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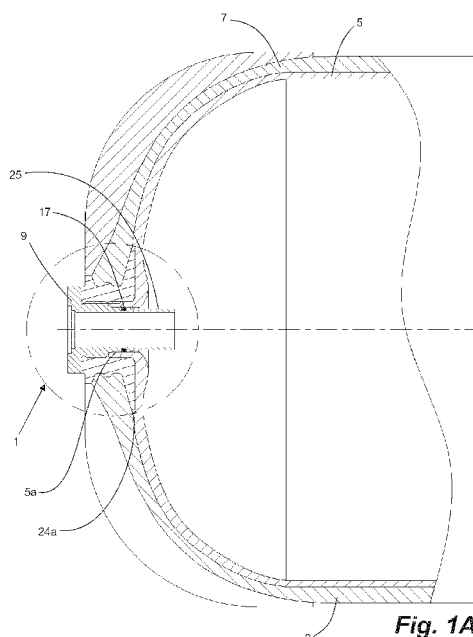
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(54) Title: SEALING SYSTEM FOR THE OUTLET OF A PLASTIC-LINED COMPRESSED GAS CYLINDER



(57) Abstract: A sealing system for an outlet of a plastic-lined cylinder has a plastic liner outlet extending into a bore of a boss. An insert is engageable with the bore, forming a primary seal between the insert and portion of the liner outlet. A tapered compression surface of the insert engages a tapered bore portion of the liner outlet adjacent the primary seal forming a tapered interface and a secondary seal. An axial position in the boss, and dimensional integrity, of the liner outlet is maintained by engaging an annular distal end of the liner outlet in the bore by a stop. The stop can be formed on the insert.

1 SEALING SYSTEM FOR THE OUTLET OF A
2 PLASTIC-LINED COMPRESSED GAS CYLINDER
3
4

5 CROSS REFERENCE TO RELATED APPLICATIONS

6 This application claims the benefits under 35 U.S.C 119(e) of US
7 Provisional Application Ser. No. 61/308,736, filed Feb. 26, 2010 and US Provisional
8 Application Ser. No. 61/308,751, filed Feb. 26, 2010, which are incorporated fully
9 herein by reference.
10

11 FIELD OF THE INVENTION

12 The present invention relates to fibre-wrapped, plastic-lined cylinders,
13 particularly to sealing systems within an end fitting of an outlet boss of the cylinder,
14 and more particularly to anti-extrusion and anti-creep measures at the sealing
15 interface.
16

17 BACKGROUND OF THE INVENTION

18 Fuel cylinders for liquefied natural gas (LNG), liquefied petroleum gas
19 (LPG), and particularly for hydrogen gas (H₂) are ideally as light as possible.
20 Cylinder structures used to maintain the high pressures and remain lightweight
21 include use of aluminum cylinders or liners wound with carbon fibres and plastic
22 liners or bladders similarly wrapped in carbon fibres. The carbon fibre wraps provide
23 the necessary structural integrity where less structurally-capable, yet low
24 permeability, fuel-retaining liners are used.

1 Cylinder structures capable of containing high pressures utilize
2 hemispherical or polar heads. Whether lightweight metal cylinders or plastic liners
3 are used, one or more outlets are presently formed of metal. For example, a polar
4 head of a fibre-wrapped, plastic lined vessel can be fit with a metal boss. Usually,
5 the metal boss is integrated with the liner prior to wrapping with carbon fibres. The
6 boss can have a partial polar shoulder which is over-wrapped as well with the
7 carbon fibres. The boss is threaded and fit with an “end fitting” or insert – including a
8 plug, valve or pressure regulator.

9 The boss itself is needed for installation of an end fitting or insert such
10 as a valve or regulator. It is known that the conventional threaded connections
11 between boss and insert are not adequate to block a leak path of the pressurized
12 fluid within, and particularly challenging with low molecular weight gases.

13 Current versions of lightweight fuel cylinders typically comprise a
14 plastic liner fit with a metal boss and then wrapped with carbon fibre. Due to the
15 introduction of plastic liners, there is now a new problem introduced with sealing of
16 the boss at the entrance to the cylinder. There is a problematic interface between
17 the liner and the polar end ports used to access the interior of the cylinder. The
18 interface of the plastic liner and the metal boss has the potential to leak.

19 Some manufacturers go to great lengths of providing a seal interface
20 between the boss and the liner by leaving the bore of the boss free of any liner
21 components and accepting conventional fittings. An example is a tongue and
22 groove form of interface as set forth in US 6,227,402 to Shimojima et al. wherein the
23 plastic liner is integrated into annular grooves in the boss. Other forms where a

1 boss embedded in the liner itself are set forth in US 5,253,778 to Sirosh, US
2 5,518,141 to Newhouse et al. and US 7,549,555 to Suzuki et al. When a leak does
3 occur, the cylinder cannot be repaired and is scrap.

4 A characteristic of plastic is a higher rate of creep under sustained
5 loading. In this case, creep is exhibited at the seal interface of the liner and the
6 insert. Seals typically comprise an elastomeric seal element compressed against
7 rigid seat. With the introduction of plastic liners, the rigid seat is replaced with the
8 plastic material. Over time, plastic tends to slowly move away from a sealing
9 engagement with the seal element and pressurized fluid then can escape thereby.

10 It is known in the prior art to introduce a liner outlet into the bore of the
11 boss. Accordingly, there has been an attempt to provide a seal between the plastic
12 liner within the boss and the insert. In US 5,938,209 to Sirosh et al. and US
13 6,186,356 to Berkley et al., an O-ring is sandwiched axially between an annular end
14 face of the liner and end face of the insert. In another form, as set forth in published
15 US Application 2009/0071930 to Sato et al., an O-ring is located between the liner
16 and the boss. Again, should a leak occur, the cylinder cannot be repaired and is
17 scrap.

18 Other prior art arrangements include placing an O-ring
19 circumferentially in an annular groove formed in the insert, the insert and O-ring
20 portion protruding into and sealing against a cylindrical throat of the liner.

21 Other factors contributing to seal leakage include differential thermal
22 expansion of the differing materials. The insert is usually aluminum or stainless

1 steel which has a lower coefficient of thermal expansion than plastic which can also
2 cause issues at the interface.

3 Accordingly, a new sealing system would overcome the deficiencies
4 experienced by the prior art.

5 6 SUMMARY OF THE INVENTION

7 Embodiments described herein are directed to a sealing system
8 formed between an outlet of a plastic liner extending into a bore of a boss. The liner
9 outlet and the bore of the boss form a profiled bore. An insert, engageable with the
10 profiled bore, forms a profiled surface for sealing with profiled bore. The liner outlet
11 is retained along the bore of the boss for dimensional stability. The sealing system
12 enables sealing using an annular sealing element and avoids extrusion of the seal
13 element therebetween. Other embodiments provide secondary sealing using
14 compressive interference of a tapered interface between the profiled bore and
15 profiled surface. Other embodiments provide compression of any assembly
16 clearance to obviate extrusion and optionally to preload the liner outlet for minimizing
17 the effects of creep.

18 Accordingly in one broad aspect a sealing system for an outlet of a
19 plastic-lined cylinder for compressed gas is provided. The plastic-lined cylinder
20 comprises a plastic liner and a boss. The boss has a bore for accessing the cylinder.
21 The sealing system comprises a liner outlet of the plastic liner extending axially into
22 the bore of the boss to form a profiled bore. The profiled bore comprises a liner
23 section and a boss section. The liner section comprises a cylindrical, sealing bore

1 portion, a tapered bore portion, and an annular distal end having an axial position in
2 the boss's bore. The boss section comprises an insert-securing bore portion. The
3 sealing system also comprises an insert having a profiled surface. The insert is
4 engageable with the profiled bore for sealing the profiled bore. The insert's profiled
5 surface comprises an annular seal element, a tapered compression surface, and a
6 bore-securing surface. The sealing system further comprises a retaining shoulder.
7 When the bore-securing surface axially engages the insert-securing bore portion, the
8 insert's profiled surface engages the profiled bore. The seal element corresponds
9 and seals with the sealing bore portion to form an annular primary seal. The
10 retaining shoulder engages the annular distal end for retaining the annular distal end
11 at the axial position in the boss's profiled bore. The tapered compression surface
12 corresponds and engages with the tapered bore portion to form an annular tapered
13 interface and compresses the liner outlet to form a tapered secondary seal.

14 In an embodiment, the tapered interface is adjacent the primary seal
15 for closing any annular assembly clearance. In another embodiment the insert is
16 provided with a leakage path downstream of the primary seal to bypass the tapered
17 interface.

18 Accordingly in another broad aspect a method for sealing the plastic-
19 lined cylinder is provided. The method comprises axially extending a liner outlet of
20 the plastic liner into the bore of the boss to form a profiled bore. An insert having a
21 profiled surface is engaged into the profiled bore for forming an annular primary seal
22 and a tapered secondary seal with the profiled bore liner outlet. The primary and
23 secondary seals are formed by first axially inserting the insert into the profiled bore

1 and engaging a bore-securing surface on the insert with an insert-securing bore
2 portion of the profiled bore for securing the insert to the boss. The primary seal is
3 formed by engaging an annular seal element of the profiled surface insert with a
4 cylindrical sealing bore portion of the profiled bore. The secondary seal is formed by
5 compressing a tapered compression surface of the profiled surface with a tapered
6 bore portion of the profiled bore for forming an annular tapered interface. The
7 tapered interface forms the secondary seal. An axial position of an annular distal end
8 of the liner outlet is maintained in the boss's bore by retaining the annular distal end
9 of the liner outlet against a stop.

10 Accordingly in yet another broad aspect a method for servicing a
11 sealing system of an outlet of a plastic-lined compressed gas cylinder is provided.
12 The cylinder comprises a plastic liner and a boss. The boss has a bore for accessing
13 the cylinder which is normally sealed with an insert. The method comprises
14 disengaging the insert from the outlet of the cylinder for exposing a profiled bore of a
15 liner outlet extending axially into the bore of the boss. An annular seal element
16 located about the insert is replaced. The seal element normally sealably engages
17 the profiled bore. At least one sealing surface located on the profiled bore is
18 refurbished.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1A is a partial cross-sectional view of a plastic-lined, fiber-wrapped cylinder according to one embodiment, the polar boss being fit with a plug-type of insert and the insert having a retaining shoulder;

Figure 1B is an exploded view of the polar boss of Fig. 1 fit with a flow through-type of insert, the insert shown prior to engagement with the boss and the liner outlet shown prior to engagement with the boss;

Figure 2 is an enlarged view of the polar boss of Fig. 1 fit with a flow through-type of insert;

Figure 3 is an enlarged view of the polar boss of Fig. 1 fit with the plug-type of insert;

Figure 4A is an enlarged view of the liner, an annular tapered interface, an annular seal element and backer ring common to both embodiments of the inserts of Figs. 2 and 3;

Figures 4B and 4C are enlarged, staged views of the seal element at the tapered interface of Fig. 4A, Fig. 4B illustrating the seal element before engaging the liner and Fig. 4C illustrating the seal element after engagement with the liner;

Figure 5 is an isometric view of one embodiment of a boss;

Figure 6 is a partial cross-sectional view of the liner and liner outlet compatible with a boss such as that of Figs. 1 through 4 and 5;

Figures 7A and 7B are side and cross-sectional views respectively of a form of polar boss;

Figure 8 is an isometric view of the flow through-type insert according to Fig. 2;

Figure 9 is an isometric view of the plug-type insert according to Figs. 1 and 3;

Figures 10A and 10B are side and cross-sectional views respectively of the flow through-type insert according to Fig. 2;

Figures 11A and 11B are side and cross-sectional views respectively of the plug-type insert according to Figs. 1 and 3;

Figure 12 is a cross-sectional view of another embodiment of the boss with the insert installed therein, the boss having the retaining shoulder and the insert having the seal element;

Figure 13 is a cross-sectional view of a further embodiment of the boss and the insert installed therein, the boss having the retaining shoulder and the insert having the seal element and the backer ring;

Figure 14 is a partial cross-sectional view of the insert's profiled surface and the boss's profiled bore according to Fig. 13;

Figure 15 is a partial cross-sectional view of the profiled surface and profiled bore according to Fig. 13 being fit with a backpressure anti-extrusion insert;

Figure 16 is a partial cross-sectional view of the profiled surface and profiled bore according to Fig. 13; and

Figure 17A and 17B are cross-sectional exploded views of the threaded assembly of the liner outlet (Fig. 17A) to the boss (Fig. 17B).

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

Herein, embodiments are directed to a sealing system for an outlet of a plastic lined cylinder for compressed gas. The cylinder comprises a plastic liner having a liner outlet and a boss coupled with the liner outlet. The boss has a bore for accessing the cylinder. For storage of compressed gas, the liner is supported against bursting using an overlying structure such as a carbon fibre wrap. The plastic liner and boss are wound with carbon fibres to provide the necessary structural integrity. The boss and the liner are integrated through a fibre-wrapping to form the cylinder.

The liner outlet extends axially into a bore of the boss to form a profiled bore. The profiled bore is sealed by an insert engageable with the profiled bore. The insert has a corresponding profiled surface. When the insert is engaged with the boss, at least an annular primary seal is formed between an annular seal element of the profiled surface and the profiled bore. In one embodiment, an annular, tapered, secondary seal is also formed between the profiled surface and the profiled bore. The secondary seal can be formed by interference and compression at an annular tapered interface between the profiled surface and profiled bore. The liner outlet is restrained in the boss by retaining an annular distal end of the liner outlet against a stop.

