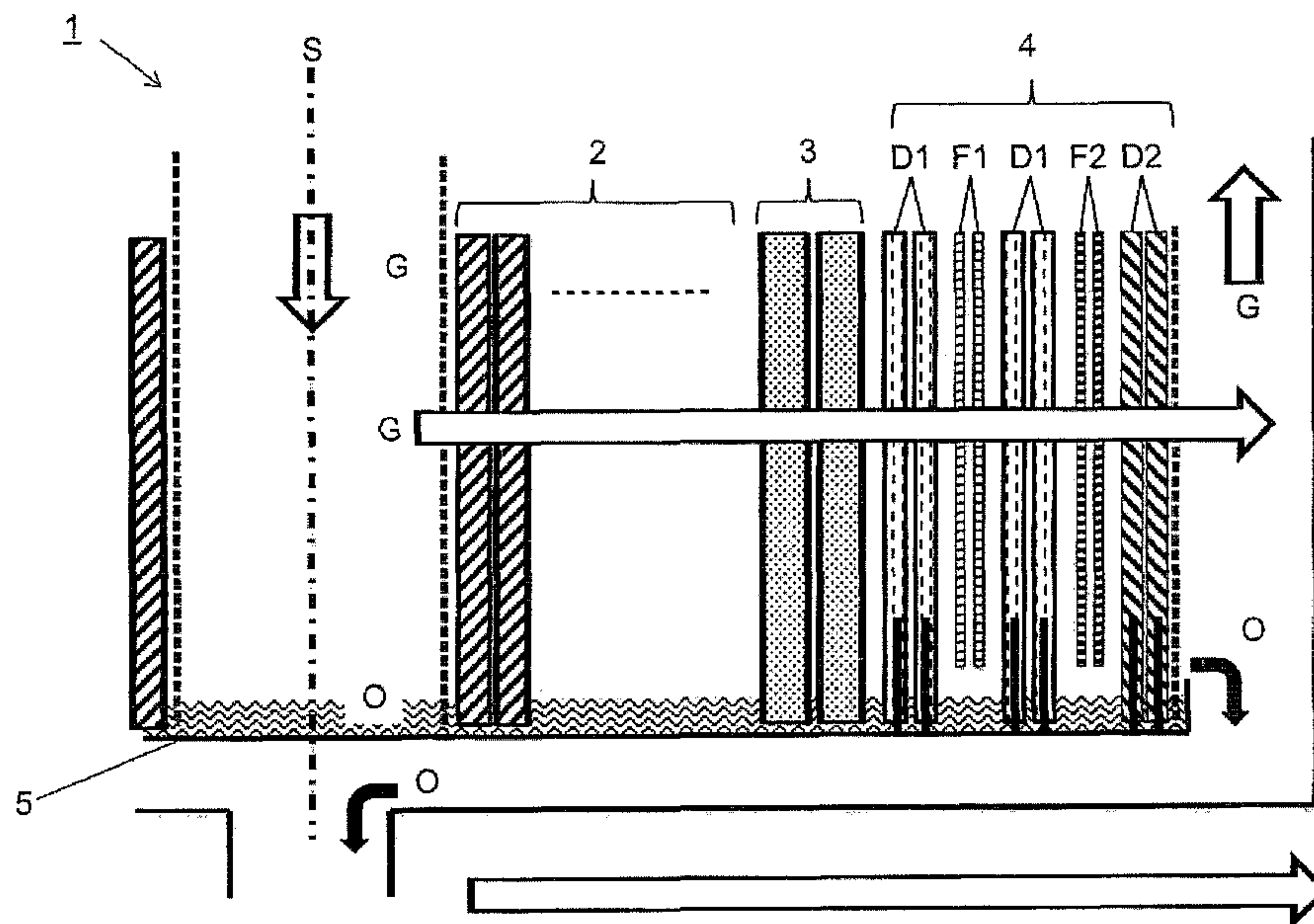




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(54) Title: A FILTER FOR SEPARATING LIQUID SUSPENDED PARTICLES FROM A GAS



(57) **Abrégé/Abstract:**

A filter (1) for separating liquid suspended particles from a gas including:

- at least one filter portion (2) for coarse separation, and
- at least one filter portion (4) for fine separation,

wherein at least one drainage layer (D1) is arranged within the filter portion (4) for fine separation.

