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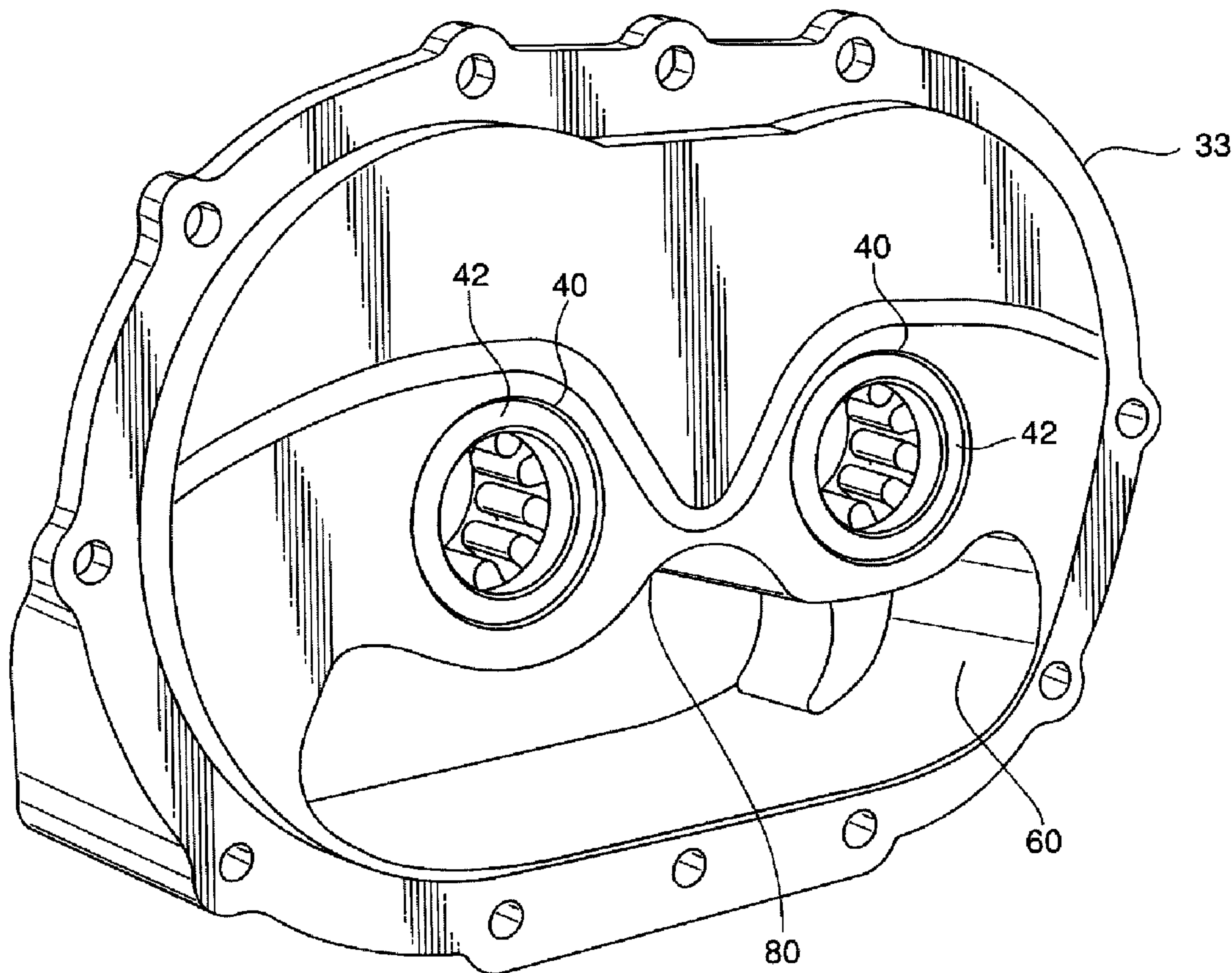
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(54) Titre : COMPRESSEUR A ENGRENAGE DU TYPE ROOTS AVEC LOBES HELICOIDaux POURVUS DE CAVITE A RETROACTION

