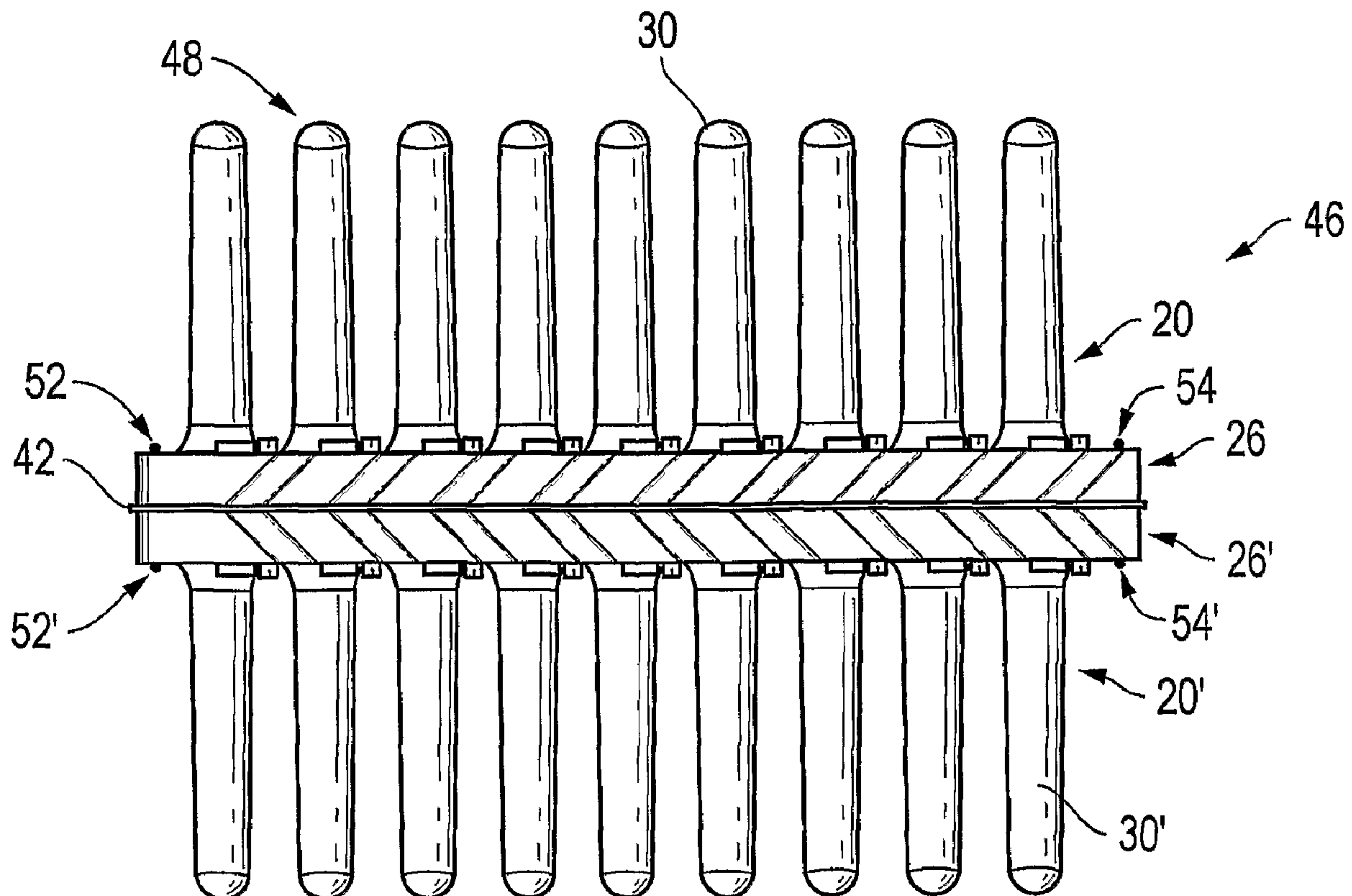




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(72) Inventeurs/Inventors:
WU, ZHONGLIN, US;
CAO, TUAN, US
(73) Propriétaire/Owner:
CARLETON LIFE SUPPORT SYSTEMS, INC., US
(74) Agent: R. WILLIAM WRAY & ASSOCIATES

(54) Titre : MODULES DE TUBE ET COLLECTEUR INTEGRES A BANDES CONDUCTRICES EN SERIE
(54) Title: IMAT MODULES WITH SERIAL CONDUCTIVE STRIPES



(57) Abrégé/Abstract:

An ionically conductive ceramic element (20) comprises a plurality of tubes (30) each having interior (24) and exterior (38) surfaces and closed (48) and open (50) ends. A tube support (14) receives open tube ends (50). A first electrically conductive coating (36) is

(57) **Abrégé(suite)/Abstract(continued):**

formed on the exterior tube surfaces (38). A second coating (22) is formed on the interior tube surfaces (24). A bottom electrically conductive stripe (16) makes electrical connections between second coatings (22) on the interior tube surfaces (24). A top electrically conductive stripe (40) creates electrical connections between first coatings (36) on the exterior tube surfaces (38). The top and bottom stripes are connected such that at least one stripe (40) on the top is electrically connected to at least one stripe (16) on the bottom.

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(71) Applicant (for all designated States except US): **CARLETON LIFE SUPPORT SYSTEMS, INC.** [US/US];
co/ Carleton Technologies, Inc., 10 Cobham Dr., Orchard
Park, NY 14127-4195 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): **WU, Zhonglin**
[CN/US]; Carleton Life Support Systems, Inc., 2734
Hickory Grove Road, Davenport, Iowa 52804 (US). **CAO,**
Tuan [US/US]; Carleton Life Support Systems, Inc., 2734
Hickory Grove Road, Davenport, Iowa 52804 (US).

(74) Agent: **MARSTELLER, Thomas**; Marsteller & Associates, P.C., PO Box 803302, Dallas, TX 75380-3302 (US).