Abstract

A filter (1) for separating liquid suspended particles from a gas including:

- at least one filter portion (2) for coarse separation, and

5 - at least one filter portion (4) for fine separation,

wherein at least one drainage layer (D1) is arranged within the filter portion (4)
for fine separation.

(Figure 1)

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A FILTER FOR SEPARATING LIQUID SUSPENDED PARTICLES FROM A GAS

The invention concerns a filter for separating liquid suspended particles from a gas and an internal combustion engine having such a filter.

5 In operation of an internal combustion engine it is known that so-called blow-by gases are produced, which are to be discharged from a crankcase of the internal combustion engine to avoid a rise in the pressure in the crankcase. In closed crankcase ventilation systems that crankcase venting gas is fed back to an air intake of the internal combustion engine. The carrier gas contains fine oil droplets and solid particles of the order of magnitude of between about 0.1 μm and 10 μm .

10 To avoid negative effects of the oil contained in the blow-by gas on components in the air intake of the internal combustion engine it is known for oil and solid particles to be separated from the carrier gas.

Inter alia, filters are used for that purpose. To achieve high degrees of separation in that particle size range filter media for fine separation are frequently
15 employed. In particular filter media are used, which are based on the principle of depth filtration and coalescence. In that case the gas to be cleaned passes through the filter medium and the particles are retained by mechanical effects in 3-dimensionally curved flow paths of the filter medium. The principle of coalescence filters is that the fine oil droplets are brought into contact at suitable surfaces so that
20 they combine to form larger units and can flow away by way of the force of gravity and the gas flow.

In filters of the general kind set forth portions with filter media for coarse separation are usually followed by portions with filter media for fine separation.

The fine separation filter media are usually characterised by a small
25 fiber diameter and small pore diameters. Depending on a series of filter media properties and liquid properties as well as the prevailing interface forces under usual operating conditions separated liquid is frequently not sufficiently purged from the

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filter medium whereby the filter medium in operation is rapidly clogged and the filter difference pressure rises.

Proposals for filters with a high degree of separation while maintaining a low counterpressure are known from the state of the art.

5 US 8 277 529 describes for example a structure for a filter element, which has at least two layers of a filter medium comprising non-woven fleece, wherein the filter substrates contain various fractions of fibers of differing diameter and the filter media have various pore sizes. US 8 360 251 describes a filter medium for coalescence filtration, wherein the filter medium has at least three adjoining layers
10 which are arranged in series and which are so configured in respect of their porosity that the substrate with the largest porosity is disposed in the central layer.

US 8 021 455 describes a filter element comprising at least two layers of a filter medium of non-woven material, wherein a first filter medium has various fiber fractions of differing fiber diameter and there is provided a second filter medium
15 comprising only one fiber fraction.

US 4 759 782 describes a coalescence filter comprising three layers, wherein the first layer has a first pore size and a fiber fraction of a first diameter, the second layer – upstream of the first layer – is of a larger pore diameter than the first layer, and a third layer which is arranged downstream and which has a pore size
20 larger than the central layer, wherein the surface energies of each layer are greater than the surface tension of water.

DE102012217019 (A1) discloses a filter whose structure is intended to prevent rapid clogging of the filter. The filter of that specification has a layer of high density and a layer of low density, which are laminated together. The high-density
25 layer is arranged at an upstream side in a flow direction of the gas and is formed by fibers for collecting oil or water. The low-density layer is arranged at a downstream side and is formed by fibers for draining water or oil collected by the high-density

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layer. The fibers of the high-density layer are each of a fiber shape which is configured to collect oil or water. The fibers of the low-density layer are each of a fiber shape configured to drain oil or water.

5 An aspect of the present disclosure is directed to improving transport and drainage of retained liquid of a filter, in comparison with the state of the art.