In one embodiment, the stop is a retaining shoulder provided on the insert. In another embodiment, the stop is a retaining shoulder provided in the boss. In another embodiment, compression of the liner outlet at the tapered interface can also close any annular assembly clearance to block extrusion of the seal element at

1 high pressures. Compression of the liner material can also minimize creep of the
2 sealing surfaces otherwise susceptible to sustained sealing element and pressure
3 loads. Further, the arrangements disclosed herein enable methods for refurbishing
4 the sealing system. Should a leak develop over time, the liner or insert interfaces
5 can be accessed for servicing and to quickly place the cylinder back into service.

6 Figs. 1 to 11B illustrate an embodiment of the sealing system wherein
7 the insert is provided with a retaining shoulder. The embodiments shown in Figs. 1
8 to 11B are suitable and tested for use with the storage of conventional gas such as
9 compressed natural gas (CNG) at pressures of about 250 bar.

10 With reference to Figs. 1A, 1B, 2 and 5, the polar head 1 of a plastic-
11 lined, fuel cylinder 2 is fit with a rigid boss 3, such as a metal boss, having a bore 4
12 therethrough for accessing the cylinder. The boss 3 has a flare 3a at a vessel end
13 and a fuel opening 3b (Fig. 5) at an outer end for accessing the bore 4 of the boss
14 and the interior of the cylinder or vessel. An outlet 5a of a liner 5 extends into the
15 bore 4 of the boss 3 and is coupled to the boss 3. In an embodiment, the outer
16 surface of the liner outlet is threaded 5b for coupling with an internal, threaded
17 portion 3c of the boss. Alone or in addition to threaded coupling, an adhesive can
18 also be used between the liner outlet 5a and the boss 3 for coupling the liner outlet
19 5a to the boss 3. The boss 3 and liner 5 are wrapped with a carbon fibre wrap 7,
20 sandwiching the flare 3a of the boss within the fibre-wrap and therefore integrated
21 into the polar head 1 of the cylinder 2. The bore 4 of the boss 3 is sealed by an
22 insert 9. The insert 9 is releasably engageable with the boss 3.

1 As shown in Fig. 1B, the insert 9 has a generally cylindrical body which
2 includes an external, threaded portion 9a which engages with the internal, threaded
3 portion 3c of the boss 3 for releasably coupling the insert 9 with the boss 3. Sealing
4 of the vessel's pressurized fuel contents is performed at the interface of the insert 9
5 and the liner outlet 5a.

6 Having reference to Fig. 4A, a sealing system between the insert 9 and
7 the liner outlet 5a comprises a profiled bore 4a (best illustrated in Fig. 1B) formed by
8 the liner outlet 5a extending into the bore 4 of the boss. The insert 9 has a
9 complementary profiled surface 4b (best illustrated in Fig. 1B) for engagement with
10 the profiled bore 4a. Axially spaced, as referenced from the inside of the vessel or
11 cylinder 2, the profiled bore 4a comprises a liner section LS (best illustrated in Fig.
12 1A) and a boss section BS (best illustrated in Fig. 1A). The liner section LS
13 comprises a cylindrical, sealing bore portion 12, a tapered bore portion 13, and an
14 annular distal end 14. The annular distal end 14 has an axial position in the bore 4.
15 The boss section BS comprises an insert-securing bore portion 15. Preferably, the
16 insert-securing portion 15 is the internal threaded portion 3c of the boss. The insert's
17 profiled surface 4b comprises an annular seal element 17 fit to an annular recess
18 17a formed circumferentially about a cylindrical plug portion 18 of the insert 9 for
19 corresponding and sealing with the sealing bore portion 12 during insertion of the
20 insert 9. A typical annular seal element 17 is a form of O-ring. One suitable material
21 for the O-ring, for many compressed gases including CNG, is nitrile 700LT.

22 In this embodiment, the profiled surface 4b of the insert 9 further
23 comprises a tapered compression surface 19, a retaining shoulder 20 and a bore-

1 securing surface 21. Preferably, the bore-securing surface 21 is the external
2 threaded portion 9a of the insert. The insert's profiled surface 4b engages the
3 profiled bore 4a when the bore-securing surface 21 axially engages the insert-
4 securing portion 15.

5 In operation, threaded insertion of the insert 9 locates the insert's seal
6 element 17 with the liner's sealing bore portion 12 to form an annular primary seal
7 between the insert 9 and the liner outlet 5a. Further, the insert's tapered
8 compression surface 19 axially engages the liner section's tapered bore portion 13
9 at an annular tapered interface 4c to form an annular, tapered secondary seal
10 between the insert 9 and the liner outlet 5a. The tapered interface 4c is a truncated
11 frustum of a right circular cone. The insert's retaining shoulder 20 engages and
12 axially retains the distal end 14 of the liner outlet 5a for maintaining the axial position
13 of the annular distal end 14 at the axial position in the bore 4 of the boss 3.

14 As shown in Figs. 4A and 4C, the seal element 17 is fit within the
15 cylindrical plug portion 18 of the insert 9. The cylindrical plug portion 18 engages
16 the cylindrical sealing bore portion 12 of the liner section LS of the profiled bore 4a
17 forming a small annular assembly clearance or gap 29 (Fig. 4C) therebetween (not
18 distinguishable at the resolution of the drawings). The assembly clearance enables
19 the seal element 17 to enter the cylindrical sealing bore portion 12 during assembly.
20 However, this assembly clearance can also introduce challenges at higher
21 pressures. The annular seal element 17, under a combination of factors including
22 the seal material properties, the dimensions of the assembly clearance and the

1 pressure, would be subject or vulnerable to extrusion out of the annular recess 17a
2 and into the assembly clearance.

3 As shown in Fig. 4B, the annular seal element 17 is elastomeric and in
4 the uncompressed, free state, has a first relaxed cross-section, shown in Fig. 4B as
5 a circular cross-section of an O-ring embodiment. As shown in Fig. 4C, when the
6 annular seal element 17 engages the sealing bore portion 12, it is compressed into
7 the annular recess 17a, substantially assuming the cross-sectional shape of the
8 recess 17a. A backer ring 22 can also be provided in the annular recess 17a. The
9 backer ring 22 is located in the annular recess 17a between the annular seal
10 element 17 and a wall 17b of the annular recess 17a between the tapered interface
11 4c and the annular seal element. The backer ring 22 can include an annular and
12 concave alignment recess 22a into which the annular seal 17 compresses. Backer
13 rings can assist in resisting movement of the annular seal element 17 during insert
14 installation and when compressed, expand radially to reduce risk of extrusion. The
15 compressive action of the annular seal element 17 into concave alignment recess
16 22a can also aid in the radial displacement of the backer ring 22 within the annular
17 recess 17a and blockage of the assembly clearance. Suitable backer ring material
18 includes 90 durometer nitrile.

19 Also, it is found that the compression can also form a direct insert-to-
20 liner seal or the secondary seal at the tapered interface 4c.

21 The liner outlet 5a is restrained from axial movement by the retaining
22 shoulder 20, such movement including that from axial extrusion or creep under

1 compressive forces imparted by the tapered compression surface and cylinder
2 pressures.

3 As a result a simple and reliable sealing system or arrangement is
4 achieved.

5 In one embodiment of the liner as shown in Fig. 6, the liner 5 is a
6 bladder comprising about 5mm of high density polyethylene (HDPE) which is
7 suitable for natural gas. The cylindrical sealing surface can be about 33.3 mm in
8 diameter, 20 mm in axial length and the outer diameter of the liner outlet 5a is about
9 42 mm for a liner thickness of about 4.35 mm. The tapered compression surface 19
10 is about 5.4 mm in length axially and has taper of 20 degrees from the axis.

11 In another embodiment of the liner, the liner 5 could include a
12 supplemental layer of EVOH EVAL F101B for improved resistance to permeability of
13 the fuel gas.

14 The liner outlet 5a is axially aligned with the boss 3 to maintain the
15 axial position of the annular distal end 14 in the boss's profiled bore 4a. The insert 9
16 is axially aligned with the boss 3 so that the retaining shoulder 20 engages and
17 retains the annular distal end 14 at the axial position when the tapered compression
18 surface 19 engages the tapered sealing bore portion 13. In one embodiment, axial
19 alignment between the boss 3 and the liner 5 is provided as follows: the boss 3 is
20 provided with a first annular datum surface 24a and a second annular datum surface
21 24b (best illustrated in Figs. 1A and 1B). The insert 9 is provided with a terminating
22 outer 24c. The datum surface 24a is provided between the flare 3a of the boss 3
23 (which is ultimately covered in fibre-wrap) and a surface of the polar head end of the

1 liner 5 (preferably machined to correspond to the boss flare 3a , such as a flat
2 surface perpendicular to the vessel axis. The datum surface 24b is provided at the
3 fuel opening 3b of the boss. The annular distal end 14 of the liner outlet 5a is axially
4 spaced a reference distance from the annular datum surface 24a. As the distance
5 from the fuel opening 3b of the boss to the flare 3a of the boss is known, distance of
6 the annular distal end from the fuel opening 3b of the boss can be calculated. This
7 forms a second reference distance. The retaining shoulder 20 is spaced from the
8 outer terminating shoulder 24c by a distance equal to the second reference distance
9 so that when the terminating outer shoulder 24c engages the annular datum surface
10 24b, the retaining shoulder 20 engages and retains the annular distal end 14 at the
11 axial position when the tapered compression surface 19 is engaged with the tapered
12 bore portion 13.

13 The boss 3 and insert 9 are typically formed of aluminum alloy such as
14 anodized AA6061-T6 ASTM B221. The liner outlet 5a can be secured by a metal-
15 bonding adhesive to the inside of the boss 3. The adhesive can assist with one or
16 more aspects including securing the liner outlet 5a to restrain the liner outlet within
17 the boss during assembly and to fill inconsistencies in the mating of the liner and
18 boss for maintaining dimensional stability. A suitable adhesive is a two-component,
19 high peel strength, metal-bonding adhesive. An example of a suitable adhesive
20 includes LoctiteTM U05-FL (Trademark of Henkel, Ohio USA).

21 In an embodiment of the insert 9 as shown in Figs. 1A, 1B, 2, 8, 10A
22 and 10B, the insert 9 includes an additional tube extension 25 which extends into the
23 interior of the cylinder 2. During the filling and emptying of the cylinder 2, the gas

1 flow is throttled through the insert 9, or a fitting installed to the insert 9.
2 Pressurization of the cylinder 2 can result in localized temperature increases and
3 decompression can result in temperature decreases. The tube extension 25 can act
4 to shift such thermal effects to the interior of the cylinder 2 and can also act as a
5 static build-up accumulator away from the plastic surface. In any event, grounding
6 of the insert 9 to an exterior ground, such as the mounting assemblies can bleed off
7 static build-up.

8 Figs. 12 to 17 illustrate an embodiment of the sealing system wherein
9 the axial position of the annular distal end 14 of the liner outlet 5a in the bore 4 of the
10 boss 3 is maintained by a retaining shoulder 20a formed in the boss 3. The
11 embodiments shown in Figs. 12 to 17 have been shown suitable for use with the
12 storage of compressed gas at high service pressures of about 700 bar (with a safety
13 factor of 1.25 or pressures of about 875 bar). The liner 5 illustrated in Figs. 12 to 17
14 is well suited to contain compressed gas at pressures ranging from about 250 bar to
15 about 875 bar and at temperatures ranging from about -40°C to about 85°C. The
16 compressed gas can be hydrogen, helium or methane. The liner 5 suited for storage
17 of such gases at pressures stated above can be a monolayer bladder or a multilayer
18 bladder comprising a EVOH EVAL F101B layer, a BASELL LUPOLEN 4261A
19 (Trademark of LyondellBasell Industries Holding B.V., Rotterdam Netherlands) layer
20 and a layer of DUPONT BYNEL 40E529 (Trademark of DuPont, Delaware USA).

21 The sealing system illustrated in Figs. 12 to 17 and the sealing system
22 illustrated in Figs. 1A to 11B have common elements. The common elements are the
23 profiled bore 4a formed by the liner outlet 5a extending partially into the bore 4 of the

1 boss 3 and the insert 9 having a profiled surface 4b. The profiled bore 4a has the
2 cylindrical sealing bore portion 12, the tapered bore portion 13 and the insert-
3 securing portion 15. The profiled surface 4b of the insert 9 comprises the annular
4 seal element 17 located in the recess 17a in the cylindrical plug portion 18, the
5 tapered compression surface 19 and the bore-securing surface 21. A difference
6 between the sealing system described in Figs. 1A to 11B and the sealing system
7 described in Figs. 12 to 17 is that in the sealing system described in Figs. 1A to 11B
8 the retaining shoulder 20 is located on the insert 9 and in the sealing system
9 described in Figs. 12 to 17 the retaining shoulder 20a is located on the boss 3. The
10 retaining shoulder extends radially into the bore 4 of the boss. Also, in the sealing
11 system described in Figs. 12 to 17, the annular tapered interface 4c (portion where
12 the tapered bore portion 13 meets the tapered compression surface 19) is
13 substantially immediately adjacent the annular recess 17a housing the annular seal
14 element 17. The sealing system described in Figs. 12 to 17 generally works in the
15 same manner as the sealing system described in Figs. 1A to 11B except that the
16 function of the tapered interface 4c in Figs. 12 to 17 is more directed towards
17 providing compression of the liner outlet 5a around the annular seal element 17.
18 Compression of the liner outlet 5a at the tapered interface 4c aids in anti-extrusion of
19 the annular seal element 17 from the annular recess 17a and also resists reactive
20 creep from around the annular seal element 17. More detailed functioning of the
21 tapered interface 4c in Figs. 12 to 17 is explained below.

