



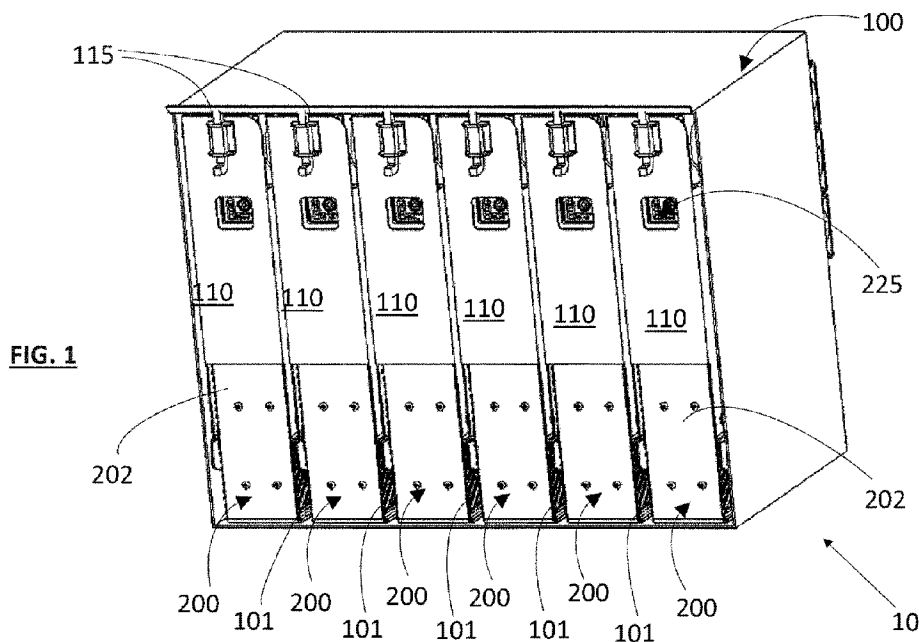
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(54) Titre : SYSTEME DE BATTERIE AU LITHIUM-ION MODULAIRE POUR ELEVATEURS A FOURCHE
(54) Title: MODULAR LITHIUM-ION BATTERY SYSTEM FOR FORK LIFTS



(57) **Abrégé/Abstract:**

Many embodiments involve rechargeable battery assemblies that are forklift-battery-sized but that comprise multiple removable battery modules. The removable battery modules are individually rechargeable and are interchangeable with each other. A housing contains six battery modules installed vertically on the front side of the assembly, with their electrical and data connections occurring within the housing on the rear side. Assemblies will be two sided so that the system has two racks with six modules per rack. The handles of each module are collapsible and on the top edges of the overall assembly so that they are readily accessible during removal. Each battery module has an integrated battery supervisor system (BSS). A Battery Operating System Supervisor (BOSS) module processor serves as a battery management system for the all the battery modules. The BOSS module grants permissions to battery modules to enable them to connect and disconnect from busbars at the appropriate times to prevent electrical issues.

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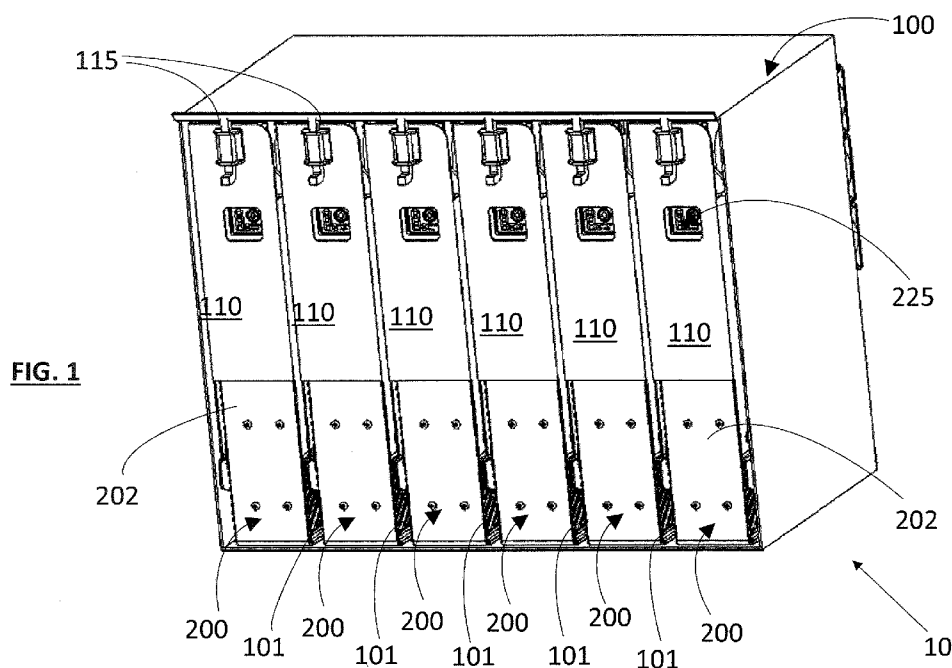
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(57) Abstract: Many embodiments involve rechargeable battery assemblies that are forklift-battery-sized but that comprise multiple removable battery modules. The removable battery modules are individually rechargeable and are interchangeable with each other. A housing contains six battery modules installed vertically on the front side of the assembly, with their electrical and data connections occurring within the housing on the rear side. Assemblies will be two sided so that the system has two racks with six modules per rack. The handles of each module are collapsible and on the top edges of the overall assembly so that they are readily accessible during removal. Each battery module has an integrated battery supervisor system (BSS). A Battery Operating System Supervisor (BOSS) module processor serves as a battery management system for the all the battery modules. The BOSS module grants permissions to battery modules to enable them to connect and disconnect from busbars at the appropriate times to prevent electrical issues.

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MODULAR LITHIUM-ION BATTERY SYSTEM FOR FORK LIFTS**MODULAR LITHIUM-ION BATTERY SYSTEM FOR FORK LIFTS**

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CLAIM OF PRIORITY TO PRIOR APPLICATIONS

[0001] The present application claims the benefit of previously filed co-pending U.S. Provisional Application, Serial Number 62/532,199, filed on July 13, 2017, as well as previously filed co-pending U.S. Provisional Application, Serial Number 62/692,702, filed on June 30, 2018. By this reference, the full disclosures, including the claims and drawings, of U.S. Provisional Application, Serial Numbers 62/532,199 and 62/692,702, are incorporated herein as though now set forth in their entirety.

BACKGROUND OF THE INVENTION

1. Field of the Invention

[0002] The present invention relates to battery-powered industrial trucks and their rechargeable batteries, as well as to related aspects of their use. More particularly, the invention is most directly related to Class I forklifts but may also find applicability in relation to other classes of battery-powered industrial trucks.

2. Description of Related Art

[0003] Before reviewing the particular field of the invention, it may be helpful to consider background information on rechargeable lithium-ion batteries in general. Rechargeable lithium-ion batteries were developed in the 1970's, and many of their benefits and potential industrial uses were well understood even then. Although commercial adoption was initially slow, they became much more widely popular by the 1990's. They are principally characterized by reference to the type of intercalated lithium compound used as the cathodes in their battery cells. Lithium metal oxides have been the most successful, with lithium cobalt oxide (LCO, or LiCoO_2) being most

popular for use in industry, although its use has not been without drawbacks, particularly with respect to thermal runaway and related safety concerns. Through the course of development, substantial improvements have been realized by doping of lithium cathode formulations with additional metals such as nickel, manganese, and aluminum. Various innovations have also involved core-shell particle cathodes, improved anodes, and the use of solid lithium polymer electrolytes, and still other innovations have led to smaller cathode particle sizes, increased electrode surface areas, and other improvements in overall battery capacity.

[0004] Today, the most popular lithium-ion batteries are of the LCO type, with lithium nickel cobalt aluminum oxide (NCA, or LiNiCoAlO_2) and lithium nickel manganese cobalt oxide (NMC, or LiNiMnCoO_2) being particularly popular. Other alternative cathode compositions have included other lithium metal oxides such as lithium manganese oxide (LMO) and lithium manganese nickel oxide (LMNO), and other lithium-ion chemistries can be considered for particular needs. Lithium metal phosphates, for instance, have also long been theoretically available for improved cycle counts, shelf life, and safety, although other performance trade-offs have made them less popular than LCO types amongst manufacturers. As one particular type of lithium metal phosphate, lithium iron phosphate (LFP, or LiFePO_4) batteries have long been known as an available type of rechargeable lithium-ion battery, with various pros and cons relative to NCA, NMC and other LCO batteries, which have generally weighed against use of LFP.

[0005] As a particular example of successful implementation of lithium-ion batteries in other fields, Tesla, Inc. has popularized the use of NCA batteries for its Model S electric cars. Their NCA batteries work well largely due to their high energy density, although they tend to have relatively low thermal stability, with a thermal

runaway temperature of around 150°C. Tesla's battery manufacturing method helps balance the benefits and risks by safely interconnecting hundreds of smaller battery cells in a much larger assembly, in a way that enables the necessary energy density while minimizing the risk of arcing and overheating. Within the larger assembly, the hundreds of smaller battery cells are connected in groups, each group including a parallel arrangement of numerous cells connected by wire bonds to adjacent busbars. The busbars of those groups are then combined in series to produce a much larger assembly that meets the power demands for an electric car. The method permanently connects each terminal of each cell into the overall assembly, although rather than using traditional methods of soldering, resistive spot welding, or laser welding, Tesla uses ultrasonic vibration welding, and the wire bonds are made of low resistance wire that allows for expected currents to pass through without significant overheating. Each wire bond is only about a centimeter in length, with one end bonded to the battery terminal and the other end bonded to an aluminum busbar conductor, which in turn is electrically joined in a circuit with other busbars. In the event of overcurrent such as with a short circuit or the like, each wire bond can serve as a fuse that breaks to prevent excessive overheating.

[0006] Although LFP batteries tend to have lower energy densities than NCA and NMC batteries, they have also long been known to have greater thermal stability. Thermal runaway for LFP batteries typically does not occur until around 270°C, which improves safety and decreases the likelihood of catastrophic failure. LFP batteries are also more stable under short circuit or overcharge conditions and will not readily decompose at high temperatures. As other arguable advantages, LFP batteries also tend to have greater power density (i.e., they can source higher power levels per unit volume) as well as greatly increased cycle life in comparison to lead-acid batteries.

While common lead-acid batteries have an average life of 300 cycles with 20% degradation of stored charge, LFP batteries can last over 2000 cycles with the same 20% degradation of stored charge.

[0007] Meanwhile in the field of the present invention, despite long availability of lithium ion batteries in general, Class I forklifts are still typically powered by lead-acid batteries. One reason is that many forklifts, especially Class I forklifts, require a substantial counterbalance for safe use. While lead-acid forklift batteries commonly weigh more than a thousand pounds, many forklifts have therefore been designed to use the weight of lead-acid batteries to maintain stability. However, their massive weight also presents numerous challenges, particularly in the context of extracting, replacing and otherwise handling them. While personnel cannot safely lift anything near that heavy, special hoists and battery changing equipment are required, which in turn involves more expense and floor space, not to mention the risks of back injury and the like.

[0008] Beyond the weight-related risks, because of the corrosive nature of sulfuric acid, lead-acid batteries also present risks of damage to eyes, lungs, skin and clothing of personnel who work with them. Plus, hydrogen gas is commonly released during battery recharge, which can combine explosively with oxygen, as well as cause accelerated corrosion of surrounding components. Consequently, special safety protocols are needed with lead acid batteries, and special attention is needed to ensure adequate ventilation of hydrogen and sulfuric fumes around forklifts and their recharging stations.

[0009] Moreover, lead-acid forklift batteries are also expensive in terms of time, space and inventory. A lead-acid forklift battery can generally only be used continuously for around six hours before requiring 8-9 hours to recharge. They can

also require extensive hours of maintenance and have a much shorter life cycle when compared to lithium-ion technologies. They also tend to require dedication of large areas in warehouses for charging and maintenance, and each forklift generally requires two spare batteries for a facility conducting 24-hour operations.

[0010] As a result of many of the above-mentioned and other reasons, others have long considered use of lithium-ion forklift batteries as an alternative, but any resulting attempts have been weak at best, and many of the challenges of the characteristically massive lead-acid forklift batteries still plague forklift-related industries.

[0011] Therefore, despite the well-known characteristics and long availability of rechargeable LFP and other lithium-ion battery technologies, there are still substantial and long-felt unresolved needs for battery technology improvements in the forklift industry. Commonly owned U.S. Provisional Patent Application 62/532,199 is incorporated herein by reference in its entirety.

SUMMARY OF THE INVENTION

[0012] The innovations of the present invention improve safe and reliable operations of conventional electric forklifts in various ways, in part by enabling rechargeable lithium-ion forklift batteries that are interchangeable with lead-acid forklift batteries for which such forklifts are conventionally adapted to be used. Many embodiments of the present invention involve rechargeable battery assemblies that are forklift-battery-sized but that comprise multiple removable battery modules. The removable battery modules are individually rechargeable and are interchangeable with each other. Each such battery module is self-contained, is equipped with an integral handle for easy removal from the outer assembly, and is preferably sized and

otherwise adapted to be manually removable by forklift operators and maintenance personnel. Hence, each individual battery module can be selectively removed for purposes of recharging it or replacing it with a fully charged replacement module.

[0013] Preferred adaptations are such that, if the operator or maintenance personnel desires to recharge the entire assembly, that entire assembly can be removed and recharged in the same manner as conventional lead-acid forklift batteries, or the preferred method of charging the entire assembly while it remains in the forklift; whereas one or more of the separately removable modules can alternatively be removed by hand for recharge or replacement. Aspects of the invention further allow for removal of multiple modules out of the larger battery assembly, to allow for its recharge or replacement, while still allowing continued forklift operation. Moreover, due to other innovative aspects of Applicant's approach, the individual battery modules and/or the larger assembly can be recharged with lithium-ion chargers but are also readily compatible to be recharged with conventional lead acid battery chargers.

[0014] Preferred embodiments of the larger battery assemblies include a housing that is forklift-battery-sized, together with a symmetrical arrangement of individually removable and interchangeable modules. Preferably, the housing contains six battery modules installed vertically on the front side of the assembly, with their electrical and data connections occurring within the housing on the rear side. Preferred embodiments will be two sided so that the system has two racks with six modules per rack for a total of 12 modules. The handles of each module are collapsible and oriented on the top edges of the overall assembly so that they are readily accessible during manual removal of the corresponding modules.

[0015] A preferred embodiment has battery modules secured in place using doors with latches. Each battery module has a low friction surface to ensure smooth and controlled movement during release of the battery modules. There is interlock functionality built into pins in a low voltage connector. This interlock is wired so that three conditions must be met before the battery module will engage the communication bus. These conditions include mating of the low current connector, engagement of the physical locking system on the housing rack, and successful link to the communication bus. The interlock pin loops through the physical latch in the slot where the module connects so that the BOSS module knows that the module is connected. When a module is inserted and the latch closes, the interlock pin is shorted with module ground pin. This mechanism helps prevent arcing in many embodiments of the present invention. Without associated benefits, arcing might otherwise lead to overcurrent scenarios which, in turn, run the risk of causing destruction of electrical connectors in the absence of proper safeguards.

[0016] Each battery module has an integrated battery supervisor system (BSS). The system monitors the health to include cell voltage, current, and temperature. During charging, the system monitors the state of charge, compensates for voltage differences, and ensures the pack remains operational if and only if the battery cells are properly balanced and within the operating temperature limits. Additionally, the system can retain and communicate history and information to lift trucks and chargers through a physical CAN bus.

[0017] Battery modules of preferred embodiments are connected in a combination of series and parallel to achieve higher voltage, higher capacity, and higher ampacity. Each battery module is self-sufficient containing its own internal

controllers. However, there will be some redundant monitoring and control conducted by secondary controllers, e.g. motor controllers and/or chargers.

[0018] Within each module, individual battery cells are connected using an approach that is comparable to the Tesla method of wire bonded battery manufacture. An important difference from Tesla, however, involves the use of LFP battery technologies rather than NCA or other LCO battery technologies, as previously discussed. Amidst a number of resulting performance differences, it is notable that in the preferred embodiment, removal of up to four modules per housing rack for charging still allows continued operation of the forklift, since such removal does not decrease the voltage below the overall requirements. The assembly requires a minimum number of two 24 Volt battery modules for continuous operation. Located between the battery cells and the printed circuit board (PCB) are plastic battery trays and a thermally conductive adhesive. A thermally conductive, electrically insulative adhesive is used between the top plastic battery tray and the PCB. Additionally, the same adhesive is used between the battery cells and the top and bottom plastic battery trays. A thermal gap filler is applied between the bottom of the battery cells and the module enclosure for the purpose of thermal management.

BRIEF DESCRIPTIONS OF THE DRAWINGS

[0019] **Fig. 1** shows a perspective view of a preferred embodiment of the disclosed assembly with closed doors. The assembly includes a housing rack containing six separable battery modules.

[0020] **Fig. 2** shows a side view of a Class I forklift in a configuration representative of the prior art, showing its inclusion of a conventional lead-acid forklift battery in an openable battery compartment with arrows conceptually illustrating the relationship between its counterweight, the weight of its load, and the resulting center

of mass in comparison to the force of the opposing fulcrum created at the front wheels of the forklift.

[0021] Fig. 3 is a side view of a Class I forklift without the conventional lead acid forklift battery of Fig. 1, instead incorporating a rechargeable battery assembly according to the teachings of the present invention.

[0022] Fig. 4A shows the disengagement of a slam latch from the housing.

[0023] Fig. 4B shows the pin locking feature of the door which holds the battery module in place.

[0024] Figs. 5A and 5B show a door of housing in a halfway open position and the location of the door pin.

[0025] Figs. 6A and 6B show a door of housing in a fully open position and the location of the door pin.

[0026] Figs. 7A and 7B show the removal process for the module from the housing once the door is fully opened.

[0027] Figs. 8A and 8B show the disengagement of a slam latch from the housing for an alternative embodiment.

[0028] Figs. 9A and 9B show a door of housing in a halfway open position and the location of the module pin.

[0029] Figs. 10A and 10B show a door of housing in a fully open position and the location of the module pin.

[0030] Figs. 11A and 11B show the removal process for the module from the housing once the door is fully opened.

[0031] Fig. 12 shows a rear view of the housing with the modules inserted.

[0032] Fig. 13 shows a perspective view of the rear and sides of the housing with the modules inserted.

- [0033] **Fig. 14** shows a rear view of a battery module.
- [0034] **Fig. 15** shows a sectional front view of a battery module.
- [0035] **Fig. 16** shows a perspective view of the interior of a battery module.
- [0036] **Fig. 17** shows a top interior view of a battery module.
- [0037] **Fig. 18** shows a a cross sectional view of an individual battery cell within a module.
- [0038] **Fig. 19** shows a schematic diagram where the six battery modules are connected in parallel to the housing rack.
- [0039] **Fig. 20** is an elevation view of the rechargeable battery assembly **220** of an alternative embodiment. The assembly **220** is a variation that incorporates eight separable battery modules **330**, while **Fig. 15** shows the outer housing rack **300** and one half of those eight battery modules **330** (namely modules **330a-330d**) operatively positioned therein.
- [0040] **Fig. 21** is a middle cross-section view of the rechargeable battery assembly **220** of an alternative embodiment, showing the outer housing rack **300** and the other half of the battery modules **330** (i.e., the half *not* shown in **Fig. 21**, namely modules **330e-330h**) operatively positioned therein, with the viewing plane of **Fig. 22** being numbered as the cross-sectional plane 4-4 in **Fig. 23**.
- [0041] **Fig. 22** is a partially-cut-away isometric perspective view of the rechargeable battery assembly **220** of an alternative embodiment with its battery modules **330** operatively positioned therein, with a large portion of the top wall **303** and part of central wall **350** partially cut-away in order to reveal some of its detail.
- [0042] **Fig. 23A** is a partial isometric perspective view focusing on one of the individual battery modules **330** (namely, module **330a**) of an alternative embodiment in its operatively engaged position within bay **307a** of housing rack **300**, with most of

that housing being cut-away to show the module **330a** and its removability in the direction of arrows **608** and **609**.

[0043] **Fig. 23B** is a simpler isometric view showing the rear of an individual battery module **330a** of an alternative embodiment resting on elemental representations of slides **610** and **611** of the housing rack assembly **300**.

[0044] **Fig. 24A** is an isometric view of the *top* of the interior of a battery module **330** of an alternative embodiment and its rear connections **400**, **401** and **402**.

[0045] **Fig. 24B** is an isometric view of the *bottom* of the interior of the battery module **330** of the alternative embodiment of **Fig. 24A**, and its rear connections **400**, **401** and **402**.

[0046] **Fig. 25** is an elemental top view of a battery module **330** of an alternative embodiment showing symbolic representations of its connections and mechanisms for operative installation and removal in and from the housing rack **300** of **Fig. 23**.

[0047] **Fig. 26** is a schematic diagram example of an alternative embodiment with the battery modules in the housing rack connected in parallel and connected to a housing rack control system **901**.

DETAILED DESCRIPTIONS OF PREFERRED EMBODIMENTS

[0048] The following descriptions relate to presently preferred embodiments and are not to be construed as describing limits to the invention, whereas the broader scope of the invention should instead be considered with reference to the claims, which may be now appended or may later be added or amended in this or related applications. Unless indicated otherwise, it is to be understood that terms used in these descriptions generally have the same meanings as those that would be understood by persons of ordinary skill in the art. It should also be understood that terms used are generally intended to have the ordinary meanings that would be

understood within the context of the related art, and they generally should not be restricted to formal or ideal definitions, conceptually encompassing equivalents, unless and only to the extent that a particular context clearly requires otherwise.

[0049] For purposes of these descriptions, a few wording simplifications should also be understood as universal, except to the extent otherwise clarified in a particular context either in the specification or in particular claims. The use of the term “or” should be understood as referring to alternatives, although it is generally used to mean “and/or” unless explicitly indicated to refer to alternatives only, or unless the alternatives are inherently mutually exclusive. When referencing values, the term “about” may be used to indicate an approximate value, generally one that could be read as being that value plus or minus half of the value. “A” or “an” and the like may mean one or more, unless clearly indicated otherwise. Such “one or more” meanings are most especially intended when references are made in conjunction with open-ended words such as “having,” “comprising” or “including.” Likewise, “another” object may mean at least a second object or more.