(54) Title: ROOTS TYPE GEAR COMPRESSOR WITH HELICAL LOBES HAVING FEEDBACK CAVITY



(57) Abrégé/Abstract:

A gear compressor or supercharger for compressing compressible fluids such as air, having a pair of intermeshing helical lobed rotors. A plenum or cavity is provided at a rear end of the gear compressor, situated rearwardly of said rotors and below an

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respective axis of rotation of each of said rotors, which spans at least a distance between said respective longitudinal axis of rotation of each of said rotors. In a preferred embodiment the plenum is in direct fluid communication with high pressure fluid which is discharged from said high pressure discharge port. The above modification improves the efficiency of the compressor, particularly at high revolutions.

ABSTRACT

A gear compressor or supercharger for compressing compressible fluids such as air, having a pair of intermeshing helical lobed rotors. A plenum or cavity is provided at a rear end of the gear compressor, situated rearwardly of said rotors and below an respective axis of rotation of each of said rotors, which spans at least a distance between said respective longitudinal axis of rotation of each of said rotors. In a preferred embodiment the plenum is in direct fluid communication with high pressure fluid which is discharged from said high pressure discharge port. The above modification improves the efficiency of the compressor, particularly at high revolutions .

ROOTS TYPE GEAR COMPRESSOR WITH HELICAL LOBES HAVING FEEDBACK CAVITY

5 FIELD OF THE INVENTION

This invention relates to Roots-type gear compressors or blowers , and in one aspect thereof relates to a modified supercharger for an internal combustion engine.

10 BACKGROUND OF THE INVENTION AND DESCRIPTION OF THE PRIOR ART

Roots-type gear compressors are well known in the prior art, and have existed in various configurations for many years.

Such Roots style gear compressors typically comprise a pair of
15 intermeshing rotors placed side by side so as to permit meshing of lobes on each of said rotors, for the purpose of transferring quantities of compressible fluid from a low pressure region to a high pressure region.

In early non-helix type gear compressors having lobed rotors, it was realized
20 that at high circumferential velocities of the gear rotors in the range of 1/10 the speed of sound, adverse momentum losses become significant. These losses occur as a result of the sudden exposure of the gear wells between the gear lobes which are filled with low pressure inlet gas to the high pressure outlet region, bringing about a violent rush of high pressure gas back against the oncoming gear lobe thereby
25 creating adverse momentum forces which impede the rotor's rotation and thereby require greater horsepower to operate.

Accordingly, in one improvement related to non-helix gear type compressors,
as shown in US Patent 3,531,227 to Weatherston, a plurality of feedback passages
30 were provided (by drilling or coring) extending from the discharge plenum through

the sides of the cylindrical chambers containing such gears, which permitted high pressure discharge gas to then impact on a rear face of each lobe so as to allow a reaction force thereon which acts in the direction of motion of the gears and therefore functions to augment the work imparted to the gears, thereby reducing the horsepower requirement required to drive the compressor.

US 4,215,977 also to Weatherston discloses a similar concept for providing a three-lobe (now-helix) type Roots blower with feed back structure within the sides of the cylindrical chambers containing such rotors, to bring the gas trapped in the rotor well up to the discharge pressure prior to delivery. Specifically machined surface was provided over an angular portion Φ of each of the cylindrical chambers which allowed high pressure discharge air to enter trapped wells during a rotation of the rotors to reduce discharge pulses.

Disadvantageously, in the case of the gear compressor disclosed in US 3,531,227 the provision of a plurality of feedback passages in the sides of the chamber was an expensive machining or casting step, requiring extensive and complicated machining or creating of expensive molds, making such feature undesirably expensive.

Likewise disadvantageously in the case of the (non-helix) Roots blower disclosed in US 4,215,977, the machined surface provided a loss of seal for a portion of the rotation of each rotor, thereby having an offsetting efficiency loss.

Roots-type superchargers or "blowers" having helical rotors have been used, such as of the type shown in US 2,014,932, which provide for two 3-lobed rotors with an approximate 60° helical twist for the lobe on each of such two rotors, to more uniformly dispense pressurized air thereby reducing cyclical pulsing each time a trapped volume rotates into contact with the high pressure discharge air of the discharge port.