According to an aspect of the present invention, there is provided a filter for separating liquid suspended particles from a gas including: at least one filter portion for coarse separation, and at least one filter portion for fine separation, wherein at least one drainage layer (D1) is arranged within the filter portion for fine separation, and the filter portion for fine separation comprises a sequence of layers for fine separation (F1, F2) and layers for fine drainage (D1, D2) and wherein the gas flows through the individual filter portions one by one, wherein the sequence of layers (F1) for fine separation and layers (D1) for fine drainage is defined as $(D1+F1)n + D1$, with n the number of repetitions of the combination (D1+F1), and with $n > 1$, wherein
10 each of the layers (F1, D1) comprises one or more layer portions of a filter material for fine separation and fine drainage respectively.
15

The fact that at least one drainage layer is arranged within the filter portion for fine separation provides that transport and drainage of the caught liquid in the filter is facilitated and the filter is improved in respect of counterpressure and
20 separation effect.

The arrangement according to an aspect of the invention provides that the separated liquid is carried away from the layer for fine separation and is thus relieved of separated liquid and thus opposes a lower flow resistance to the gas to be cleaned.

25 In some embodiments, it can be provided that further drainage layers are arranged upstream and/or downstream of the layer for fine separation.

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According to a further preferred variant of some embodiments, it is provided that at least one further drainage layer and/or spacing is provided between the at least one filter portion for coarse separation and the at least one filter portion for fine separation.

5 Alternatively or in addition to the drainage layer it is also possible to provide a spacing between filter portions for coarse separation and filter portions for fine separation. A spacing can be implemented in the filter structure for example by a procedure whereby, when winding the filter layer portions, a spacer portion, for example a layer portion of little compressibility of knitted fabric, is also wound therein.

10 Preferably it can be provided the filter portion for fine separation comprises a sequence of layers for fine separation and layers for fine drainage.

In some embodiments, it can also be preferably provided that the filter portion for fine separation comprises different layers for fine separation, wherein the mean pore size of the first layer for fine separation is of a larger mean pore size than
15 the second layer for fine separation.

In some embodiments, preferably it can be provided that the fiber diameter of the layers for fine separation is less than 10 μm , preferably less than 5 μm . That means that the filter media constituting the different layers for fine separation are of a mean fiber diameter of less than 5 μm . The filter media typically
20 comprise a woven fabric, a knitted fabric or a knitted fabric of fibers.

In some embodiments, preferably it can be provided that the layers for fine separation have liquid-repellent surface properties. Liquid-repellent means that the material cannot be wetted by liquid or can scarcely be wetted by liquid. The liquid-repellent surface properties can either be inherent (that is to say specific to the
25 base material) or they be ensured by a suitable treatment.

In some embodiments, it can further be provided that a barrier layer and/or a spacing is provided between layers for fine separation and layers for fine

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drainage. That barrier layer or spacing is intended to prevent liquid being discharged from drainage layers to the following filter layers.

In some embodiments, preferably it can be provided that the drainage layers have a capillary action in relation to the liquid. The choice of the drainage material depends on the material structure and the surface tension of the liquid in relation to the filter medium. The rise height for characterising the capillary action can be easily determined by experiment.

In some embodiments, preferably the material is such that a rise height for the liquid in the drainage layer of between 2 and 10 cm, preferably between 5 and 10 cm, is achieved.

In some embodiments, it is preferably provided that a mean pore size of the filter material of the drainage layers is so much smaller than the mean fiber length of fibers of the filter material of the separation layers and the drainage layers are joined, preferably glued, at their ends in surface contact with end boundaries of the filter, that substantially no fibers of the filter media which are disposed upstream in the flow direction are discharged from the filter with the liquid and return of liquid drops into the gas flow is substantially prevented.

According to another aspect of the present invention, there is provided an internal combustion engine having a filter as described above.

According to another aspect of the present invention, there is provided use of a filter as described above in an internal combustion engine.

The invention can best be understood by reference to the following description of example embodiments together with the accompanying drawings in which:

Figure 1 shows a cross-sectional view of a filter,

Figure 2 shows a detail view of a filter, and

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Figure 3 shows a diagrammatic view of the arrangement of a filter device on an internal combustion engine.

It should be noted at the outset that the Figures always show two layers of the same filter medium. That is not required. It can also be provided that there is
5 only one respective layer of a respective filter medium.