Preferred Embodiments

[0050] The following descriptions relate principally to preferred embodiments while a few alternative embodiments may also be referenced on occasion, although it should be understood that many other alternative embodiments would also fall within the scope of the invention. It should be appreciated by those of ordinary skill in the art that the techniques disclosed in these examples are thought to represent techniques that function well in the practice of various embodiments, and thus can be considered to constitute preferred modes for their practice. However, in light of the present disclosure, those of ordinary skill in the art should also appreciate that many changes

can be made relative to the disclosed embodiments while still obtaining a comparable function or result without departing from the spirit and scope of the invention.

Housing Rack and Battery Module Interface Design

[0051] In **Fig. 1**, there is shown a perspective view of a preferred embodiment **10**, showing the front of the housing rack ("housing") **100**. Housing **100** is preferably constructed of steel or another material suitable for providing strength and stability. A preferred embodiment **10** has six battery modules ("modules") **200** arranged vertically. When installed in housing **100**, each module **200** is secured in place by doors **110** with slam latches **115**. Slam latches **115** are attached to the front of each door **110**. The doors **110** prevent the modules **200** from sliding back and forth and preventing the contacts from becoming loose. Each door **110** extends from the top of housing **100** to the exposed bottom sheath **202** of module **200**. Additionally, partitions **101** are fixed to housing **100** and located between each module **200** to prevent side to side movement. There are a total of five partitions **101** fixed to housing **100**. Each of the doors **110** is hollowed out so that the display panels **225** on each module **200** are visible. The display panels **225** are lit up using LEDs and indicate the status of each module **200**. Further details regarding the display panels **225** are shown in **Fig. 15** and described later in the specification.

Representative Lift Truck

[0052] **Fig. 2** shows a side view of a conventional Class I electric forklift **130**, which is representative of a prior art lift truck design with which and in which the present invention may be incorporated, embodied or used. The particular model of forklift **130** illustrated is most like a Caterpillar model E6000 forklift, which specifies a 48V battery that is 34.4 inches long (i.e., depth from front to rear) x 39.5 inches wide (i.e., the lateral dimension when installed on the forklift) x 23.3 inches in height and

that meets minimum weight requirements. As a Class I forklift, forklift **130** is a mobile truck with a lifting assembly **131** for raising and lowering forks or other load supporting members **132** that are adapted to support a load **150** thereon, for the purpose of lifting, carrying or moving that load **150**.

[0053] While the load supporting members **132** are conventionally designed to support the load **150** in a cantilevered fashion, extending forward of a fulcrum generally created by the front wheels **142** of the forklift **130**, heavier loads present risks of tipping over the forklift **130**. Hence, minimizing that risk of tipping under load is basic to safe operation of such a forklift **130** and, in line with its classification as a Class I lift truck, the full range of weight (F_L , illustrated by arrow **151**) of the loads **150** to be carried by forklift **130** must be properly counterbalanced by a counterweight force (F_c , illustrated by arrow **121**). In other words, for safe lifting and maneuvering of a load **150** without tipping, the forward-tipping torque created principally by the weight (F_L , illustrated by arrow **151**) of that load **150** must be exceeded by the opposing torque created principally by the counterweight force (F_c) of the forklift **130**, particularly for loads at the heavier end of the range of manufacturer specified load capacities for forklift **130**.

[0054] In the prior art, such a forklift **130** generally includes a large lead acid battery **160** as a major part of the counterweight force (F_c), and Class I forklifts are generally designed accordingly. The design of such forklifts generally incorporates structure to safely support the weight of the forklift battery **160** within a battery compartment **122** of a particular length (i.e., depth), width and height. The battery compartment **122** is generally defined in part by removable or openable panels or the like that partially or completely contain and define the space for the forklift battery **160** therein. In the case of the illustrated forklift **130**, for instance, the battery compartment

122 is defined in part by a seat assembly **135** and a partial side panel **136**. The seat assembly **135** normally sits over the top of the forklift battery **160** but has a releasable latch that allows it to be manually pivoted up and away from the forklift battery **160** to enable an operator to access the forklift battery **160** or its compartment **122**. Analogously, panel **136** or other structures are provided to help enclose and define the battery compartment **122**, and panel **136** may also be either removable or openable to enable more complete access to that battery compartment **122**, such as for purposes of checking or replacing the forklift battery **160** therein. Forklift **130** also has positive and negative electrical conductors for removably connecting the forklift's electrical circuitry to the corresponding terminals of the conventional forklift battery **160**.

[0055] The forklift uses a fulcrum (illustrated by arrow **91**) which is created between the forklift's front wheels and the underlying floor **90**. If the moment created by the load force (F_L) of load **150** forward of that fulcrum **91** exceeds the opposite moment of the forklift counterweight (F_c), the forklift **130** will tip forward, toward the load **150**, resulting in a dangerous situation. The location of the center of gravity **161** depends partly on if the forklift is loaded or unloaded. When the forks **171** are raised while carrying a load **150**, the center of gravity **161** naturally shifts toward the front of the forklift and upward.

Rechargeable Lithium-Ion Battery Assembly

[0056] **Fig. 3** shows the same representative Class I electric forklift **130** as illustrated in **Fig. 2**, but having a preferred rechargeable battery assembly **230** according to the teachings of the present invention operatively installed in the battery compartment **122**, in place of the conventional lead acid forklift battery **160** of **Fig. 1**. In contrast to the conventional lead-acid battery **160**, rechargeable assembly **230**

includes a plurality of separable battery modules **200**, preferably an even number of such modules **200** (six in the illustrated embodiment), each of which includes numerous lightweight lithium-ion battery cells therein. Most preferably, those numerous battery cells are of the LFP type. Even without recharging or replacing individual modules **200**, the entire assembly **230** can hold an operable charge for around ten hours before requiring approximately 60 minutes to recharge, in contrast to the shorter usage durations and much longer charging durations that are characteristic of conventional lead acid battery **160**. Also, due to their lithium-ion chemistry, each module **200** can be cycled through about six times as many charging cycles as conventional lead-acid battery **160**.

[0057] For LFP chemistries in particular, charge rates corresponding to one hour or less charge times are often within the recommended operating limits of the cell. Additionally, the ease of removal of modules **200** allows for opportunity charging during work breaks. For example, an operator can remove a module **200** during a 15 minute break and get a substantial recharge during this short interval. The longer run times of rechargeable assembly **230** compared to conventional lead-acid batteries **160** also improves workplace efficiency. For lead-acid batteries **160**, large areas are allocated for recharging. After an 8-hour work shift ends, lead-acid battery **160** is removed for recharging and another charged lead-acid battery **160** is inserted. Replacing this system with rechargeable assembly **230** can save time and valuable space in the work environment.

[0058] Another important advantage of rechargeable assembly **230** is the lower equivalent series resistance (ESR) in LFP batteries than lead-acid batteries **160**. Lead-acid batteries **160** experience decreased performance as a result of having higher ESR. Often as these batteries **160** discharge, a “voltage droop” occurs, causing

sluggish operation of the forklift truck under load or acceleration. Most often, this occurs around 6 hours into a shift, requiring an additional recharge per shift, whereby reducing the life of the battery. LFP batteries provide an improvement in sustained performance during shifts while significantly reducing the risk of voltage droop.

[0059] The preferred embodiment of rechargeable assembly **230** has six battery modules **200** installed in a larger housing rack **100**. Those modules **200** are preferably arranged in two symmetrical groupings, half being removable from one lateral side of the housing rack **100**, and the other half being removable from the other lateral side of that housing rack **100**. The complete assembly **230** preferably contains two sets of six modules **200** arranged back-to-back and vertically oriented, the front faces of which are exposed on one side or the other of the forklift when any detachable panels **136** are removed or opened. Alternative embodiments may have a different location or different quantities of battery modules making up the housing rack **100**.

[0060] Sized, weighted and otherwise adapted to be roughly comparable to the conventional battery **160**, the height “H”, depth “D” and width (the dimension perpendicular to **Fig. 2**) of assembly **230** are substantially the same as those for the conventional forklift battery **160** intended for use with forklift **130**. Hence, assembly **230** may be described as “forklift-battery-sized”. Due to its forklift-battery-sized characteristic, for the forklift **130** as illustrated, assembly **230** is able to safely fit in the same battery compartment **122** as conventional battery **160**. The preferred embodiment of rechargeable battery assembly **230** is also weighted with centrally-oriented steel plates in its base, integrally secured to its lower surface **304**, to meet the minimum (and maximum) weight requirements of batteries to be used in forklift **130**, as specified by the manufacturer of forklift **130**.

[0061] Hence, for use on the Class I electric forklift **130** shown in **Fig. 3**, lithium-ion battery assembly **230** is adapted to fit in a Caterpillar E6000 forklift battery compartment **122**, for use as a replacement of conventional lead-acid battery **160**. More specifically, for the E6000, lithium-ion battery assembly **230** roughly fits the dimensions of 34.4 inches long (i.e., depth from front to rear) x 39.5 inches wide (i.e., the lateral dimension when installed on the forklift **130**) x 23.3 inches in height, and assembly **230** has a minimum weight of 3100 pounds, preferably with a margin of fifty pounds over the manufacturer's specified minimum battery weight requirement.

[0062] Those of skill in the art will understand that the dimensions, fit, shape and weight for different makes and models of forklifts will dictate a range of dimensions for alternative embodiments that are intended to be used with any particular make and model of forklift. The full range of sizes for Class I forklift batteries are intended for alternative embodiments. The range of minimum battery weight requirements for Class I electric forklifts are approximately 1,500 to 4,000 lbs., which is also intended for alternative embodiments.

[0063] It is contemplated that the preferred embodiment allows for the removal of four modules **200** on each housing rack **100** for replacement or recharge, while still being able to maintain operation of the forklift with two modules per rack **100**. To accommodate continued operation despite removal of one module **200**, such removal will not decrease the voltage below the requirement for the forklift **130**.

[0064] Although many aspects of the present invention can be appreciated with other types of rechargeable batteries, preferred embodiments use battery cells of one of the lithium-ion types. Most preferably, each module **200** of the battery assembly **230** incorporates hundreds of self-contained battery cells of the LFP (lithium iron phosphate) type. Although all lithium-ion battery types can experience thermal

runaway, LFP battery cells of the preferred embodiment have a fairly high thermal runaway temperature, of 270 C, substantially higher than the runaway temperature for NCA or other LCO cells, which are the more conventional of lithium-ion battery cells, which typically have a thermal runaway temperature of around 150° C. Although the preferred embodiment uses LFP batteries, it should be understood that some aspects of the invention can be appreciated through use of other types of rechargeable lithium-ion battery cells. For example, alternative compounds for some aspects of the invention are contemplated to include, without limitation, lithium cobalt oxide (LiCoO_2), lithium manganese oxide (LiMn_2O_4 , Li_2MnO_3), lithium nickel cobalt aluminum oxide (LiNiCoAlO_2), and lithium nickel manganese cobalt oxide (LiNiMnCoO_2).

[0065] Within each of the battery modules **200** of the preferred embodiment, a plurality of self-contained battery cells (preferably somewhere in the range from one-hundred, sixty to two-hundred cells per module **200**) is connected in a combination of series and parallel using a wire bonding method. The wire bonding method connects batteries using wire bonds instead of busbars. The wire bonding is achieved through ultrasonic friction welding. By interconnecting batteries with wire bonding, the wire bonds can prevent short circuits while acting as fuses. The wire bonds are made of wire that allows for the expected current to pass through without significant overheating and allows the wire bond to break to prevent over-currents of individual cells. Additionally, FET's or other forms of conventional fuses are placed inside battery modules. If the current carrying capacity is exceeded, the fuse will open and prevent the overcurrent from also blowing out the wire bonds. Alternative embodiments of this design may connect battery cells in parallel. Additionally, alternative methods of connecting batteries could include traditional soldering and spot welding.

Removal and Insertion of Battery Modules

[0066] Turning to **Fig. 4A**, there is shown a disengagement of a slam latch **115** from the housing **100**. The bottom end **116** of latch **115** is pushed down in order to release the top end **117** from the engagement with housing **100**. Pin **201** is permanently attached to door **110** and fits into the groove **112**. In **Fig. 4B**, there is shown a hinge **111** of door **110** that engages module **200**. Though not visible in **Fig. 4B**, door **110** has an identical pin **201** on its opposite side. Similarly, module **200** has an identical groove **112** on its opposite side. Pins **201** remain at the top of grooves **112** until the door **110** is opened.

[0067] Turning to **Fig. 5A**, there is shown a door **110** of housing **100** in a halfway open position. It is shown in **Fig. 5A** that module **200** is protruding from the front edge **102** of housing **100**. In **Fig. 5B**, the pin **113** is shown halfway up the groove **112**. When the door **110** is opened, it **110** rotates counterclockwise on hinge **111**. Simultaneously, pin **113** moves down groove **112** toward the bottom of module **200**. It should be understood that the same mechanism occurs at the same time on the opposite side of module **200**. As the door **110** is opened, the module **200** begins to slide out of the housing **100**.

[0068] Turning to **Fig. 6A**, there is shown a door **110** of housing **100** in a fully open position, rotated 90 degrees from the closed position. As a result of opening door **110**, module **200** is pulled out of housing **100** and protrudes from the edge **102**. The carry handle **205** of module **200** is clearly visible in **Fig. 6A**. Carry handle **205** is preferably bolted to module **200** and can be detached. In **Fig. 6B**, the pin **113** is shown at the bottom of groove **112**, enabling module **200** to be removed from housing **100**.

[0069] Turning to **Fig. 7A**, there is shown module **200** removed from housing **100** and resting on door **110**. At the top of module **200**, there is a protective top sheath **203** with a hollowed out area for viewing display panel **225**. Once the door **110** is in

the fully open position, a user can manually slide module **200** along tracks (not shown) out of housing **100** and onto door **110**. The preferred embodiment **10** has low friction slides located below each module **200**. Turning to **Fig. 7B**, the user can manually fold the carry handle **205** upward and lift module **200** off of the door **110**. The user can carry module **200** using carry handle **205** to a battery charging station and replace it with another charged module **200**. Preferably, the battery modules **200** weigh no more than 51 pounds in compliance with OSHA and other workplace standards. Replacing a module **200** requires performing the opposite actions of the aforementioned removal procedure.

[0070] Figures 8A-11B show the procedure for removal of module **200** in an alternative embodiment. Turning to **Fig. 8A**, there is shown a disengagement of a slam latch **115** from the housing **100**. The bottom end **116** of latch **115** is pushed down in order to release the top end **117** from the engagement with housing **100**. In **Fig. 8B**, there is shown a hinge **111'** of door **110'** that engages module **200**. A pin **201'** that is permanently attached to module **200** fits into the groove **112'** in hinge **111'**. The pin **201'** remains at the bottom of hinge **111'** until the door **110'** is opened.

[0071] Turning to **Fig. 9A**, there is shown a door **110'** of housing **100** in a halfway open position. In **Fig. 9B**, the pin **201'** is shown halfway up the groove **112'**. When the door **110'** is opened, the hinge **111'** rotates counterclockwise around the fixed pin **201'**. As the door **110'** is opened, the module **200** begins to slide out of the housing **100**. At this time, an electric switch (not shown) is actuated. The interlock pin **911** (shown schematically in **Fig. 19**) loops through the physical latch (not shown) in the slot where module **200c** connects. When module **200c** is inserted and the latch closes, the interlock pin **911** is shorted with module ground pin **914**. It is shown in **Fig. 9B** that module **200** is protruding from the front edge **102** of housing **100**. Turning to

Fig. 10A, there is shown a door **110'** of housing **100** in a fully open position. As a result of opening door **110'**, module **200** is pulled out of housing **100** and protrudes from the edge **102**. The carry handle **205** of module **200** is clearly visible in **Fig. 10A**. Carry handle **205** is preferably bolted to module **200** and can be detached. In **Fig. 10B**, the hinge **111'** is shown rotated 90 degrees counterclockwise from the closed position. The pin **201'** is outside groove **112'**, enabling module **200** to be removed from housing **100**. Turning to **Fig. 11A**, there is shown module **200** removed from housing **100** and resting on door **110'**. Once the door **110'** is in the fully open position, a user can manually slide module **200** along tracks (not shown) out of housing **100** and onto door **110'**. The embodiment has low friction slides located below each module **200**. Turning to **Fig. 11B**, the user can manually fold the carry handle **205** upward and lift module **200** off of the door **110'**. The user can carry module **200** using carry handle **205** to a charging station and replace it with another charged module **200**. Replacing a module **200** requires performing the opposite actions of the aforementioned removal procedure.

[0072] Turning to **Fig. 12**, there is shown a rear view of housing **100**. There are six sets of fans **120** for cooling the modules **200**. Each set has three fans **120** and the sets are located between modules **200**. For example, the first set shown on the left of **Fig. 12** is located between the first and second modules **200**. The second set is located between the second and third modules **200**, the third set between the third and fourth modules **200**, the fourth set between the fourth and fifth modules **200**, and the fifth set between the fifth and sixth modules **200**. The sixth set of fans is located between the sixth module **200** and the housing **100** wall. Different numbers of fans are also contemplated by the inventor for the purpose of providing module cooling. Six sections of the housing **100** are hollowed out so that the rear side connections of

modules **200** are exposed. At the rear of each module, the 10-pin signal connector **210** and positive **211** and negative **212** connectors are visible.

[0073] Turning to **Fig. 13**, there is shown a perspective view of a preferred embodiment **10**, showing the back of housing **100**. From this view, it is clearly shown that the positive **211** and negative **212** battery terminals protrude from the back surface **103** of housing **100**. It is important to understand the purpose of having these connections **211**, **212** protrude while signal connector **210** is recessed. It is necessary to make sure the high current battery terminals **211**, **212** are mated before the battery module **200** is “enabled” during the insertion process. “Enablement” occurs when the 10-pin signal connector **210** goes through a series of interlocks with the bus (not shown). If the module **200** is “enabled” before it is physically connected to the bus and the bus voltage and battery voltage differ, then at the moment the terminals **211**, **212** mate, there will be instantaneous high current to equalize the potentials. The purpose of the mechanism is to ensure the high current connector is mated before enabling the battery module **200** and disabling the battery module **200** before it is disconnected for safety, notably to prevent arcing which can damage electrical connectors.

[0074] For these reasons, the signal connector **210** is the last connector to mate during module **200** insertion and the first connector to disengage during module **200** removal. This method requires the pins in the 10-pin connector **210** to be substantially shorter than the battery terminals **211**, **212**, so that during the removal process, the 10-pin connector will disconnect while the battery terminals **211**, **212** are still connected. At this point in the process, the module **200** will detect that it is no longer connected to housing **100** via the 10-pin connector **210**, and shut itself off instantaneously before the battery terminals **211**, **212** are disconnected.

[0075] Turning to **Fig. 14**, there is shown a rear view of battery module **200**. The protective case **204** of battery module **200** is preferably constructed of aluminum or another lightweight material with similar properties. The bottom sheath **202'** is hollowed out for the 10-pin connector **210** and battery terminals **211**, **212**. Each module **200** has a microcontroller and is able to connect to a CAN bus using its 10-pin connector **210**.

[0076] Turning to **Figure 15**, there is shown a sectional front view of battery module **200**. The top sheath **203** is hollowed out for the display panel **225** and the carry handle **205**. Display panel **225** is illuminated using LEDs and has a button **221** with a status bar **222** and a fault bar **223**. A user can press button **221** to “wake” the display from sleep mode. A coded push can be used for diagnostics. If the status bar **222** lights up blue, the module **200** is operating normally. If the fault bar **223** lights up red, there is a fault with module **200**. There are five bars **223** that light up green and indicate the battery charge level of module **200**. The five bars **223** will show charge status in increments of 20% of charge ranging from 0%, to 100% based on the number of LEDs illuminated. For example, one bar indicates that the charge is very low (around 20%) and five bars indicates the module **200** is fully charged (100%).

Electrical Design of Battery Cell Network and Battery Module

[0077] Turning to **Fig. 16**, there is shown a perspective view of the interior of module **200**. Each battery cell **1710** is wire bonded to a printed circuit board (PCB) **1722**. Located between the battery cells **1710** and the PCB **1722** is a top plastic battery tray **1720a** and a thermally conductive glue **1721** or other adhesive. Plastic battery trays **1720a**, **1720b** are placed directly on top of and below the battery cells **1710**. The thermally conductive glue **1721** is used between battery trays **1720a**,

1720b and the PCB **1722**. The thermally conductive glue **1721** is also an electrical insulator.

[0078] Turning to **Fig. 17**, there is shown a top interior view of module **200**. Each battery cell **1710** is wire bonded to a printed circuit board (PCB) **1722**. There are three wires **1725a**, **1725b**, **1725c** bonded to pads on the PCB **1722** for each battery cell **1710**. Two of the wires **1725a**, **1725b** are negative and one of the wires **1725c** is positive. The purpose of two negative wires is for redundancy. The preferred embodiment contains 184 LFP battery cells. The battery cells **1710** can be divided into groups of 23 cells called “banks.” The BSS can monitor voltage, temperature, and state of charge for banks but cannot monitor individual battery cells **1710**. Alternate embodiments may contain variations of the arrangement or numbers of battery cells **1710**.

[0079] Turning to **Fig. 18**, there is shown a cross sectional view of a single battery cell **1710**. As previously mentioned, the battery cells **1710** and other components are surrounded by a protective enclosure **204**, preferably constructed of aluminum. Directly above battery cell **1710**, there is a plastic battery tray **1720a**. The thermally conductive adhesive **1721a** is used between the top of battery cell **1710** and top battery tray **1720a**. Similarly, the same thermally conductive adhesive **1721b** is applied between the top battery tray **1720a** and the PCB **1722**. It is clearly shown that positive wire **1725c** and two negative wires **1725a**, **1725b** are wire bonded to the top of PCB **1722**. Turning to the bottom of **Fig. 18**, the thermally conductive adhesive **1721c** is applied between the bottom of battery cell **1710** and bottom battery tray **1720b**. Furthermore, a thermally gap filling material **1726** is used between the bottom of battery cell **1710** and the bottom of protective enclosure **204**. The gap filling material

1726 allows heat to be transferred from the battery cells to the enclosure **204** so it can dissipate from the module **200**.

[0080] Turning back to **Fig. 17**, each module **200** has an integrated battery supervisor system (BSS). The BSS **1700** monitors the health to include cell voltage, current, and temperature. Each module **200** is composed of a plurality of battery cells **1710** connected in series and parallel via wire bonding and ultimately terminating into an integrated BSS **1700**. The wire bonding will be completed using a method similar to the Tesla ultrasonic friction welding method. The holes shown are used to wire bond the battery cells **1710** to the PCB **1722**. In each hole, tiny wires **1725a**, **1725b**, **1725c** will be bonded to both the PCB **1722** and the battery cell **1710**. The PCB **1722** is then used to directly transfer the electric current through the interior of the battery module **200**. The use of the PCB **1722** prevents the entire battery module **200** from failing if one battery cell **1710** malfunctions because the other cells are still connected to the plate.