US 4,556,373 to Soeters, Jr. teaches an improved supercharger or blower, having a pair of 3-lobed rotors, each with an approximate 60 helical twist. As shown in Fig. 9 and Fig. 16 thereof, pairs of recesses 46 and 48 in a front end wall 20 (see Fig 9 and 15) and pairs of recesses 58, 60 in an end wall are provided, which are variably covered and uncovered at times by the lobes of the rotors.

US 2,578,196 to Montelius, discussed in US 4,556,373 to Soeters, Jr. above, teaches a screw type compressor having a pair of non-uniform but meshably engageable rotors, with one end of one of the cooperating rotors being closed by a valve plate, which in the valve plate passages from each rotor groove are made adjacent to one side of the rotor threads and cooperate with a channel in the end wall, which is connected to the outlet but covered by a valve plate. The channel drains trapped volumes when exposed by said valve plate directly to the compressor discharge outlet.

More recently, superchargers having rotors with helically arranged lobes such as those manufactured by Kobelco Compressors (America) Inc. have become publicly available. These are of the "backflow" type, where air is drawn in at a location proximate the front end thereof and proximate the top of the blower, and which by rotating helixes on each of the rotors, is drawn downwardly and axially rearwardly, wherein upon reaching the opposite end of the blower, is forced backwards via said helical lobes on said rotors and forcefully expelled from a high pressure discharge port on the bottom side of the blower towards the front end of such compressor.

A need exists for modifying such Kobelco superchargers for increased efficiency so as to require less horsepower for providing the same volume and pressure of compressed air or compressible fluid.

SUMMARY OF THE INVENTION

5 The present invention broadly relates to a gear compressor or supercharger for compressing compressible fluids such as air, having pair of helical rotors positioned in juxtaposed relation, further having a cavity, chamber, or plenum at a rear end thereof situated below an axis of rotation of said helical rotors . In a preferred embodiment the cavity or plenum spans approximately the distance between the axis of rotation of the rotors, and up to 1.5 times such distance.

10 In an important further embodiment of the present invention, the plenum or cavity at the rear of the compressor is in fluid communication with high pressure fluid which is expelled from a high pressure discharge port .

15 The feature of a cavity individually, and in combination with the feature of fluid communication with the discharge port, have been experimentally found to provide significant improvements in efficiency of such gear compressors and superchargers. In particular, such modifications have been found , particularly at high rpm's, to substantially reduce the amount of work and horsepower otherwise required to compress to a desired pressure an otherwise equal volume of air.

20 Without being held to the theory of why , particularly at high rpm's, a significant increase in efficiency results from such modification as broadly described above and more intimately described hereinafter, it is surmised that in the case of providing a cavity as more particularly defined and claimed herein, at high rpm's the
25 helical rotors impart a significant axial momentum component to transferred volumes of air, and energy in such axial momentum is allowed to be preserved when said transferred volume passes into said plenum or cavity at the rear of the compressor and executes a 180° turn and is able to pass and be directed into transferred volumes which are being axially backward towards said discharge port located at
30 the front of the supercharger by the intermeshing lobes on the rotors.

Where the further feature of directing high pressure discharge air is permitted to enter said cavity, it is further surmised that such discharge air serves to partially pressurize transferred volume of air when forced back toward the front of the supercharger by the intermeshing helical rotors, thereby reducing the otherwise sudden inrush of high pressure discharge air at the front end of the compressor to the transferred volumes which negatively impinges on rotor lobes at in a reverse-momentum direction thereby requiring additional energy input to make up for such losses.