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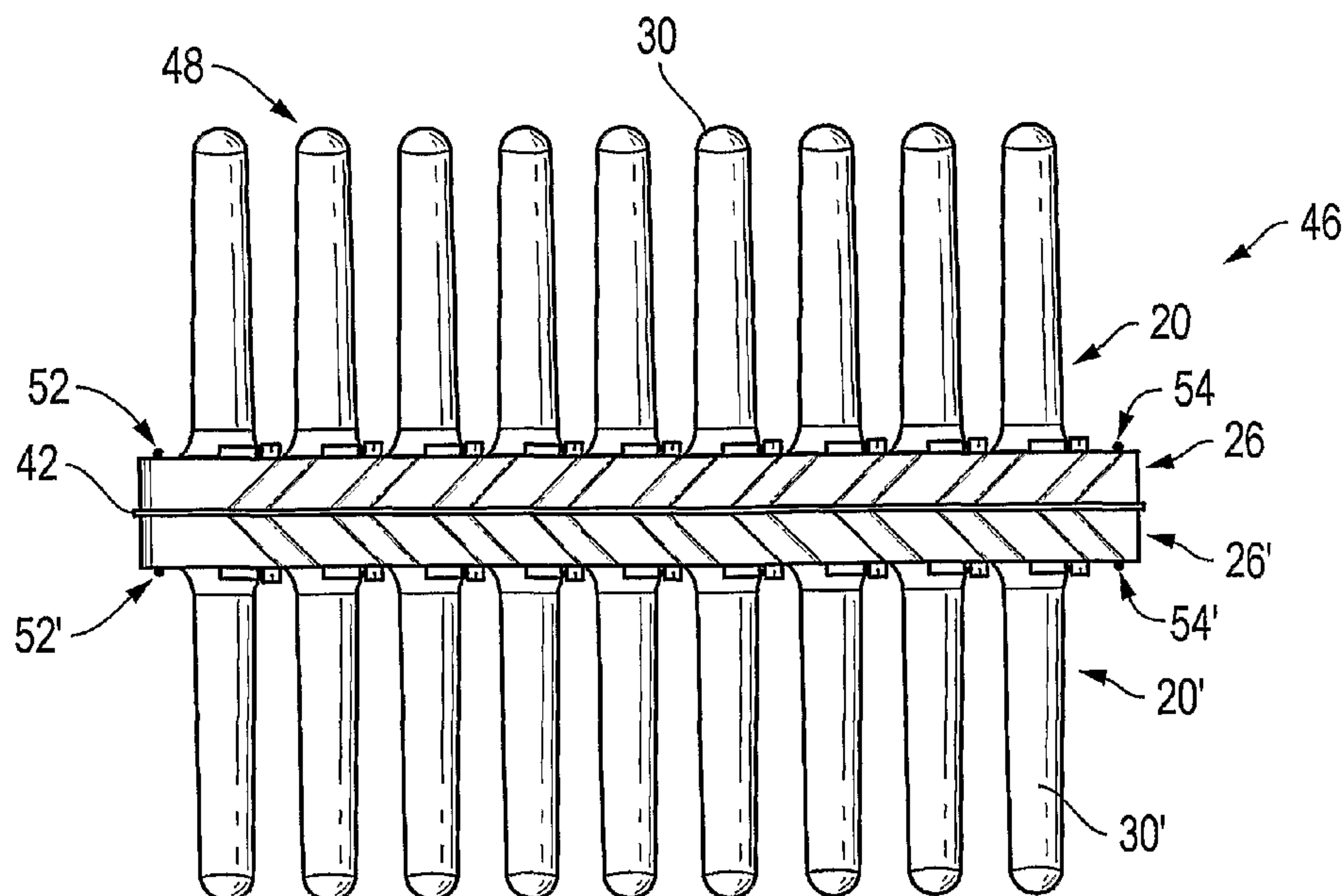
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[Continued on next page]

(54) Title: IMAT MODULES WITH SERIAL CONDUCTIVE STRIPES



(57) Abstract: An ionically conductive ceramic element (20) comprises a plurality of tubes (30) each having interior (24) and exterior (38) surfaces and closed (48) and open (50) ends. A tube support (14) receives open tube ends (50). A first electrically conductive coating (36) is formed on the exterior tube surfaces (38). A second coating (22) is formed on the interior tube surfaces (24). A bottom electrically conductive stripe (16) makes electrical connections between second coatings (22) on the interior tube surfaces (24). A top electrically conductive stripe (40) creates electrical connections between first coatings (36) on the exterior tube surfaces (38). The top and bottom stripes are connected such that at least one stripe (40) on the top is electrically connected to at least one stripe (16) on the bottom.

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IMAT MODULES WITH SERIAL CONDUCTIVE STRIPES

Background of the Invention

1. Technical Field.

The invention relates to the field of devices for separating oxygen from a more complex gas containing oxygen to deliver the separated oxygen for use. More particularly, the invention relates to solid state electrochemical devices for separating oxygen from a more complex gas.

2. Background Art.

The ceramic oxygen generation system, Integrated Manifold and Tube (IMAT), as described in US patent 5,871,624, has demonstrated the capability of generating high purity oxygen at high pressure. In a typical IMAT, tubes in each row are electrically connected in parallel and each row is electrically connected in series through via wires. Using this approach, the IMATs can be operated at reasonable current and voltage levels as compared to the approach when all tubes are connected in parallel which requires larger current to generate the same amount of oxygen. Further, the via wires are inserted into the via holes on the IMAT bases. To generate oxygen with above ambient pressure, the via wires need to be sealed tightly with the ceramics.

The challenge the prior approach faces is the difficulty associated with sealing via wires and labor time and equipment/materials cost involved with via insertion. Because of the operation temperature (600-750°C) and the conductivity requirements, only a limited number of metals such as silver (Ag), gold (Au), platinum (Pt), and their alloys can be viable candidates. From a cost standpoint, silver would generally be the best candidate. However, silver has a thermal expansion coefficient that is much larger

than that of IMAT ceramics and thus makes the sealing process very challenging due to unavoidable temperature cycling in product manufacturing and application.

While the above cited references introduce and disclose a number of noteworthy advances and technological improvements within the art, none completely fulfills the specific objectives achieved by this invention.

Summary of Invention

In accordance with the present invention, an electrically conductive ceramic element comprises a plurality of tubes each having interior and exterior surfaces. Each tube has a closed end and an open end. A tube support member having a top surface and a bottom surface receives open ends of the plurality of tubes. A first electrically conductive coating or current collector is formed on at least the exterior surfaces of the plurality of tubes. A second electrically conductive coating or current collector is also formed on at least the interior surfaces of the plurality of tubes.

At least one bottom electrically conductive stripe is formed on the bottom surface of the tube support member to create electrical connections between two or more selected second electrically conductive coatings or current collector on the interior surfaces of the tubes. At least one top electrically conductive stripe is similarly formed on the top surface of the tube support member to create electrical connections between two or more selected electrically conductive coatings that are on the exterior surfaces of the tubes.

The electrically conductive stripes on the top extend to and over the edges of the tube support member and the electrically conductive stripes on the bottom extend to and over the edges of the tube support member, so that the top stripes and the bottom stripes are connected in such a way that at least one stripe on the top connecting one row of tubes is electrically connected to at least one stripe on the bottom connecting an adjacent row of tubes.

These and other objects, advantages and features of this invention will be apparent from the following description taken with reference to the accompanying drawings, wherein is shown the preferred embodiments of the invention.

Brief Description of Drawings

A more particular description of the invention briefly summarized above is available from the exemplary embodiments illustrated in the drawings and discussed in further detail below. Through this reference, it can be seen how the above cited features, as well as others that will become apparent, are obtained and can be understood in detail. The drawings nevertheless illustrate only typical, preferred embodiments of the invention and are not to be considered limiting of its scope as the invention may admit to other equally effective embodiments.

Figure 1 is a schematic cross-sectional drawing showing the prior art of connecting neighboring rows of IMAT tubes in series using via wires through the IMAT base.

Figures 2a through 2c are schematic drawings showing the present invention of connecting rows of IMAT tubes in series using silver stripes around the IMAT edges. Figure 2a is a back side view of the IMAT portion; Figure 2b is a front side view of the IMAT; and, Figure 2c is a side view of the IMAT.

Figure 3 is a side view of two IMAT segments or portions with both having the stripe-silver connections sealed together with a glass tape.

Figure 4a is a schematic representation of the area of the stripe that is tightly sandwiched between glass seal and IMAT base being split into several smaller stripes to reduce mechanical stress.

Figure 4b is a schematic representation of the silver stripe in the corresponding area of the second IMAT portion that will be sealed to the first IMAT with silver stripe showing in Figure 4a also being split, but moved one width of small stripe downwards along an IMAT edge.

Figure 5 is a side perspective view of a known IMAT module with 28 columns of 8 tubes each, or stated another way, 8 rows of 28 tubes each.