22 In the sealing system described in Figs. 12 to 17, a small annular
23 assembly clearance 29 (Figs. 12 and 14) is provided between the cylindrical plug

1 portion 18 of the insert 9 and the cylindrical sealing bore portion 12 of the liner
2 section LS to enable the annular seal element 17 to enter the cylindrical sealing bore
3 portion 12 during assembly. The annular assembly clearance 29 is not
4 distinguishable at the resolution of the drawings. At high pressures, the annular seal
5 element 17 can extrude from the annular recess 17a into the annular assembly
6 clearance 29. Compression of the liner outlet 5a at the tapered interface 4c can act
7 to reduce and close the assembly clearance for avoiding opportunity for extrusion of
8 the annular seal element 17. The tapered interface 4c is located downstream from
9 normally-pressurized gaseous contents of the vessel 2. The tapered interface 4c is
10 caused to be in such intimate interference and compressive contact as to effectively
11 eliminate the annular assembly clearance and thus obviate and tendency or
12 opportunity for extrusion. In an embodiment, the tapered interface 4c is immediately
13 adjacent the annular recess 17a, ensuring any assembly clearance is closed
14 immediately adjacent the annular seal element 17.

15 The insert's annular seal element 17 imposes a radial sealing load on
16 the cylindrical sealing bore portion 12. At high pressures, over time, liner creep in
17 response to sustained radial sealing load can lessen the sealing contact and result
18 in leakage past the annular seal element 17. The annular seal element 17 can also
19 extrude from the annular recess 17a into the annular assembly clearance when the
20 sealing contact is lessened. This problem can be overcome by sufficiently pre-
21 stressing the liner 5 around the annular seal element 17. Threaded engagement of
22 the insert 9 compresses the tapered compression surface 19 and compressively
23 loads the liner outlet 5a at the tapered bore portion 13, the compressive influence

1 including the material of the liner about the cylindrical sealing bore portion 12. The
2 tapered bore portion 13 is compressed between the insert's tapered compression
3 surface and the boss 3 at the tapered interface 4c. The load imparts sufficient pre-
4 stress in the liner 5 to resist and counteract creep.

5 A threshold compression or pre-determined amount of pre-stress can
6 be controlled. In one embodiment, the threshold compression is controlled by
7 monitoring the torque necessary to set the insert 9 into the profiled bore 4a. In this
8 embodiment, the insert's profiled surface 4b is threadably engaged with the profiled
9 bore 4a. The insert 9 is rotated to engage the tapered bore portion with the tapered
10 compression surface for compressing the liner outlet 5a around the annular seal
11 element 17. The torque necessary to engage the tapered bore portion with the
12 tapered compression surface to a threshold compression is monitored. Rotation of
13 the insert 9 is stopped when a threshold torque signifies the threshold compression
14 has been achieved. As the insert 9 is threaded into the profiled bore 4a the tapered
15 surface 19 meets the tapered bore portion 13 and the tapered bore portion 13 is
16 compressed. The torque necessary to rotate the insert 9 increases to the threshold
17 torque. When the torque reaches the threshold torque, sufficient compression has
18 been achieved. Further, the retaining shoulder 20a engages the annular distal end
19 14 of the liner 5, firstly as a stop for preventing axial movement of the liner outlet 5a
20 to maintain dimensional integrity and optionally, secondly, for imparting additional
21 compression.

22 In another embodiment, the threshold compression is controlled by
23 determining a corresponding axial threaded insertion and forming the insert 9 with

1 the outer terminating shoulder 24c (such as the diametral change at the hexagonal
2 tool) to engage the boss 3 when the necessary threaded insertion has been
3 achieved. One can match the datum surface 24 on the boss 3 with the terminating
4 shoulder 24c on the insert 9 , the axial positioning of each of which being calculated
5 to stop the axial insertion of the insert by “bottoming” of the terminating shoulder 24c
6 against the boss’s datum surface 24b when the threshold compression is achieved.
7 The axially spacing of the elements of the insert 9 and the elements of the boss 3,
8 are dimensionally spaced so as to: locate the O-ring seal 17 in the cylindrical sealing
9 bore portion, engage and compress liner’s tapered bore portion 13, and axially retain
10 the annular distal end 14 of the liner upon or prior to the insert’s outside components
11 engage or bottom out on the boss’s outside face.

12 With reference to Fig. 15, in the case of an O-ring seal, and over time,
13 high pressure gas such as hydrogen permeates through the O-ring and fills any
14 minor downstream O-ring voidage between the annular seal groove or recess 17a,
15 the O-ring 17 and the cylindrical sealing surface 12. During rapid decompression of
16 the cylinder 2, trapped, high pressure gas in the annular recess 17a will be restricted
17 from escaping. If the rate of decompression is sufficiently high, then the trapped gas
18 can push the O-ring 17 back into the cylinder 2, extruding along the parallel,
19 cylindrical surfaces of the liner 5 and insert 9.

20 A solution is to provide a small decompression leak path from the O-
21 ring voidage, to bypass the tapered interface, and into the insert-securing portion 15
22 or threaded section between the boss 3 and the insert 9, which itself is a poor seal.

Accordingly, a conical sleeve 28 is provided as part of the insert 9 and is formed of a compatible insert material, such as metal. The decompression leak path formed between the conical sleeve 28 and the insert 9 extends between the annular seal element 17 and the bore-securing portion 21. The conical sleeve 28 is fit to the insert 9 between the annular seal element 17 and the bore-securing portion 21. The conical sleeve 28 has a tapered outside surface 28a, a cylindrical inside bore 28b and an upstream end 28c. The tapered outside surface 28a forms the insert's tapered compression surface 19 and performs the same compression objectives as described in the previous embodiment when the conical sleeve 28 is fit to the insert. The upstream end 28c forms a wall of the annular recess 17a housing the annular seal element 17 when the conical sleeve 28 is fit to the insert 9. The cylindrical inside bore 28b which fits to a cylindrical outside surface of the insert 9 forms a metal-to-metal interface. The metal-to-metal interface forms a decompression leak path between the conical sleeve 28 and the insert 9. The leak path extends from the O-ring voidage, past the retaining shoulder 20 and threaded portion between the insert 9 and the boss 3. The O-ring voidage is downstream of the annular seal element 17. Little of the cylinder's contents should pass the O-ring seal 17. Accordingly, while the metal-to-metal interface is restrictive, there is a sufficient leak path to avoid a high pressure build up and associated energy capable to extruding the O-ring 17 on quick or rapid decompression of the cylinder 2.

Differential thermal expansion of the differing materials at the outlet can be minimized. Differential thermal expansion can occur as the plastic material of the liner outlet 5a has a higher co-efficient of thermal expansion (CTE) than that the

1 material of -the boss 3. In both embodiments of the sealing system, radial
2 expansion of the liner outlet 5a due to temperature changes can be minimised by
3 reducing the thickness of liner material in the the liner outlet 5a. In both
4 embodiments of the sealing system, should a leak develop over time due to
5 deterioration of the O-ring or the sealing surface on the liner outlet 5a or the sealing
6 surface on the insert 9, the liner outlet or insert sealing surfaces can be serviced or
7 repaired. This is possible as the liner outlet 5a extends into the bore 4 of the boss 3
8 and can be easily accessed for repair or service. As the O-ring is located on the
9 insert 9 and since the insert 9 can be disengaged from the boss, the O-ring can also
10 be easily replaced.

11 Accordingly, a method for servicing the sealing system of Figs. 1A to
12 11B and Figs. 12 to 17 is provided. The method comprises disengaging the insert 9
13 engaged with the liner outlet 5a from the bore 4 of the boss 3 for exposing the
14 profiled bore 4a. The annular seal element 17 is replaced, if the same requires
15 replacement. The annular seal element normally sealably engages with the profiled
16 bore 4a. The sealing surfaces located on the liner outlet 5a namely the tapered bore
17 portion 13 and/or the cylindrical sealing bore portion 12 are refurbished. The sealing
18 surfaces located on the insert 9, namely the tapered compression surface 19 and
19 the cylindrical plug portion 18, while robust, could also be refurbished. The bore-
20 securing portion 21, the insert securing portion 15, the annular distal end 14 and the
21 retaining shoulder 20, 20a can also be refurbished as necessary during the servicing
22 operation.

23

1 THE EMBODIMENTS OF THE INVENTION FOR WHICH AN
2 EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS
3 FOLLOWS:
4

5 1. A sealing system for an outlet of a plastic-lined cylinder for
6 compressed gas, the plastic-lined cylinder comprising a plastic liner and a boss, the
7 boss having a bore for accessing the cylinder, the sealing system comprising:

8 a liner outlet of the plastic liner extending axially into the bore of the
9 boss to form a profiled bore, the profiled bore comprising a liner section and a boss
10 section, the liner section comprising a cylindrical, sealing bore portion, a tapered
11 bore portion, and an annular distal end having an axial position in the boss's bore,
12 and the boss section comprising an insert-securing bore portion;

13 an insert having a profiled surface and engageable with the profiled
14 bore for sealing the profiled bore, the insert's profiled surface comprising an annular
15 seal element, a tapered compression surface, and a bore-securing surface; and

16 a retaining shoulder;

17 wherein, when the bore-securing surface axially engages the insert-
18 securing bore portion, the insert's profiled surface engages the profiled bore, the
19 seal element corresponding and sealing with the sealing bore portion to form an
20 annular primary seal, the retaining shoulder engaging the annular distal end for
21 retaining the annular distal end at the axial position in the boss's bore, and the
22 tapered compression surface corresponding and engaging with the tapered bore
23 portion for forming an annular tapered interface and compressing the liner outlet to
24 form a tapered secondary seal.

25

1 2. The sealing system of claim 1, wherein the retaining shoulder is
2 formed in the insert's profiled surface between the bore-securing surface and the
3 tapered compression surface.

4
5 3. The sealing system of claim 1 or 2, wherein the seal element is
6 fit in an annular recess formed circumferentially about the insert's profiled surface.

7
8 4. The sealing system of claim 3, wherein the tapered interface is
9 axially spaced from the annular recess.

10
11 5. The sealing system of claim 3 or 4, wherein the annular recess
12 further comprises a wall between the seal element and the tapered interface, the
13 system further comprising a backer ring located in the annular recess and positioned
14 axially between the seal element and the wall for resisting extrusion of the seal
15 element into the tapered interface.

16
17 6. The sealing system of any one of claims 1 to 5, wherein the
18 insert-securing bore portion is an internal threaded portion and the bore-securing
19 surface is an external threaded portion.

20
21 7. The sealing system of any one of claims 1 to 6, wherein the
22 tapered interface is a truncated frustum of a right circular cone.

1 8. The sealing system of any one of claims 1 to 7, wherein the liner
2 is a monolayer or a multi-layer structure.

3
4 9. The sealing system of any one of claims 1 to 8, wherein the liner
5 outlet is threadably coupled to the boss.

6
7
8 10. The sealing system of any one of claims 1 to 9, wherein the liner
9 outlet is coupled to the boss by a metal-bonding adhesive material.

10
11 11. The sealing system of any one of claims 1 to 10, wherein the
12 liner is adapted to store the compressed gas at pressures of about 250 bar.

13
14 12. The sealing system of any one of claims 1 to 11, wherein the
15 insert is a flow through type or plug type insert.

16
17 13. The sealing system of any one of claims 1 to 12, wherein the
18 boss has a first annular datum surface at an outlet of the boss and a second annular
19 datum surface at a flare of the boss and the insert has a terminating outer shoulder,
20 the system further comprising:

21 the annular distal end of the liner outlet is axially spaced a reference
22 distance from the first annular datum surface; and

1 the retaining shoulder is similarly spaced the reference distance from
2 the terminating outer shoulder so that

3 when the terminating outer shoulder engages the first annular datum
4 surface, the retaining shoulder engages and retains the annular distal end at the
5 axial position when the tapered compression surface is engaged with the tapered
6 bore portion.

7
8 14. A method for sealing an outlet of a plastic-lined cylinder for
9 compressed gas, the plastic-lined cylinder comprising a plastic liner and a boss, the
10 boss having a bore for accessing the cylinder, the method comprising:

11 axially extending a liner outlet of the plastic liner into the bore of the
12 boss to form a profiled bore; and

13 engaging an insert having a profiled surface into the profiled bore for
14 forming an annular primary seal and an annular secondary seal with the profiled
15 bore liner outlet by:

16 axially inserting the insert into the profiled bore and engaging a
17 bore-securing surface on the insert with a insert-securing bore portion of the
18 profiled bore for securing the insert to the boss;

19 engaging an annular seal element of the profiled surface insert
20 with a cylindrical sealing bore portion of the profiled bore for forming the
21 primary seal by,

22 compressing a tapered compression surface of the profiled
23 surface with an tapered bore portion of the profiled bore for forming an

1 annular tapered interface, the tapered interface forming the secondary seal;
2 and
3 maintaining an axial position of an annular distal end of the liner
4 outlet in the boss's bore by retaining the annular distal end of the liner outlet
5 against a stop.
6

7 15. The method of claim 14 wherein the maintaining of the axial
8 position of an annular distal end in the boss further comprises:

9 providing the stop in the insert's profiled surface between the bore-
10 securing surface and the tapered compression surface; and

11 engaging the stop against the annular distal end of the liner outlet
12 against the stop.
13
14

1 16. The sealing system of claim 14 or 15, wherein the maintaining
2 of the axial position of an annular distal end in the boss's bore comprises.