Accordingly, in a first broad aspect of the present invention, such invention comprises a gear compressor or supercharger for compressing compressible fluids such as air, comprising:

a housing defining first and second mutually adjacent, parallel, elongate overlapping cylindrical chambers, having a front end and a rear end and a low pressure inlet port and a high pressure discharge port thereon;

a pair of juxtaposed rotors (in a preferred embodiment such rotors are "mirror images" of each other, with a first rotor having a helical twist about a respective longitudinal axis, with the other rotor having an equal and opposite helical twist), each disposed in a respective cylindrical chamber and oppositely rotatable, each having a plurality of radially outwardly extending lobes thereon equidistantly circumferentially spaced about a periphery of each rotor and intermeshed along a side thereof with lobes of an opposite rotor of said pair of rotors, each of said lobes on said rotors twisted about a respective longitudinal axis of rotation of each rotor in a helix angle, each helix angle of each of said lobes on a first of said pair of rotors being equal and opposite to said helix angle of each of said lobes on said other of said pair of rotors, said rotors within said respective cylindrical chambers each adapted to transfer volumes of compressible low pressure fluid from said low

pressure inlet port via spaces created between walls of said respective cylinder chambers and unmeshed lobes of each rotor to said high pressure outlet port;

5 said high pressure discharge port situated on a bottom of said gear compressor/supercharger proximate said front end thereof;

said low pressure inlet port situated on a top surface of said gear compressor/supercharger proximate said front end thereof;

10 a front end wall situated at said front end of said gear compressor/supercharger;

a rear end wall situated at said rear end of said gear compressor/supercharger; and

15 a plenum or cavity at said rear end situated rearwardly of said rotors and below said respective axis of rotation of each of said rotors, which spans at least a distance between said respective longitudinal axis of rotation of each of said rotors.

20 In a further preferred embodiment of the gear compressor/supercharger of the present invention, the plenum or cavity is further in fluid communication with high pressure fluid which is discharged from said high pressure discharge port.

25 In a further embodiment of the gear compressor or supercharger of the present invention, piping fluidly connects the plenum or cavity with said high pressure discharge port. In this embodiment it is expressly contemplated that the rear end wall of the compressor have pipe-coupling means thereon in communication with said plenum or cavity, and that the pipe coupling means be adapted to permit fluid communication via piping connected thereto to high
30 pressure fluid exiting from said high pressure discharge port.

In a further embodiment, it is contemplated that the plenum or cavity at the rear end of said gear compressor /supercharger be of a sufficient height so as to span substantially a radial height of each individual lobe of each rotor.

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While not necessary to the operation of the compressor/supercharger of the present invention, it is contemplated in a preferred embodiment that an aperture area be provided on a lower point of intersection of said mutually adjacent chambers , proximate said rear end of said gear compressor/supercharger, which aperture is in fluid communication with the plenum or chamber. Such aperture assists in allowing transferred volumes which travel axially rearwardly with angular momentum to thereafter pass into an intermeshing area and thereafter be directed axially forwardly to the high pressure discharge port by the intermeshing of rotor lobes upon rotation thereof. In a preferred embodiment, the aperture area is a 'v'-shaped area, having its largest area proximate said rear end of the gear compressor/supercharger.

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BRIEF DESCRIPTION OF THE DRAWINGS

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Further advantages and permutations and combinations of the above elements will now appear from the above and from the following detailed description of various non-limiting embodiments of the invention, taken together with the accompanying drawings, in which:

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FIG. 1 is a top perspective view of a gear compressor of the present invention, with the helical gears or rotors removed;

FIG. 2 is a bottom perspective view of a gear compressor of the present invention, with the helical gears/rotors in operative position;

FIG. 3 is rear end view of the gear compressor/supercharger of the present

invention, with the rear end wall removed, showing the helical rotors;

5 **Fig. 4** is a rear end view of the gear compressor/supercharger of the present invention with the rear end wall removed and similar to the view shown in Fig. 3, but with the rotors removed;

FIG. 5 is a view of the rear end wall of a helical gear compressor of the prior art;

10 **FIG. 6** is a side perspective view of a first embodiment of rear end wall for a helical gear compressor of the present invention, having a plenum/cavity in accordance with and in the location shown in accordance with the present invention;

FIG. 7 is a schematic rear end view of the gear compressor, with the location of the cavity/plenum superimposed thereon;

15 **FIG. 8** is a rear perspective view of a second alternative embodiment of the rear end wall for a gear compressor of the present invention, having a plenum/cavity in accordance with and in the location shown in accordance with the present invention;

20 **FIG. 9** is a front perspective view of the rear end wall shown in **FIG. 8**; and

25 **FIG. 10** is a rear perspective view of a third alternative embodiment of the rear end wall for a gear compressor of the present invention, showing pipe coupling means thereon to permit fluid communication with high pressure discharger air from the compressor high pressure discharge port.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

30 **FIG. 1** shows a top perspective view of a gear compressor / supercharger

10 of the present invention. **FIG. 2** is a bottom perspective view of a gear compressor **10** of the present invention. As seen from **Fig.'s 1, 2, 3 & 4**, gear compressor **10** has a housing **12** which defines first and second mutually adjacent, parallel, elongate overlapping cylindrical chambers **14a, 14b** respectively.