[0081] **200200**The preferred embodiment of the BSS **1700** uses real-time battery cell information and compares this information to a set of reference values. It uses this comparison to determine abnormalities in individual battery cells and in the plurality of cells to diagnose the problem. The diagnostic information can be transmitted externally using a communication unit. The BSS**1700** will also use this real-time data to prevent any issues during the battery operation by disconnecting the battery from the housing rack **100** electronically if it senses a problem.

[0082] During charging, the BSS **1700** monitors the depth of discharge for each bank of 23 cells, compensates for voltage temperature differences, and ensures battery banks are properly balanced. If one battery cell has slightly more or slightly less capacity than the rest of the batteries, then its level of discharge will deviate from

the other batteries over several charge and discharge cycles. The BSS **1700** must balance the batteries to prevent over-discharge as well as over-charge, which causes damage and eventually complete battery module failure and can present a safety risk.

Charge Management Systems Integration

[0083] Fig. **19** is a schematic diagram where the six battery modules **200a-f** are connected in parallel to the housing rack **100**. At any particular point in time, each battery module **200** may have a different state of charge, particularly as the module charges are drained through use in powering the forklift. The “state of charge” is defined as the percentage charge the module **200** currently has. Each module **200** may be at a different initial voltage due to differences in battery life or initial charge levels. Each module **200** may also have a different max voltage when they are “fully charged,” considering differences in age and usage of particular modules **200**. For example, module **200a** may have a voltage of 24.0 V when fully charged while module **200f** may have a voltage of 23.9 V when fully charged.

[0084] It is necessary for a Battery Operating System Supervisor (BOSS) module processor (“BOSS module”) **901** to serve as a battery management system for the modules **200a-f**. But for the control of BOSS module **901**, in such scenarios where the voltage in one module exceeds the others, the lower voltage battery modules would draw a current flow from the higher voltage modules into the lower voltage modules that would be only limited by resistance of the connectors, cells, bus bars, and bond wires. A large difference in voltage would cause high current flow to the battery module with lower voltage. These situations are undesirable because the current flow to the motor is reduced as current flows between battery modules, rather than out of the housing **100**. If a high current is maintained for an extended period of time, or the voltage discrepancy is high enough such as to produce a current higher

than the handling capability of the bond wires, it can also lead to battery failure by draining the battery rapidly or opening the bond wires.

[0085] Turning back to **Fig. 19**, there are a total of three bus bars which the modules **200** connect to. The negative terminals **212** of the modules **200** will either connect to the 0 V (ground) bus bar or the 24 V bus bar, depending on the grouping. Half of the modules **200** negative terminals **212** will connect to the 0 V bus bar and the other half will connect to the 24 V bus bar. The positive terminals **211** of the modules **200** will connect to the 48 V bus bar. As previously described, the Boss module **901** grants permissions to battery modules **200** to determine which are connected to the bus bars and which modules **200** are disconnected, by sending signals to the modules **200**. Modules **200** then use MOSFET switches to connect and disconnect.

[0086] It should be understood that module **200c** is used here only as an example and that each module **200** is wired and employed in the same manner. Communication between the BOSS module **901** and the modules **200** is best understood by describing the low voltage ten-pin connection **210**, (actual connector **210** shown in **Fig. 14**) depicted schematically in **Fig. 19**. Four of the pins are “isolated” and five pins are “non-isolated,” with one spare pin not currently utilized but may be employed later. The term “pin” is also used here when describing the wires corresponding to their respective pins in wire harnesses **904** and **909**. The isolated pins are grouped as part of an isolated wire harness **904**. It will be understood by those of ordinary skill in the art that “isolated” refers to galvanic isolation. Transformers are used to separate the isolated wire harness **904** from the main power supply. If an electrical short occurs in the isolated wire harness **904**, there is no risk of damage to the rest of the circuits in the system. The isolated wire harness **904** is depicted as the upper dashed line connected to module **200c**. Isolated wire harness **904** also

connects to the vehicle bus **920**. The vehicle bus **920** is the communication network depicted by the multiple dashed lines. When a module **200c** is inserted into a “slot” in housing **100**, the isolated 5 V pin **905** connects to it and signals the BOSS module **901**. There are two pins **905**, **906** for communication between module **200c** and BOSS module **901**. There is a CAN HI pin **906** and a CAN LO pin **907**. Lastly, there is a ground **908** pin on isolated wire harness **904**.

[0087] The non-isolated pins are grouped as part of a non-isolated wire harness **909**. When module **200c** is inserted in housing **100**, the identification (ID) pin **910** connects to the BOSS module **901** in order to assign CAN addresses in the housing **100** (identify the slot position of the module **200c** within housing **100**). The interlock pin **911** loops through the physical latch (not shown) in the slot where module **200c** connects so that the BOSS module knows that module **200c** is connected. There is also a pin **912** for controlling fan power, a pin **913** for controlling fan speed, and a module ground pin **914**. Battery module **200c** (and all battery modules) is responsible for controlling its own fan speed and fan power. When module **200c** is inserted and the latch closes, the interlock pin **911** is shorted with module ground pin **914**. Once this occurs, the BOSS module **901** can then grant permissions to module **200c** to connect to the bus bars.

[0088] An example of the importance of BOSS module **901** can be understood during continuous operation of a forklift and replacement of modules **200**. While the forklift is operating, the process of inserting a fully charged module **200** is known as “hot swapping.” Looking at **Fig. 19**, module **200c** is fully charged and was inserted while modules **200a-200f** were already connected. BOSS module **901** will not grant permission for module **200c** to immediately connect to the bus bars. Module **200c** will wait until there is a low demand on the other modules **200** before connecting to

the bus bars. Low demand refers to a time when the forklift does not require a lot of current. For example, a forklift carrying a load and driving up a hill would require a lot of current. When the forklift is idle, the current demanded will be low and this would be an appropriate time for module **200c** to connect. ~~a threshold~~ The BOSS module **901** does not control the disconnection and connection of modules **200** from the bus bars. BOSS module **901** only grants permissions to the modules **200** for the conditions when they are able to connect and disconnect. Each module **200** uses internal MOSFET switches **903a-f** to rapidly open and close the circuit connections from the modules **200** to the bus bars. Once a fully charged module **200c** is connected, a module **200** at a lower state of charge can disconnect. For example, if module **200f** is at 60% and the other modules **200** are above 80%, module **200f** will disconnect and only reconnect once the other states of charge decrease to about 60%. **200**.

[0089] For at least these reasons, BOSS module **901** in housing **100**, to the extent networked, is designed to monitor the states of charge in each module **200** and will grant permission for a module **200** that varies by more than some threshold to disconnect. This allows the forklift to continue operating without hindering to performance. The specific 24 V battery modules are used in preferred embodiments, but alternative embodiments can use various voltages depending on the needs of the particular lift truck.

[0090] **200**Another important feature of the system can be described in a case when there is an empty housing and the system is completely turned off. When the modules **200** are unplugged from housing rack **100**, they automatically turn off. With an empty housing **100**, when module **200a** is inserted, the BOSS module **901** will not power on by itself. For this reason, preferred embodiment **10** has a continuously hot separate 5 V control connector **905**. When module **200a** is inserted, it connects to

control connector **905** which powers up the BOSS module **901**. This process occurs on a 5 V bus, separate from the vehicle bus **920**. Since the current is so low on the 5 V bus, there is no risk of arcing. **200** Although the aforementioned figures depict a housing rack **100** with one side, preferred embodiments will be two sided with six modules **200** on each side for a total of 12 modules **200**. In the preferred embodiment, six battery modules **200** are connected in parallel in each housing **100** to attain a higher current capacity at a constant voltage. Alternative embodiments may employ any number of battery modules.

Alternative Embodiments

[0091] The following sections describe alternative embodiments of the disclosed system.

Lithium-Ion Battery Module System Design

[0092] **Fig. 21** provides an elevation view of the rechargeable battery assembly **220** of the alternative embodiment, separate from forklift **130**. The rechargeable battery assembly **220** has eight removable and interchangeable battery modules **330a-330h**, which are operatively inserted in one of the eight identical module bays **301a-301h** defined within an outer housing **300**. The housing **300** makes up the outer surfaces of the larger battery assembly **220**, and the overall height (“**H**”, as labeled in **Fig. 21**), depth (“**D**”, as also labeled in **Fig. 3**) and width (i.e., the dimension perpendicular to the sheet of **Fig. 3**; width not being labeled in **Fig. 21**) of the assembly **220** is about the same as the height, width and depth of lead acid batteries **160** (shown in **Fig. 2**) that are of a size suitable for intended use in forklift **130**.

[0093] The alternative embodiment has the form of a unitary housing rack **300** with a capacity of receiving and managing eight removable battery modules **330**, each of which is interchangeable with the others. **Fig. 21** only shows four modules because

the alternative embodiment has two symmetrical arrangements of four modules aligned back-to-back. This is so that the handles are exposed to the openings of the detachable panel on the forklift **136** on both sides. This also simplifies the connection point in the housing rack to only one location. The housing rack **300** of serves multiple purposes and benefits. In addition to housing the battery modules **330** within the forklift **100**, the rack can be removed, and used as a charging station, typically a floor-standing charging station. The housing rack **300** in the alternative embodiment is constructed of a metal. Particularly in preferred embodiments, housing rack **300** will be constructed of steel which provides durability. In addition to providing durability, having housing rack **300** constructed of steel adds weight that helps to prevent housing rack **300** from tipping when one or more battery modules **330** are removed, particularly when housing rack **300** is used as a charging station. Other materials are contemplated including, but not limited to, composites and polymers.

[0094] In addition to having dimensions that are forklift-battery-sized, as previously explained, the lowermost surface **304** of housing rack **300** is preferably weighted by the addition of a heavyweight material affixed thereto, preferably in the form of steel plates resting thereon but within the enclosure of housing **300**. The added weight of those steel plates increases the weight of the overall assembly **220**, so that it weighs more than the minimum battery weight specified by the manufacturer of forklift **130**, while still enabling the lightweight characteristic of removable modules **330**, which each weigh less than fifty-one pounds. It will be evident to those skilled in the art that this counterweight will consist of a heavyweight material, such as a high-density steel, and may be composed of multiple plates or sections to allow the user to manipulate the center of gravity **161** to maximize the safe lifting capabilities of the forklift. Alternate embodiments may include, but are not limited to, different locations

of an adjustable counterweight, such as on top of the housing rack, or the multiple variations of the material of the housing rack and counterweight. The housing rack **300** may be designed in such a manner so that the rack itself can be replaced by a housing rack **220** of different material to adjust the counterweight.

[0095] It is contemplated that the minimum battery weight requirements will be satisfied by a housing rack **300** and counterweight with less than a complete arrangement of battery modules **330**. This is to allow for the user to still safely operate the forklift **100** in the event that there are not enough battery modules with enough charge. Alternative embodiments will be able to meet weight requirements with 6-7 modules. Other alternative embodiments will ideally meet minimum weight requirements with somewhere between 1 and 3 batteries **330** short of a complete arrangement.

[0096] Combined with the moderate weight of the housing rack **300**, alternative embodiments weigh substantially less than a conventional lead-acid battery. Even in situations where the housing rack **300** has an incomplete arrangement of battery modules **330**, the modules will still weigh less than 51 pounds. Each battery module **330** or “pack” is equipped a handle **335**, at the rear of the module. The handle **335** will be designed to ensure easy gripping and for safe movement of the module. The design of the handle and functional method for removal and installation of the modules **330** will be discussed in more detail in subsequent sections.

[0097] Alternative embodiments include other adaptations to enable and ensure safe removal of both the battery modules and the housing rack **300** from the forklift **130**. Preferably, there is a module release button **333** on the back of each battery module **330** that will ensure safe disengagement of the module **330** from the housing rack **300**, safe release being considered from a mechanical perspective. Electrical

disengagement will occur with an interlock pin configuration. This button will be described in more detail in the following section, "Housing Rack and Battery Module Interface Design." The front of the battery module will also have an indicator that will show if the battery is actively engaged or has been switched off. It will be evident to those skilled in the art that this indicator may take on a variety of alternate embodiments including, but not limited to, a small led indicator, a light that illuminates as a part of the button **333**, or a LCD display panel on the front of the battery pack that also displays other indicators about the health of the battery. In this alternative embodiment, the LCD display panel will display indicators used to monitor battery health including but not limited to voltage, temperature, and remaining battery usage time.

[0098] **Fig. 21** includes another important safety feature. There is an eyehook **226** located within a boss **225** at the top of the housing rack assembly **300**. The alternative embodiment of the housing rack **300** will include eyehooks **226** at both ends of the housing rack for easy removal or installation of the rack into the forklift battery compartment. It will be evident to those skilled in the art that the structure of this boss **225** and eyehook **226** will mimic the existing eyehooks **125** and safe removal mechanisms currently used in the design of the conventional lead-acid battery **160** to ensure complete backwards compatibility. This may differ in shape from the representation in Fig. 21. Alternate embodiments may utilize different methods for the removal of the housing rack **300** from the forklift **130**, but will be utilized so that the removal is conducted in a safe and convenient manner.

[0099] **Fig. 22** shows a rear view of one half of the housing rack **300**, so that the battery pack connection points are visible. The location of this viewing plane is shown as section 4-4 in **Fig. 23**. There is another eyehook **226** at the top of the rear

of the housing rack **300**. Located at the rear of the battery pack **330**, the six-pin male connector **400** and the positive **401** and negative **402** battery terminals are the only wired connection points for engaging and disengaging the module. Within each module **330** is a plurality of lithium-ion battery cells. It will be understood by those of ordinary skill in the art that other connectors with various numbers of pins may be implemented. The outer casing of the battery module **330** is constructed of a hard, lightweight metal. Other materials are contemplated including, but not limited to, alloys, composites, and polymers.

[00100] **Fig. 23** is an isometric view of the alternative embodiment of the housing rack **300**. The alternative embodiment will have eight (four shown here) battery modules **330** arranged back-to-back in two stacks of four. When installed in housing **300**, each module **330** sits on top of low friction slides **310** that allow for the smooth motion of the modules **330** into and out of the corresponding bay **307** in the housing **300** for assembly. Also, the features previously described on the module are included in this view. The front of each module has a handle **335** and the back has a button **333** for removal. The button on the rack will release the unit to be pulled from the rack. The pack will rely on a pin interlock (first to connect, last to break) to turn power on/off to the high current terminals. The latch is meant to keep the battery in place so that the contacts do not become loose. At the rear of each module the 6-pin connector **400** and positive **401** and negative **402** connectors are visible. Additionally, the eyehooks **226** and bosses **225** are visible at the front and rear of the housing rack **300**.

Battery Module Design

[00101] **Fig. 24A** and **24B** are isometric views of the battery module **330** showing the individual battery module and the frictionless slide **310**. **Fig. 24A** depicts the front of the alternative embodiment of the module **330** with both the disengagement button

333 and handle **335** visible. As previously mentioned, the handle **335** will be used to safely carry and remove the module **330**. As clear from **Fig. 24A**, the alternative embodiment uses a handle bolted on behind the face of the module **330**. It will be evident to those skilled in the art that the handle will be located to ensure easy lifting and gripping and relative dimensions and location may vary from those shown in **Fig. 24A**. The handle **335** is designed to carry the weight of the entire module.

[00102] The handle **335** allows the user to move the module **330** in the housing rack **300** in a fashion similar to a drawer and is constructed of a hard, lightweight metal. Other materials are contemplated including, but not limited to, alloys, composites, and polymers. Alternate embodiments are contemplated that could include a handle at the rear or handles on the side of the individual modules **330**. Each of these handles will be fashioned in a manner to the battery module **330** to allow for the easy gripping and for safe movement of the module. It will be evident to those skilled in the art that handles added to module of the alternative embodiment may have hinges to lie flat with the surface, so that they will not interfere with the battery connection points or movement in and out of the battery rack **300**.

[00103] **Fig. 24B** depicts the rear of the battery module. The six-pin connector **400** is wired directly to a BSS that is used to monitor battery health. Finally, the positive **401** and negative **402** terminals are connected to the same plurality of battery cells. The positive **401** and negative **402** terminals connect to the housing rack **300** through the use of a quick release connection. The requirements for this quick release connection are that they are able to: maintain performance through a high number of cycles, blindly connect the battery module **330** and the housing rack **300**, and safely transfer current from the module **330** to the housing rack **300** through multiple contact points. The alternative embodiment makes use of a spring biased connection that that

allows each battery terminal **401** and **402** to slide into the corresponding socket when the battery module **330** is connected. Other alternative embodiments may make use of a similar quick connections that allow for blind sliding connecting and disconnecting.

[00104] Due to the nature of utilizing multiple battery modules **330** in a larger housing rack **300**, the removal and installation of modules into the rack is an important aspect of this design. The alternative embodiment has low friction slides **310** located below each battery pack. Alternative embodiments may use other methods to achieve this sliding motion to position the modules **330** in the housing rack **300**, such as the use of rollers or ball bearings to facilitate removal and installation.

[00105] In such an alternative embodiment, the module **330** slides on cylindrical rollers with roller bearings and is guided by a track on each side of the module, in the same location as the frictionless slide **310**. The rollers and roller bearings would be constructed of lightweight metal in the embodiment. Alternative embodiments may employ various types of roller bearings and rollers constructed of different materials besides metal. It is contemplated that every embodiment of the design will include some method to prevent the module from moving uncontrollably out of the assembly.

[00106] It is contemplated that the alternative embodiment of battery module removal will accomplish two things: have a mechanism to prevent the battery from being removed in an uncontrolled manner, and not add an excessive number of additional moving parts to the battery module design. The alternative embodiment, in **Fig. 24A**, includes two stops **603** and **604** located on either side of the module connected to the housing rack **300**. There are also two tabs on either side of the module **605** and **606**. The stops **603** and **604** are meant to catch the battery tabs **603** and **604** along the rear of the sides of the module to prevent the battery from sliding out unexpectedly. The motion of the battery module **330** during removal in the

alternative embodiment is shown in the **Fig. 24A** as the dashed section **607**. The module **330** will be removed from the housing rack assembly **300** by gripping the handle **335** at the front of the module and sliding the case forward in the direction of arrow **608**. The module will slide along the low friction slides **310**, until the battery tabs **605** and **606** come into contact with the stops **603** and **604** on the housing rack assembly **300**. The module **330** must then be lifted over the stops **603** and **604** to be completely removed in the direction of arrow **609**. The installation motion, in this alternative embodiment will require the exact reverse order of steps for removal.

[00107] Other alternative embodiments of this design may include, but are not limited to, a stop that allows the battery module **330** to pivot and rotate 90° downward so the battery can be lifted off a pivot rod by a handle at the rear of the module. Furthermore, the pivot rod is preferably connected to rotational dampeners positioned on either side of housing rack **300**. These rotational dampeners will slow the rotation of the battery module **330** to its vertical lift-out orientation during removal which decreases the chance of damage to the battery module **330** or the housing rack **300**. Alternate embodiments contemplated may include detents or latches on the exterior of the battery, but they will be implemented so as not to fail before the life of battery has ended.

Electrical Design of Battery Cell Network and Battery Module

[00108] **Fig. 25A** and **25B** show an isometric view of the top and bottom of the battery module **330**, respectively. Each battery pack **330** is composed of a plurality of battery cells connected in series and parallel via wire bonding to and ultimately terminating into an integrated BSS **700**. The wire bonding will be completed using a method similar to the Tesla ultrasonic friction welding method. Although wire bonding has been widely used in other contexts such as with integrated circuits and discrete

electronics, the battery industry has incorporated wire bonding that allows for bonding larger gauge wires than has previously been done. Both figures show a plurality of battery plates **701-709**. The holes shown in each plate are used to wire bond the battery cells to the plates. In each hole a tiny wire will be bonded to both the plate and the battery cell. The plates are then used to directly transfer the electric current through the interior of the battery module **330**. The use of the plates prevents the entire battery module **330** from failing if one battery cell malfunctions because the other cells are still connected to the plate.

[00109] The plurality of cells is connected by the arrangement of plates **701-709** as shown in **Fig. 25A** and **25B**. There are four plates (**702, 704, 706, and 708**) located at the top of the interior of the battery module and five plates (**701, 703, 705, 707, and 709**) located at the bottom of the interior of the battery module.

[00110] Each plate alternates between positive battery cell arrangements and negative battery cell arrangements. For plates **702-708**, this is roughly half of the geometric area of the space. In the alternative embodiment, each of these interior plates is in contact with 50 battery cells, with one half being a negative contact and the other half being a positive contact, and the most negative and most positive plates are in contact with 25 cells each. Plates **701** and **709** are only in contact with 25 cells as they are only in contact with the positive (**701**) or negative (**709**) ends of the battery cells. These plates are also directly connected to the battery terminals or the BSS. Plate **701** is connected to the BSS, which is then connected to the positive terminal **401**. Plate **709** is connected to the negative terminal **402**. The alternative embodiment contains 200 LFP battery cells. Alternate embodiments may contain variations of the arrangement or numbers of battery cells. This also implies that the plates in alternate

embodiments could have different numbers, arrangements, or geometry than the alternative embodiment.

[00111] The flow of current through the battery cells alternates between the top and bottom of the module **330** as it works its way around the module **330** interior. The current flows from the positive terminal **401** to plate **701**, located on the bottom of the battery module (**Fig. 25B**). Plate **701** is positively charged and in contact with only the positive end of the 25 battery cells above it. The negative ends of these battery cells are in contact with the negative portion of plate **702**, located at the top of the battery module (**Fig. 25A**). The negative portion of plate **702** is shown by the dashed section **702a**. The other half of plate **702**, **702b**, is in contact with the positive end of the 25 cells beneath it. The plate has contact with 25 negative battery cell ends, in **702a**, and 25 positive cell ends, in **702b**. Subsequently, the negative end of the battery cells for plate **703** are the same cells that have a positive connection with the **702b** portion of plate **702**. These cells have a negative connection to plate **703**. The other half of plate **703** lies in the region of **704a**. This region contains the positive contacts with the battery cells. Region **704b** of plate **704** continues the pattern and has a negative connection to plate **705**. The contacts here on plate **705** are negative. The other half of plate **705** is positively connected and the cells also have a negative connection with plate **706** in region **706a**. The region **706b** is positively connected on the top and on the bottom, is negatively connected to plate **707**. The other half of the plate is positively connected and has a negative connection with **708a**. The current passes through the positive connections in **708b**. By the time the current reaches the negative plate **709**, and a negative voltage flows from the negative terminal **402**.