3 pre-determining the axial position of the annular distal end of the liner
4 outlet in the boss's bore and axially spaced a reference distance from a first datum
5 surface on the boss; and

6 pre-determining the axial position of the stop axially spaced the
7 reference distance from a datum surface on the insert; and

8 engaging the insert and profiled surface with the profiled bore so that,
9 when the first and second datum surfaces engage, the retaining shoulder engages
10 and retains the annular distal end at the axial position and the tapered compression
11 surface is engaged and compresses the tapered bore portion.

12
13 17. A method for servicing a sealing system of an outlet of a
14 plastic-lined compressed gas cylinder, the cylinder comprising a plastic liner and a
15 boss, the boss having a bore for accessing the cylinder which is normally sealed
16 with an insert, the method comprising:

17 disengaging the insert from the outlet of the cylinder for exposing a
18 profiled bore of a liner outlet extending axially into the bore of the boss;

19 replacing an annular seal element located about the insert, the seal
20 element normally sealably engaging the profiled bore; and

21 refurbishing at least one sealing surface located on the profiled bore.
22

1 18. The method of claim 17 wherein the refurbishing further
2 comprises refurbishing a cylindrical sealing bore portion of the profiled bore which
3 normally seals with the seal element.

4
5 19. The method of claim 17 wherein the profiled bore comprises a
6 sealing bore portion and tapered bore portion, the refurbishing further comprises:

7 refurbishing the sealing bore portion which normally seals with the seal
8 element; and

9 refurbishing the tapered bore portion which normally engages a
10 tapered compression surface on the insert.