Detailed Description

So that the manner in which the above recited features, advantages, and objects of the present invention are attained can be understood in detail, more particular description of the invention, briefly summarized above, may be had by reference to the embodiment thereof that is illustrated in the appended drawings. In all the drawings, identical numbers represent the same elements. The use of terms such as

"downwardly", "upwardly", "left", "right", etc. as used herein is only for purposes of convenience of description and these terms should be construed in the relative sense.

The present invention describes an IMAT and a process of forming serial connections from row to row and sealing two IMAT halves to form an IMAT module.

As is known, element 20 is formed having a series of tubes 30 extending from a generally planar tube support member 14. By way of example, in a typical embodiment the tubes 30 may be formed into 7 columns of 9 tubes each, or stated another way, 9 rows of 7 tubes each. The outer end 48 of each tube 30 is closed at the top or tip of the tube 30. The tube support member 14 also receives open ends 50 of the plurality of tubes 30. The outer surfaces 38 of the tubes 30 along with the closed ends 48 thereof, are generally first coated with a catalyzing and electrically conductive material or electrode and then coated with an electrically conductive material or current collector. Likewise, the interiors 24 of each of the tubes 30 are generally first coated with a catalyzing and electrically conductive material or electrode and then coated with an electrically conductive material or current collector.

As schematically shown in Figure 1, the previous method uses silver wires 10 as vias through openings 12 formed in the IMAT support member or base 14 to create electrical connections. The present invention uses silver stripes 16 to form electrical connections, thereby eliminating the need of via wires 10.

In the present approach, silver stripes 16 are formed on a bottom surface or back side 18 of the tube support member 14 of an IMAT segment or part 20. The silver stripes 16 electrically connect current collector coatings 22 on inside surface 24 of tubes 30 to the stripes 16. The silver stripes 16 preferably electrically connect the electrically conductive coating 22 on the insides 24 of all tubes in a singular or same row with one stripe 16. The stripes 16 are extended all the way to the edges 26 of the IMAT support member or base 14 (Figure 2a and Figure 2c).

On the top surface or front side 28 (tube 30 side) of the IMAT segment 20, silver stripe electrical connections 32 are formed at the feet 34 of tubes 30 to establish or make an electrical connection between current collectors 36 coated on or formed on the outside or exterior surface of the tubes 30 and a row bus stripe 40 on the base 14. The electrical connections 32 may be extensions of the stripe 40 or the stripe 40 may

overlap or merge with a current collector **36** forming an electrical bond or joint. The electrically conductive coatings **36** for all tubes **30** in a same row are preferably electrically connected to one stripe **40** and each row of tubes preferably has a corresponding stripe **40** associated with it.

The stripes **40** are extended to and over the edges **26** of the IMAT base **14** (Figure 2b). The stripes **40** on the tube side **28** of the IMAT segment **20** are electrically connected with the stripes **16** on the back side **18** of the IMAT segment **20** in such a way that each stripe **40** on the front side **28** of the IMAT segment **20** connecting one row is electrically connected to the stripe **16** connecting a neighboring or adjacent row on the back side **18** of the IMAT segment **20** (Figure 2c). This system of establishing electrical connections between a stripe **40** on the top or front side **28** and an adjacent or neighboring stripe **16** on the back side **18** of the base **14** permits a serial pattern of connections for the current collectors of the IMAT element **20**.

A current collector coating **22** on the inside of a single tube **24** is preferably electrically isolated from the current collector coating **22** on the inside of another single tube **24** except through the electrical connection made through the stripes **16**. Similarly, a current collector **36** on a single tube **30** is preferably electrically isolated from the current collector **36** on another single tube **30** except through the electrical connection established through the electrically conductive stripes **40**.

By way of example, LSCF (lanthanum strontium cobalt ferrite) may be chosen as an electrode material, and silver could be selected for the current collector function.

Electrically conductive wires, such as silver wires, **52** and **54** are attached to both ends of the ceramic element **20** at the front side **28** to allow application of DC voltage to the ceramic element. Silver wire **52** is connected to the current collector coating of the bottom row of tubes (Figure 2b). Silver wire **54** is connected to the first silver stripe from the top (Figure 2b).

The symmetry of the modular construction of the ceramic element **20** allows a second element to be inverted and sealed to the first element to form either the oxygen generator or fuel cell assembly. The second element **20'** is preferably identical to the first element **20** and identical features are denoted with an apostrophe. Two IMAT segments or parts **20** and **20'** both with stripe silver connections are then sealed together with glass using a glass tape or paste **42**. This creates or forms the V-shaped

or “zebra” pattern of the stripes on the sides of **26** and **26'** shown in Figure 3. The parts **20** and **20'** are fired to elevated temperature to form seals **42**.

The thickness and width of the silver stripes are determined by the requirement to carry the required current through the stripes with minimal loss due to electrical resistance and the requirement to seal the IMAT parts **20** and **20'** together to withstand high pressure and maintain the gas-tightness upon repeated temperature cycling and pressure cycling. The thickness of stripes does not have to be the same; only the portion tightly sandwiched between the IMAT base **14** and the glass seal **42** (when a leak-free seal is required) should be strictly controlled within a certain range to minimize the resistance and the stress. The remaining area of stripes may optionally be thicker to improve the current carrying capability.

Multiple applications of silver stripes onto the IMAT parts **20** may be made to determine the best thickness where the IMAT current is maximized. IMAT segments **20** with desired silver stripe thickness may then be sealed together and can be temperature cycle tested (in combination with pressure cycling) for over 30 cycles with peak pressure over 150psi at each cycle (self generating oxygen with applied DC voltage at elevated temperatures), by way of example.

To further reduce the stress introduced by having silver stripes sandwiched between the glass seal **42** and the IMAT base **14**, the area of each stripe tightly sandwiched between glass seal **42** and IMAT base **14** can be further separated into a cluster of smaller stripes **44a - c**, as schematically shown in Figure 4a. To reduce the stress further, the mating part **20'** (the second IMAT part **20'** seals with the first IMAT part **20** to form a complete IMAT module **46**) could have similar cluster of stripes and location of the corresponding cluster can be moved or displaced one small stripe up or down along the IMAT edge **26** (Figure 4b). Alternatively, stripes can be shifted $\frac{1}{2}$ width on both **20** and **20'**, but in the opposite directions along the IMAT edge **26**.

Alternatively, the locations of stripes at one side of IMAT **20** can be shifted upwardly or downwardly along the IMAT part edge relative to the positions of stripes at the other side of the same IMAT part in order that an IMAT part **20'** identical or corresponding to **20** can be inverted and sealed with **20** without overlap of silver stripes at any given location along the IMAT edges **26** and **26'**.

While silver may be used for the stripes **16** for example, any electrically conductive material, including metal, metal alloy, ceramics, and composite material,

may be used that is appropriately selected for the application to the IMAT module 46. Examples may include gold, platinum, and others. Furthermore, more than one electrically conductive material may be used in the different sections of the same stripe. Particularly, an electrically conductive material having a thermal expansion coefficient closer to that of the ceramics used in the IMAT than silver, such as gold, can be used to form the stripe section which would be sandwiched between glass seal 42 and IMAT base 14 upon bonding two IMAT segments or parts 20 and 20'.

While the above discussions address IMAT parts with two types of coatings, e.g., electrode coating and current collector coating, the electrically conductive stripes approach can also be applied where only one type of coating is used, e.g., a single coating serves as both electrode and current collector. In this situation, stripes 40 are connected to this coating on the tube side and stripes 16 are connected to this coating on the back side.