[00112] The integrated BSS **700** monitors the health of the module **330** including cell voltage, current, and temperature. With respect to monitoring, in some

embodiments, for purposes of monitoring the status of the battery modules **330**, a display having multiple LED lights may be incorporated. For instance, the display may have seven (7) LEDs wherein five (5) of the LEDs show charge status in increments of 20% of charge ranging from 0% to 100%, based on the number of LEDs illuminated. The other two (2) LEDs may show status and trouble codes based on the color of illumination and/or by a series or pattern of blinking of the LEDs, wherein different blinking series or patterns relate to particular trouble codes. Furthermore, each display may incorporate a push button that may be used to query the status of the particular battery module **330**, and also can be used to troubleshoot the battery module **330** by the number of presses of the button or by the duration of a button press. Each view (**Fig. 25A-25B**) shows a flex cable **710** wired along from the BSS **700** and the six-pin connector **400** to each of the sections of battery cells. The flex cable **710** will be used to wire all diagnostic instrumentation in the alternative embodiment to measure temperature, current, and voltage. Additionally, each module **330** will contain an arrangement of field-effect transistors (FETs) **711** in series with the battery cells to ensure the proper power handling. These switches are the aspect of the alternative embodiment that allow the module to be removed from the housing rack **300**, as well as function as an active and resettable fuse element. The number of FETs **711** is based on the power capacity of the plurality of cells, and when removing the module **330** from the housing rack **300**, they disable the power to the terminals. One alternative embodiment has twenty FETs **711**, but other alternative embodiments of this design with different power capacities will understandably have a different number of FETs or the equivalent.

[00113] An alternative embodiment of the BSS **700** uses real-time battery cell information and compares this information to a set of reference values. It uses this

comparison to determine abnormalities in individual battery cells and in the plurality of cells to diagnose the problem. The diagnostic information can be transmitted externally using a communication unit. The BSS 700 will also use this real-time data to prevent any issues during the battery operation by disconnecting the battery from the housing rack 300 electronically if it senses a problem.

[00114] During charging, the BSS 700 monitors the depth of discharge for each cell, compensates for voltage temperature differences, and ensures battery cells are properly balanced. If one battery cell has slightly more or slightly less capacity than the rest of the batteries, then its level of discharge will deviate from the other batteries over several charge and discharge cycles. The BSS 700 must balance the batteries to prevent over-discharge as well as over-charge deep discharge, which causes damage and eventually complete battery module failure and can present a safety risk.

[00115] The controller area network (CAN) communications protocol is used in the alternative embodiment as the main BSS. A CAN bus has error detection and fault tolerance, but has some significant materials cost and communications overhead. For transmitting information, various communication systems can be implemented. Other alternative embodiments can use industrial transmission interfaces such as serial peripheral interface (SPI), DC-BUS, or local interconnect networks (Lin Bus). The CAN in the alternative embodiment would interface with each BSS and be able to effectively monitor and control the performance of the entire battery housing rack. This prevents battery-to-battery performance issues and uses each module as effectively as possible. This way, the CAN allows the housing rack to interact with the VCU as a single unit rather than allowing each battery module to interact individually with the VCU. Furthermore, an isolated CAN scheme may be implemented that allows for communication with the battery modules in the “top” of the stack of battery modules,

wherein those battery modules may be sitting at a potential that is some voltage higher than those battery modules that are lower in the stack.

Housing Rack and Battery Module Interface Design

[00116] Fig. 26 is a top view schematic diagram of the battery module showing the mechanism for removal and installation in the rack. The battery module 330 is removed by pressing a button 333 on the outside handle. The button 333 is meant to ensure that the module 330 remains in place during operation of the forklift. Pressing the button 333 releases the tension from the spring-loaded male connector 800, ejecting the male connector 800 from the female connector 801, and disconnecting the battery module terminals 401 and 402 from the housing rack terminals 802 and 803. The male connector 800 and the female connector 801 are the first to engage and the last to disengage. In Fig. 26, 800-803, 401, and 402 are symbolic representations for illustration purposes. The alternative embodiment of this portion of the system will be different sizes and more intricate, but accomplish the same task.

[00117] To install a removable battery module 330 within a slot-like bay 307 of the rack 300, the user first manually positions its back face in the opening for the corresponding bay 307 and then manually slides it rearward into that bay. Once the module 330 slides far enough in so that its back face contacts the spring loaded male connector 800, connector 800 begins to compress. After the connector 800 is completely compressed, the module 330 locks in place. It is contemplated that the connector 800 will be constrained from moving along the axis of insertion. The system is spring loaded to achieve pressure contact for the battery module terminals, 401 and 402, to the housing rack terminals, 802 and 803. The male connector 800 pushes a back switch which acts as the on/off mechanism for the system located within the female connector 801.

[00118] Additionally, there is a need to safely disengage the battery module from the housing rack before removing it completely to prevent arcing. Arcing leads to overcurrent and can cause destruction of the battery in the absence of proper safeguards. Particularly, if the battery module **330** is enabled before it is physically connected to the male connector **800**, and the voltage of each differs, then the moment the connectors **800** and **801** physically mate, there will be instantaneous high current to equalize the potentials. The goal is to ensure the high current connector is mated before enabling the battery module **330** and disabling the battery module **330** before it is disconnected. This can be achieved through a plurality of methods. One such method is to use the button **333** next to the handle to send a signal to the processor to disconnect power to the terminal. An alternative method uses a pressure-sensitive switch at the rear of the battery module and only when the battery is fully engaged with the connector will the battery be switched on. The relative dimensions of the switch and the power connectors will be such that the switch will protrude just far enough from the rear of the battery so that it is disengaged before the battery module is completely disconnected.

[00119] Another alternative method is through an electronic signal. As previously mentioned, the battery module will connect to the housing rack with both a pin connector and battery terminals. The electronic signaling method would require the pin connectors to be substantially shorter than the battery terminals, so that during the removal process, the pin connector will disconnect while the battery terminals are still connected. At this point, the battery module will detect that it is no longer connected to housing rack via the pin connector, and shut itself off instantaneously before the

battery terminals are disconnected. It will be understood by those of ordinary skill in the art that mechanisms other than those employed in **Fig. 26**, or described as alternatives, can be employed in alternative embodiments. The purpose of the mechanism is for safety, notably to prevent arcing.

[00120] An additional feature of an alternative embodiment is reflected in the battery module **330** being compatible with prior art chargers used for recharging the conventional battery assemblies **160** (shown in **Fig. 2**) with which forklift **130** is designed to be used. Due in part to Applicant's design of lithium iron phosphate cell modules **330** that can be safely charged by conventional chargers when assembled in modules according to the embodiments, the character and structure of the modules **330** is such that the lithium-ion batteries are able to recharge with chargers currently used and already installed in warehouses that recharge conventional forklift batteries **160**.

Charge Management Systems Integration

[00121] **Fig. 26** is a schematic diagram an alternative embodiment where the eight battery modules **330a-330h** are connected in parallel to the housing rack **300**, which has its own BSS **901**. At any particular point in time, each battery module **330** may have a different voltage, as suggested by the voltage numbers noted in **Fig. 26**, particularly as the module charges are drained through use in powering forklift **130**. Each module may be at a different initial voltage due to differences in battery life or initial charge levels. In the example in **Fig. 26**, a couple of the modules have a fully charged voltage of 36.0 V, while others have lesser voltages as noted.

[00122] But for the control of BSS **901**, in such scenarios where the voltage in one module exceeds the others, the lower voltage battery modules would draw a current flow from the higher voltage modules into the lower voltage modules that would

be only limited by resistance of the connectors, cells, bus bars, and bond wires. A large difference in voltage, will cause high current flow to the battery module with lower voltage. These situations are undesirable because the current flow to the motor is reduced as current flows between battery modules, rather than out of the housing rack. If a high current is maintained for an extended period of time, or the voltage discrepancy is high enough such as to produce a current higher than the handling capability of the bond wires, it can also lead to battery failure by draining the battery rapidly or opening the bond wires.

[00123] For these reasons, the main BSS **901** in the housing rack **300** to the extent networked, is designed to monitor the voltages in each module and will disconnect a module that varies by more than a threshold of 0.10V. This allows the forklift to continue operating without hindering to performance. Specific 36 V battery modules are used as an example as alternative embodiments can use various voltages depending on the needs of the particular lift truck.

[00124] Other alternative embodiments of battery monitoring system architecture are contemplated within the scope of the present invention. In one embodiment, each battery module contains a PC board with a digital isolator and a multi-cell battery stack monitor. Each module has an independent interface connection to a controller board with a microcontroller, a CAN interface, and a galvanic isolation transformer. The microcontroller is able to provide the gateway to the forklift's main CAN bus and coordinate the modules.

[00125] In another alternative embodiment, each multi-cell battery stack monitor (MBSM) is on a PC board within each battery module. The BSS also contains a CAN transceiver and a galvanic isolation transformer. Each module communicates through the MBSM non-isolated SPI-compatible serial interface. This structure requires a 3-

or 4-conductor cable connected between battery modules. Only one microcontroller controls all the battery monitors through the bottom monitor integrated circuit. This microcontroller also serves as the gateway to the forklift's main CAN bus.

[00126] Another contemplated embodiment has no monitoring and control circuitry within any of the battery modules. One PC board has 3 MBSM integrated circuits (for 3 modules), each of which is connected to a battery module. The MBSM devices are able to communicate through non-isolated SPI-compatible serial interfaces. One microcontroller controls all the battery monitors through the SPI-compatible serial interface and is the gateway to the forklift's main CAN bus. Similar to the preceding disclosed embodiments, a CAN transceiver and a galvanic isolation transformer complete the BSS.

Still Other Alternatives

[00127] Although the present invention has been described in terms of the foregoing disclosed embodiments, this description has been provided by way of explanation only, and is not intended to be construed as a limitation of the invention. For instance, despite reference to Class I forklifts as such, it should be understood that some aspects of the invention may have broader application with other types of battery-powered industrial trucks. Indeed, even though the foregoing descriptions refer to numerous components and other embodiments that are presently contemplated, those of ordinary skill in the art will recognize many possible alternatives that have not been expressly referenced or even suggested here. While the foregoing written descriptions should enable one of ordinary skill in the pertinent arts to make and use what are presently considered the best modes of the invention, those of ordinary skill will also understand and appreciate the existence of numerous

variations, combinations, and equivalents of the various aspects of the specific embodiments, methods, and examples referenced herein.

[00128] Hence the drawings and detailed descriptions herein should be considered illustrative, not exhaustive. They do not limit the invention to the particular forms and examples disclosed. To the contrary, the invention includes many further modifications, changes, rearrangements, substitutions, alternatives, design choices, and embodiments apparent to those of ordinary skill in the art, without departing from the spirit and scope of this invention.

[00129] Accordingly, in all respects, it should be understood that the drawings and detailed descriptions herein are to be regarded in an illustrative rather than a restrictive manner, and are not intended to limit the invention to the particular forms and examples disclosed. In any case, all substantially equivalent systems, articles, and methods should be considered within the scope of the invention and, absent express indication otherwise, all structural or functional equivalents are anticipated to remain within the spirit and scope of the presently disclosed systems and methods.

CLAIMS

What is claimed is:

1. A modular rechargeable battery system for use as a replacement of or as an alternative to a conventional lead-acid battery in a battery-powered industrial forklift truck, said modular rechargeable battery system being adapted to power the battery-powered industrial forklift truck, said system comprising:
 - a) a plurality of battery modules, wherein each battery module in said plurality of battery modules includes a positive terminal and a negative terminal and a plurality of lithium-ion battery cells, said plurality of lithium-ion battery cells being electrically united within each respective one of said plurality of battery modules to provide a combined electrical potential between the positive terminal and the negative terminal of each respective one of said plurality of battery modules;
 - b) a housing having a plurality of bays, each of said bays being configured for receiving any one of said plurality of battery modules, said housing being sized and adapted to operatively fit within a battery compartment of the battery-powered industrial forklift truck, wherein each of said plurality of bays includes a pair of power connections for mating connection to the positive terminal and the negative terminal of any one of said plurality of battery modules when said any one is received therein;
 - c) said housing further comprising electrical conductors and external power terminals, said external power terminals being oriented and adapted for operative connection to the electrical power circuitry of a battery-powered industrial forklift truck, and said electrical conductors having a layout for

connecting electric power from the pairs of power connections of the plurality of bays to said external power terminals;

- d) a processor for monitoring the modular rechargeable battery system and for controlling power switches such that operative electrical power is directed through said electrical conductors to said external power terminals, processor being adapted to direct said operative electrical power to said external power terminals when fewer than all of said bays have a corresponding one of said battery modules operatively received therein, whereby the battery-powered industrial forklift truck can be provided with operable electrical power when fewer than all of said bays have battery modules received therein.

2. The modular rechargeable battery system as defined in Claim 1, wherein said housing is sized and adapted to operatively fit with a battery compartment of a Class I forklift, and wherein each said battery module weighs 51 pounds or less.
3. The modular rechargeable battery system as defined in Claim 1 wherein each of said lithium-ion battery cells is interconnected via wire bonding to a printed circuit board (PCB) on a top side of said lithium-ion battery cells.
4. The modular rechargeable battery system as defined in Claim 3 wherein said said wire bonding for each said battery cell comprises a wire bond connected to the positive terminal of the battery cell and one or more wire bonds connected to the rim of the top surface of said battery cell, wherein said rim is electrically integral with the negative terminal of said cell.
5. The modular rechargeable battery system as defined in Claim 1 wherein a thermally conductive gap-filling material is in thermal contact with a bottom surface of said lithium-ion battery cells, wherein said thermally conductive gap-filling material is not electrically conductive.

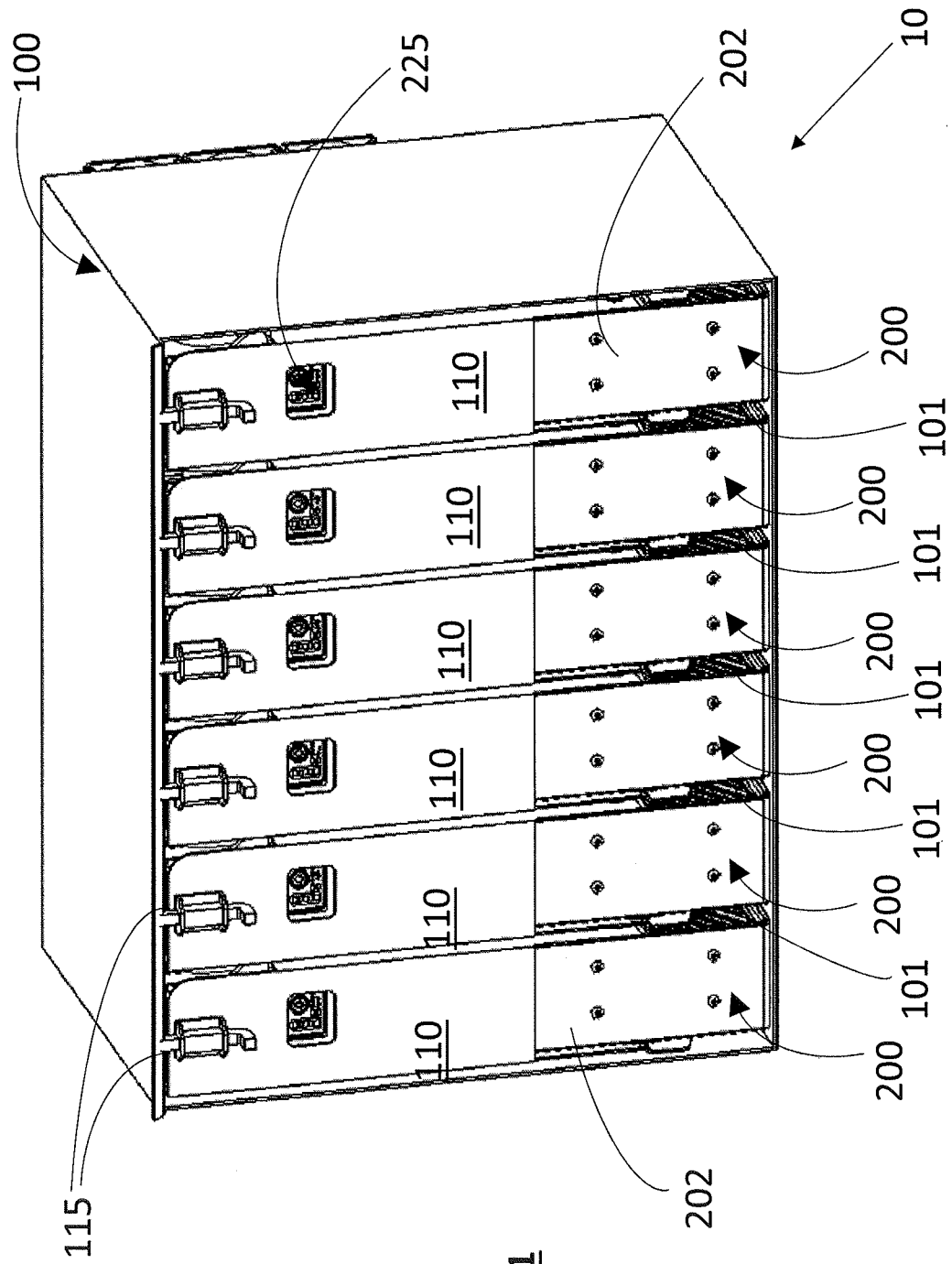
6. The modular rechargeable battery system as defined in Claim 4 wherein each of said battery module bays is further configured such that said one battery module is received within said battery module bay in a vertical orientation.
7. The modular rechargeable battery system as defined in Claim 4 wherein each of said battery module bays is further configured such that said one battery module is received within said battery module bay in a horizontal orientation.
8. The modular rechargeable battery system as defined in Claim 5 wherein each battery module bay is defined by two lateral partitions and a door on the exterior side of said housing, said door having a latch for securing said door in a closed position, said door further having a hinge and a cooperative pin for opening and closing said door.
9. The modular rechargeable battery system as defined in Claim 1 wherein each battery module in said plurality of battery modules is separately rechargeable.
10. The modular rechargeable battery system as defined in Claim 1 further comprising a battery management system, said battery management system comprising a controller area network (CAN) configured to receive and monitor diagnostic information from said plurality of battery modules.
11. The modular rechargeable battery system as defined in Claim 9 wherein said battery management system is further configured to enable and disable one or more battery modules during operation of said modular rechargeable battery system based, at least in part, on said diagnostic information.
12. The modular rechargeable battery system as defined in Claim 1 wherein each said battery module includes a pin connector, a positive battery terminal, and a negative battery terminal.

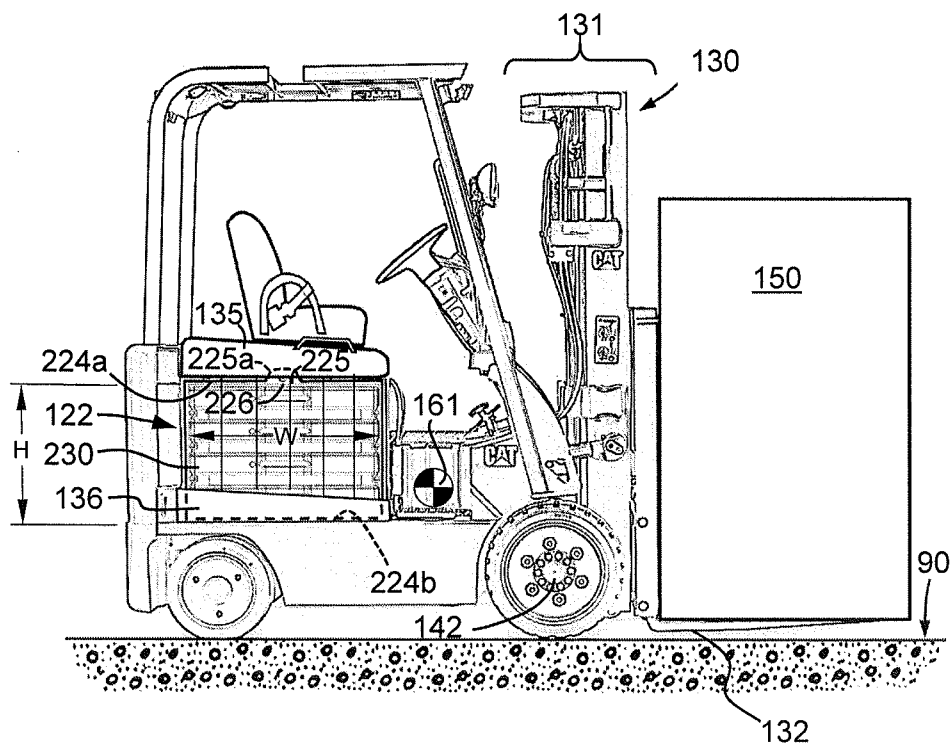
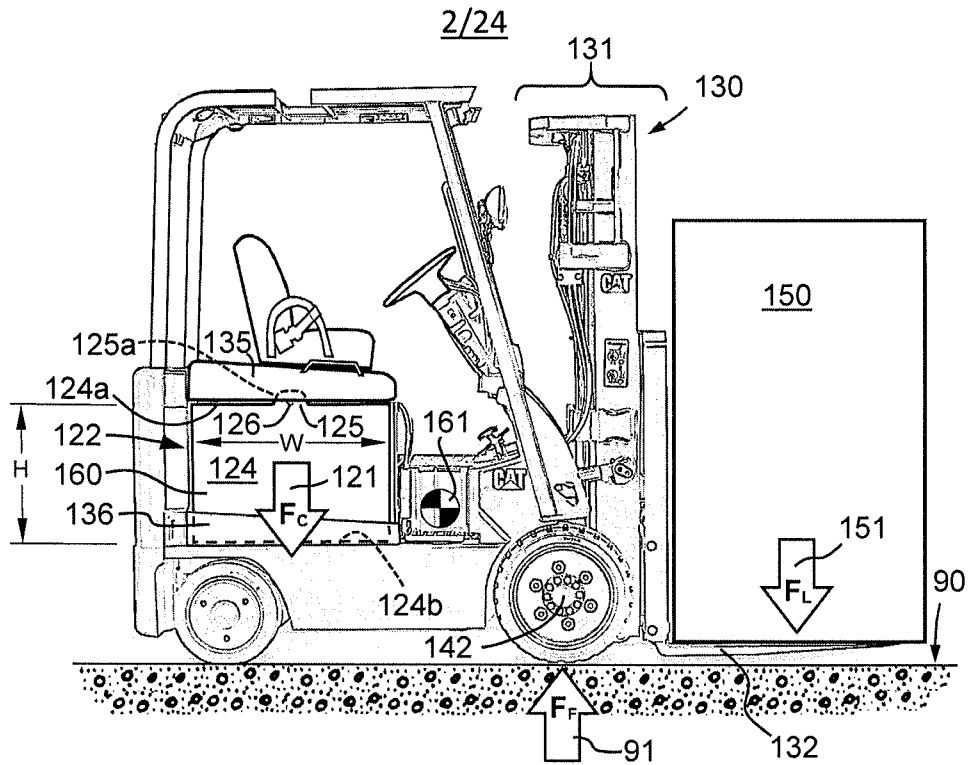
13. The modular rechargeable battery system as defined in Claim 12 wherein said pin connector is recessed from a surface of said battery module relative to said positive and negative battery terminals.
14. The modular rechargeable battery system as defined in Claim 1 wherein said lithium-ion battery cells are lithium iron phosphate (LFP) battery cells.
15. The modular rechargeable battery system as defined in Claim 1 wherein:
 - a) each of said battery modules weighs less than 51 pounds;
 - b) each of said battery modules is separately rechargeable;
 - c) each of said lithium-ion battery cells is interconnected via wire bonding to a printed circuit board (PCB) on one side of said lithium-ion battery cells;
 - d) a thermally conductive material is located between a top side of said lithium-ion battery cell and a top battery tray, between said top battery tray and said PCB, and between a bottom side of battery cell and a bottom battery tray, wherein said thermally conductive gap-filling material is not electrically conductive;
 - e) a thermally conductive gap-filling material is in thermal contact between the bottom surfaces of the battery cells and the module enclosure for enabling heat transfer from the cells to the enclosure for the purpose of thermal management, wherein said thermally conductive gap-filling material is not electrically conductive;
 - f) said housing comprises a plurality of battery module bays, each of said battery module bays being configured to receive one battery module therein, each of said battery module bays being further configured to receive said one battery module in a vertical orientation;
 - g) each said battery module bay is defined by two lateral partitions and a door on the exterior side of said housing, said door having a latch for securing said door

