canal (13) of an ear and an external surrounding (11), the housing (1) comprising
 - 5 – a sound passage (2) extending through the housing (1) for allowing at least partial transmission of sound from the external surroundings (11) into the auditory canal (13);
 - an impulse filter (3) comprising a rigid plate (4) forming an enclosed volume (12) within the sound passage (2), wherein the rigid plate
 - 10 (4) comprises at least one perforation (5) for passing part of the sound from the external surroundings (11) via the perforation (5) into the enclosed volume (12); and
 - an acoustic filter (6) for flattening an acoustic transfer function of sound from the external surroundings (11) into the auditory canal (13), the
 - 15 acoustic filter (6) comprising a mesh (7) arranged in the sound passage (2) between the rigid plate (4) and the auditory canal (13), wherein the mesh (7) comprises a grid forming a plurality of openings through the grid, wherein a cross-section surface of the openings is between 0.5 to 20 percent of the total cross-section surface of the mesh (7).
- 20 2. Acoustic valve (10) according to claim 1, wherein the openings (7h) of the mesh (7) have a cross-section diameter (D_x, D_y) between 0.1 and 70 micrometre.
3. Acoustic valve (10) according to any of the previous claims, wherein the mesh (7) is a woven mesh
- 25 4. Acoustic valve (10) according to any of the previous claims , wherein a total perforated cross-section of the at least one perforation (5) in the rigid plate (4) is between 0.01 and 0.10 square millimetre.

5. Acoustic valve (10) according to any of the previous claims,
wherein the enclosed volume (12) is formed between the rigid plate (4) and
the acoustic filter (6).
6. Acoustic valve (10) according to any of the previous claims,
5 wherein the enclosed volume (12) is between 5 and 20 cubic millimetre.
7. Acoustic valve (10) according to any of the previous claims,
wherein a thickness (14) of the rigid plate (4) at the at least one perforation
(5) is between 0.05 and 0.5 millimetre.
8. Acoustic valve (10) according to any of the previous claims,
10 wherein the rigid plate (4) is an integral part of the housing (1).
9. Acoustic valve (10) according to any of the previous claims,
wherein the impulse filter (3) is arranged for attenuating impulse sound
above 130 dB from the external surroundings (11) into the auditory canal
(13), wherein the impulse filter (3) is configured to attenuate impulse sound
15 with an input sound pressure level between 140 and 160 dB at an entrance
of the sound passage (2) to an output sound pressure level below 140 dB at
an other end of the sound passage (2).
10. Acoustic valve (10) according to any of the previous claims,
wherein the acoustic filter (6) comprises a flexible membrane (8) between
20 the rigid plate (4) and the mesh (7).
11. Acoustic valve (10) according to claim 10, wherein the flexible
membrane (8) is arranged for flexing towards the mesh (7) at elevated sound
pressure levels in the enclosed volume (12).
12. Acoustic valve (10) according to claim 11, wherein the flexible
25 membrane (8) is arranged for abutting the mesh at sound pressure levels in
the enclosed volume (12) above 120 dB.
13. Acoustic valve (10) according to claim 11 or 12, wherein a distance
(18) between the flexible membrane (8) and the mesh (7) at equilibrium is
less than 0.15 millimetre.

14. Ear plug (100) for hearing protection comprising a tip (101) with an outer contour for sealingly fitting into an auditory canal (13) of a user, wherein the tip (101) comprises a channel (102) through the tip (101), and wherein an acoustic valve (10) according to any of the previous claims is
- 5 arranged in the channel (102).