Method

A method for connecting electrically conductive ceramic elements preferably includes the steps of:

- a. forming a plurality of tubes 30 each having interior and exterior surfaces, and each having a closed end and an open end;
- b. forming a tube support member 14 for receiving open ends of the plurality of tubes 30; the tube support member 14 having a top surface and a bottom surface;
- c. forming a first electrically conductive coating or current collector on the exterior surfaces of a plurality of the tubes 30 (a conductive coating or electrode may be applied to the exterior surfaces of the tubes 30 prior to the application of the current collector coating);
- d. forming a second electrically conductive coating or current collector on the interior surfaces of the plurality of tubes 30 generally corresponding to the tubes receiving the conductive coating on the exterior surface (similarly, a second conductive coating or electrode may be applied to the interior surfaces of the tubes 30 prior to the application of the current collector coating);
- e. forming at least one bottom electrically conductive stripe 16 on the bottom surface 18 of the tube support member 14 to create electrical connections

between two or more selected second electrically conductive coatings on the interior surfaces of the tubes **30**;

f. forming at least one top electrically conductive stripe **40** on the top surface **28** of the tube support member **14** to create electrical connections between two or more selected first electrically conductive coatings on the exterior surfaces of the tubes **30**;

g. electrically connecting the top stripes **40** and the bottom stripes **16** in such a way that at least one stripe on the top connecting one row of tubes **30** is electrically connected to at least one stripe on the bottom connecting an adjacent row of tubes **30**; and,

h. inverting a second ceramic element **20'** and sealing it with the first ceramic element **20** using glass bonding to form an IMAT module **46**.

The foregoing disclosure and description of the invention are illustrative and explanatory thereof, and various changes in the size, shape and materials, as well as in the details of the illustrated construction may be made without departing from the spirit of the invention.

CLAIMS

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. An electrically conductive ceramic element comprising:
 - a plurality of tubes each having interior and exterior surfaces, and each having a closed end and an open end;
 - a tube support member receiving open ends of the plurality of tubes; the tube support member having a top surface and a bottom surface;
 - a first electrically conductive coating formed on the exterior surfaces of the plurality of tubes;
 - a second electrically conductive coating formed on the interior surfaces of the plurality of tubes;
 - at least one bottom electrically conductive stripe formed on the bottom surface of the tube support member to create electrical connections between two or more second electrically conductive coatings on the interior surfaces of the tubes;
 - at least one top electrically conductive stripe formed on the top surface of the tube support member to create electrical connections between two or more first electrically conductive coatings on the exterior surfaces of the tubes;
 - the electrically conductive stripes on the top extend to and over an edge of the tube support member and the electrically conductive stripes on the bottom extend to and over the edge of the tube support member; and,
 - the top stripes and the bottom stripes are electrically connected in proximity to an edge of the tube support member in such a way that at least one stripe on the top connecting one row of tubes is electrically connected to at least one stripe on the bottom connecting an adjacent row of tubes.

2. The electrically conductive ceramic element of claim 1 wherein the top electrically conductive stripe and the bottom electrically conductive stripe are formed from silver or silver alloy.
3. The electrically conductive ceramic element of claim 1 wherein the top electrically conductive stripe and the bottom electrically conductive stripe are formed from electrically conductive materials selected from a group consisting of: silver, gold, and platinum.
4. The electrically conductive ceramic element of claim 1 wherein at least one electrically conductive stripe is formed from two or more electrically conductive materials, each in one or more sections of the stripe.
5. The electrically conductive ceramic element of claim 1 wherein at least one electrically conductive stripe has at least one section consisting of a cluster of smaller stripes.
6. The electrically conductive ceramic element of claim 1 wherein symmetry of modular construction of the electrically conductive ceramic element allows a second electrically conductive ceramic element to be inverted and sealed to a first electrically conductive ceramic element to form a unitary ceramic module useful in an oxygen generator or fuel cell assembly.
7. The electrically conductive ceramic element of claim 6 further including a glass bond formed between said first and second electrically conductive ceramic elements.
8. The electrically conductive ceramic element of claim 6 wherein the first ceramic element has at least one stripe with at least one section consisting of a cluster of small stripes; the second ceramic element has at least one corresponding stripe with a cluster of small stripes; and, the location of the second cluster is displaced the width

of one small stripe up or down with respect to the first cluster along a ceramic element edge.

9. The electrically conductive ceramic element of claim 6 wherein the first ceramic element has at least one stripe with at least one section consisting of a cluster of small stripes; the second ceramic element has at least one corresponding stripe with a cluster of small stripes; and, the location of the second cluster is displaced approximately $\frac{1}{2}$ the width of one small stripe on both ceramic elements and in an opposite directions along a ceramic element edge.

10. The electrically conductive ceramic element of claim 6 wherein positions of stripes on one edge of the ceramic element are shifted relative to positions of stripes on another corresponding edge whereby a second identical ceramic element is adapted to be inverted and sealed with the first ceramic element forming a unitary ceramic module without overlapping of silver stripes at the edges where said first and second two elements are sealed.

11. The electrically conductive ceramic element of claim 1 wherein a catalyzing and electrically conductive coating is formed on the exterior surfaces of the plurality of tubes prior to the forming of the first electrically conductive coating.

12. The electrically conductive ceramic element of claim 1 wherein a catalyzing and electrically conductive coating is formed on the interior surfaces of the plurality of tubes prior to the forming of the second electrically conductive coating.

13. A method for connecting electrically conductive ceramic elements comprising:
- forming a plurality of tubes each having interior and exterior surfaces, and each having a closed end and an open end;
 - forming a tube support member for receiving open ends of the plurality of tubes; the tube support member having a top surface and a bottom surface;
 - forming a first electrically conductive coating on the exterior surfaces of the plurality of tubes;
 - forming a second electrically conductive coating on the interior surfaces of the plurality of tubes;
 - forming at least one bottom electrically conductive stripe on the bottom surface of the tube support member to create electrical connections between two or more second electrically conductive coatings on the interior surfaces of the tubes;
 - forming at least one top electrically conductive stripe on the top surface of the tube support member to create electrical connections between two or more first electrically conductive coatings on the exterior surfaces of the tubes; the electrically conductive stripes on the top extending to and over an edge of the tube support member and the electrically conductive stripes on the bottom extending to and over the edge of the tube support member; and,
 - electrically connecting the top stripes and the bottom stripes in proximity to an edge of the tube support member in such a way that at least one stripe on the top connecting one row of tubes is electrically connected to at least one stripe on the bottom connecting an adjacent row of tubes.
14. The method of claim 13 wherein the top electrically conductive stripe and the bottom electrically conductive stripe are formed from silver or silver alloy.

15. The method of claim 13 wherein the top electrically conductive stripe and the bottom electrically conductive stripe are formed from electrically conductive materials selected from a group consisting of: silver, gold, and platinum.
16. The method of claim 13 wherein at least one electrically conductive stripe is formed from two or more electrically conductive materials, each in one or more sections of the stripe.
17. The method of claim 13 wherein at least one electrically conductive stripe has at least one section consisting of a cluster of smaller stripes.
18. The method of claim 13 wherein, through symmetry of modular construction of the ceramic element, a second element is inverted and sealed to a first element to form a component device useful in an oxygen generator or fuel cell assembly.
19. The method of claim 18 further including a glass bond formed between two complementary formed ionically conductive ceramic elements.
20. The method of claim 18 wherein the first ceramic element has at least one stripe with at least one section consisting of a cluster of small stripes; the second ceramic element has at least one corresponding stripe with a cluster of small stripes; and, the location of the second cluster is displaced the width of one small stripe up or down with respect to the first cluster along a ceramic element edge.
21. The method of claim 18 wherein the first ceramic element has at least one stripe with at least one section consisting of a cluster of small stripes; the second ceramic element has at least one corresponding stripe with a cluster of small stripes; and, the location of the second cluster is displaced approximately $\frac{1}{2}$ the width of one small stripe on both ceramic elements and in an opposite directions along a ceramic element edge.