5

Gear compressor **10** has a front end **30**, and a rear end **32**, and a front end wall **31**, and a rear end wall **33**. A toothed drive pulley **19** is provided, to facilitate connection to a drive belt on an internal combustion engine(not shown) on which a gear compressor **10** of this type is typically mounted.

10

Various NPT pipe connections **51** are provided for allowing supply of lubricating oil to various bearings, such as roller bearings **42** which rotatably support rotatable shafts **44** and on which rotors **16a, 16b** are mounted. Other NPT threaded connections **52** are provided for injecting fuel, to be mixed with air for subsequent supply to an intake manifold (not shown) of an internal combustion engine (not shown) on which the supercharger/gear compressor of the present invention may be mounted.

15

A low pressure inlet port is **34** typically provided on a top side **36** of such compressor **10**, proximate front end **30**. A high pressure discharge port **38** is typically provided on a bottom side **48** of compressor **10**, likewise proximate front end **30** of compressor **10**.

20

Gear compressor **10** is provided with a pair of juxtaposed substantially identical lobed rotors **16a, 16b**, each disposed in a respective cylindrical chamber **14a, 14b**, each having a plurality of radially outwardly extending lobes **18** thereon. Lobes **18** are equidistantly circumferentially spaced about a periphery of each rotor

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5 **16a, 16b**, and intermeshed along a side thereof with the lobes **18** of an opposite rotor **14b** of said pair of rotors **16a, 16b**. Each of the lobes **18** on rotors **16a, 16b** are twisted about a respective longitudinal axis of rotation **20** of each rotor **16a, 16b** in a helix angle, each helix angle of each of said lobes **18** on a first rotor **16a** of said pair of rotors **16a, 16b**, being equal and opposite to said helix angle of each of said lobes **18** on said other rotor **16b** of said pair of rotors **16a, 16b**. Rotors **16a, 16b** within respective cylindrical chambers **14a, 14b** are each adapted to transfer volumes **22** of compressible low pressure fluid from low pressure inlet port **34** via transfer volumes **22** created between walls of said respective cylinder chambers **14a,14b** and unmeshed lobes **18** of each rotor **16a,16b**, and axially along said respective cylindrical chambers **14a,14b** from said front end **30** to rear end **32** of said gear compressor **10** and then axially back to a location proximate front end **30** of said gear compressor **10** and thereafter to high pressure discharge port **38**.

15 In comparison with rear end walls **33** of compressors **10** of the prior art (see **Fig. 5**), wherein such prior art rear end walls **33** are typically substantially flat and merely possess a pair of bearing housing recesses **40** for housing roller bearings **42** (see **Fig. 5**), rear end wall **33** of the present invention in each of the various embodiments shown in **Figs. 6-10** hereto possess not only bearing housing recesses **40** for mounting roller bearings **42** therein which support shafts **44** on which each of rotors **16a, 16b** are mounted, but further possess a plenum or cavity **60**. Cavity/plenum **60**, when said rear end wall **33** is mounted on the rear end **32** of compressor **10**, is situated rearwardly of said rotors **16a, 16b**, and below said respective axis of rotation **20** of each of said rotors **16a, 16b**. Cavity/plenum **60** preferably spans approximately a distance between said respective longitudinal axis of rotation **20** of each of said rotors **16a, 16b**, as best seen in **Fig. 7**, and up to 1.5 times such distance.