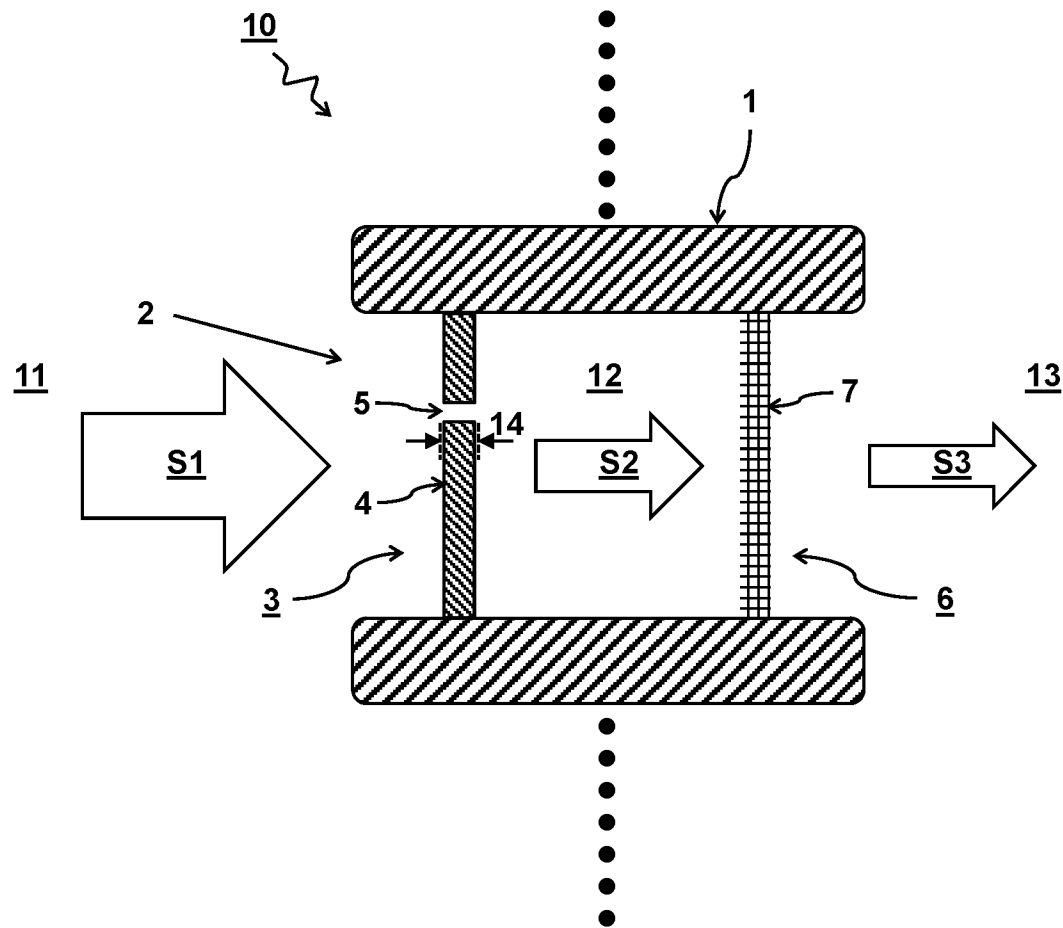


FIG 1

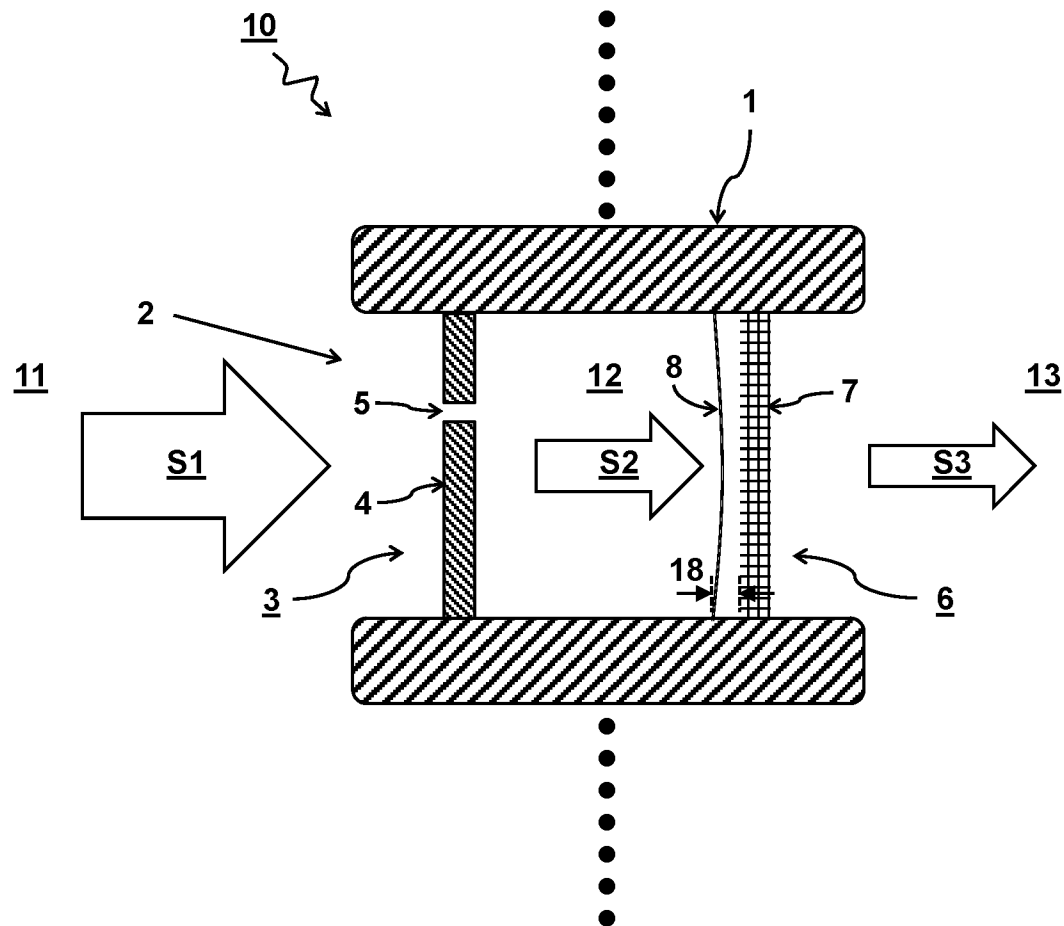


FIG 2