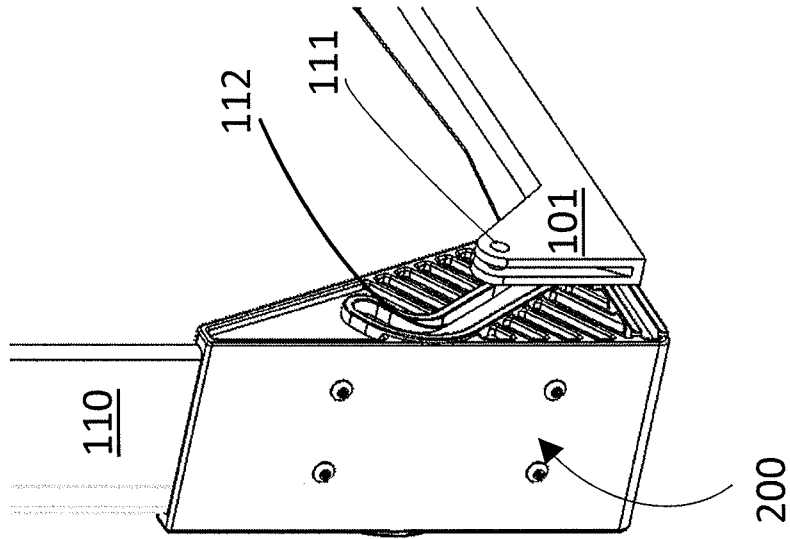
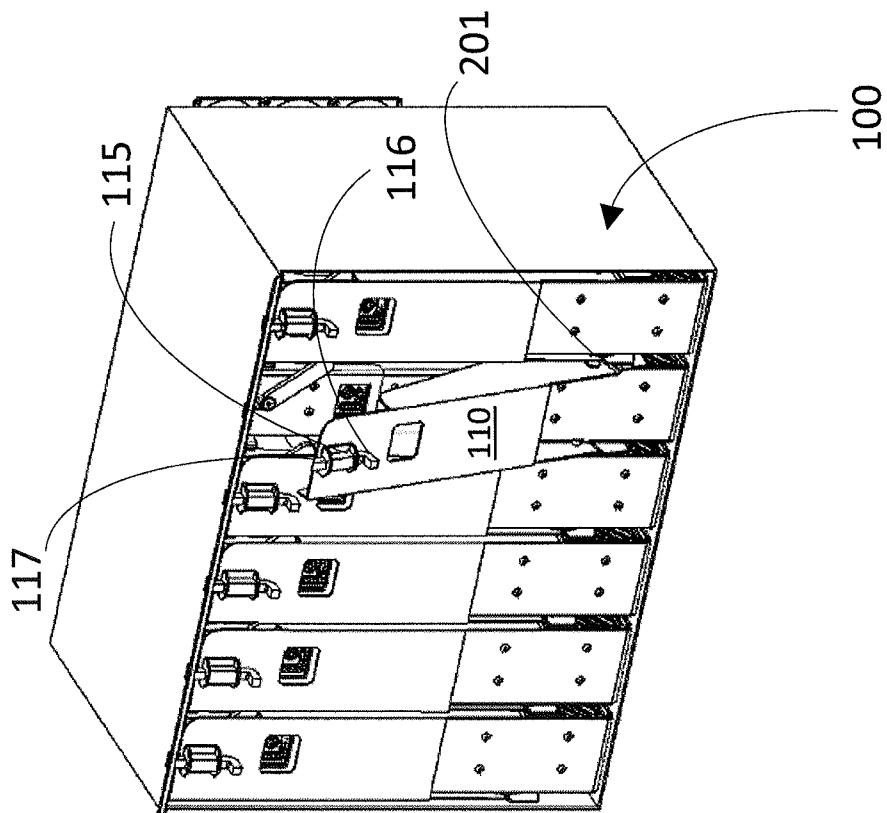
in a closed position, said door further having a hinge and a cooperative pin for opening and closing said door;

- h) a battery management system comprising a controller area network (CAN) is configured to:
- 1) receive and monitor diagnostic information from said plurality of battery modules; and
 - 2) enable and disable one or more battery modules during operation of said modular rechargeable battery system based, at least in part, on said diagnostic information;
- i) each said battery module includes a pin connector, a positive battery terminal, and a negative battery terminal, wherein said pin connector is recessed from a surface of said battery module relative to said positive and negative battery terminal; and
- j) said lithium-ion battery cells are lithium iron phosphate (LFP) battery cells.

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**FIG. 1**



3/24FIG. 4BFIG. 4A

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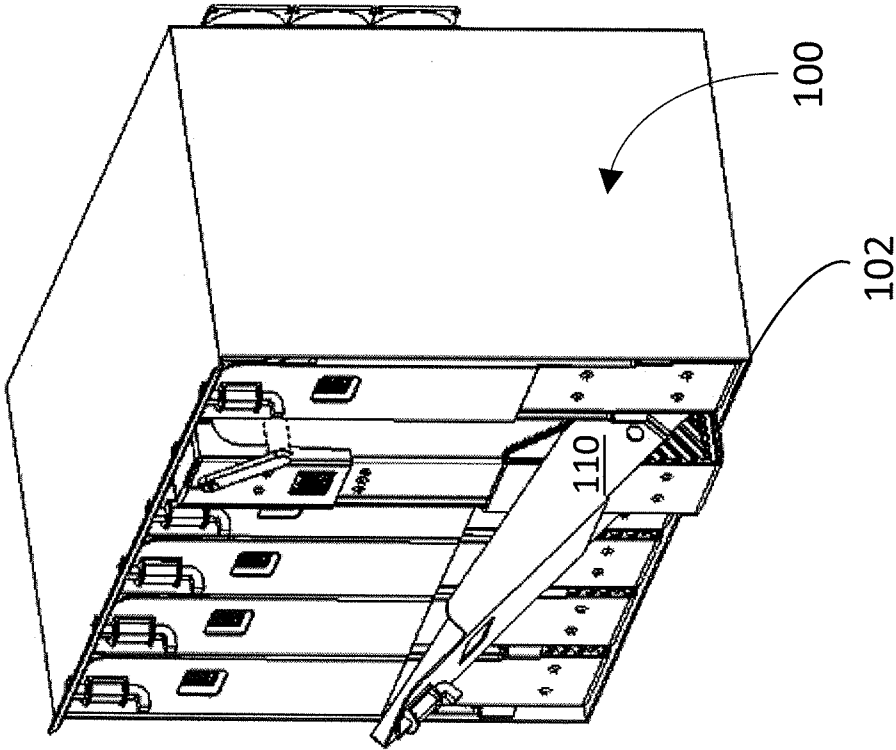


FIG. 5A

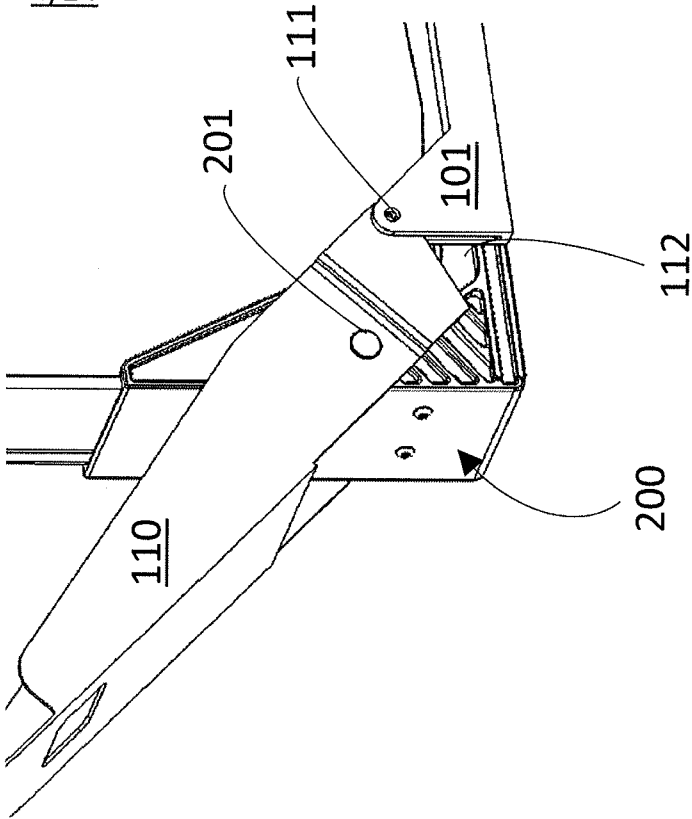


FIG. 5B

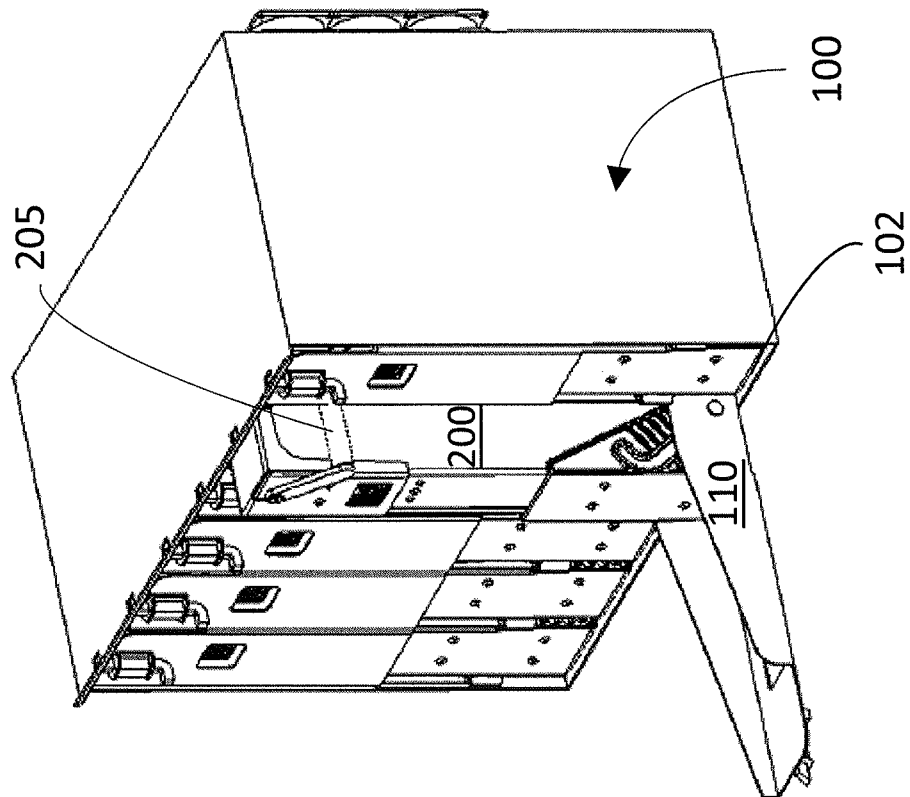


FIG. 6A

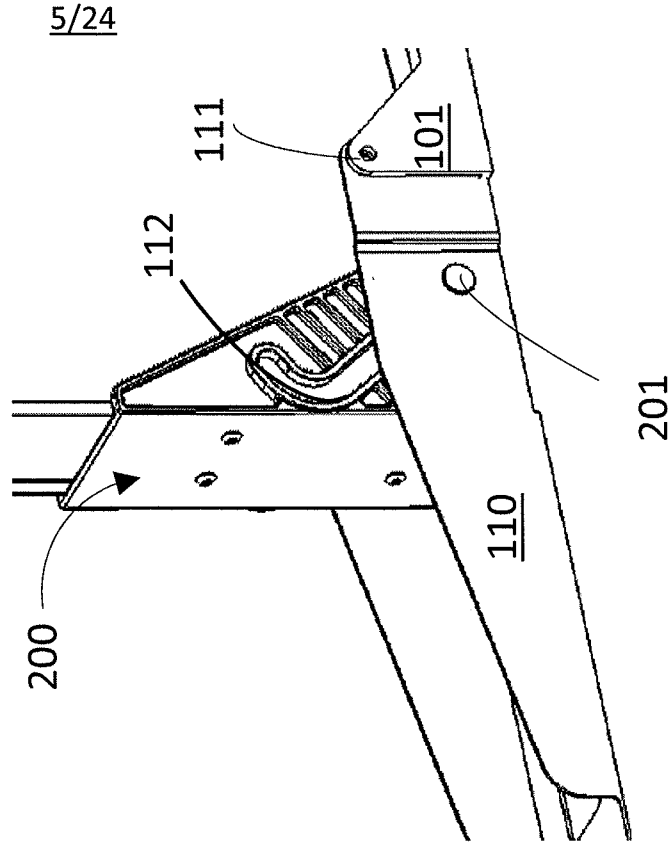


FIG. 6B

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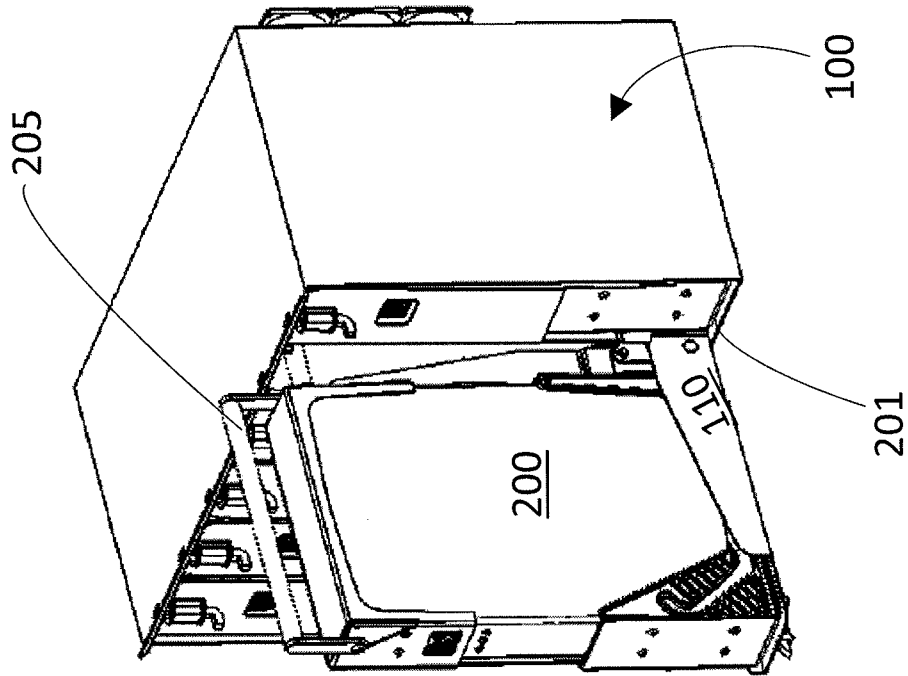


FIG. 7B

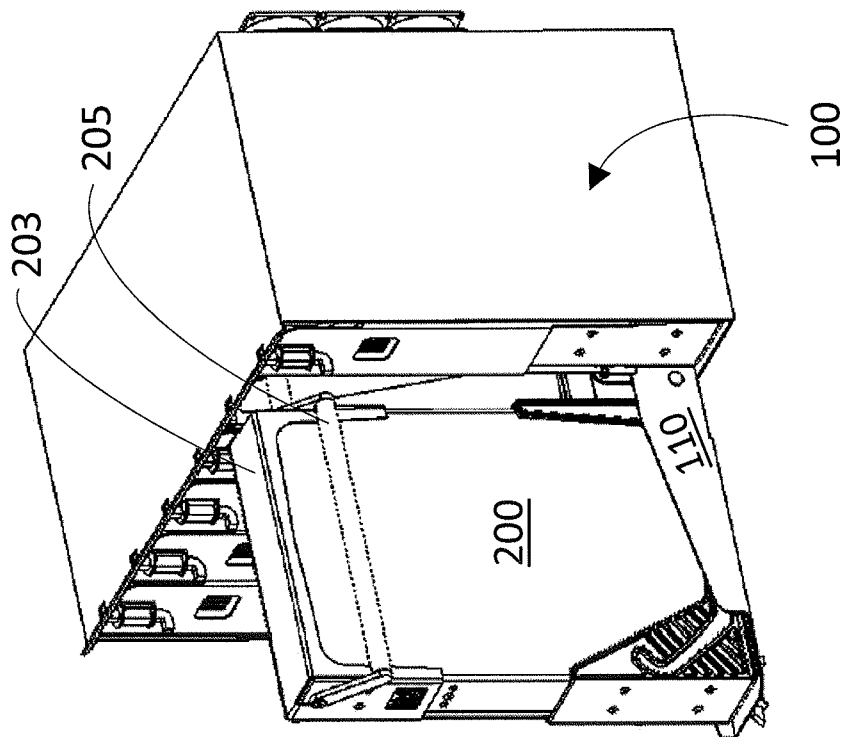


FIG. 7A

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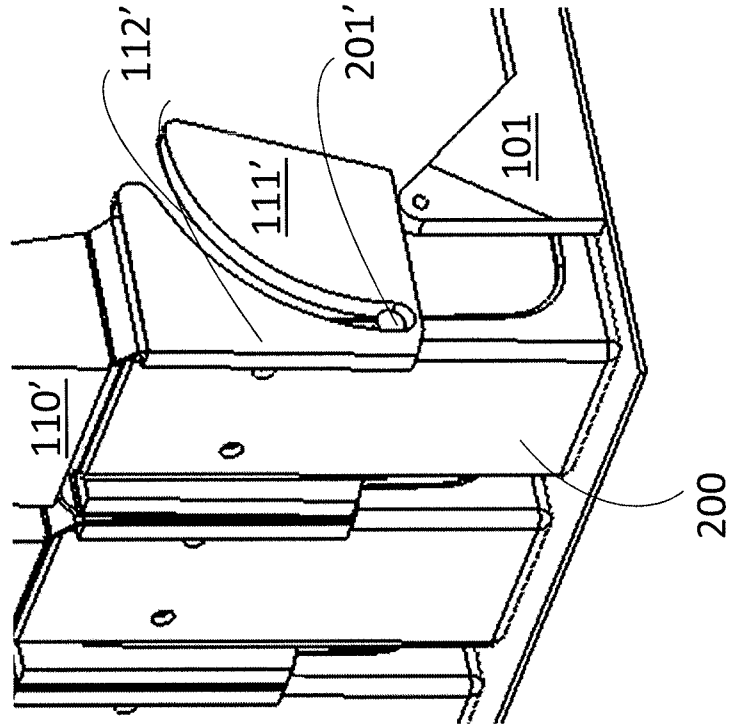