The height of such cavity **60**, and more particularly the height of aperture **75**

in rear end wall **33**, is such that such aperture extends in height from a lowermost point of travel of the path of the rotating rotors **16a, 16b** (see **Fig. 7**), up to a height no greater than the level of respective axis of rotation **20** of such rotors **16a, 16b**, to avoid otherwise creating leakage of pressurized air back to the air inlet manifold **34**.
5 The cavity **60** rearwardly of such aperture **75**, as shown in **Fig. 9**, may of course extend higher without thereby creating such a negative leakage problem.

As more fully set out below, it has been experimentally found that the provision of cavity or plenum **60** in rear end wall **33** which is continually exposed to
10 ends of rotors **16a, 16b** provides an unexpected increase in efficiency of helical compressors **10** of the type described and shown herein.

Specifically, without being limited to such explanation, it is surmised that at high rotational speeds of helical rotors **16a, 16b** the lobes **18** thereof, due to the
15 helical twist angle which may range between 50 to 130°, impart a significant axial momentum component to transferred volumes **22** of air. Energy in such axial momentum is allowed to be preserved when each said transferred volume **22** passes into said plenum or cavity **60** at the rear end **32** of the compressor **10** and executes a 180° turn and is directed and then forced axially backward towards said
20 discharge port located at the front end **30** of the compressor / supercharger **10** by the intermeshing lobes **18** on the rotors **16a, 16b**.

In a first embodiment of the rear end wall **33** of the present invention shown in **Fig. 6**, a simple cavity **60** is provided in rear end wall **33**. Upper extremities thereof
25 are generally arcuate, as best shown in **Figs. 6 & 7**, so as to allow retention of bearings **42** in bearing housings **41** and also preferably not to extend above axis of rotation **20** of rotors **16a, 16b**, as such would otherwise allow significant “bleeding” or leakage of transferred volumes **22** of air to the air inlet side (ie the upper side of rotors **16a, 16b**, namely that portion above the axis of rotation **20** thereof). Such

cavity may extend completely through rear end wall **33**, thereby offering the option of simply “blanking off” a back side of rear end wall **33**, or permit bolting or attachment of a similar additional end wall likewise having a cavity **60** therein, which allows the effective size and volume of such plenum/cavity to thereby be increased if so desired.

In a second embodiment of the rear end wall **33** for the novel gear compressor **10** of the present invention, as shown in **Fig.8** (front view) and **Fig. 9** (rear view), such rear end wall **33** may be of a casting, which allows greater volume of cavity/plenum **60** rearwardly of curved aperture **80**.

In a preferred embodiment, as shown in each of the two embodiments of the rear end wall **33** (such two embodiments shown in **Fig. 6**, and **Fig. 8&9** respectively), such plenum/cavity **60** is in fluid communication with high pressure fluid discharged from the high pressure discharge port **38** of compressor **10**. In this regard, for the rear end wall **33** shown in **Fig. 6** and **Figs' 8 & 9**, a further lower aperture **75** is provided, typically on an underside of rear end wall **33**, which allows for connection to high pressure air from the high pressure discharge port **38**. Such further aperture may be coupled via piping to the air inlet of an internal combustion engine on which the compressor **10** is mounted, or may be coupled to the high pressure discharge outlet **38** of compressor **10**.

In a third embodiment of the rear end wall **33** of the present invention (see **Fig. 10** hereto), in place of lower aperture **75** such rear end wall **33** has pipe coupling means **98** in communication with the plenum/cavity **60**, which pipe coupling means **98** is adapted to permit high pressure air from high pressure discharge port **38** to be directed to plenum/cavity **60** and thence to transfer volumes **22**.

While not necessary to the operation of the invention, it is recommended that there be provided an aperture area **95** on a lower point of intersection **96** of cylindrical chambers **14a**, **14b** and proximate the rear end **32** of gear compressor **10**, as shown in **Fig. 4**. Such aperture area **95** is in fluid communication with plenum **60**, and is recommended for the purpose of assisting in more uniform air flow from cavity **60** back to rotors **16a**, **16b** for subsequent delivery by rotors **16a**, **16b** to high pressure discharge port **38**.