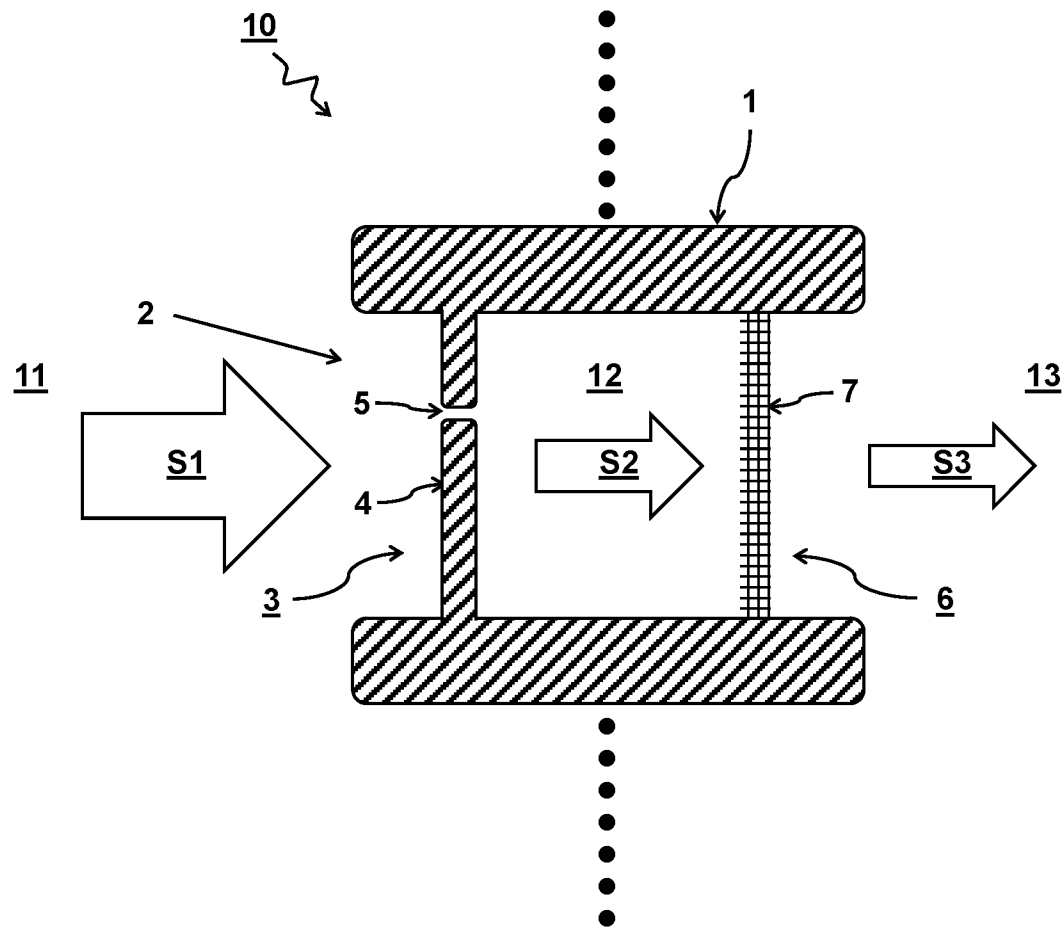


FIG 3

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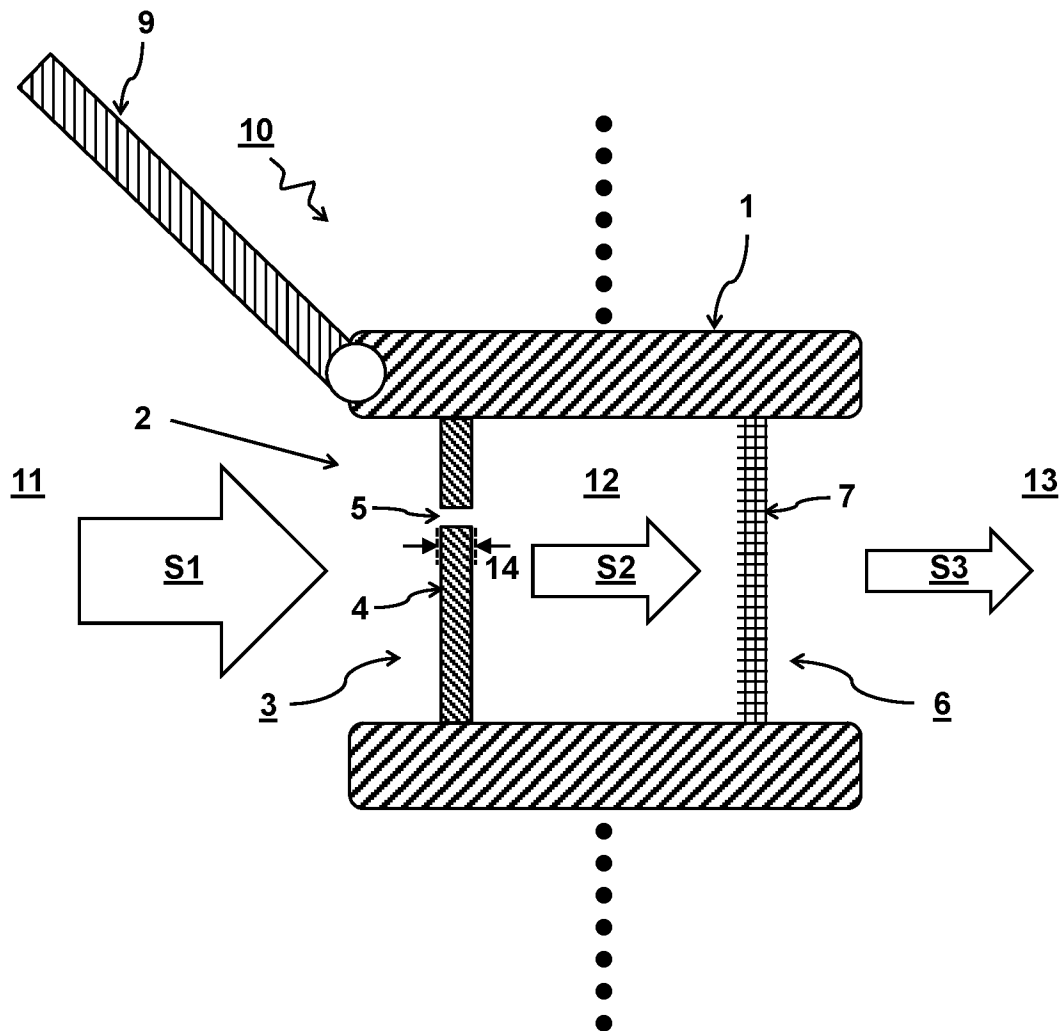


FIG 4

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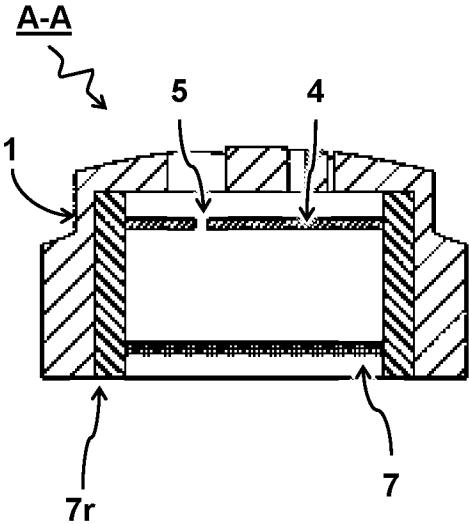