11

1/15

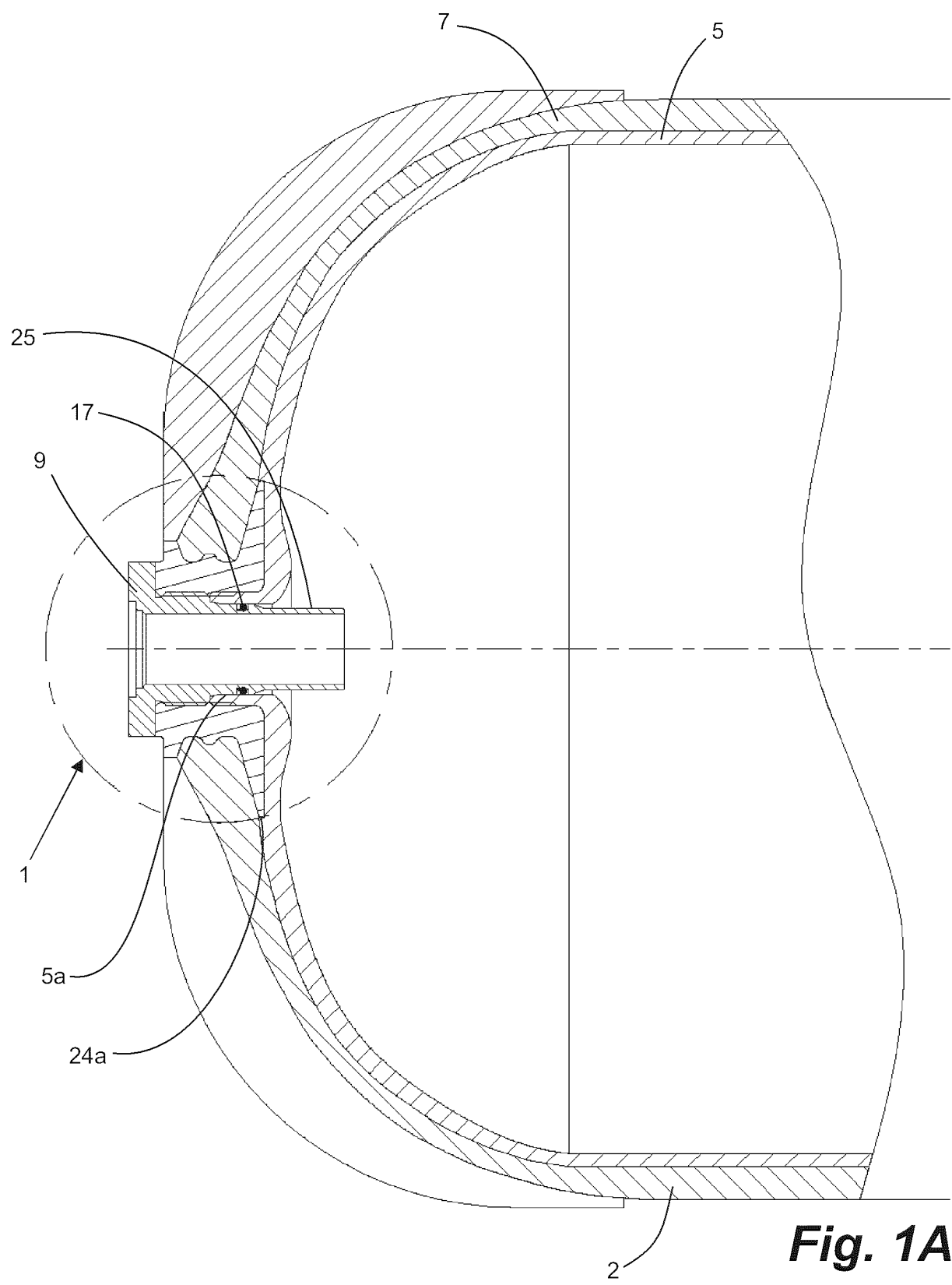


Fig. 1A

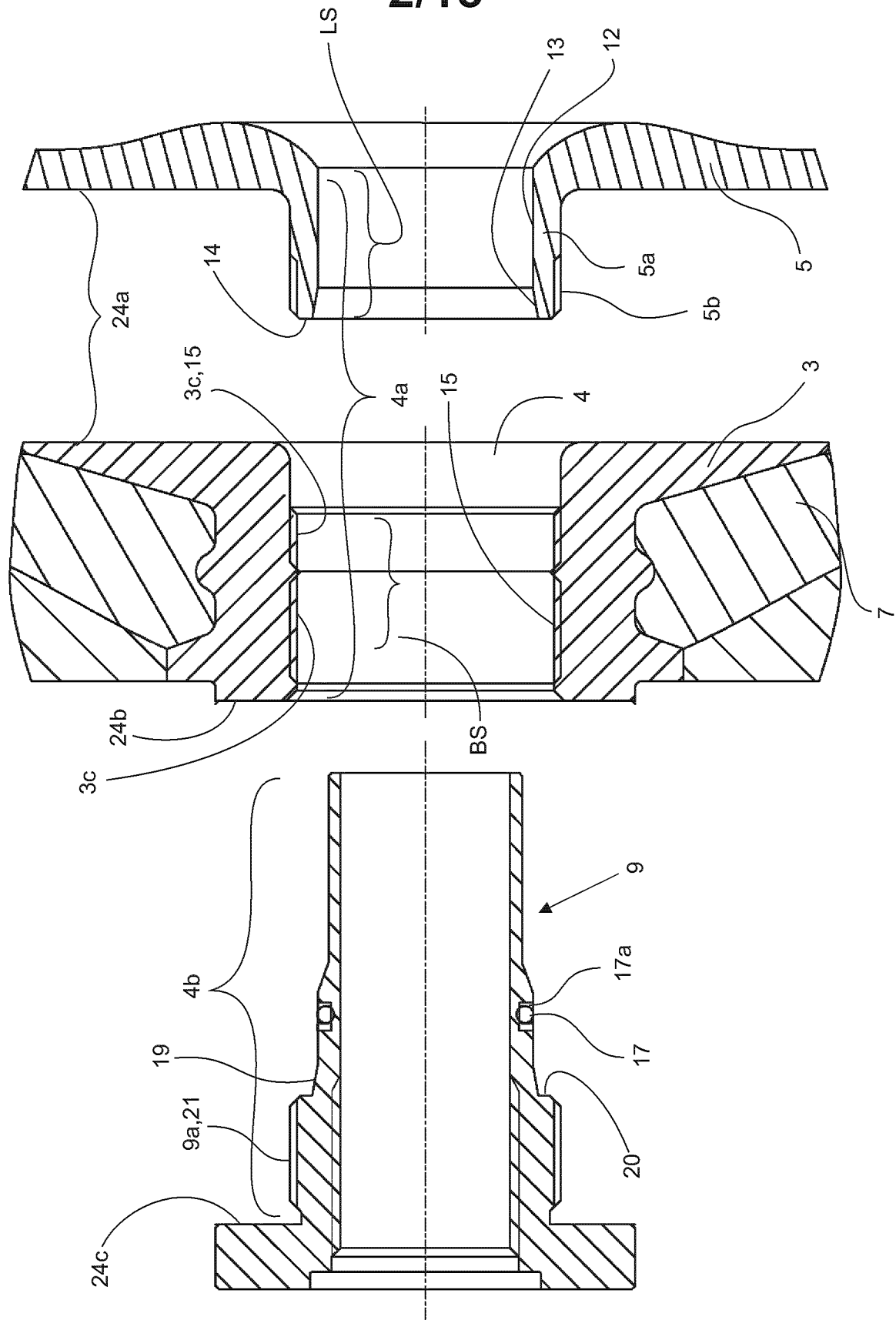


Fig. 1B

3/15

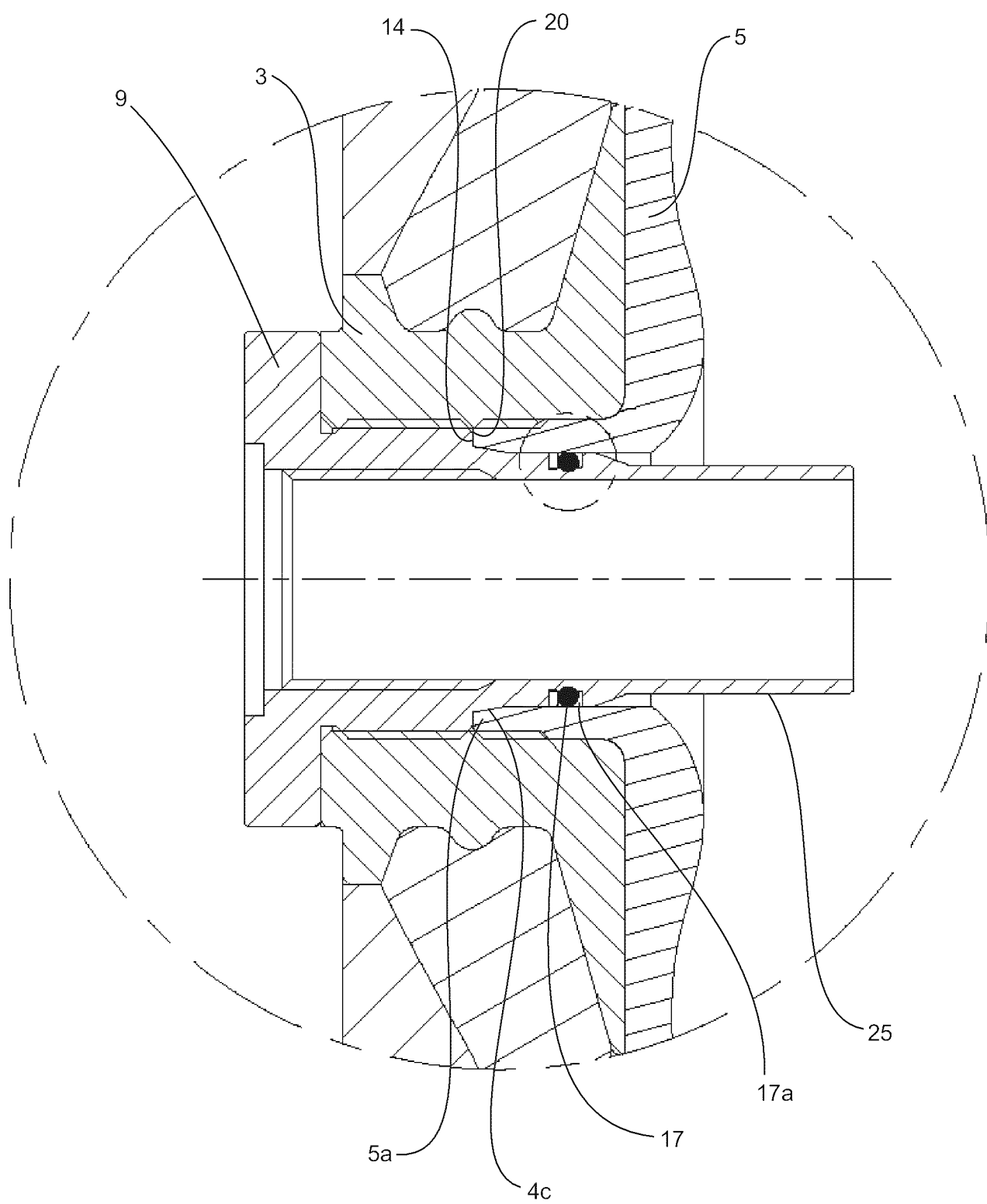


Fig. 2

4/15

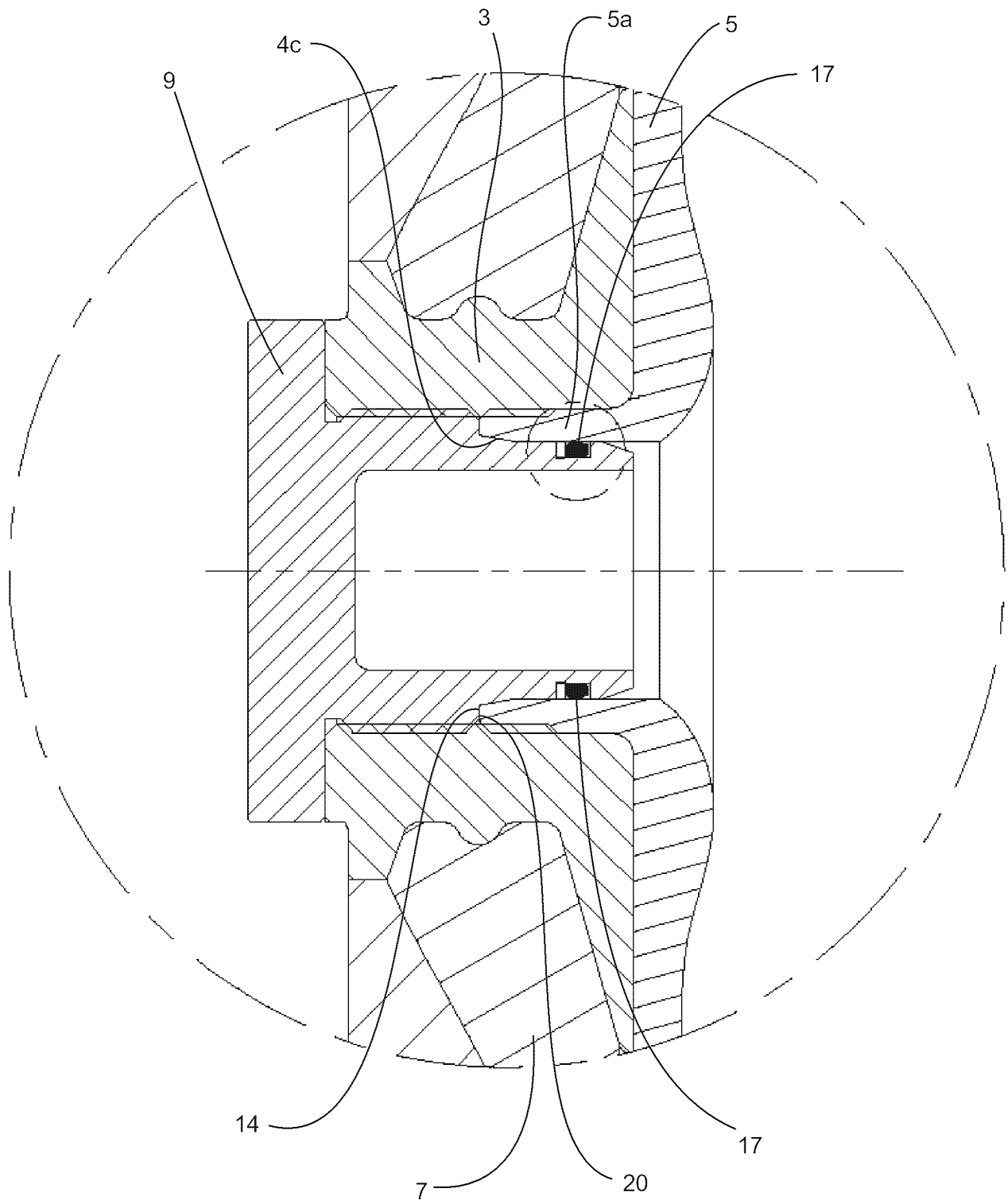


Fig. 3

5/15