22. The method of claim 18 wherein positions of stripes on one edge of the ceramic element are shifted relative to positions of stripes on another corresponding edge to allow a second identical ceramic element to be inverted and sealed with the first ceramic element without overlapping of silver stripes at the edges where two elements are sealed.

23. The method of claim 13 wherein a catalyzing and electrically conductive coating is formed on the exterior surfaces of the plurality of tubes prior to forming of the first electrically conductive coating.

24. The method of claim 13 wherein a catalyzing and electrically conductive coating is formed on the interior surfaces of the plurality of tubes prior to the forming of the second electrically conductive coating.

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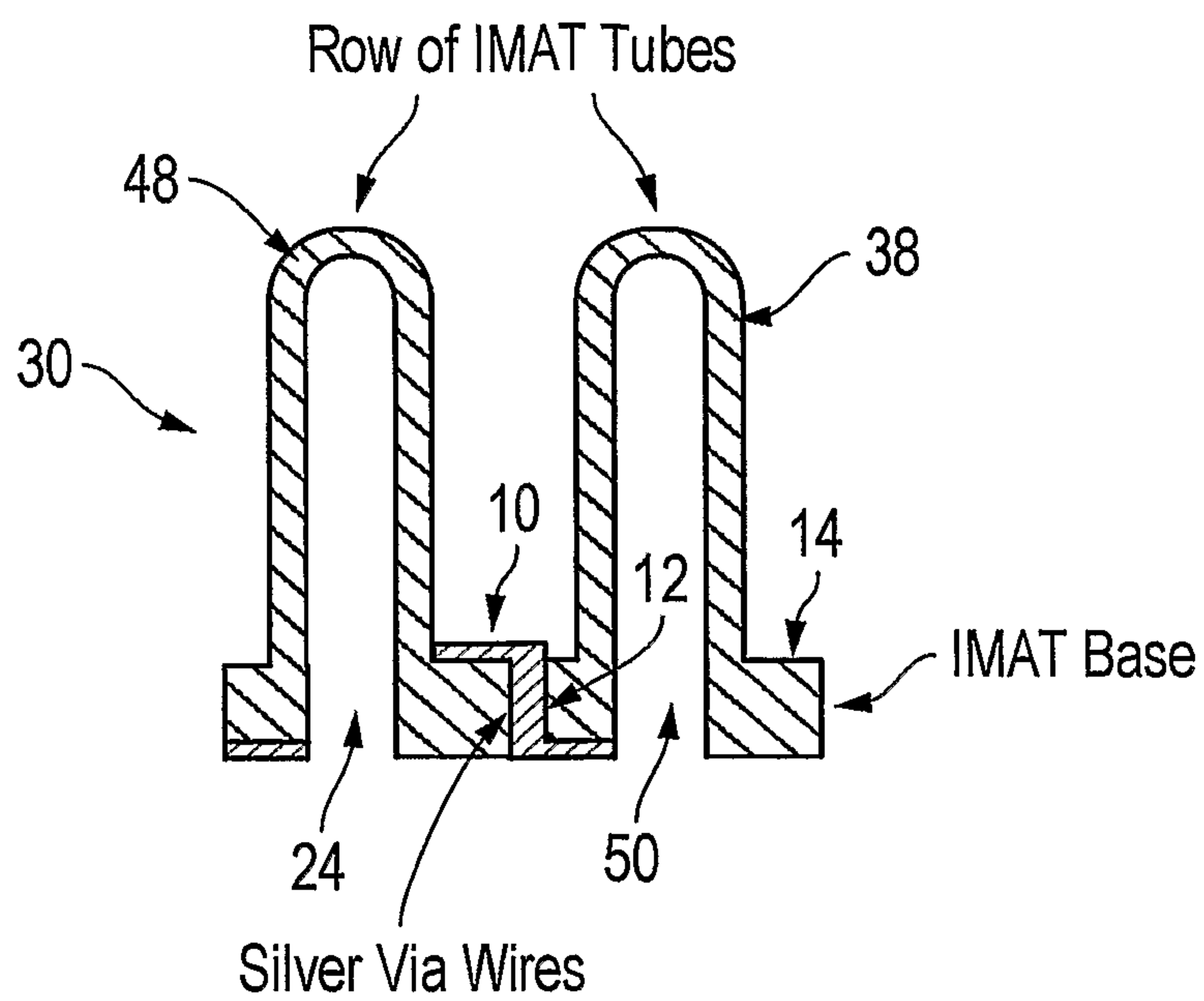


FIG. 1
(Prior Art)