FIG 5A

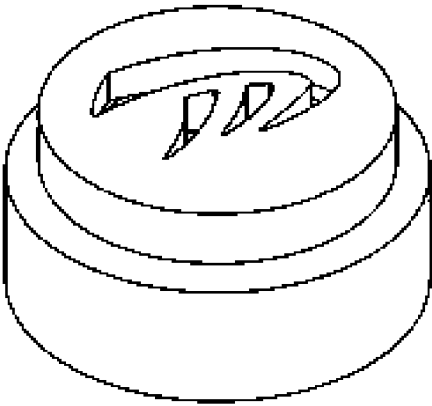


FIG 5B

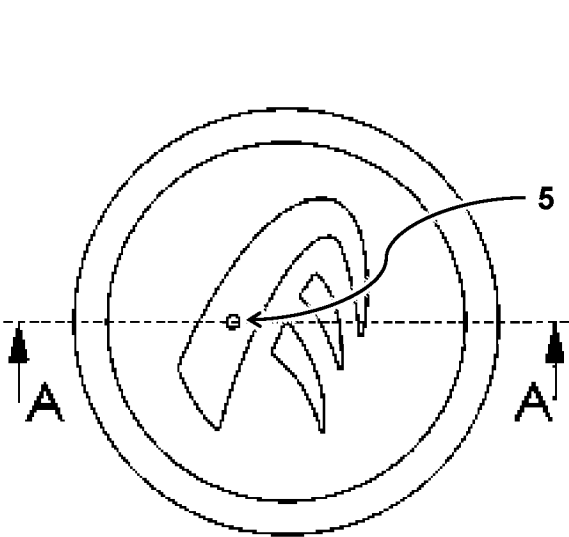


FIG 5C

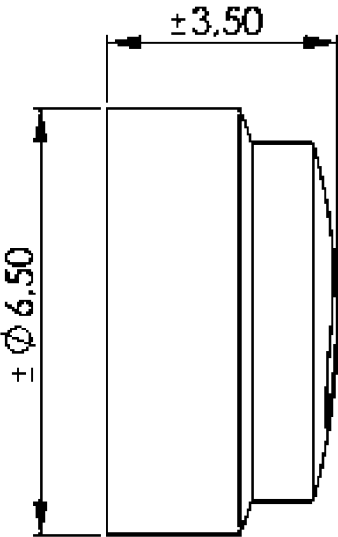


FIG 5D