The filter in Figure 1 in the present embodiment is of a cylindrical and rotationally symmetrical configuration, therefore only one half of the cross-section will be discussed for description purposes. It will be appreciated that the filter can also be of other shapes, for example cuboidal.

10 The incoming flow of the liquid-charged gas G is in the center of the cylindrical structure, the center is identified by the axis of symmetry S. The flow direction of the gas G is indicated by white arrows. The gas G which is charged with liquid drops firstly flows through portion 2 for coarse separation, comprising one or more layer portions of a filter medium for coarse separation. For the sake of clarity
15 the drawing only shows two layer portions, the dots in section 2 indicate that there can be still further layer portions.

The purpose of the portion 2 for coarse separation is to reduce the mass of liquid entrained by the gas G before it passes into the following filter layers. The portion 2 for coarse separation is followed by a layer 3 for coarse drainage. The
20 layer for coarse drainage prevents liquid which has already been separated out from being discharged into the following layer. Alternatively or additionally a spacing can be

implemented between filter portions for coarse separation and filter portions for fine separation.

Subsequently the gas G passes through a sequence of layers of filter material D1 for fine drainage and layers of filter material F1, F2 for fine separation. The layers
 5 D1 for fine drainage absorb separated liquid O from the layers for fine separation F1, F2 and transport same by way of the force of gravity to the liquid discharge at the bottom of the filter 1. The discharge flow of the liquid O is indicated by black arrows. The filter 1 includes end boundaries 5. Only the lower end boundary 5, that is to say the bottom, is shown in Figure 1. Generally the filter 1 also includes an upper end
 10 boundary 5, which can be referred to as a cover. At least the drainage layers of the filter 1 are joined, preferably glued, at their ends in surface contact with end boundaries 5 of the filter 1.

Downstream, that is to say shown at the right in this Figure, the filter 1 is delimited by a layer of filter material D2 for drainage and containment. That layer
 15 drains liquid O from the last region, that is therefore disposed downstream, of the layer for fine separation. The layer of filter material D2 for drainage and containment reduces the volume of liquid in the last layer of filter material F2 for fine separation and the flow speed of the gas G in order thereby to prevent liquid from passing back into the gas G again. In addition the layer D2 for drainage and containment encloses the
 20 layer F2 for fine separation in such a way that no fibers of the upstream-disposed media can be discharged with the separated liquid.

The number of layer portions D1, D2, F1, F2 in each portion is at least 1. As combinations of the portions, it can be provided that D1 and F1 portions can be repeated alternately, in which case the arrangement is concluded downstream with a
 25 respective layer D1. That gives a sequence of $(D1+F1)_n + D1$ with n as the number of repetitions of the combination $(D1+F1)$, with $n \geq 1$.

The combination of the portions formed from D1, D2 and F1, F2 can be formed by one or more repetitions of the arrangement $(D1+F1)_n + (D1+F2)_m + D2$, with m as the number of repetitions of the combination $(D1+F2)$, with $m \geq 1$.

30 In addition a barrier layer B (not shown) can be provided after, that is to say downstream of, each drainage layer D1. That barrier layer is intended to prevent liquid being further carried from drainage layers to the following filter layers. The medium of the barrier layer can either be a liquid-repellent material or a liquid-repellently coated material or a free space between the layers. In that case the sequence is therefore D1
 35 + F1 + D1 + B + F1.

The following are considered as suitable filter media:

- for the layers F1 and F2: for example glass fiber material with a mean fiber diameter of less than 5 μm ,
- D1 and D2: for example polyester, polyolefin or glass fiber material with a
5 fiber diameter of greater than 10 μm and porosities of greater than 90%,
- the pore diameter of the layer F1 is for example between 100 and 30 μm and is greater than the pore diameter of the layer F2 of for example between 5 and 10 μm ,
- the layers F1 and F2 for fine separation are liquid-repellent or have a liquid-repellent surface treatment, and
- 10 - the drainage materials D1 and D2 have a capillary action which leads at least to a rise height of the liquid of between 20 and 50 mm.

Figure 2 shows a portion of the filter portion 5 for fine separation, wherein in this embodiment a barrier layer B is provided after, that is to say downstream of, each drainage layer D1. That barrier layer B is intended to prevent liquid from being carried
15 from drainage layers to the following filter layers. The medium of the barrier layer can either be a liquid-repellent material or a liquid-repellently coated material or a free space between the layers. In this case therefore the sequence is F1 + D1 + B + F1.