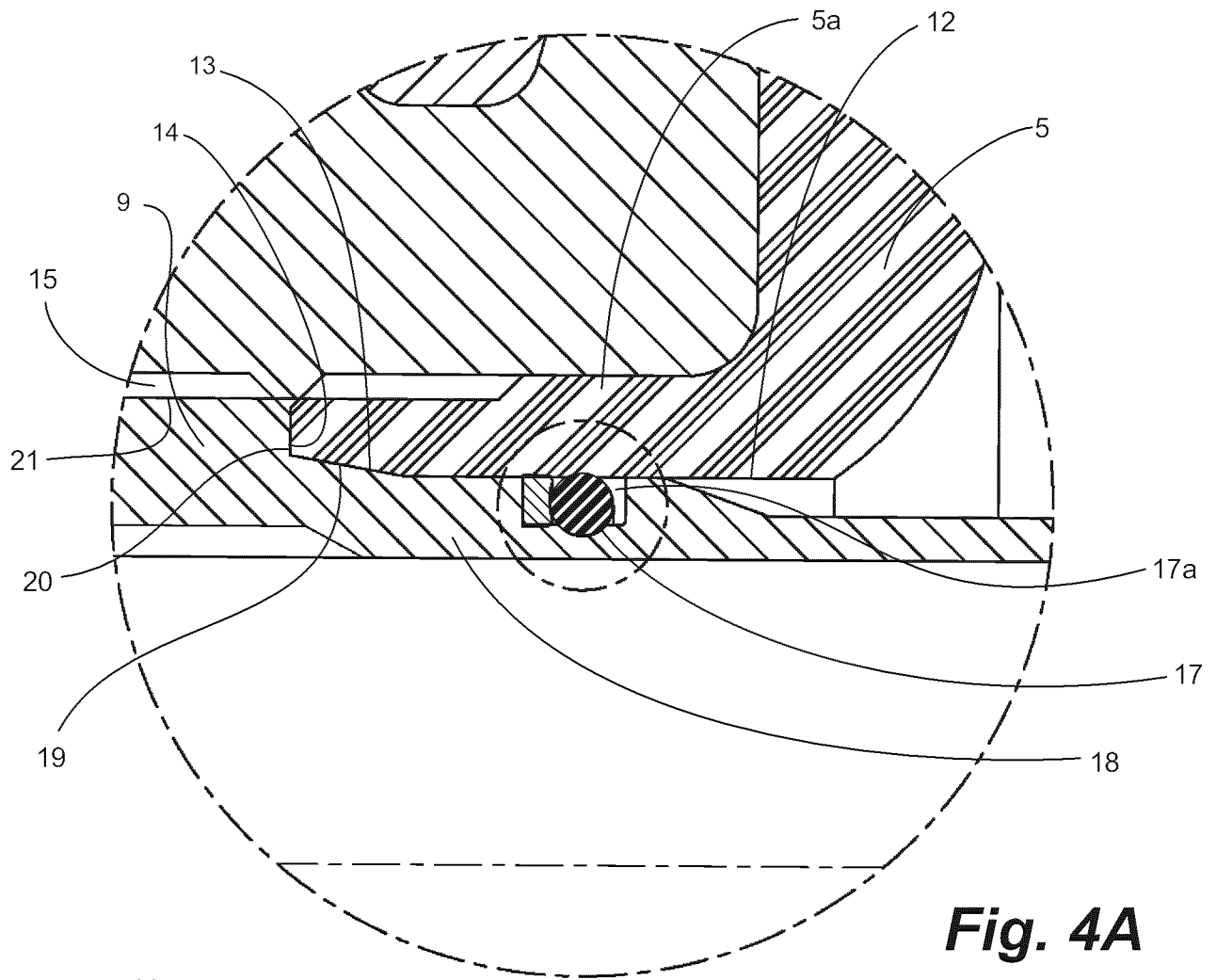


Fig. 4A

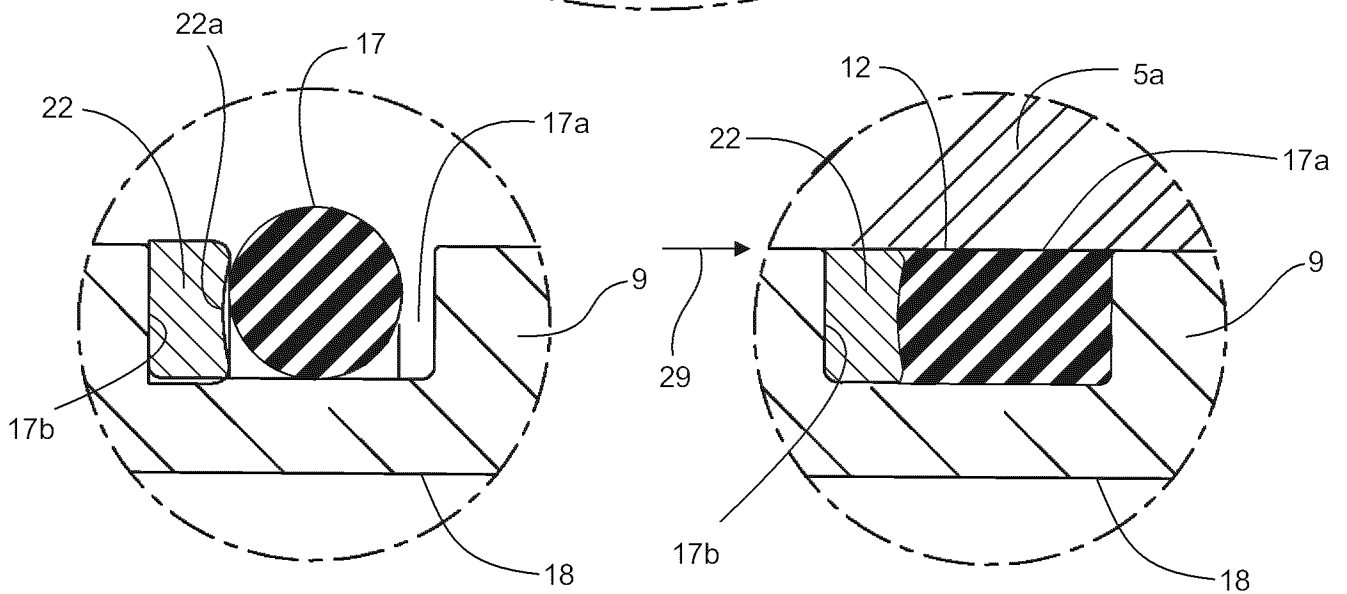


Fig. 4B

Fig. 4C

6/16

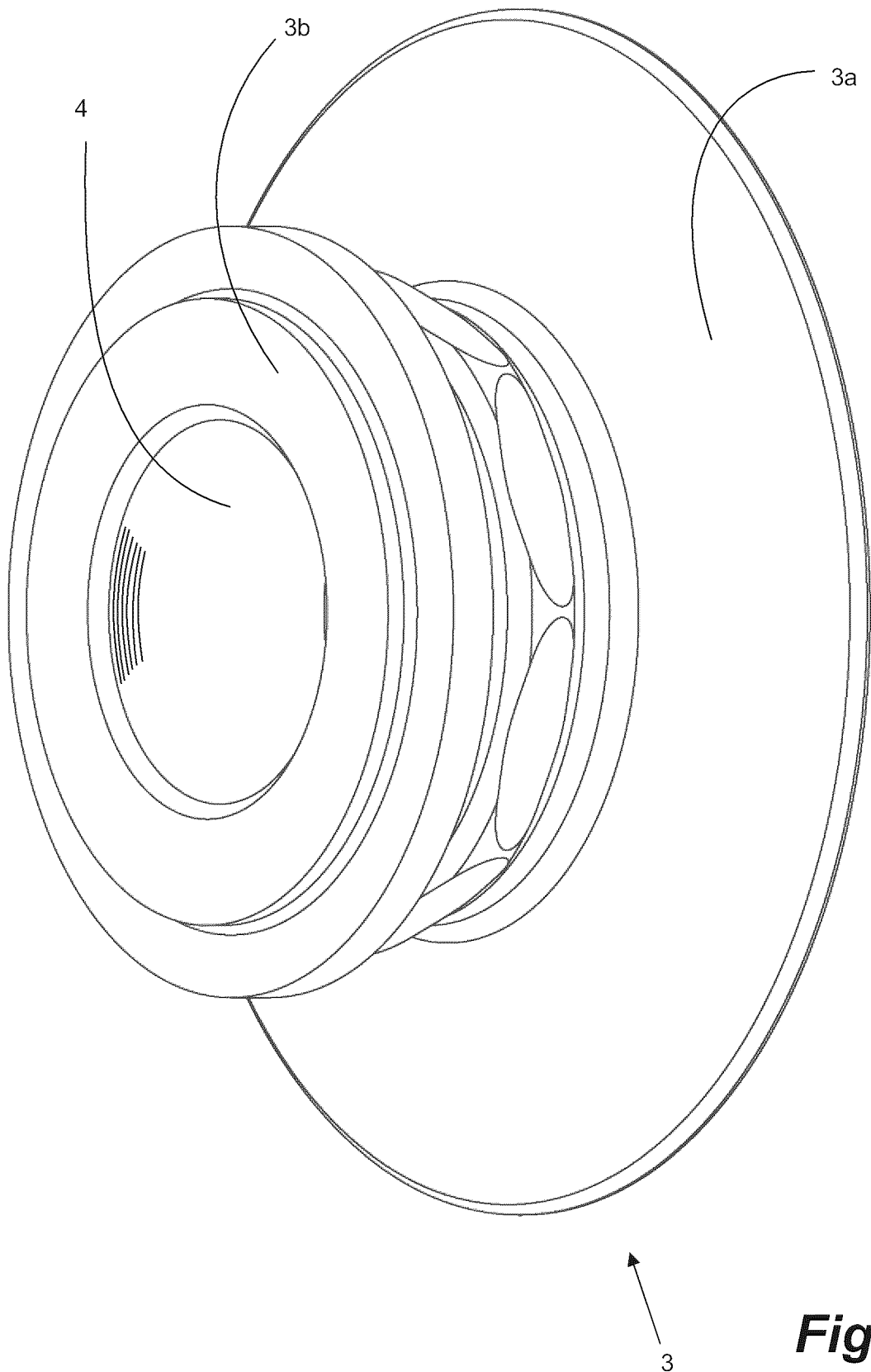


Fig. 5

7/15

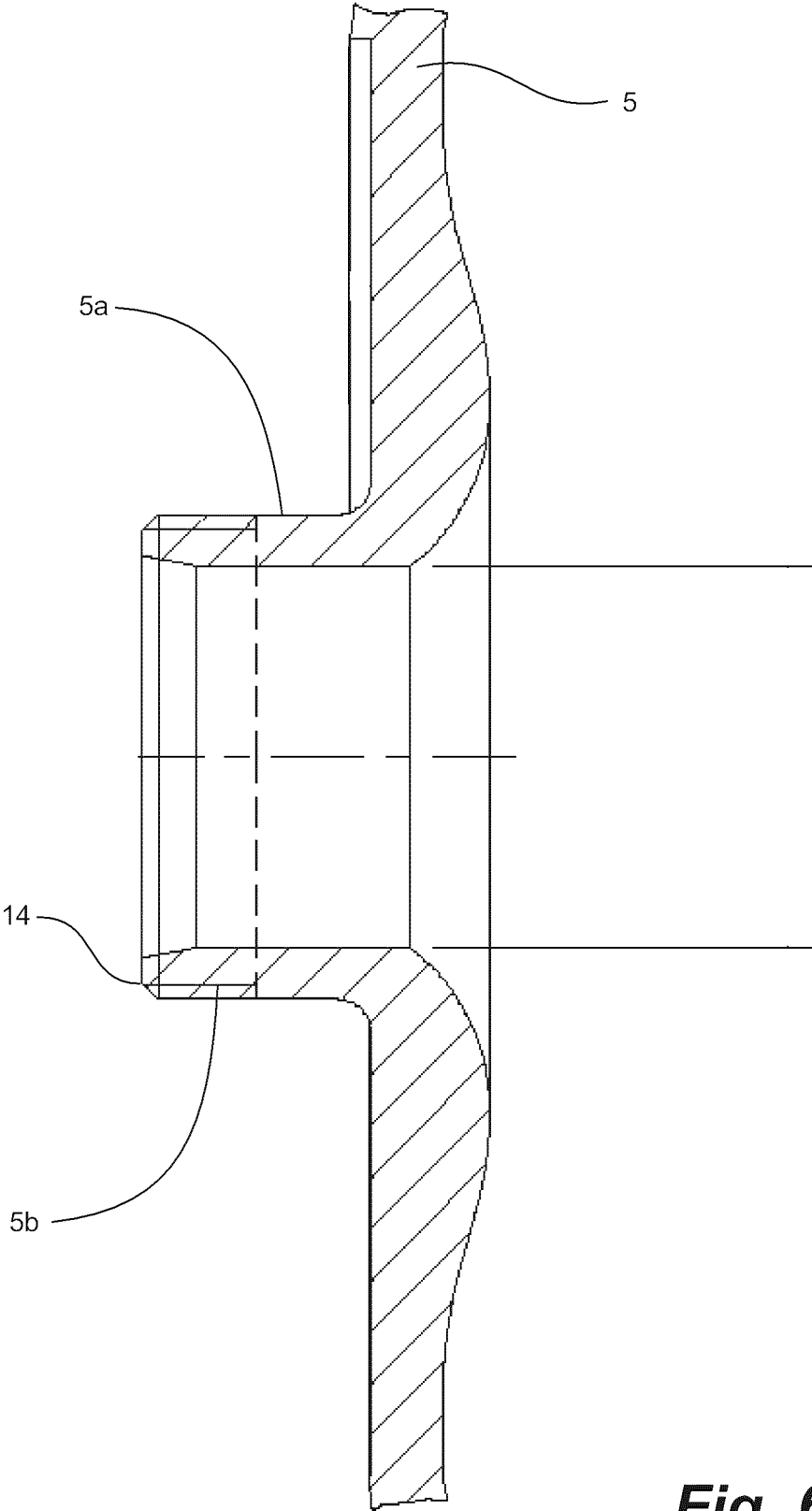


Fig. 6

8/15