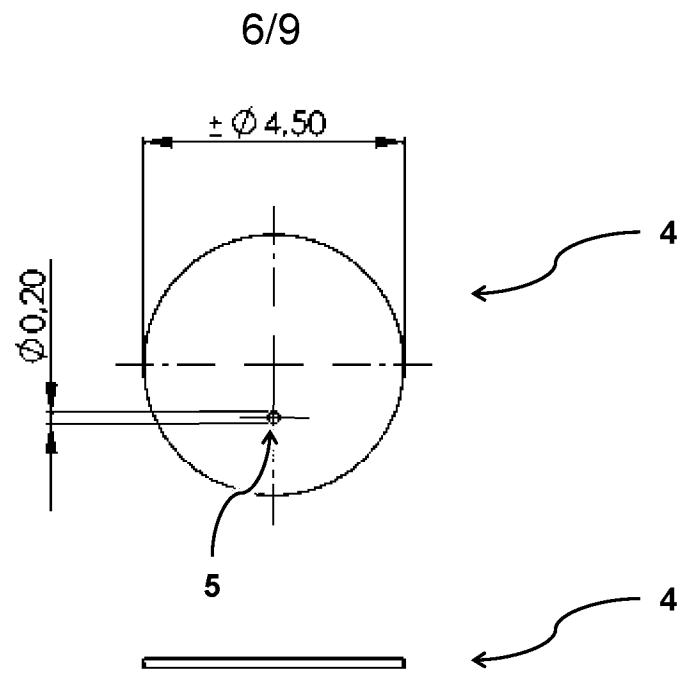


FIG 6A

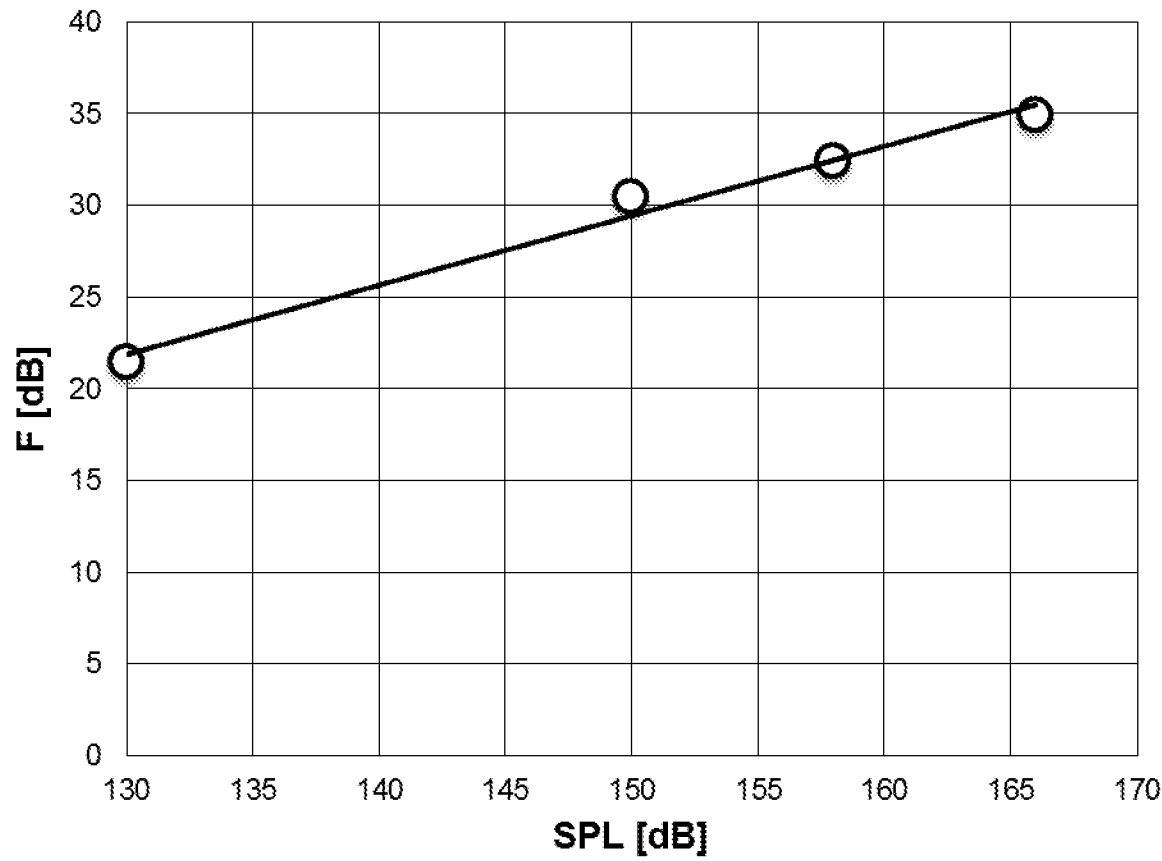


FIG 6B

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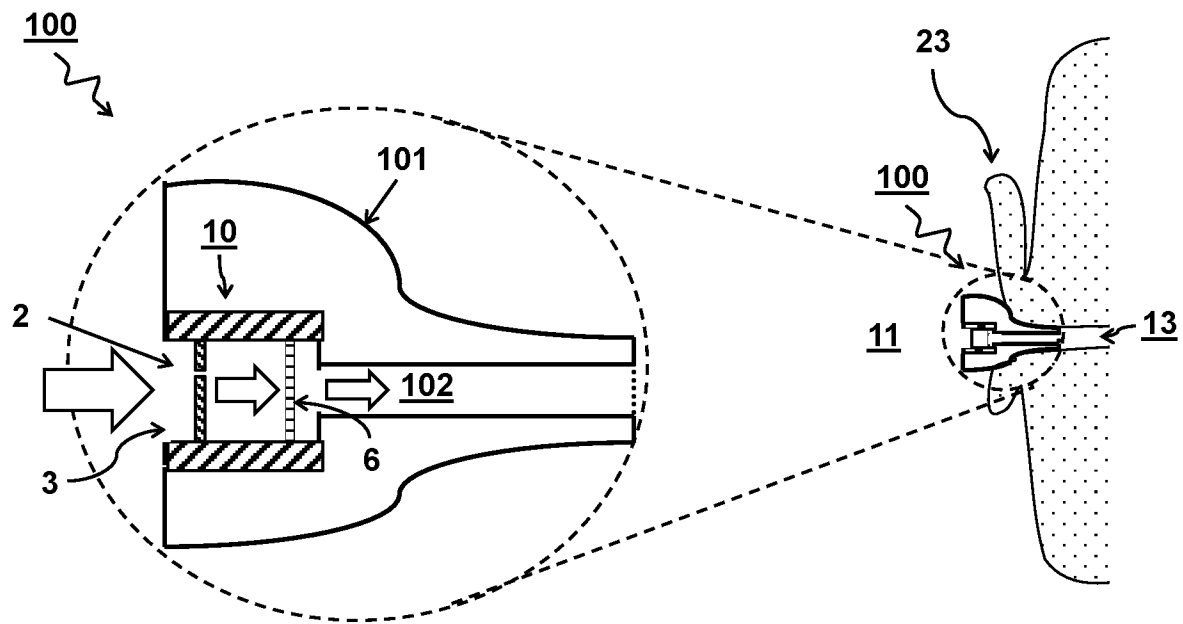