Fig. 8B

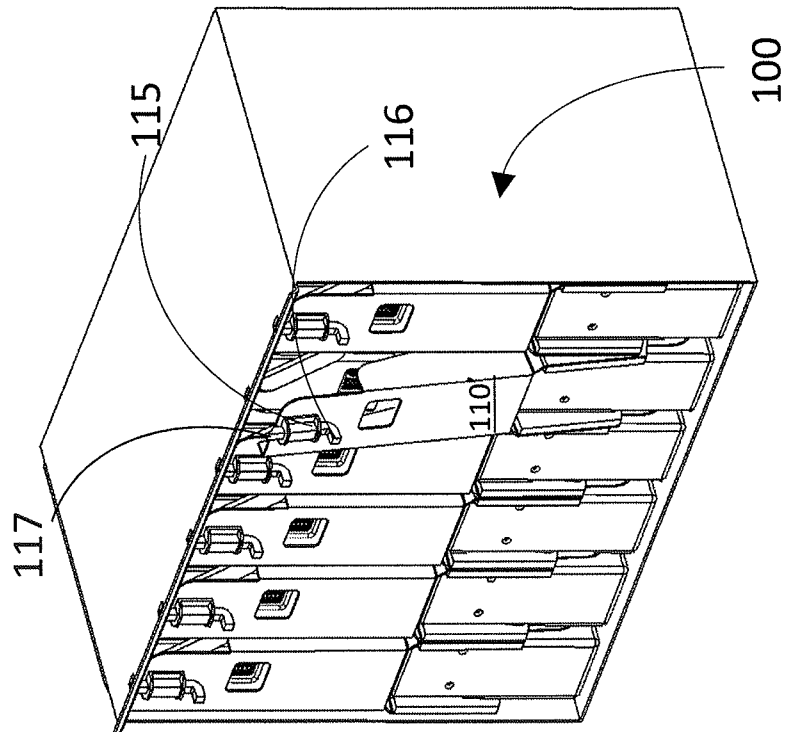


Fig. 8A

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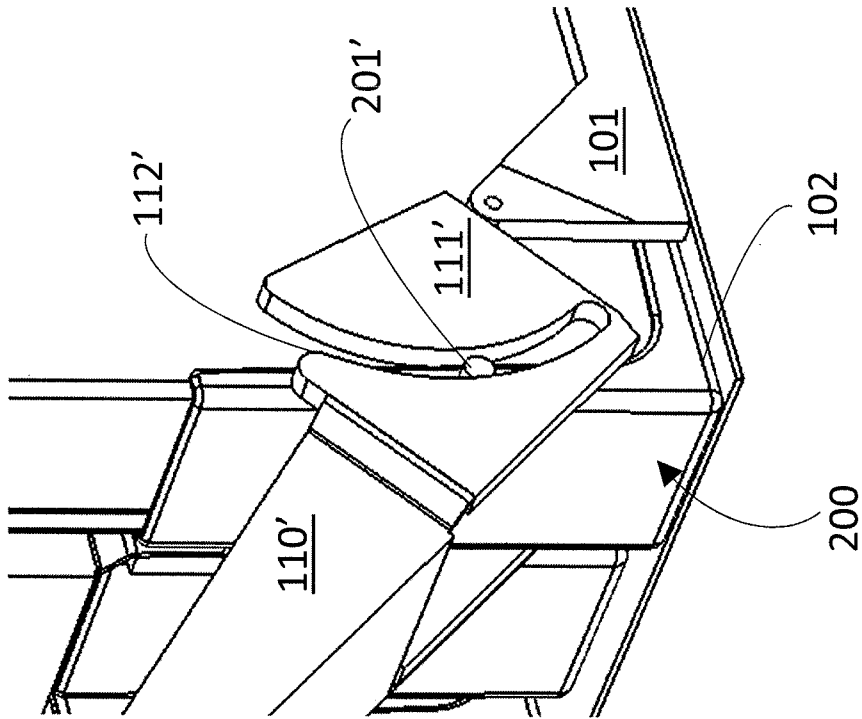


Fig. 9B

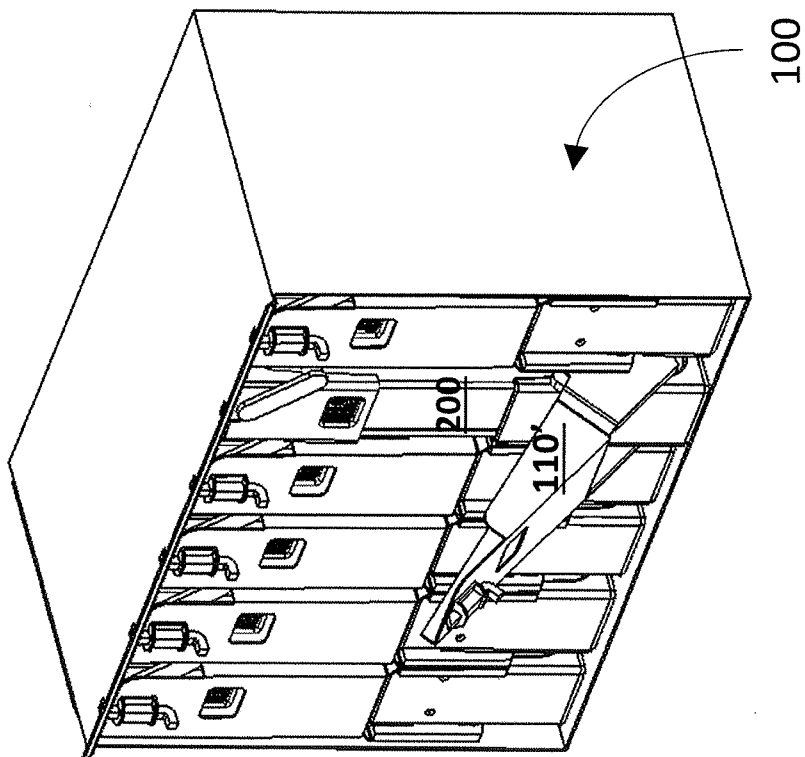


Fig. 9A

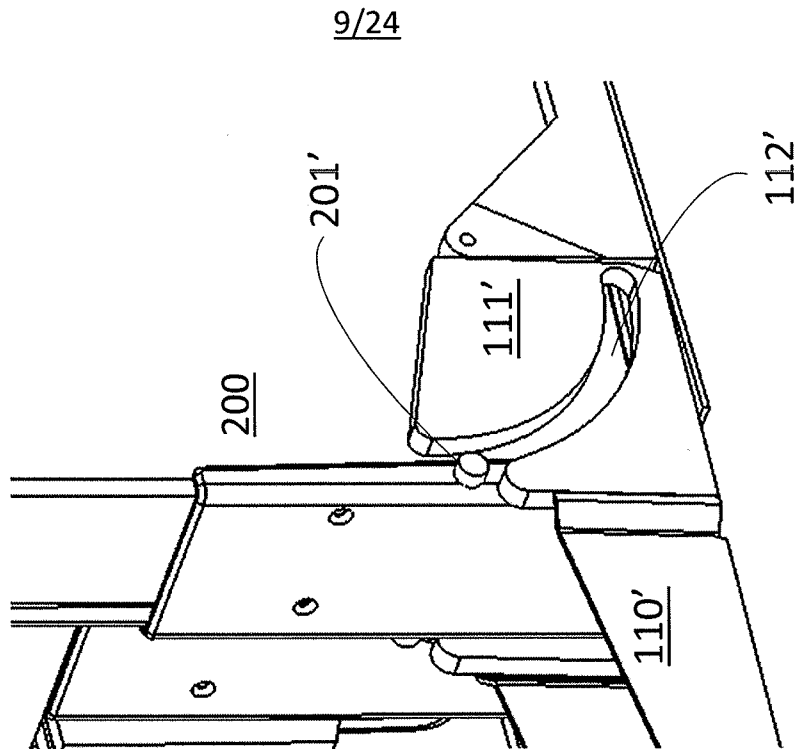


Fig. 10B

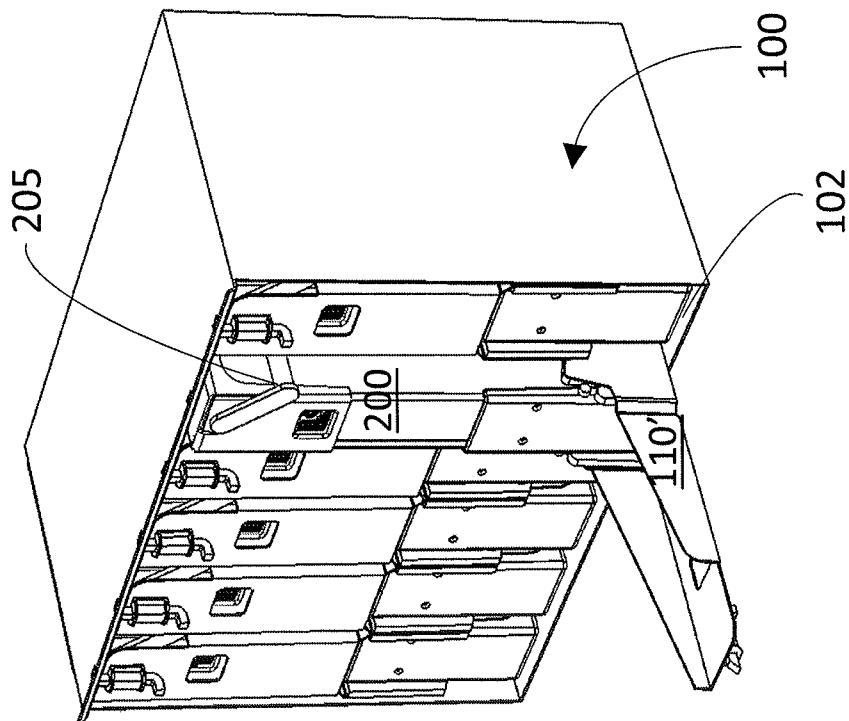
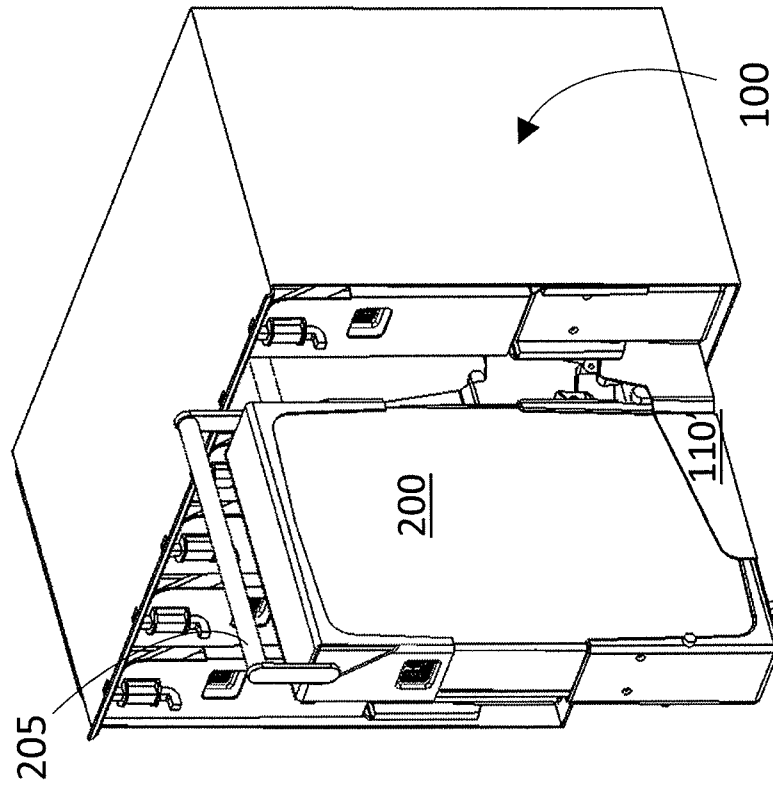
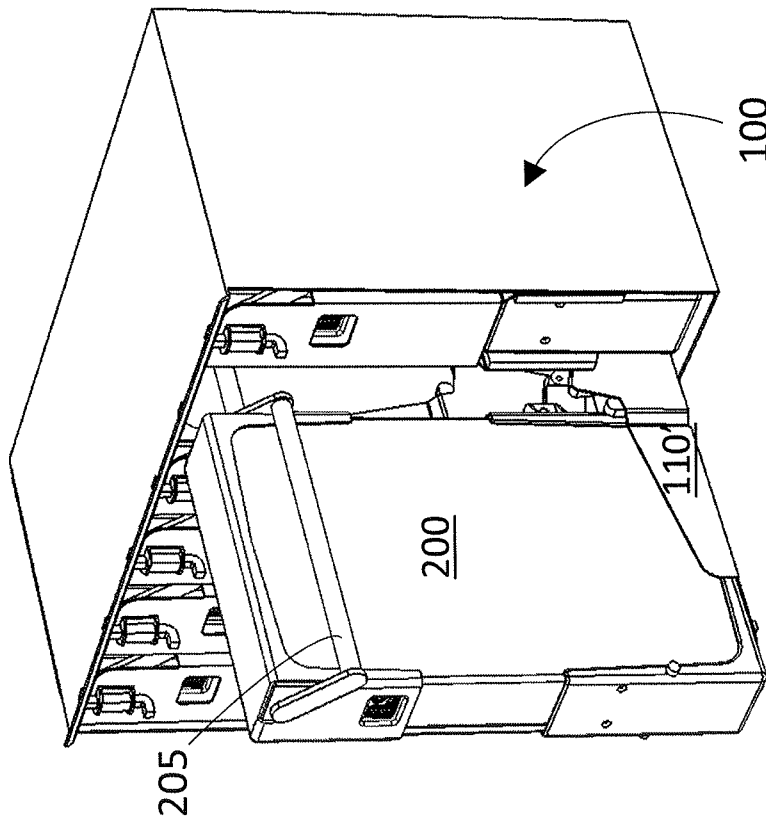
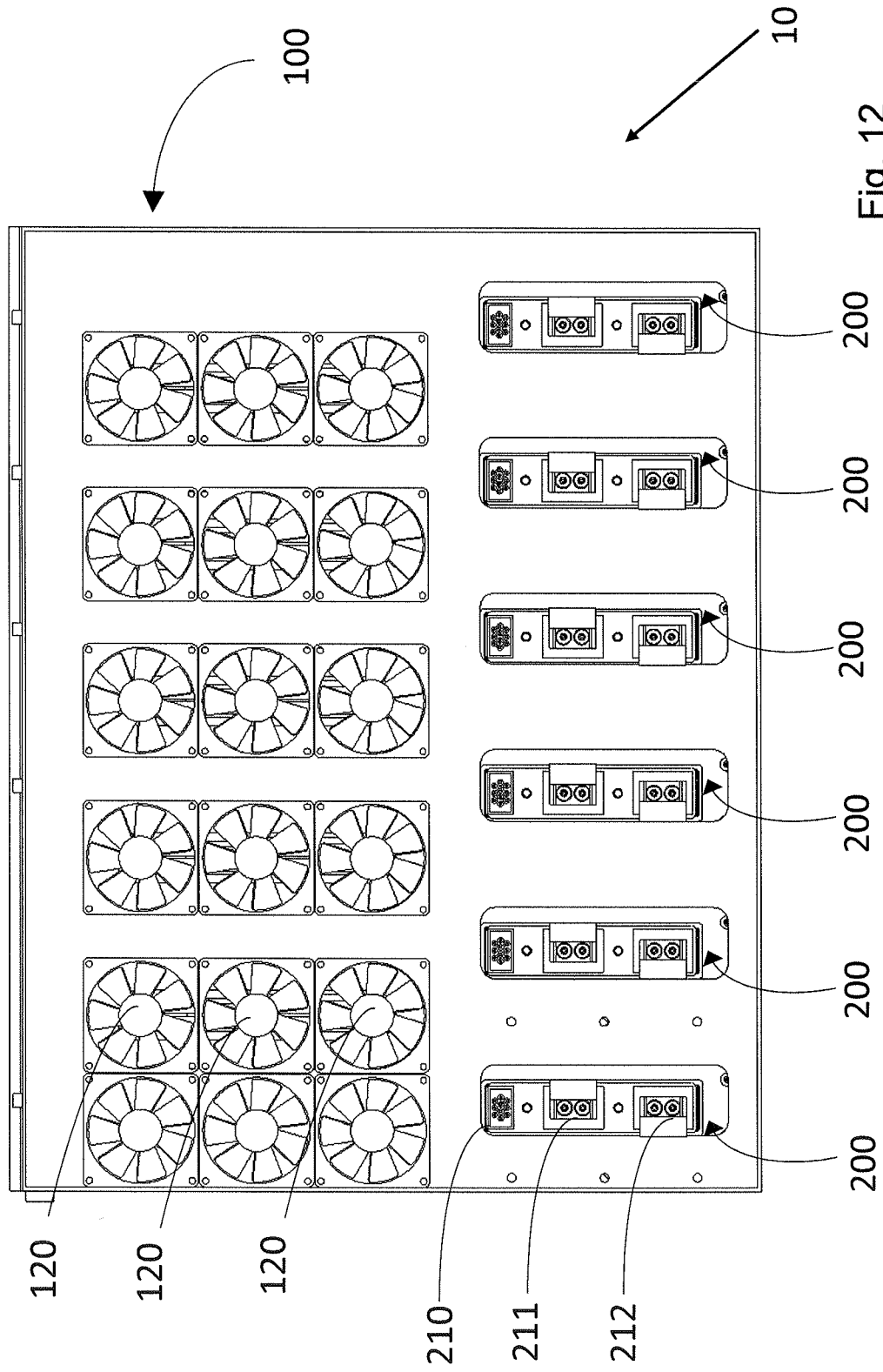
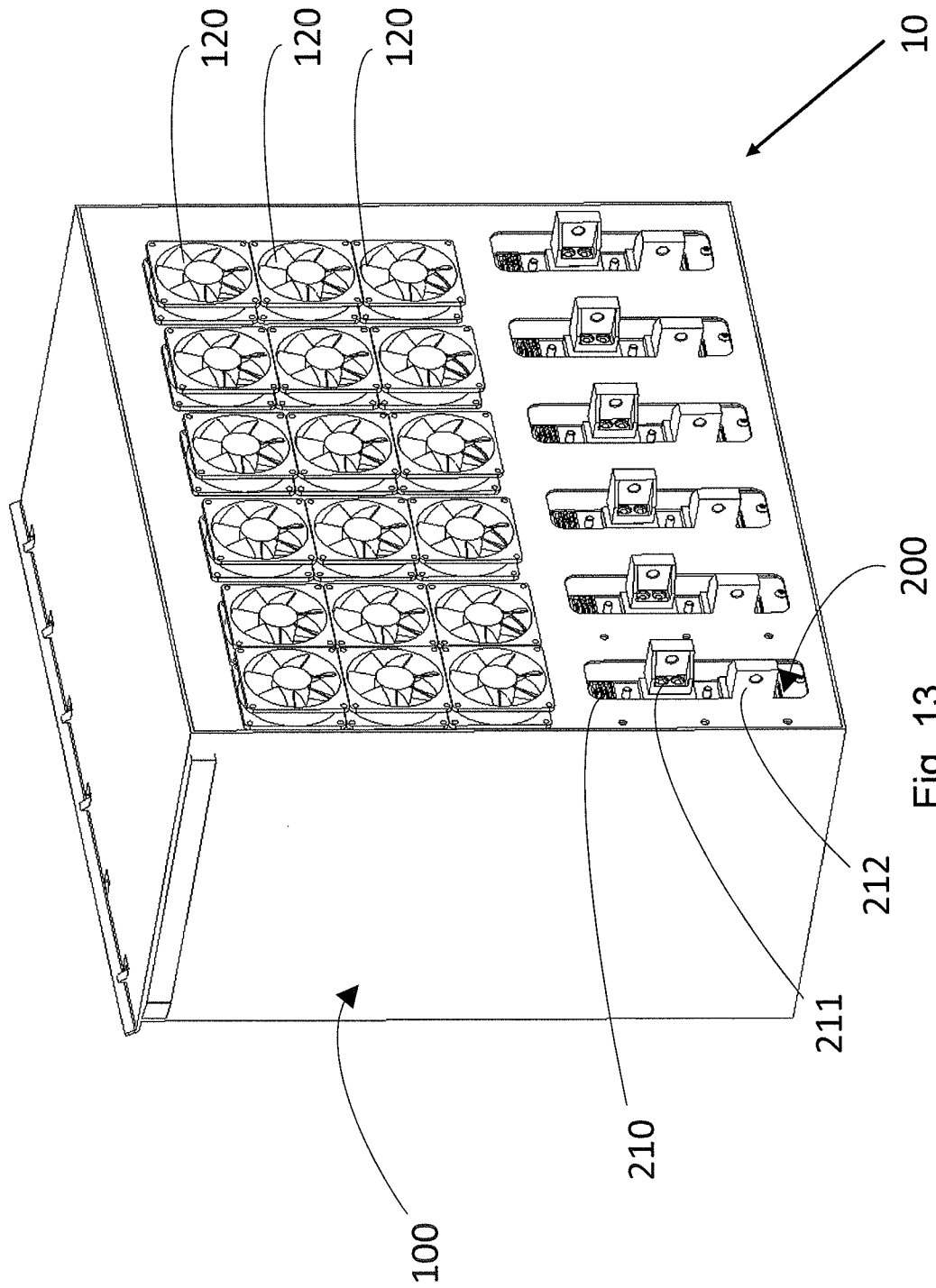
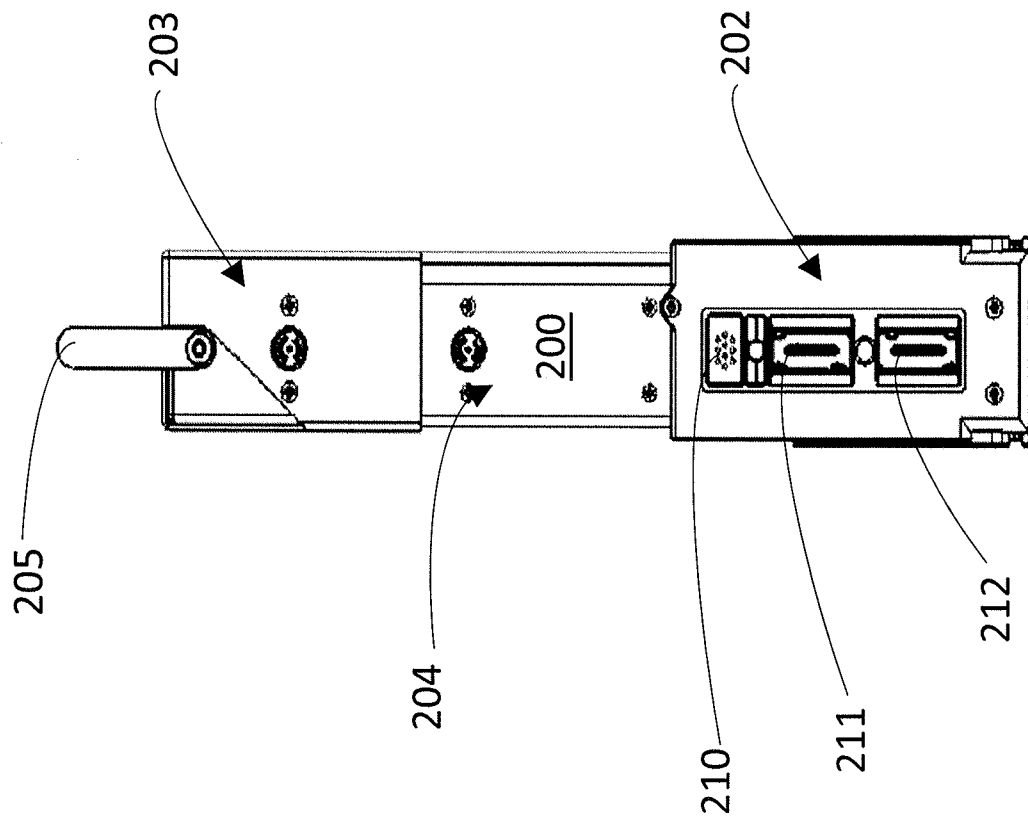