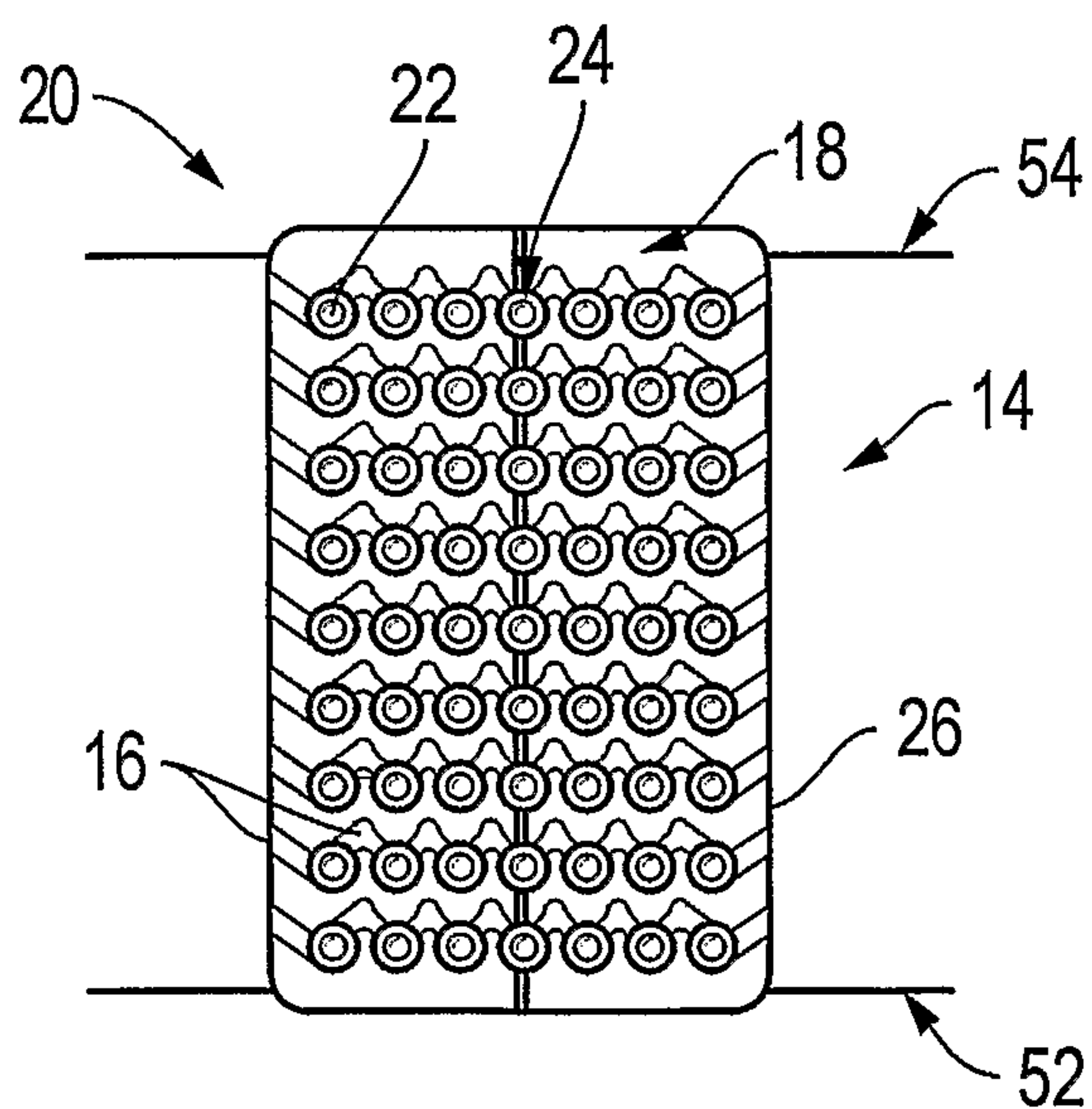


FIG. 2A

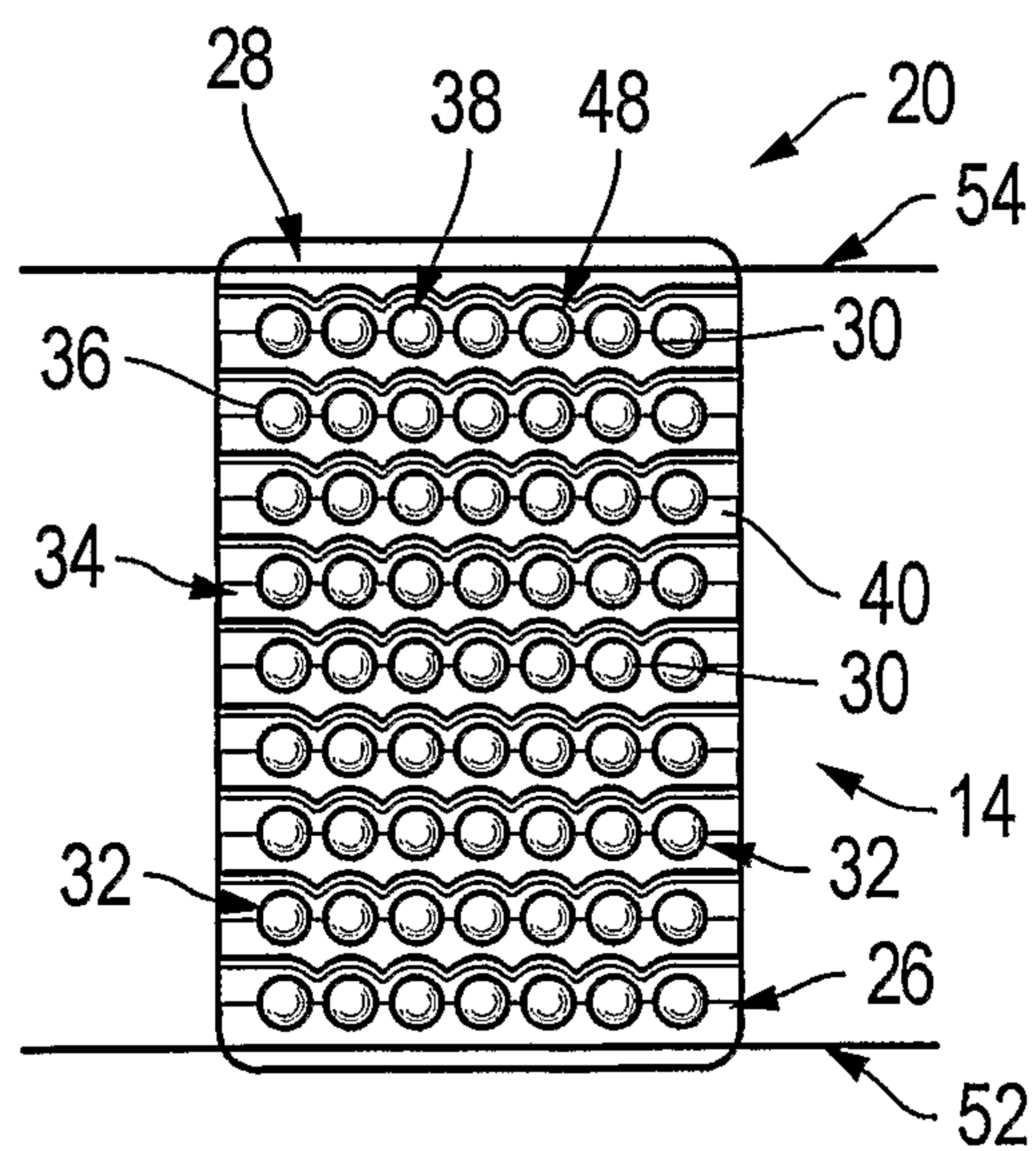
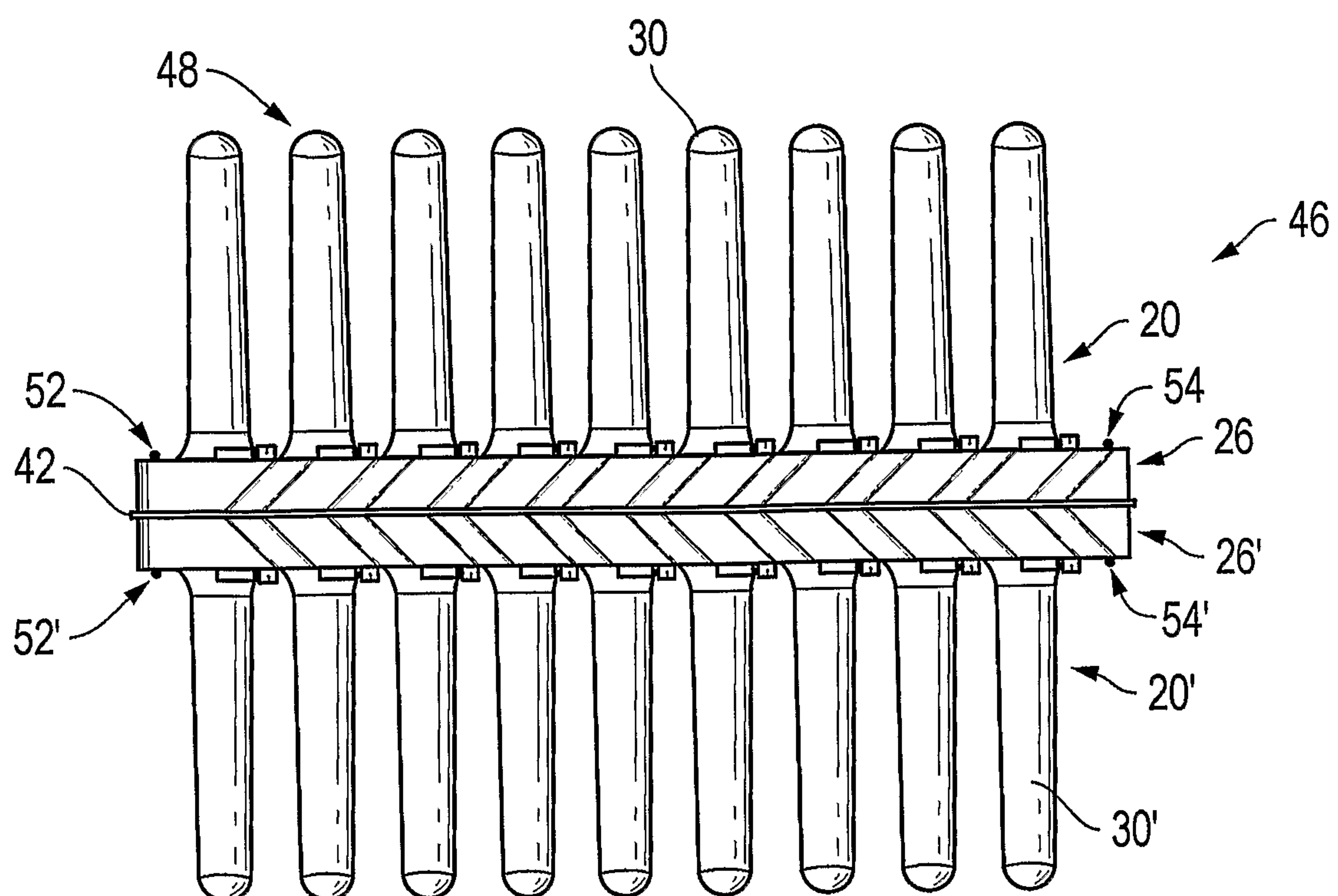
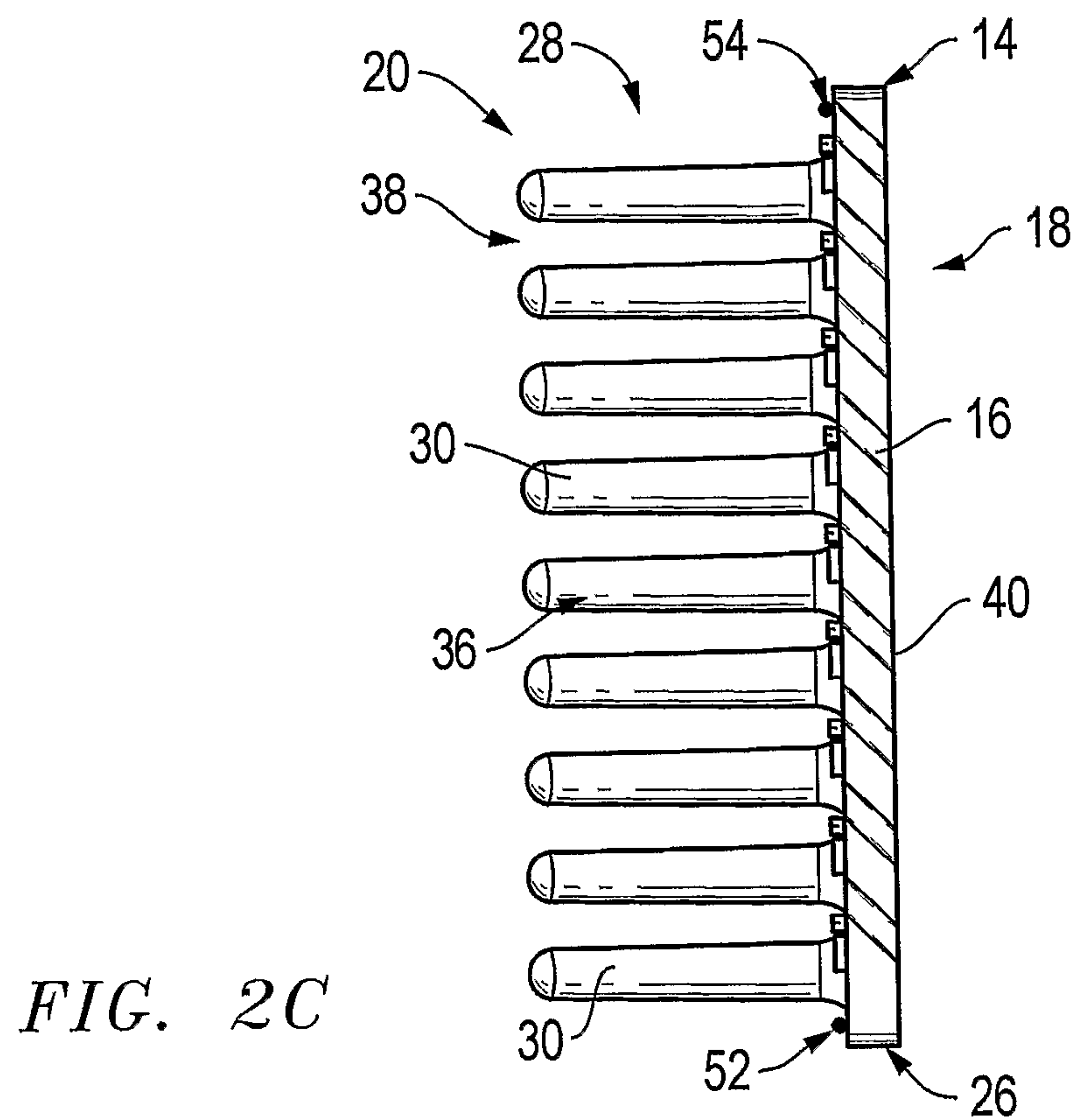