FIG 7A

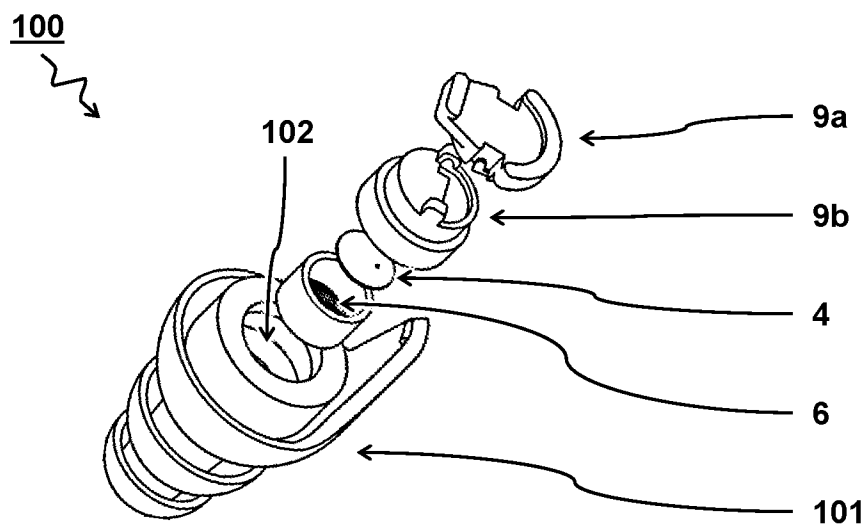


FIG 7B

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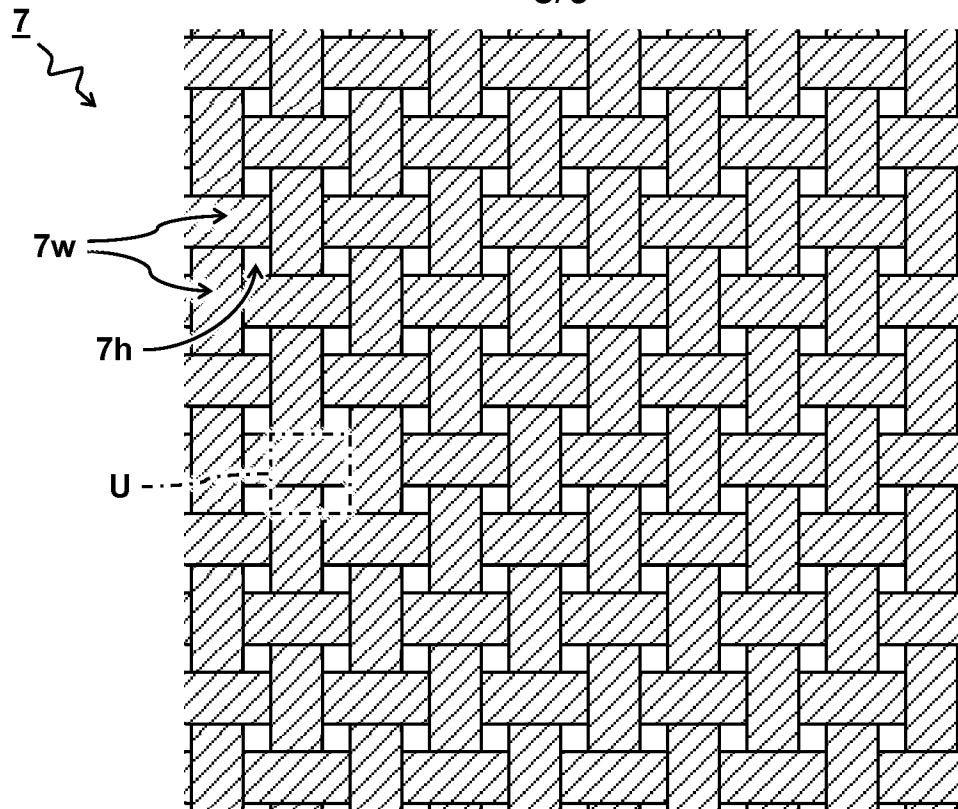