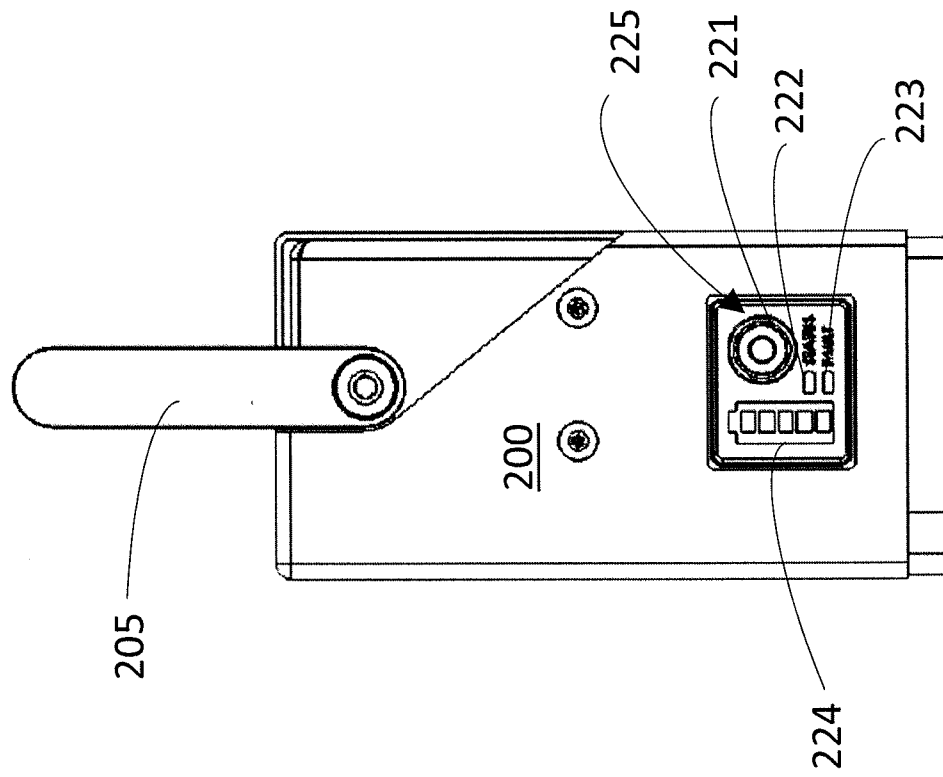
Fig. 10A

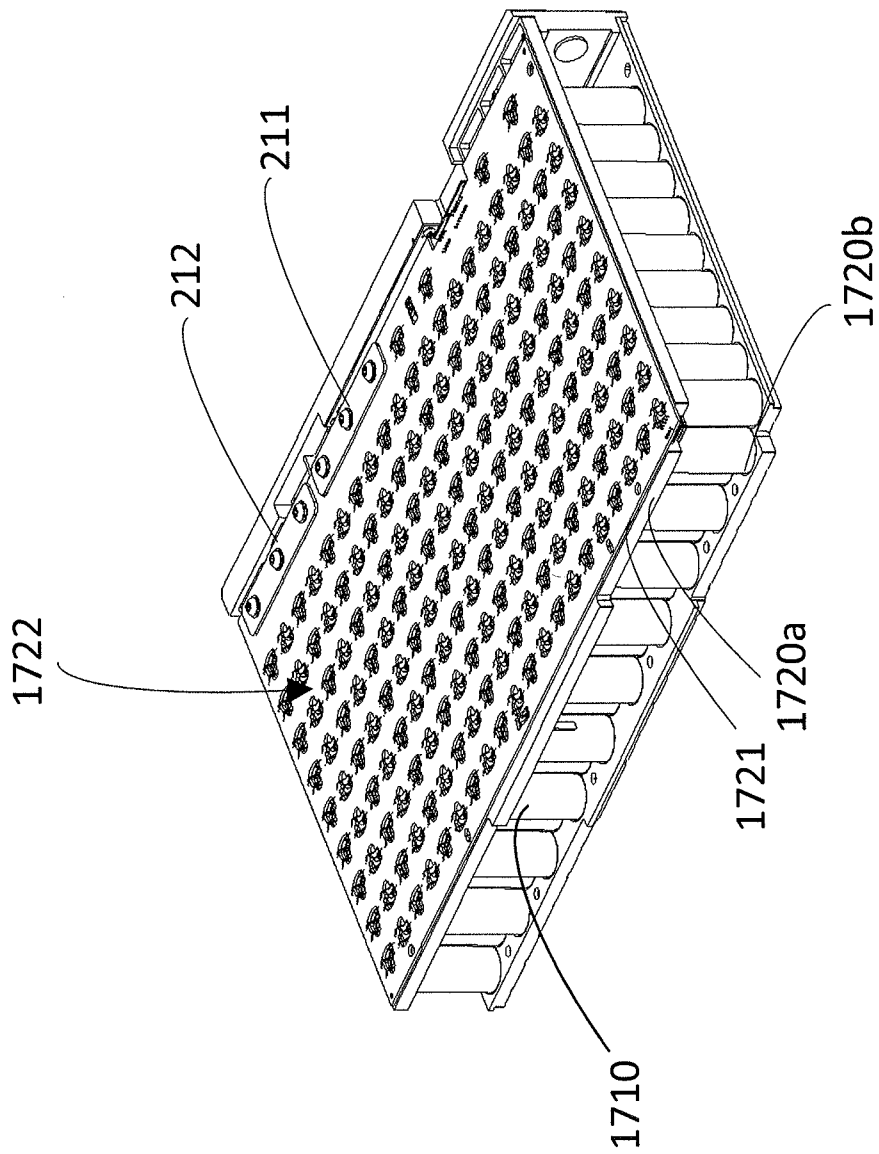
10/25Fig. 11BFig. 11A

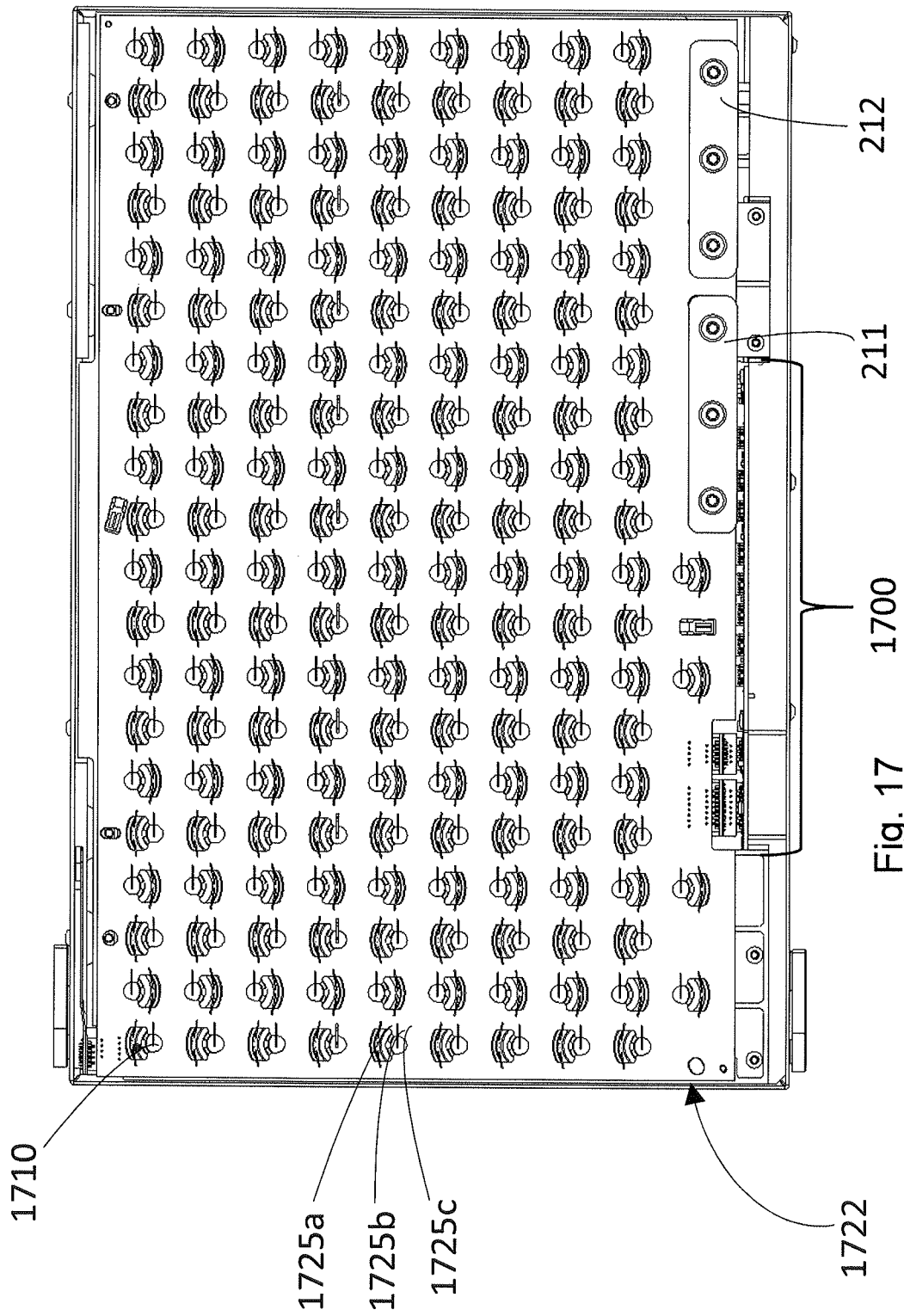




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Fig. 15

15/24Fig. 16



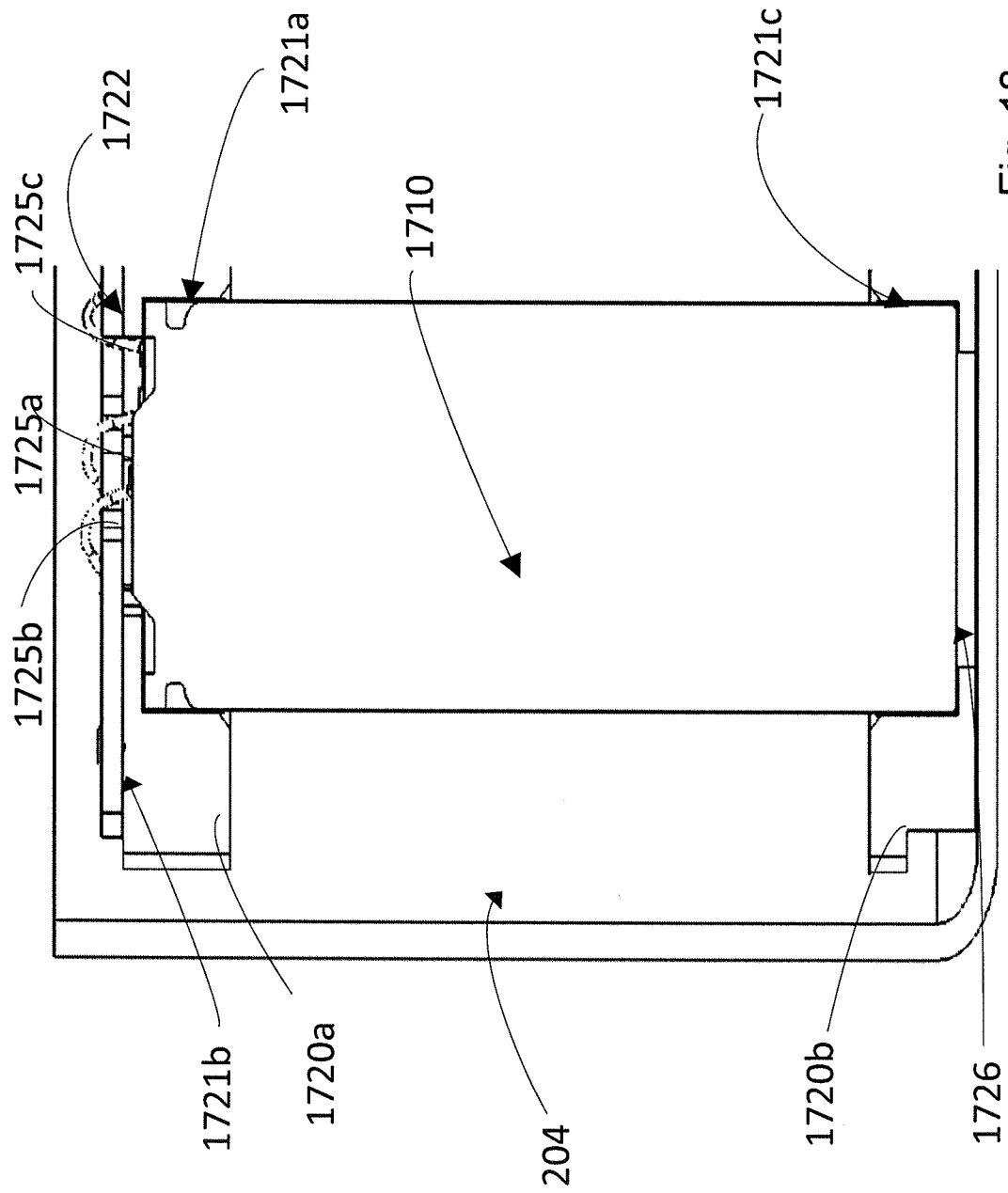


Fig. 18

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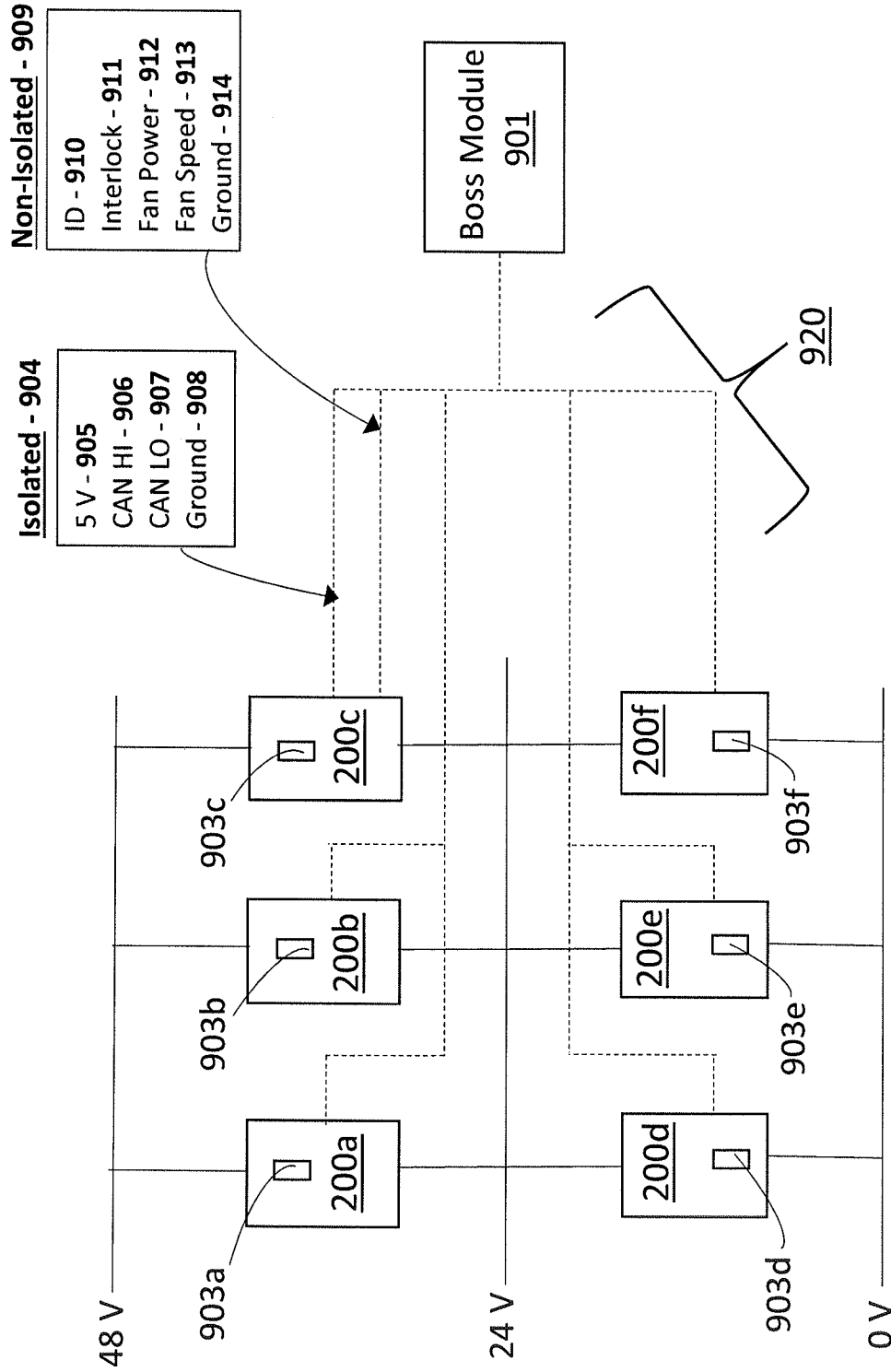
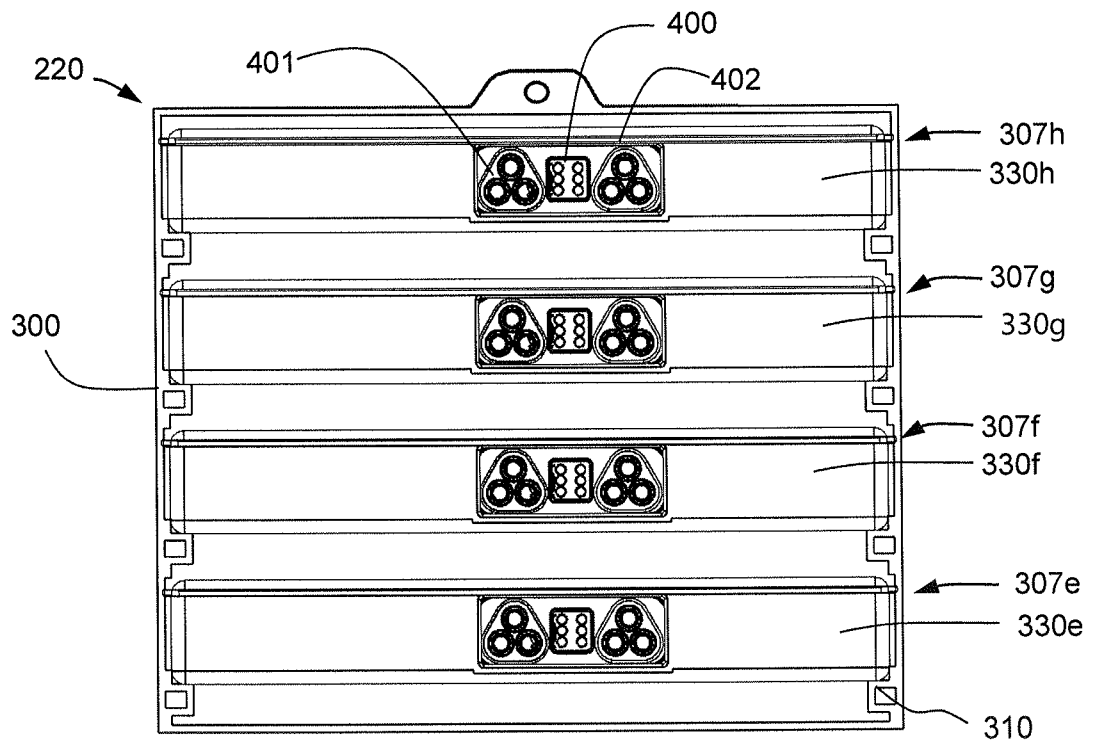
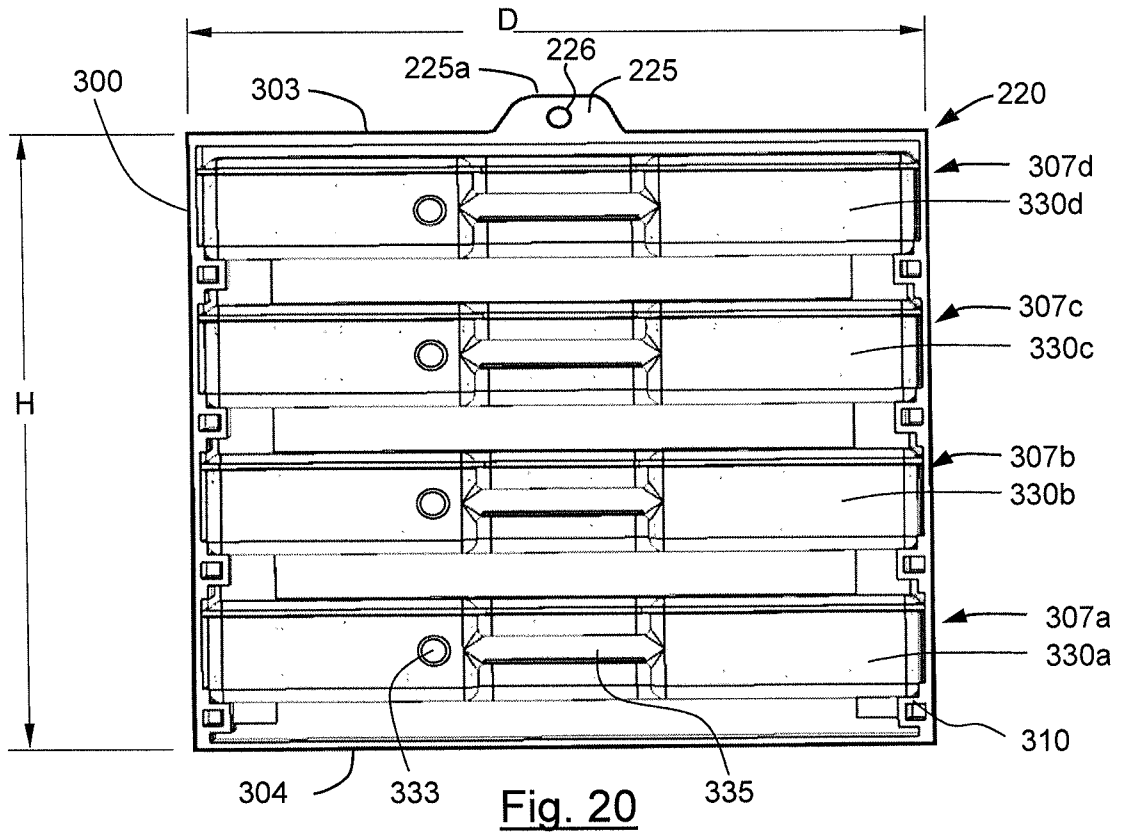