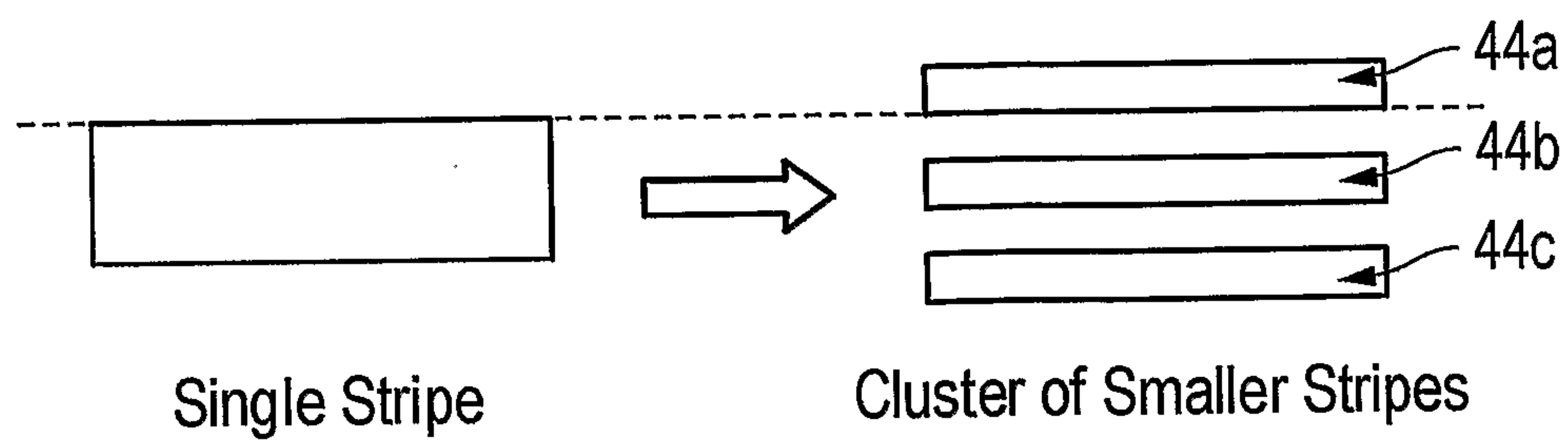
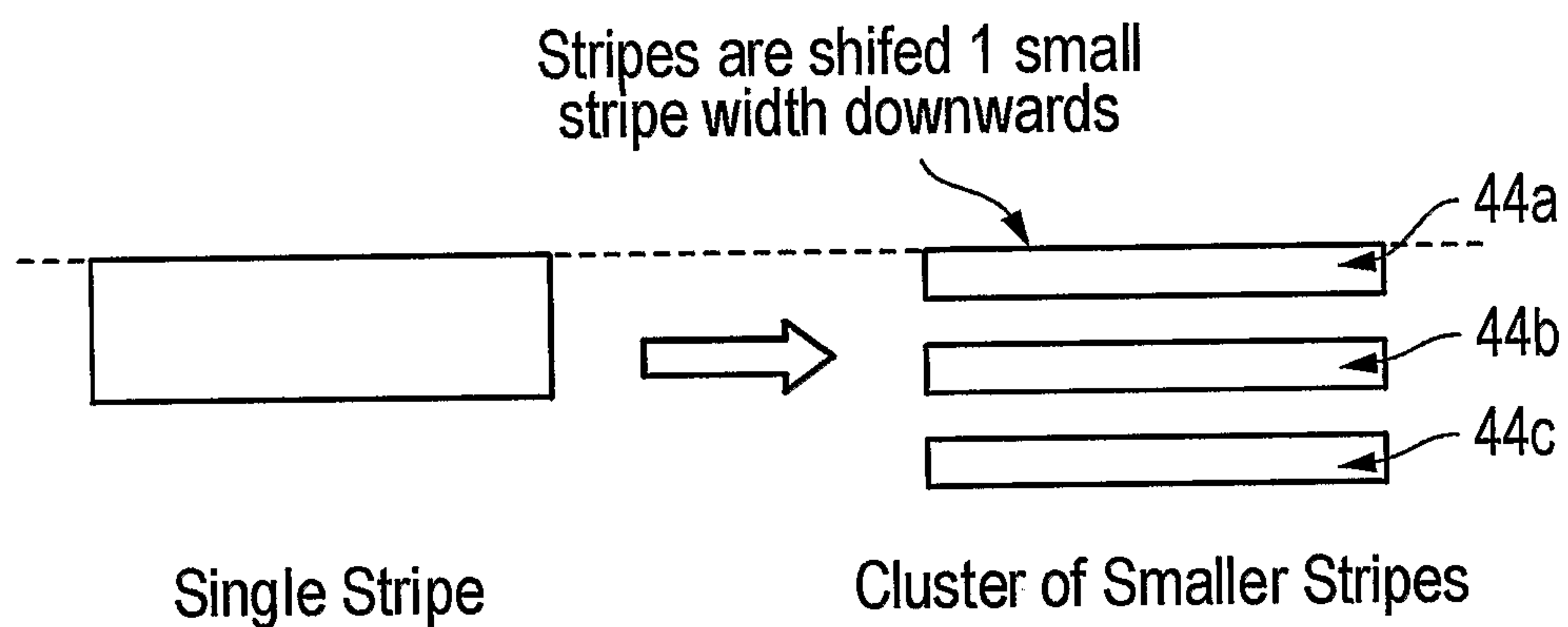
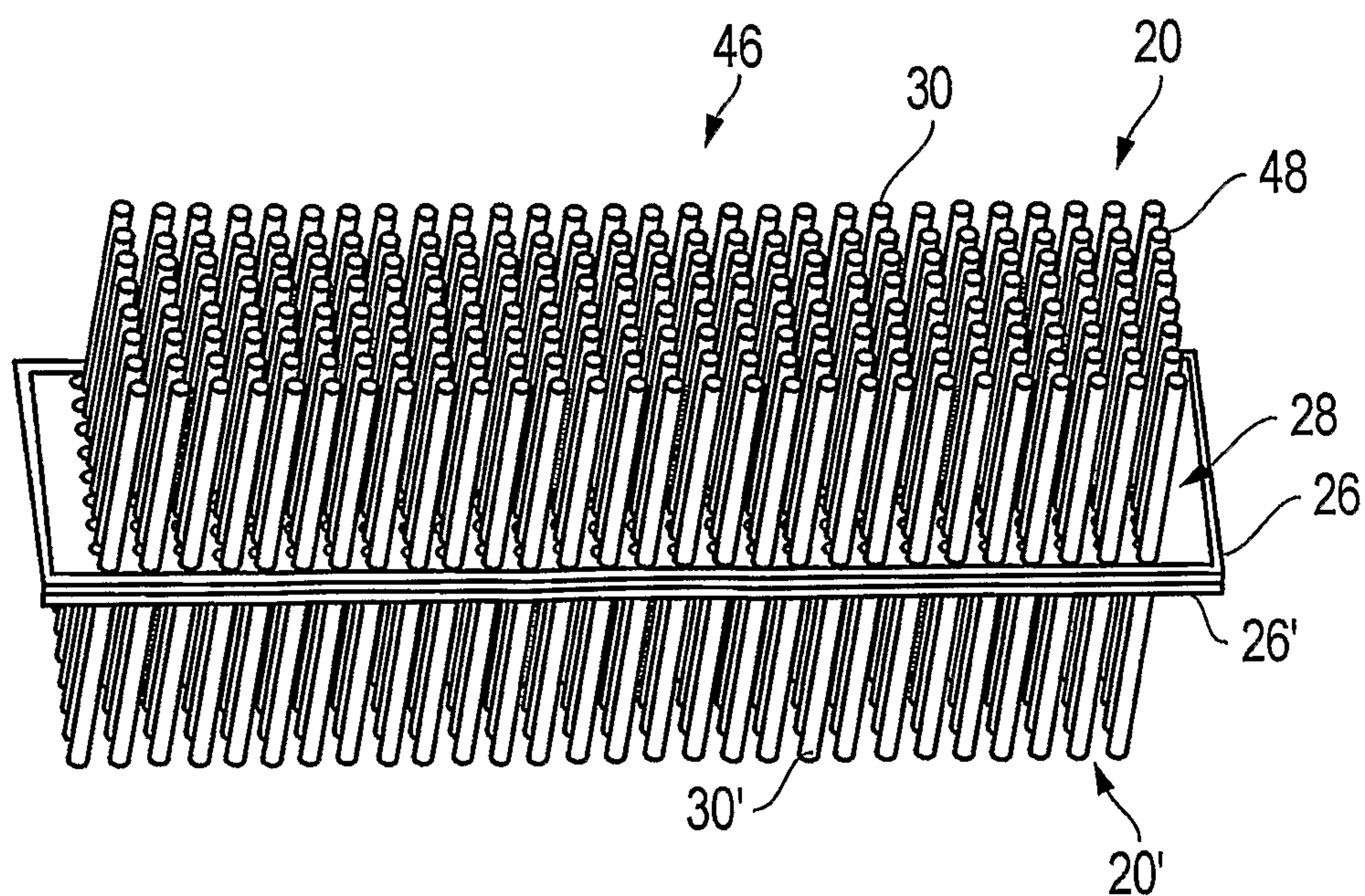


FIG. 2B

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*FIG. 3*

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*FIG. 4A**FIG. 4B**FIG. 5*
(Prior Art)