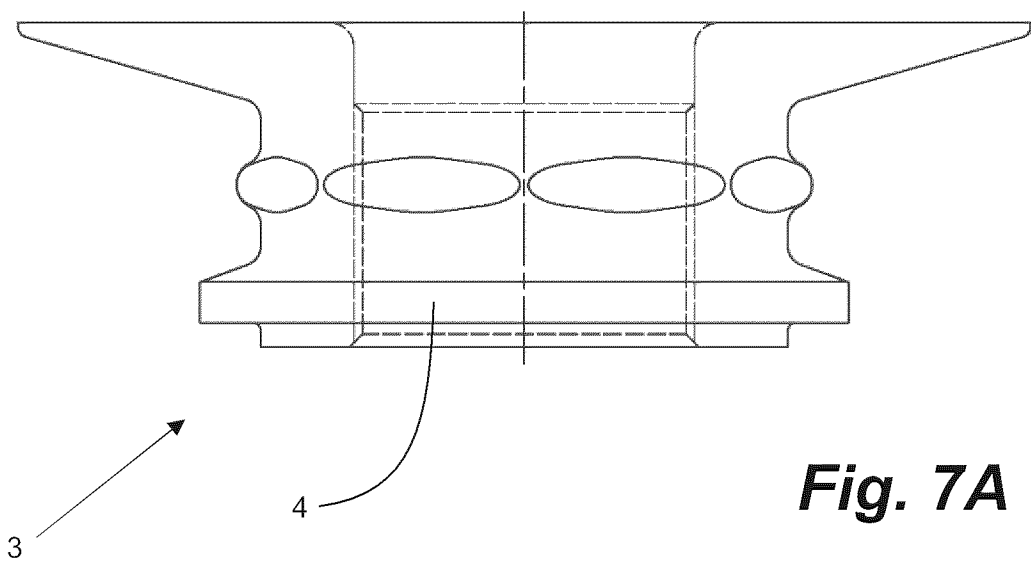


Fig. 7A

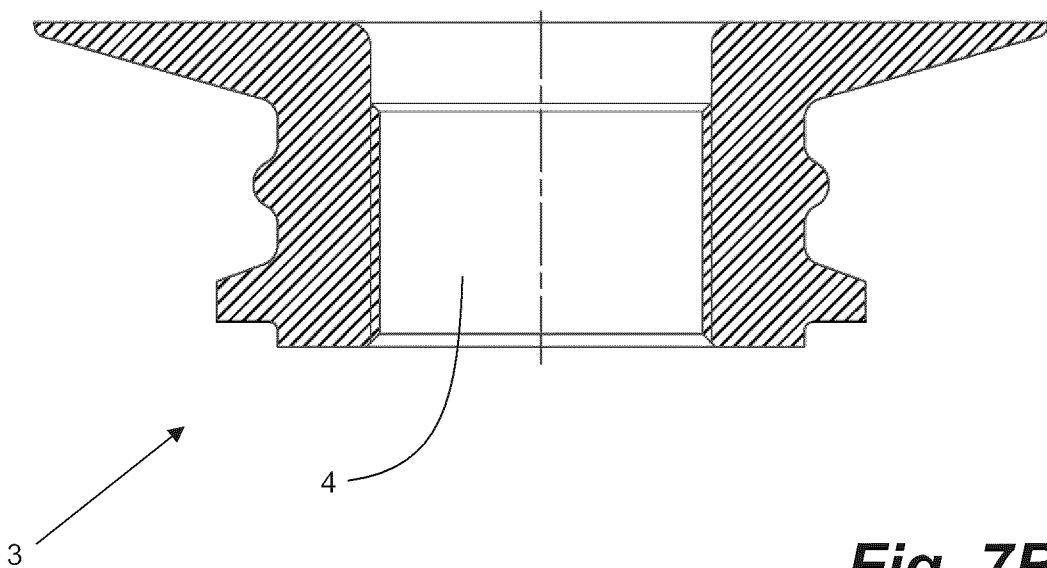
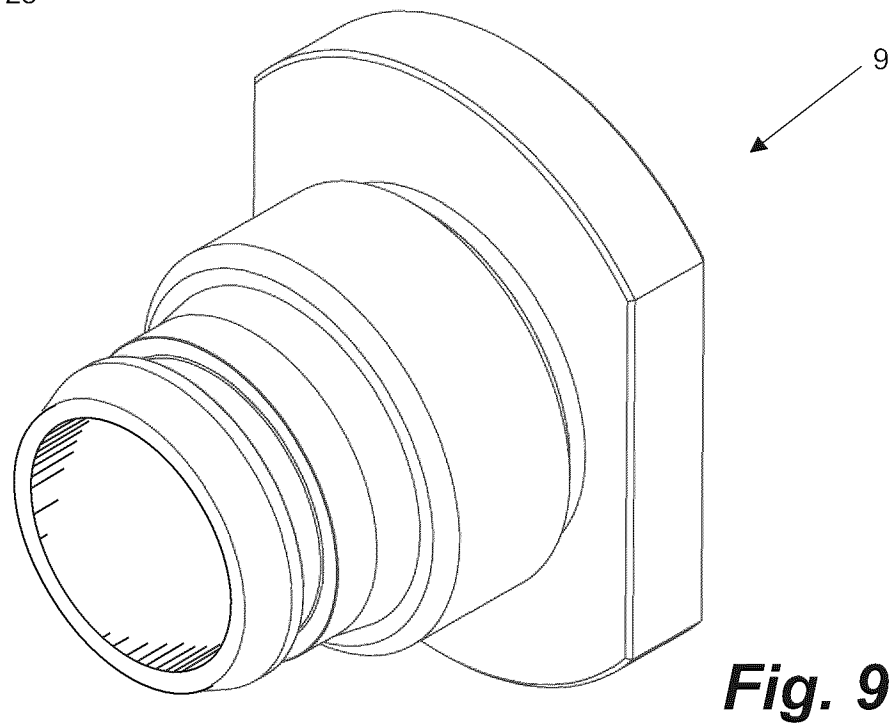
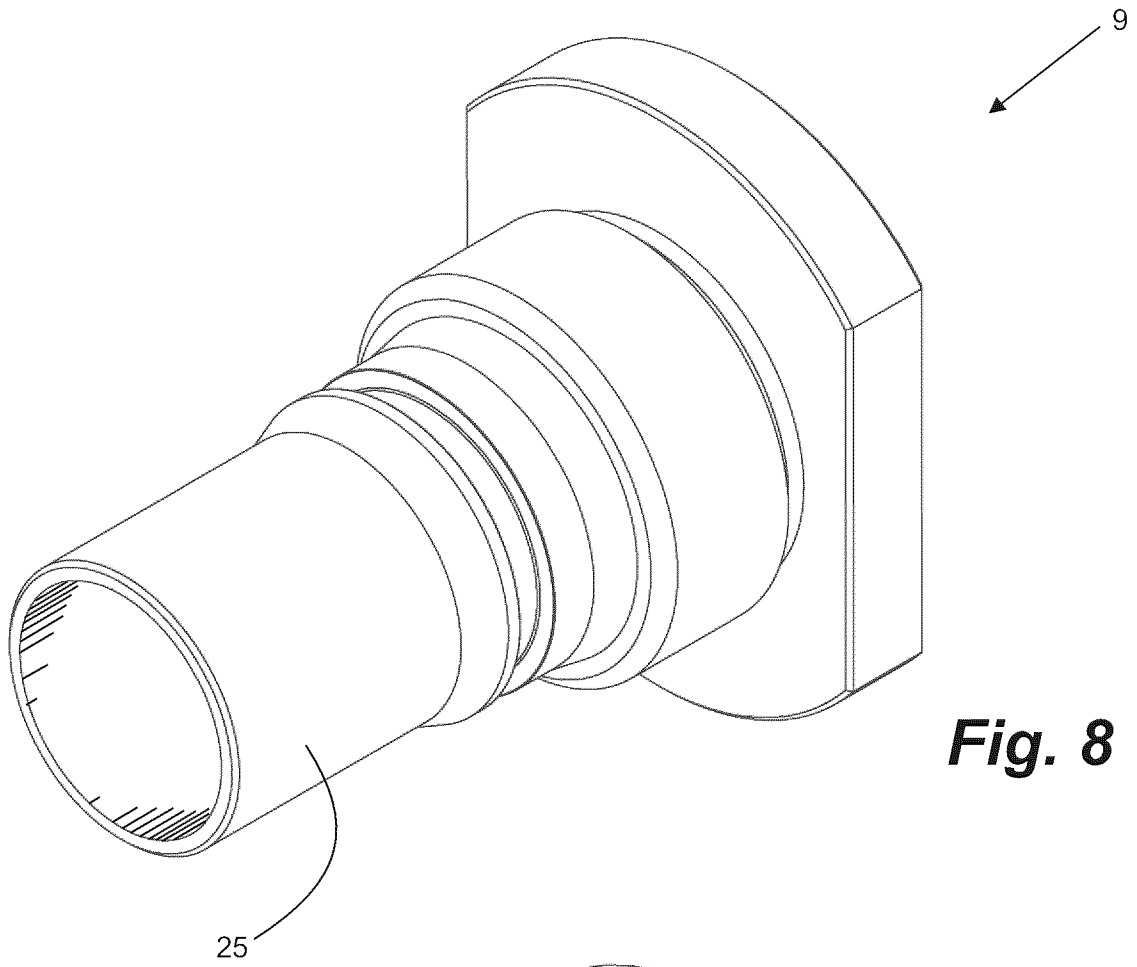
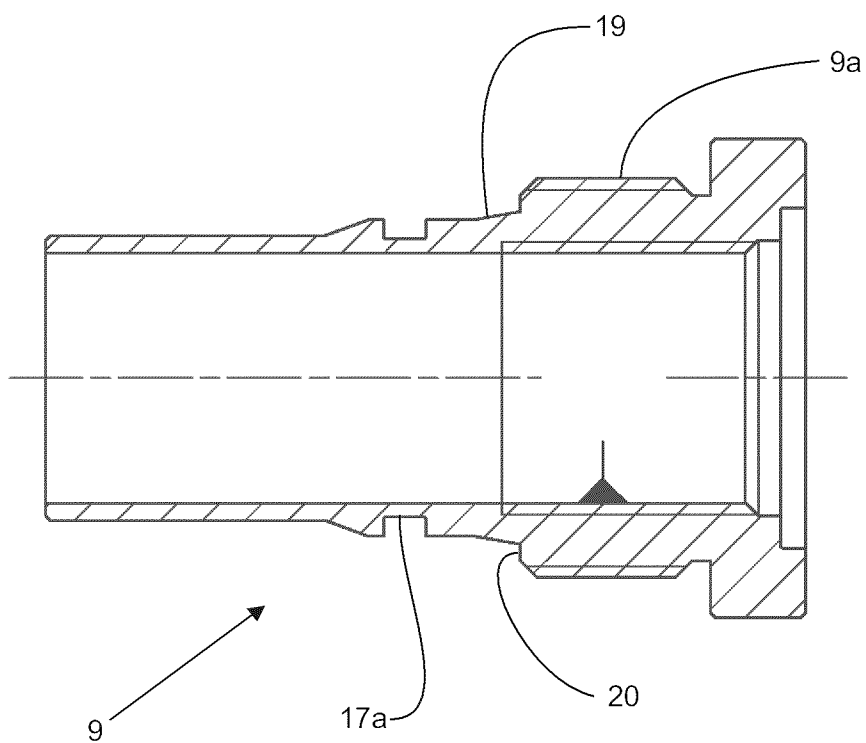
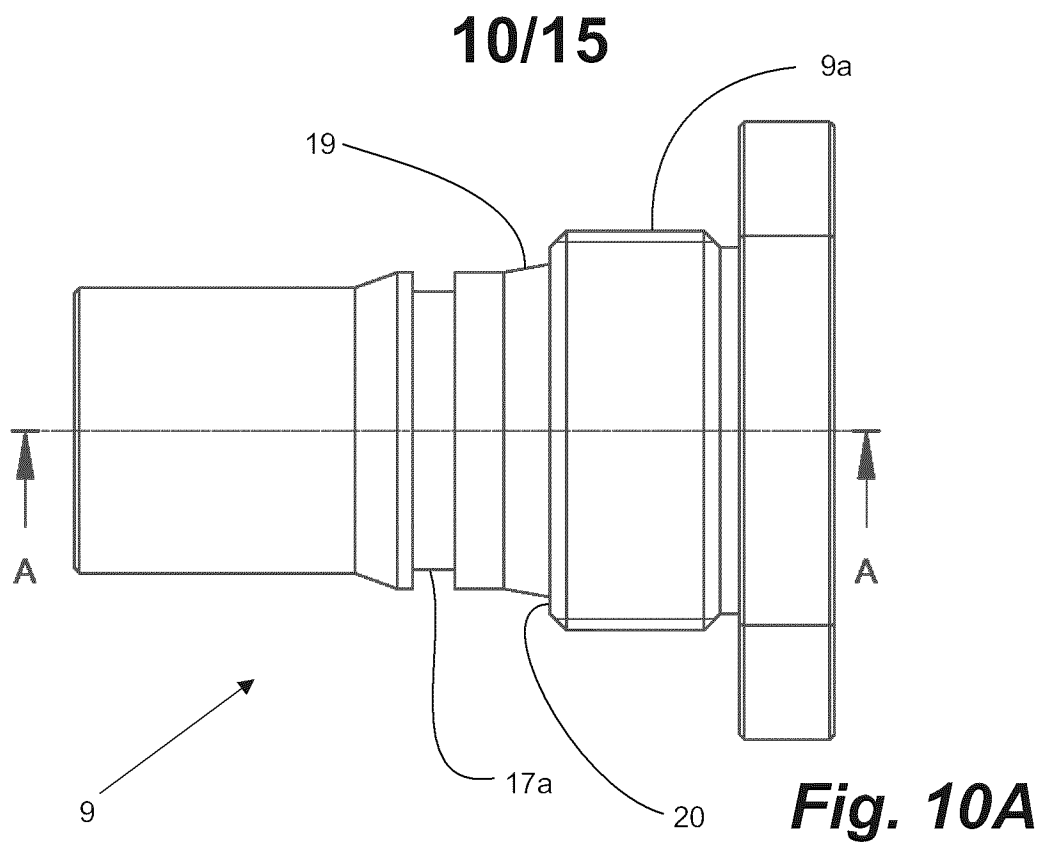