In regard to all views spacings are shown between the individual filter layer portions, for the sake of clarity. In practice the filter layer portions are closely packed
20 or wound. In addition the Figures each show two layer portions of the respective filter material. The actual number of layer portions can vary in practice.

Figure 3 shows an internal combustion engine V having a filter 1. In this case the filter 1 is used as a filter for oil separation in the crankcase ventilation system (blow-by filter).

25

List of references used:

	1	filter
	2	filter portion for coarse separation
5	3	layer for coarse drainage
	4	filter portion for fine separation
	5	end boundary
	D1	filter material for fine drainage
	F1	first filter material for fine separation
10	F2	second filter material for fine separation
	D2	filter material for drainage and containment
	B	barrier layer
	G	gas
	O	liquid
15	S	axis of symmetry
	V	internal combustion engine

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CLAIMS:

1. A filter for separating liquid suspended particles from a gas including:
 - at least one filter portion for coarse separation, and
 - at least one filter portion for fine separation,
- 5 wherein at least one drainage layer (D1) is arranged within the filter portion for fine separation, and the filter portion for fine separation comprises a sequence of layers for fine separation (F1, F2) and layers for fine drainage (D1, D2) and wherein the gas flows through the individual filter portions one by one, wherein the sequence of layers (F1) for fine separation and layers (D1) for fine drainage is

10 defined as $(D1+F1)_n + D1$, with n the number of repetitions of the combination $(D1+F1)$, and with $n \geq 1$, wherein each of the layers (F1, D1) comprises one or more layer portions of a filter material for fine separation and fine drainage respectively.
2. A filter as set forth in claim 1, wherein at least one further drainage layer and/or spacing is provided between the at least one filter portion for coarse

15 separation and the at least one filter portion for fine separation.
3. A filter as set forth in claim 1 or claim 2, wherein the sequence of layers (D1, D2) for fine drainage and layers (F1, F2) for fine separation reads as $(D1+F1)_n + (D1+F2)_m + D2$, with m the number of repetitions of the combination $(D1+F2)$, and with $m \geq 1$, wherein each of the layers (F1, D1, D2) comprises one or more layer

20 portions of a filter material for fine separation and fine drainage respectively.
4. A filter as set forth in any one of claims 1 to 3, wherein the filter portion for fine separation comprises different layers (F1, F2) for fine separation, wherein the mean pore size of the first layer (F1) for fine separation is of a larger mean pore size than the second layer (F2) for fine separation.
- 25 5. A filter as set forth in any one of claims 1 to 4, wherein the layers (F1, F2) for fine separation comprise fibers having a fiber diameter of less than 10 μm .

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6. A filter as set forth in any one of claims 1 to 4, wherein the layers (F1, F2) for fine separation comprise fibers having a fiber diameter of less than 5 μm .
7. A filter as set forth in any one of claims 1 to 6, wherein the layers (F1, F2) for fine separation have liquid-repellent surface properties or a liquid-repellent
5 surface coating.
8. A filter as set forth in any one of claims 1 to 7, wherein a barrier layer (B) and/or a spacing is provided between layers (F1, F2) for fine separation and layers (D1, D2) for fine drainage.
9. A filter as set forth in any one of claims 1 to 8, wherein the drainage
10 layers (D1, D2) have a capillary action in relation to the liquid such that a rise height of the liquid in the drainage layer of between 2 and 10 cm is reached.
10. A filter as set forth in any one of claims 1 to 8, wherein the drainage layers (D1, D2) have a capillary action in relation to the liquid such that a rise height of the liquid in the drainage layer of between 5 and 10 cm is reached.
11. A filter as set forth in any one of claims 1 to 10, wherein the filter
15 material of the separation layers comprises fibers, wherein a mean pore size of the filter material of the drainage layers is so much smaller than a mean fiber length of fibers of the filter material of the separation layers, and the drainage layers are joined at their ends in surface contact with end boundaries of the filter, that substantially no
20 fibers of filter media which are disposed upstream in a flow direction are discharged from the filter with the liquid, and wherein return of liquid drops into the gas flow is substantially prevented.
12. A filter as set forth in claim 11, wherein said drainage layers are joined by glue at their ends in surface contact with the end boundaries of the filter.
13. A filter according to any one of claims 1 to 12, wherein the separated
25 liquid is oil.