Fig. 19

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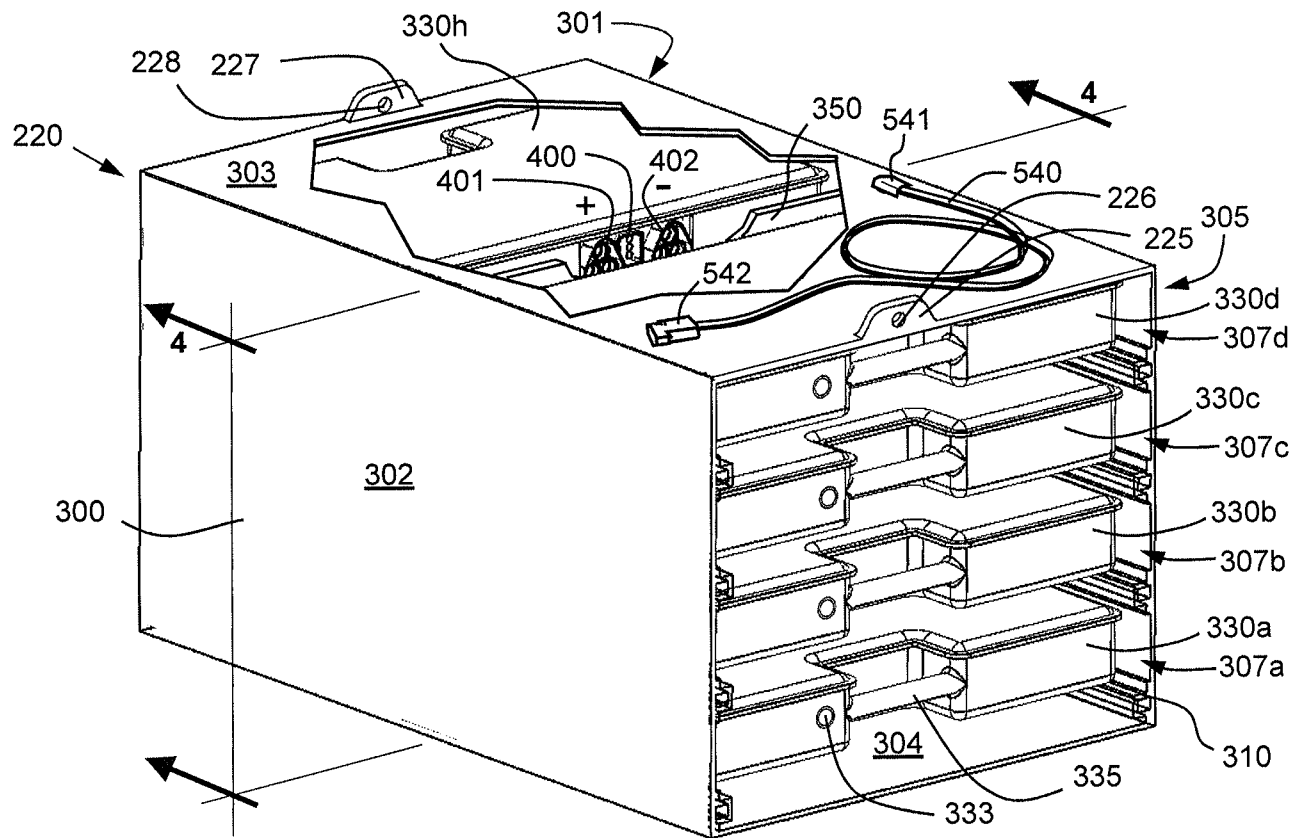


Fig. 22

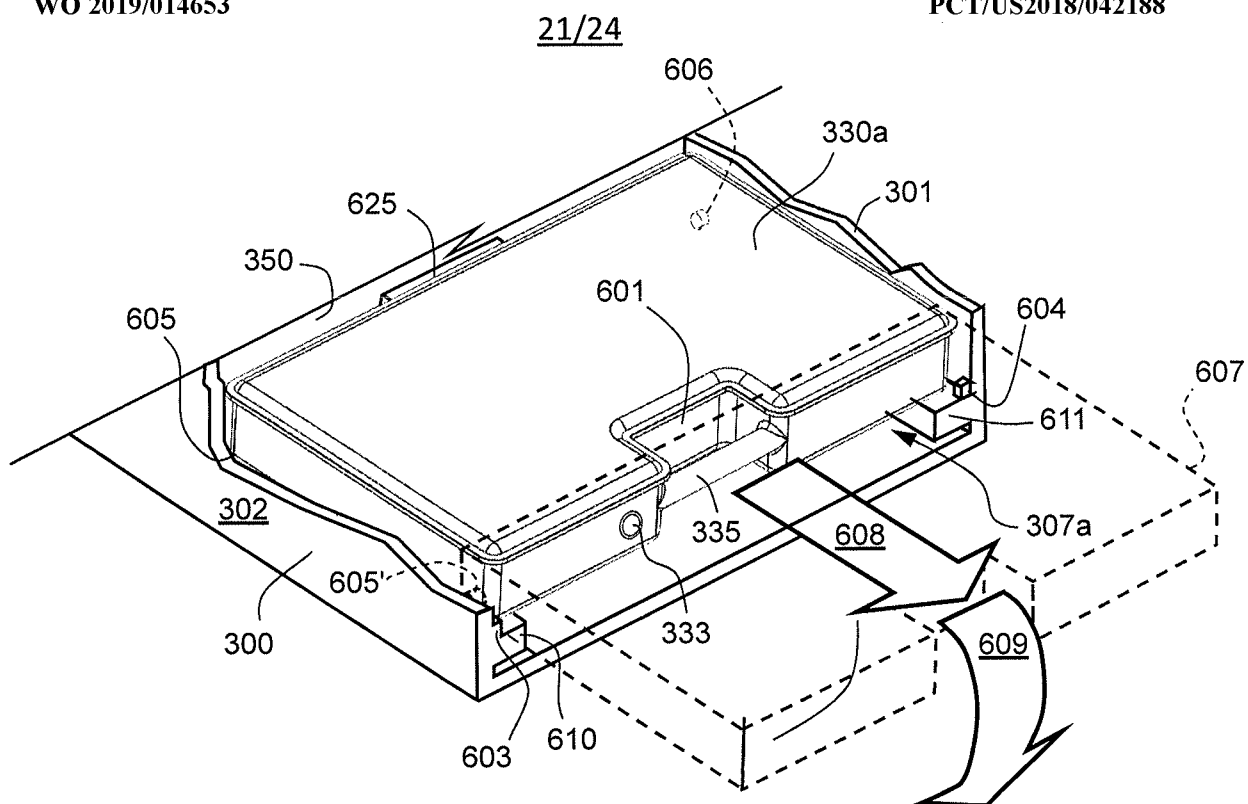


Fig. 23A

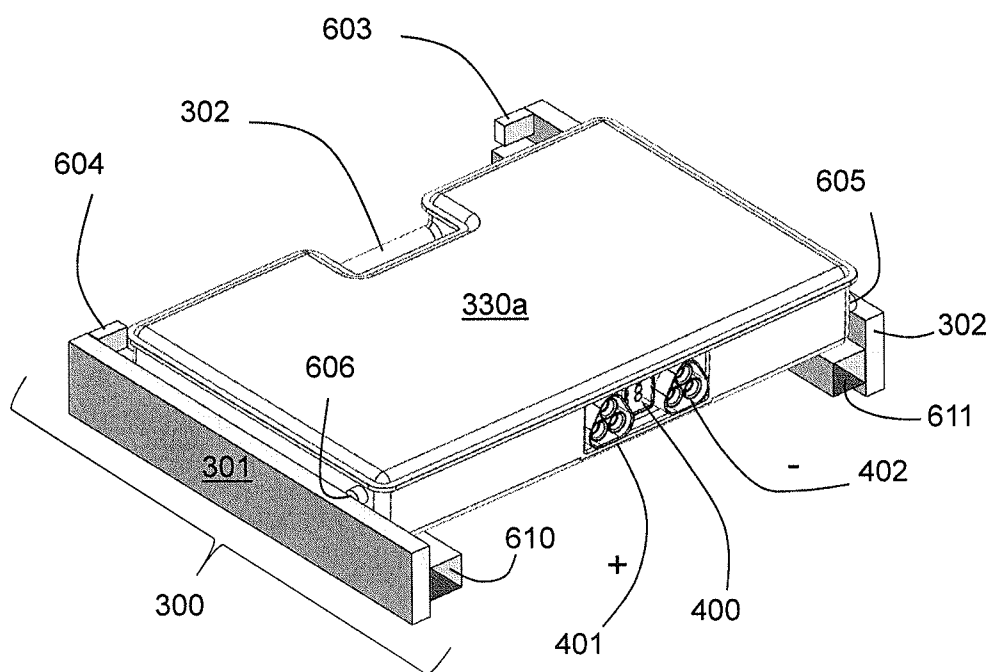


Fig. 23B

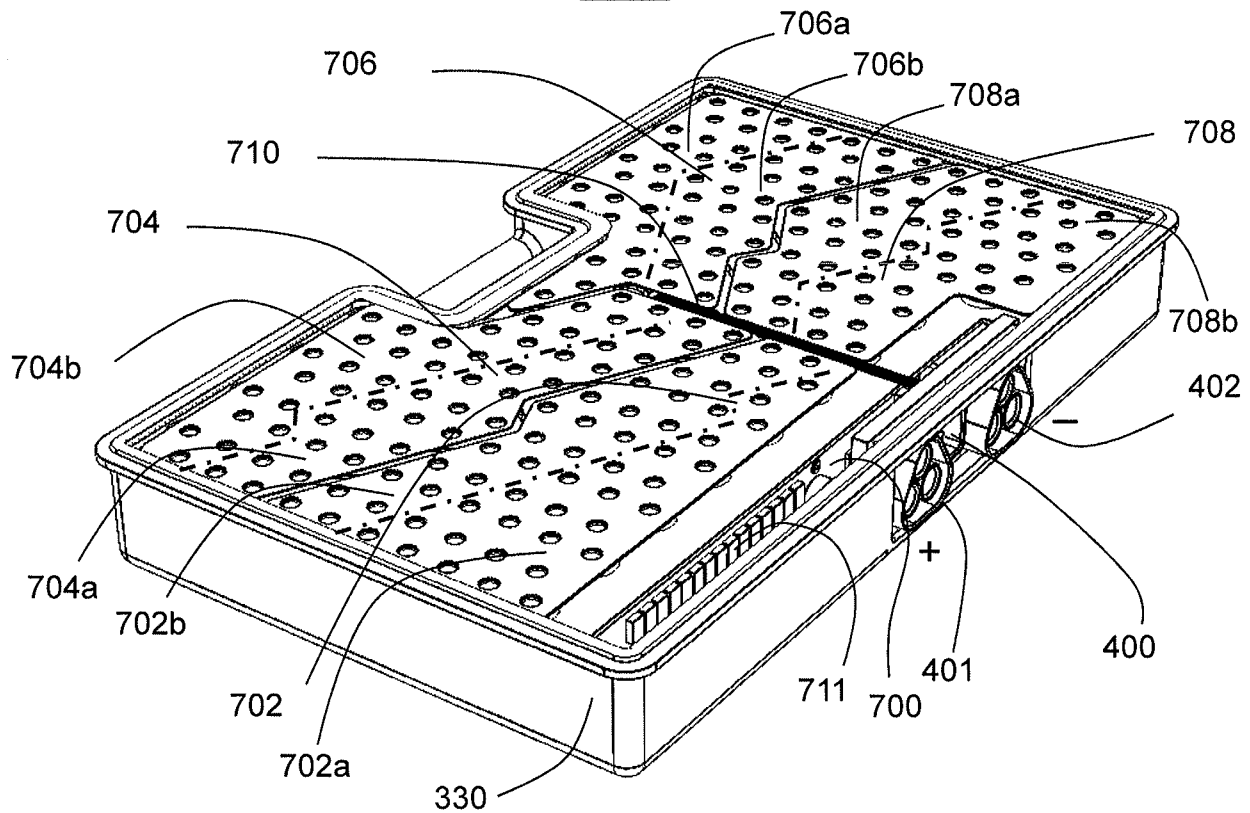


Fig. 24A – Top View of Battery Module Interior

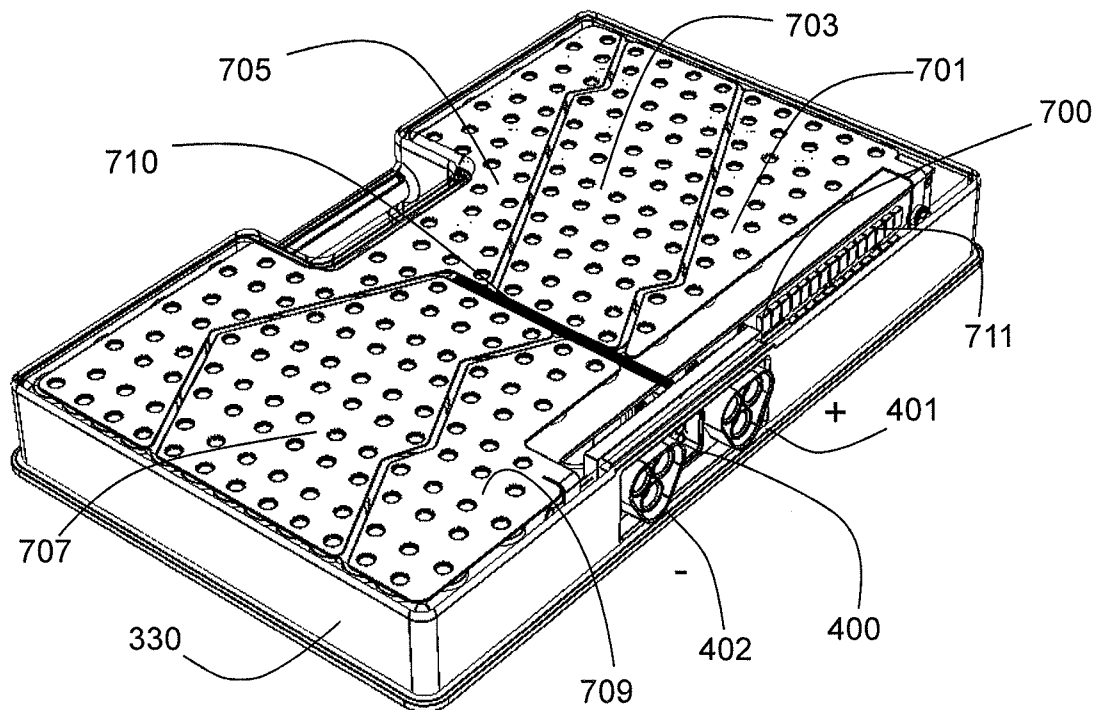
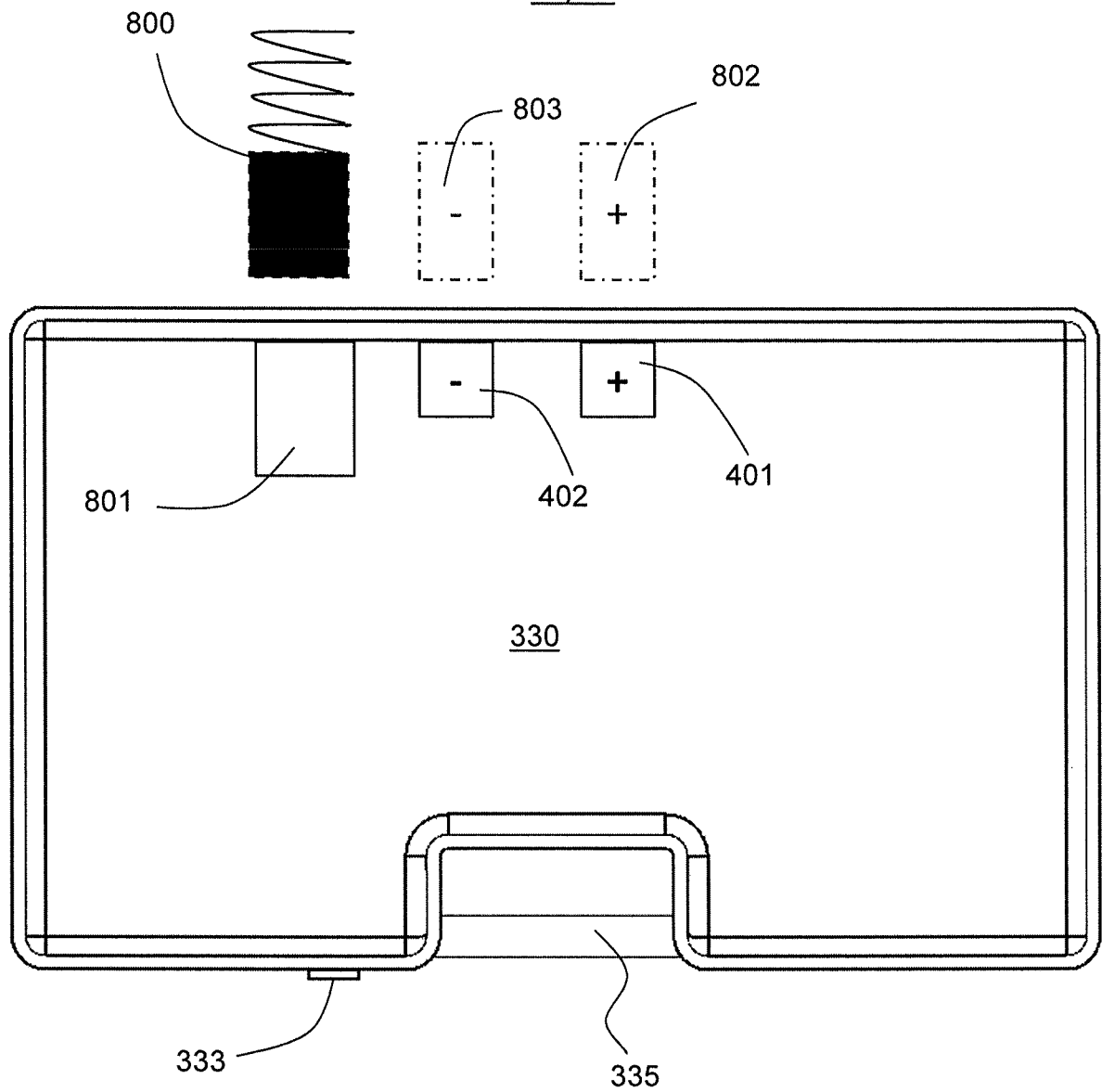


Fig. 24B – Bottom View of Battery Module Interior

FIG. 25

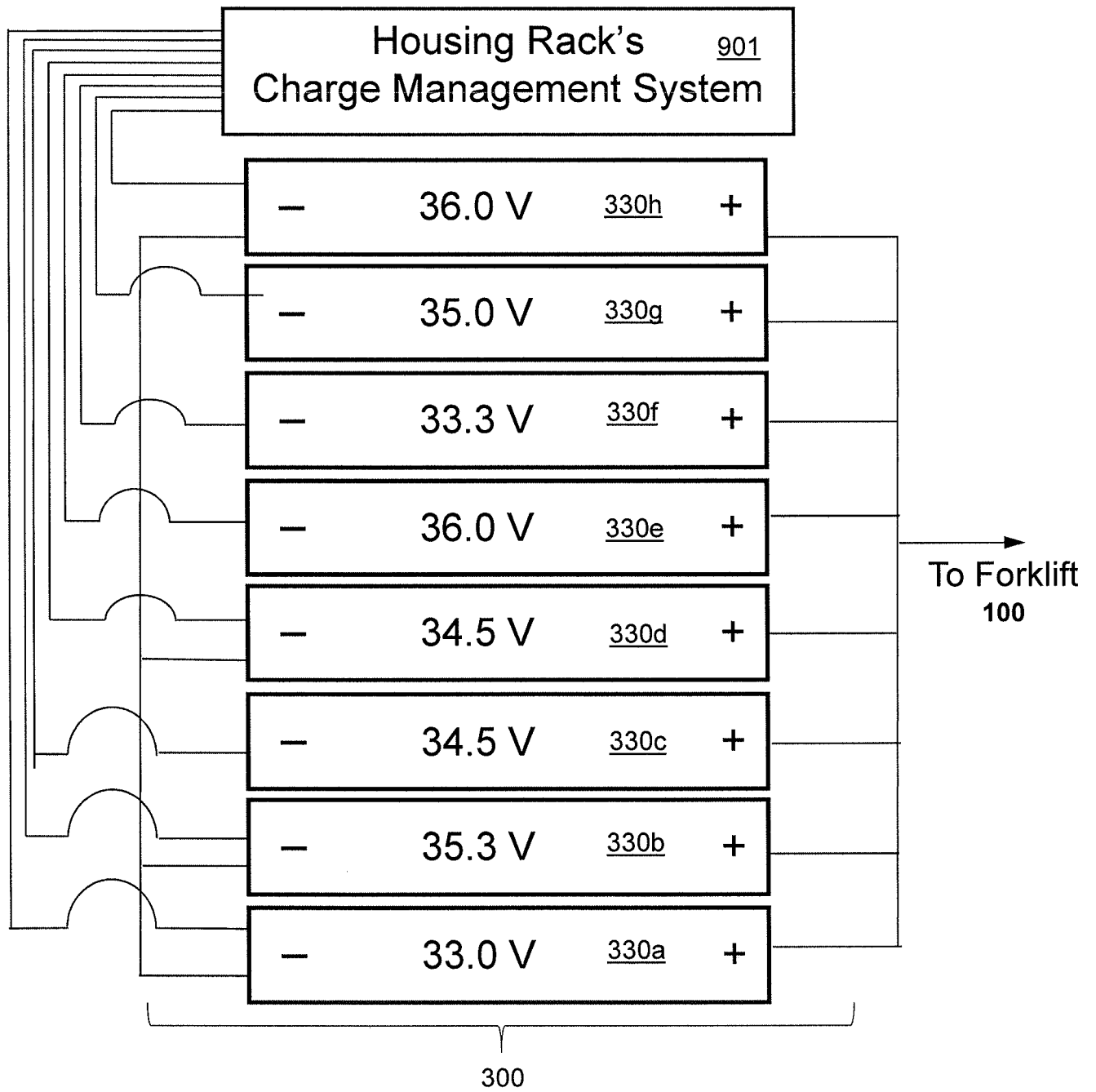
FIG. 26

FIG. 1