FIG 8A

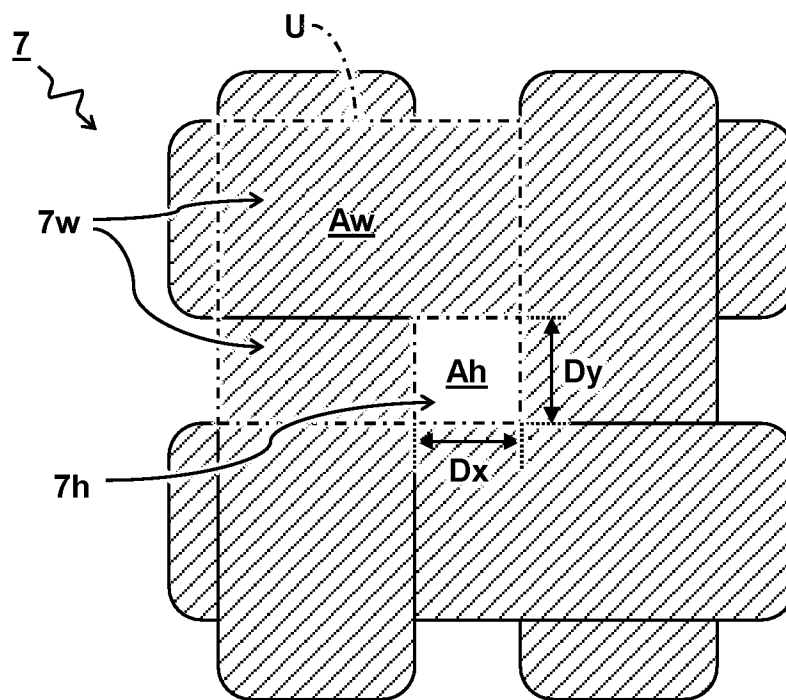


FIG 8B



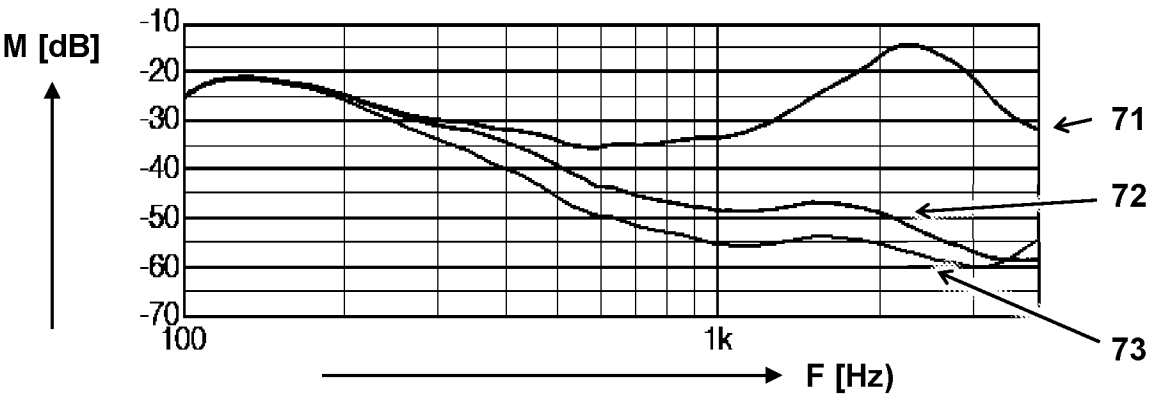


FIG 9A

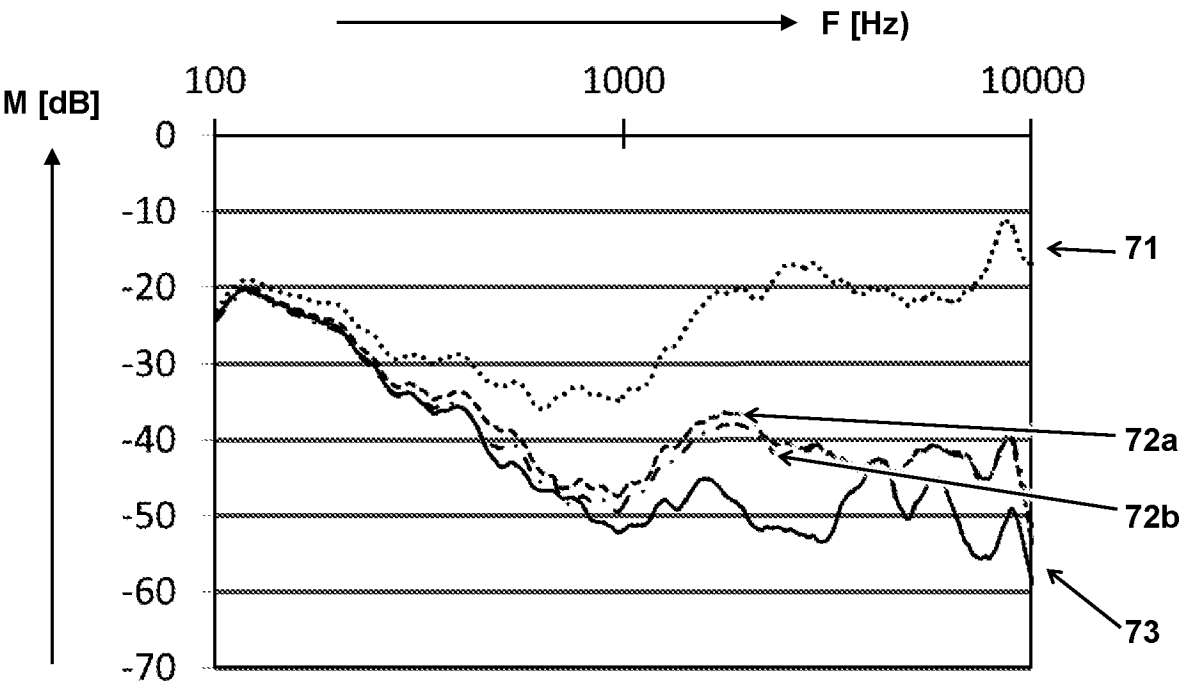


FIG 9B

## INTERNATIONAL SEARCH REPORT

International application No  
PCT/NL2015/050522

A. CLASSIFICATION OF SUBJECT MATTER  
INV. A61F11/08  
ADD.

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)  
A61F

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)

EPO-Internal, WPI Data

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

| Category* | Citation of document, with indication, where appropriate, of the relevant passages                                                                    | Relevant to claim No. |
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Further documents are listed in the continuation of Box C.



See patent family annex.

\* Special categories of cited documents :

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

23 September 2015

Date of mailing of the international search report

01/10/2015

Name and mailing address of the ISA/

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Authorized officer

Neumann, Elisabeth

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/NL2015/050522

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