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14. Use of a filter as set forth in any one of claims 1 to 13 in an internal combustion engine.

15. Use of a filter as set forth in claim 14 as a filter for oil separation in a crankcase ventilation system of said internal combustion engine.

Fig. 1

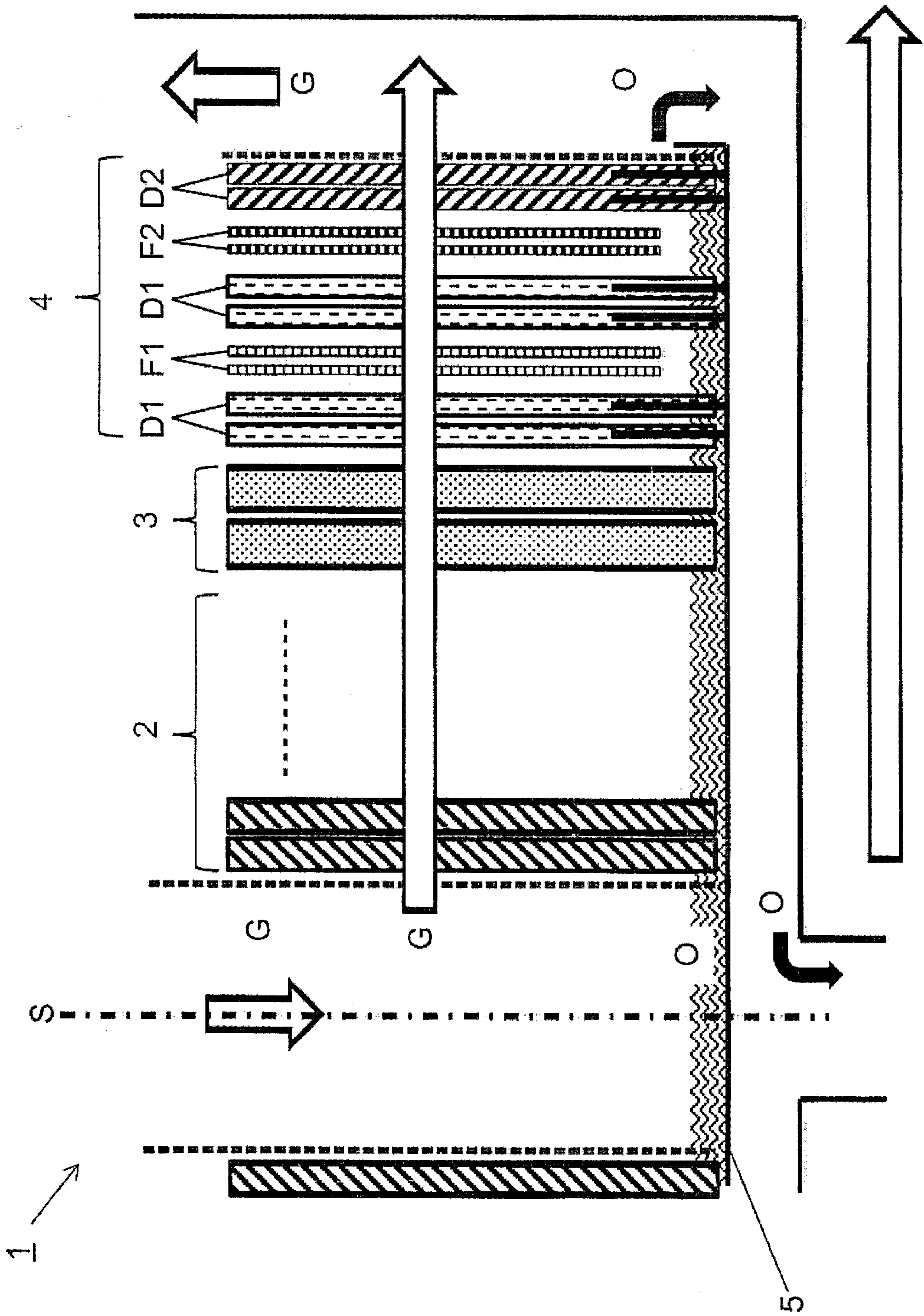


Fig. 2

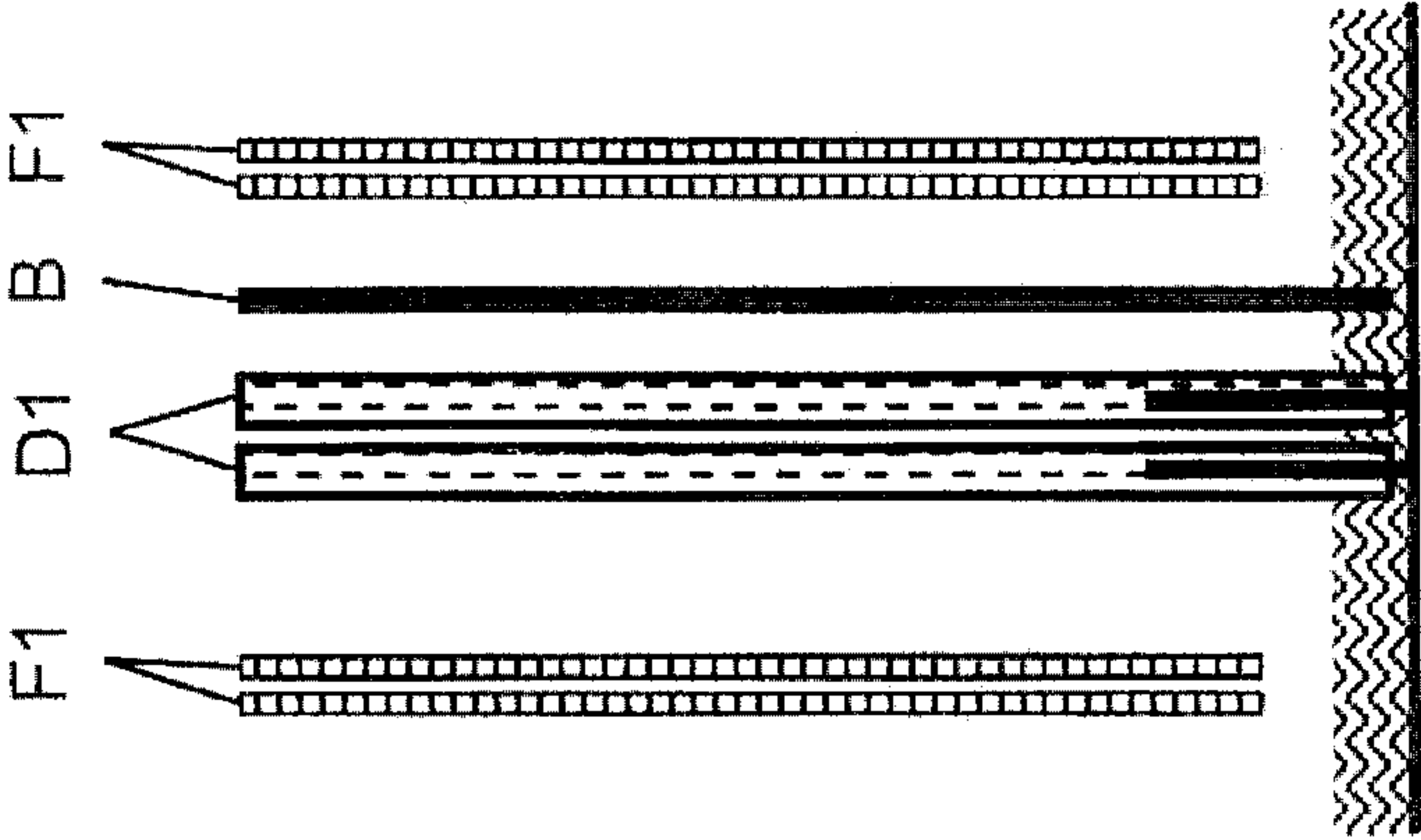


Fig. 3