Fig. 7B

9/15





11/15

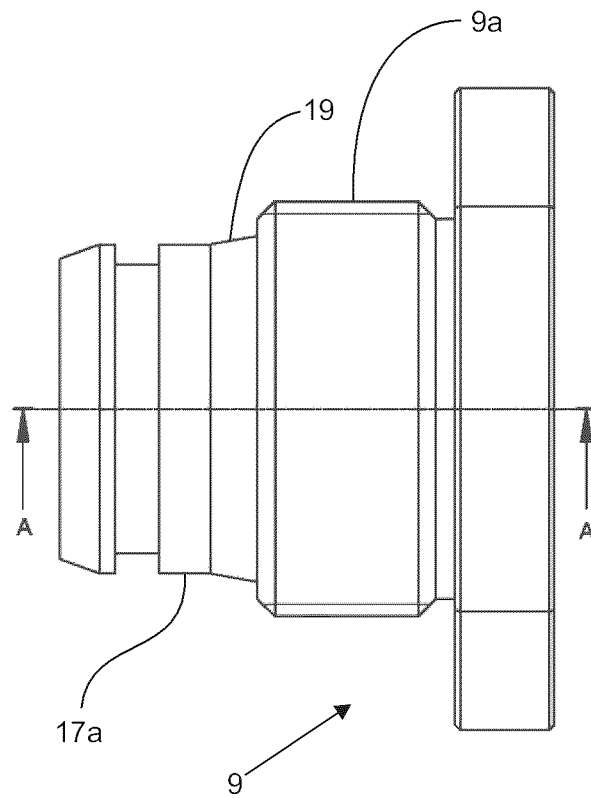


Fig. 11A

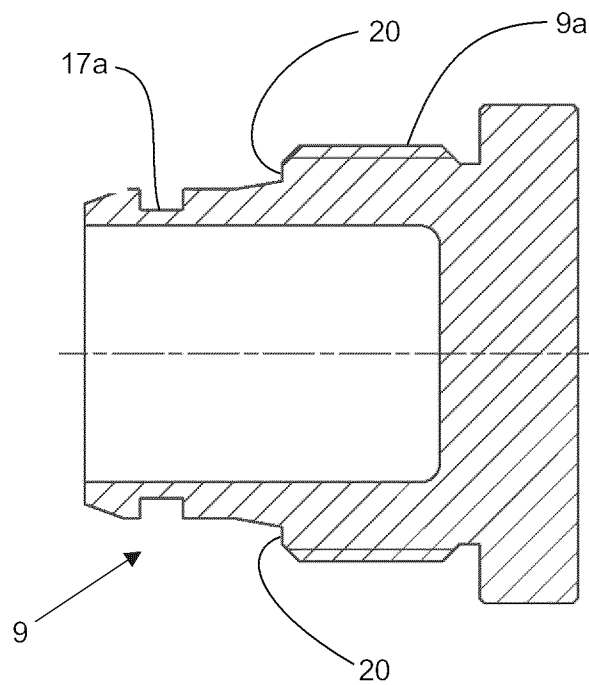


Fig. 11B

12/15

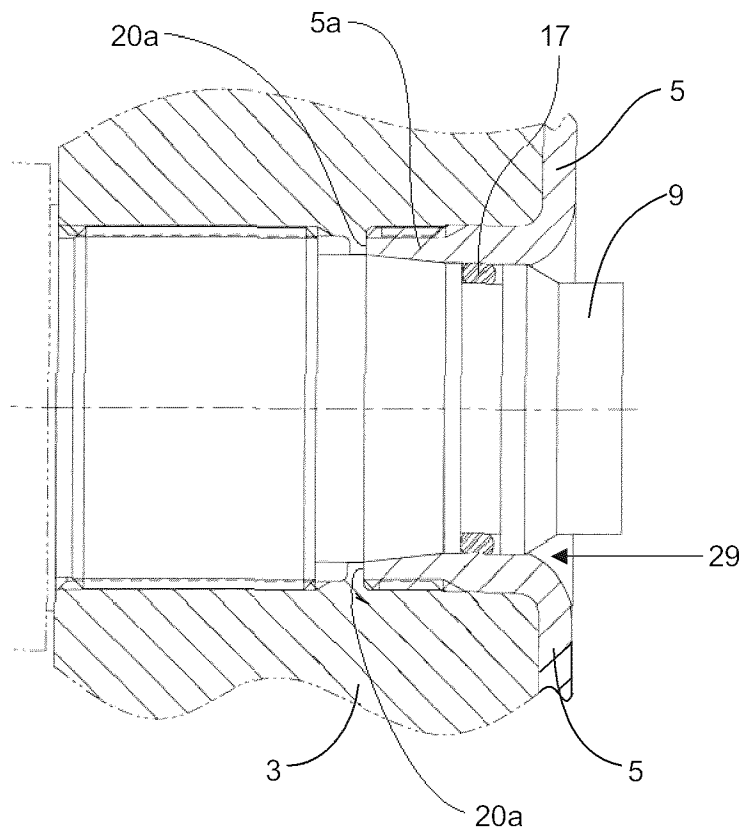


Fig. 12

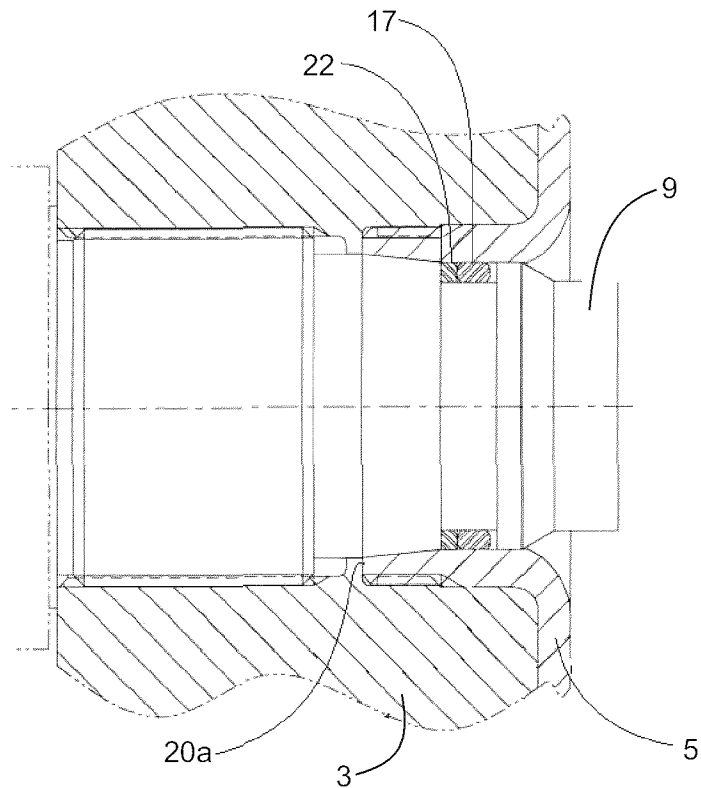


Fig. 13

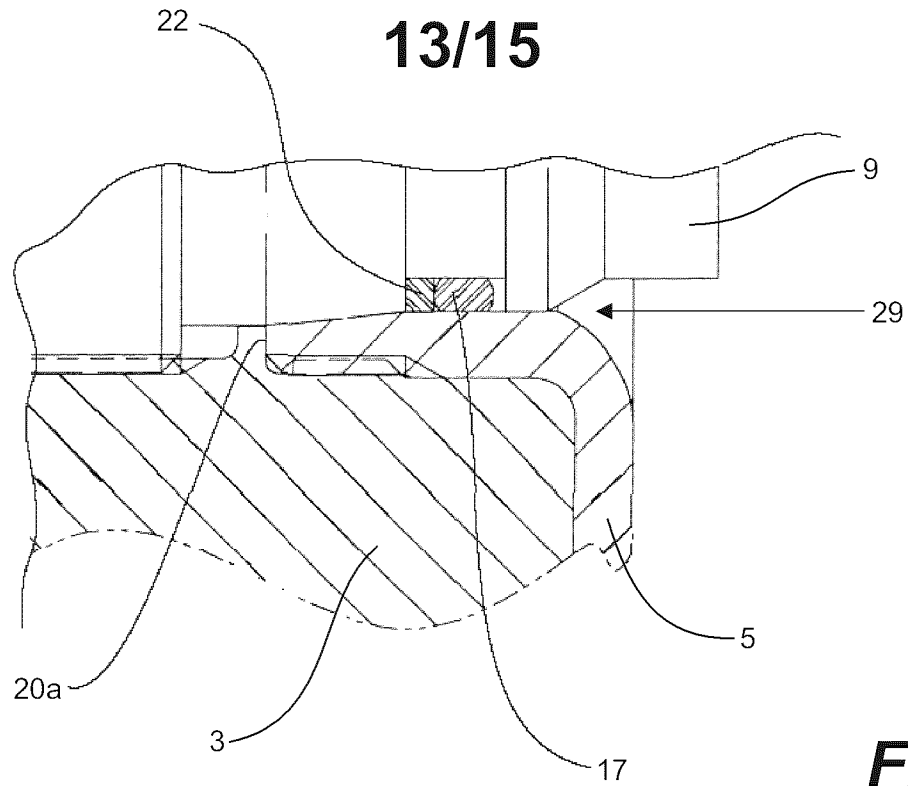


Fig. 14

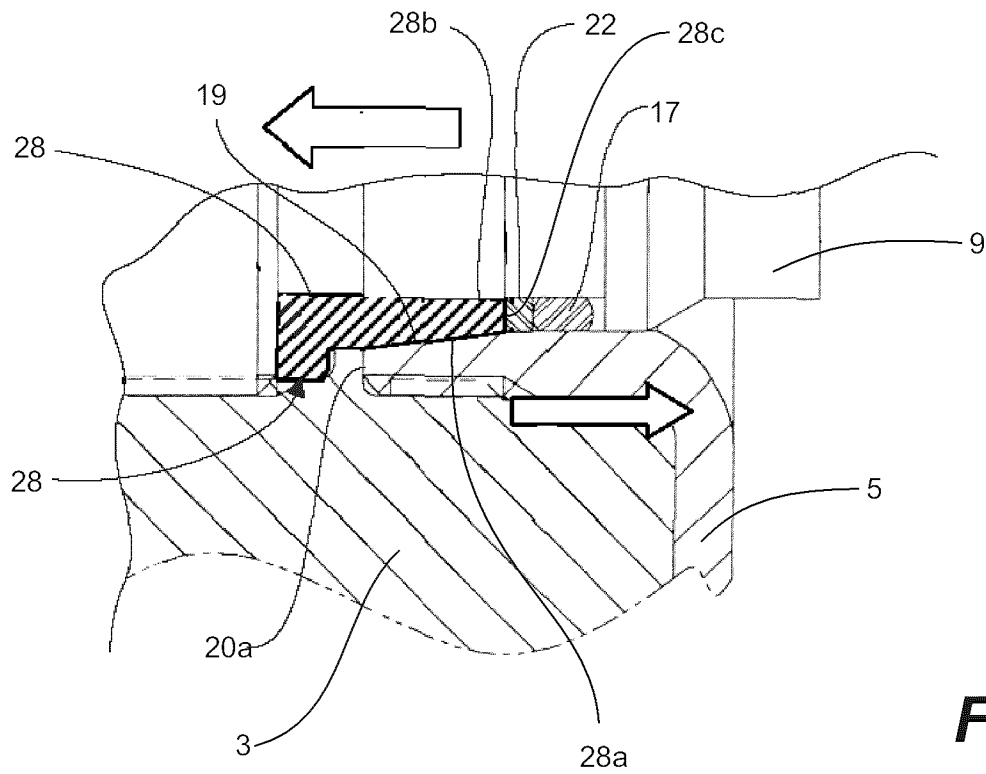


Fig. 15

14/15

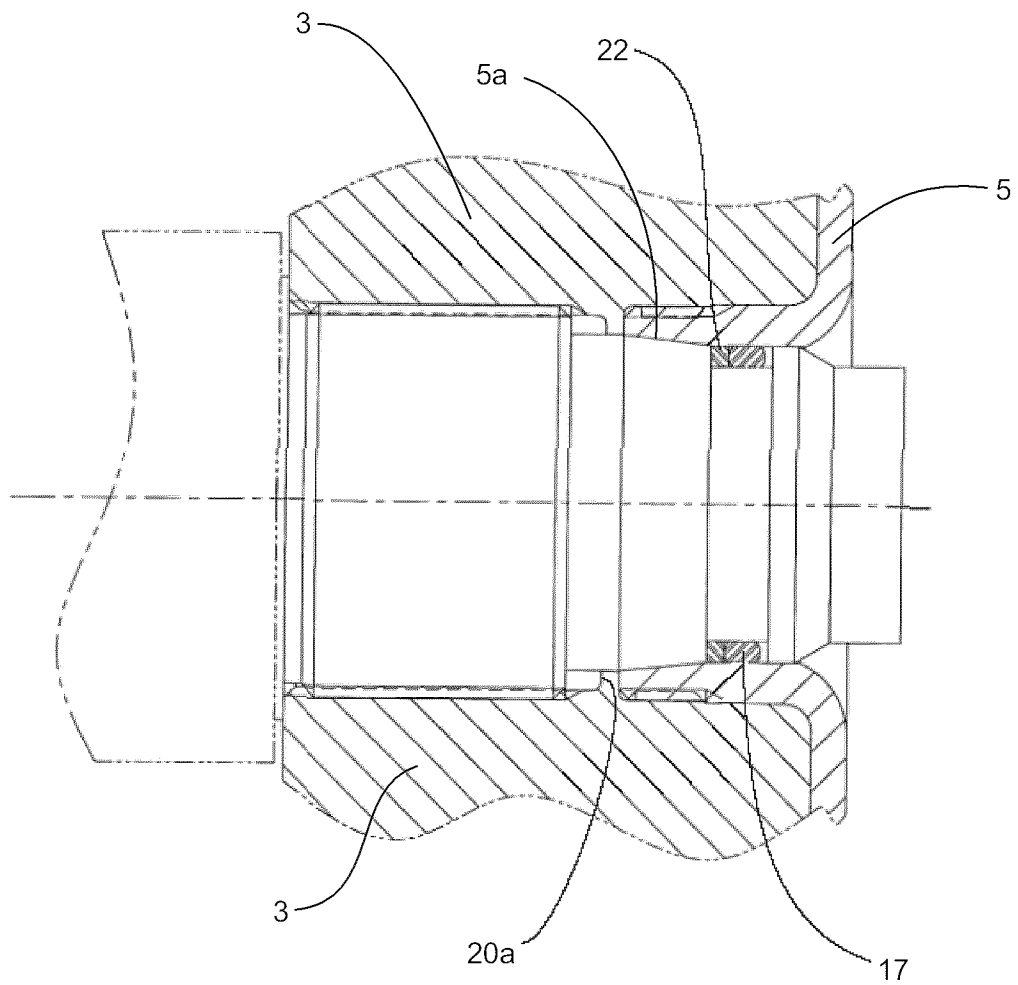


Fig. 16

15/15

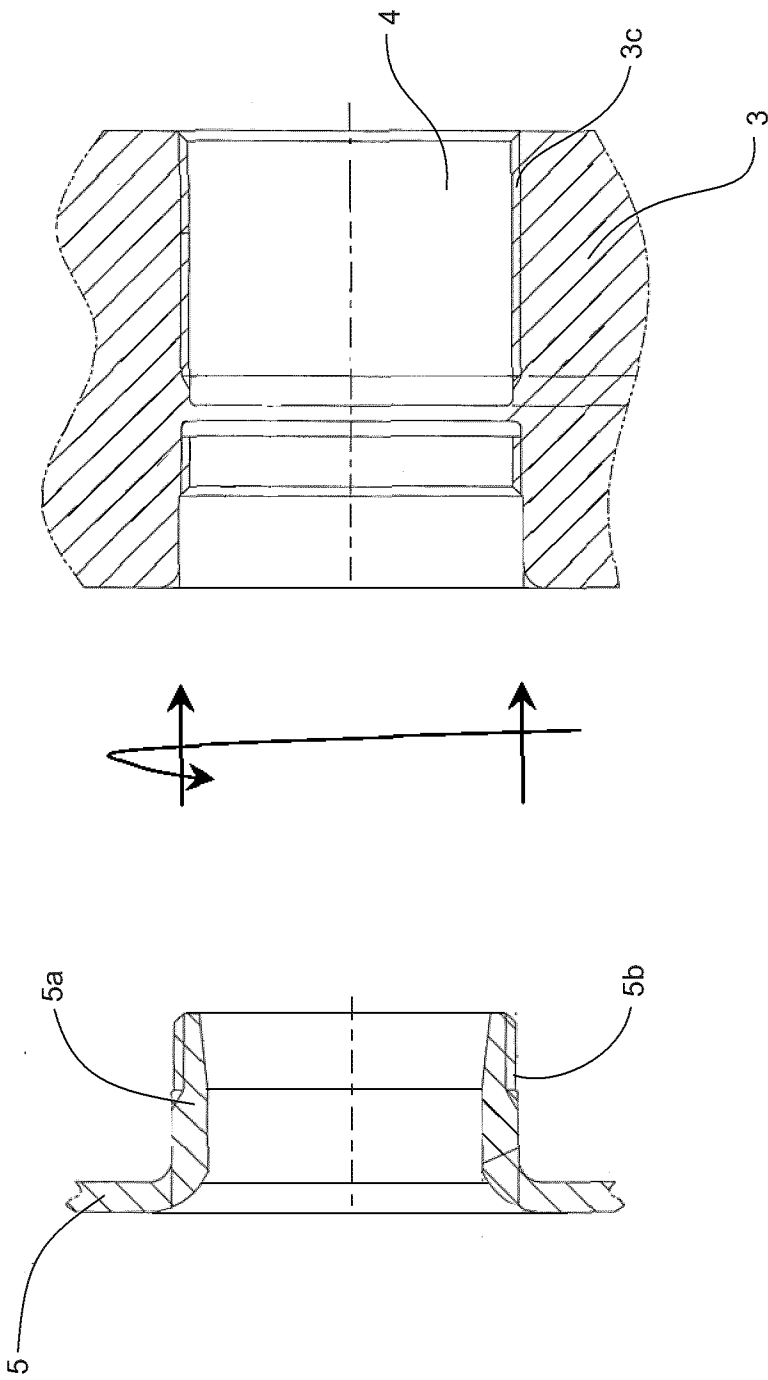


Fig. 17B

Fig. 17A

INTERNATIONAL SEARCH REPORT

International application No.
PCT/CA2011/050118

A. CLASSIFICATION OF SUBJECT MATTER
IPC: **F17C 13/00** (2006.01) , **F16J 12/00** (2006.01) , **F16J 15/02** (2006.01) , **F17C 1/06** (2006.01)
According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC (2006.01) : **F17C 13/00**, **F16J 12/00**, **F16J 15/02**, **F17C 1/06**

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

Electronic database(s) consulted during the international search (name of database(s) and, where practicable, search terms used)
Databases: EPOQUE (EPODOC and Fulltext), the Canadian Patent Database.
Keywords: Tank, vessel, cylinder, boss, seal, gas and similar words.

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X Y	US2008/0251520 A1 (OTA, M. et al.) , 16 October 2008 (16-10-2008) * Abstract, figs. 1-5, Paragraphs [0027]- [0057] *	17-18 1-16, 19
X Y	WO 00/49330 (BERKLEY, G.; WARNER, M.J.) , 24 August 2000 (24-08-2000) * Abstract, figs. 1, 3 and 4, p. 5, line 10 - p. 9, line 21*	17-18 1-16, 19
Y	US5429845 (NEWHOUSE, N.L. et al.) , 04 July 1995 (04-07-1995) * Abstract, fig. 3, col. 4, line 60 - col. 6, line 2*	1-16, 19
A, P	CN101832389 (QIANG, L.) , 15 September 2010 (15-09-2010) * Whole document*	1-19
A	US5494188 (SIROSH, S.N.) , 27 February 1996 (27-02-1996) * Abstract, figs. 4-5, col. 4, line 26 - col. 6, line 5*	1-19

☐ Further documents are listed in the continuation of Box C.

☒ See patent family annex.

* Special categories of cited documents :	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier application or patent but published on or after the international filing date	"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search
2 May 2011 (02-05-2011)

Date of mailing of the international search report
7 June 2011 (07-06-2011)

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Authorized officer

Salim Riad Taleb (819) 934-2658

INTERNATIONAL SEARCH REPORT
Information on patent family members

International application No.
PCT/CA2011/050118

Patent Document Cited in Search Report	Publication Date	Patent Family Member(s)	Publication Date
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US5494188A	27 February 1996 (27-02-1996)	AU675835B2 AU6385894A CA2078286A1 CA2158987A1 CN1074990A EP0553728A1 EP0693167A1 JP6042698A JP2690668B2 JP8511323T NO953986D0 NO953986A NZ263248A US5253778A WO9423240A1	20 February 1997 (20-02-1997) 24 October 1994 (24-10-1994) 29 July 1993 (29-07-1993) 13 October 1994 (13-10-1994) 04 August 1993 (04-08-1993) 04 August 1993 (04-08-1993) 24 January 1996 (24-01-1996) 18 February 1994 (18-02-1994) 10 December 1997 (10-12-1997) 26 November 1996 (26-11-1996) 06 October 1995 (06-10-1995) 05 December 1995 (05-12-1995) 24 February 1997 (24-02-1997) 19 October 1993 (19-10-1993) 13 October 1994 (13-10-1994)