The invention herein is particularly suited to a modification of a Roots-type gear compressor **10** similar to those manufactured by manufactured by Kobelco Compressors (America) Inc., exclusively distributed by DPME Inc. of Stevensville, Indiana and others of similar manufacture, which are of the "backflow" type, where air is drawn in at a location proximate the front end **30** thereof and proximate top side **36** of the compressor **10**, and which by operation of rotating helical rotors **16a**, **16b** is directed downwardly and axially rearwardly within the gear compressor **10** towards the rear end wall **33** of the compressor **10**, wherein upon reaching the rear end wall **33** of compressor **10**, is forced back via operation of the rotating helical lobes **18** on said rotors **16a**, **16b** towards the front end **30** of the compressor **10** and then and forcefully expelled from a high pressure discharge port **38** situated on the side **40** of the compressor **10** towards the front end **30** of such compressor **10**. However, other similar gear compressors **10** of different manufacture are suitable for the modification of the present invention for the purpose of increasing the efficiency thereof. Alternatively original manufacture of a gear compressor **10** of the present invention is contemplated.

Example 1

In order to evaluate efficiency increases to gear compressors and supercharger arising from the inventive modifications herein described and claimed, a standard prior art supercharger was tested to provide a base comparison.

Accordingly, for this purpose a publicly available model 14/71 standard helix supercharger manufactured by Kobelco Compressors (America) Inc. of Elkhart, Indiana, exclusively distributed by DPME Inc. of Stevensville Michigan, part number
5 KS14S2LS , having a pair of helical 3-lobe rotors, each with a standard (but opposite) 60° helix angle per 15 inch rotor length , was used.

Such standard model 14/71 supercharger was *inter alia* modified to mill an aperture area 95 on a lower point of intersection 96 of mutually adjacent rotor
10 chambers 14a, 14b thereof proximate the rear end 32 of the supercharger 10, commencing at about 1.5 inches from a rear wall thereof, to a maximum depth proximate the rear end of approximate 0.75 inches. Such supercharger via a gearbox thereon provided a gear reduction from engine RPM to supercharger rotor rpm of 1.102 to 1.

15 For the purpose of the tests conducted herein, such model 14/71 supercharger was mounted on a modified 369 cubic inch BAE Chrysler 8 cylinder methanol fueled engine (not shown). A dynamometer test was run to determine horsepower produced at various RPM's for such engine, having on the inlet manifold
20 of such engine the above model 14/71 supercharger mounted thereon.

Set out below in Table 1 is a tabulation of horsepower generated by such supercharged Chrysler engine, running at 79 degrees F ambient air conditions, with a relative humidity of 31%, and a SEA correction factor of 1.1819.
25

Table 1

ENGINE RPM (Engine RPM x 1.102= supercharger rotor rpm)	Horsepower Generated
6600	1303.8
6800	1378.2
7000	1434.7
7200	1496.7
7400	1522.2
7600	1532.6
7800	1551.5
8000	1529.7
8200	1543.2
8400	1540.2
8600	1550.4
8800	1594.9
9000	1619.9
9200	1656.9
9400	1600.3

Example 2

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Above model 14/71 Kobelco supercharger was modified to replace stock rear cover (end wall) with a rear end wall **33** having a cavity/plenum **60** of the present invention, of relative dimensions as shown in drawings **Fig. 6** hereto.

In particular, the cavity/plenum **60** in modified rear end wall member **33** was situated below the axis of rotation **20** of each of rotors **16a, 16b**, and was of a length slightly greater than the distance between the respective axis of rotation **20** of each of said rotors **16a, 16b**, as seen from **Fig. 6** hereto. For the purpose of this test run, as regards the lower aperture **75** in rear end wall member **33**, such was for this test run "blocked off" by affixing a blanking plate, so as to prevent fluid communication with air discharged from the high pressure discharge port **38** of the supercharger **10**. The volumetric size of cavity/plenum **60** utilized in rear end wall **33** of **Fig.6** with lower aperture **75** blanked off was approximately 8.6 cubic inches.

The identical 369 BAE Chrysler engine, having the aforesaid Kobelco supercharger mounted thereon but with modified rear end wall **33** mounted thereon as described above and shown in **Fig 6**, was again run at various RPM. Operating conditions were substantially identical to those in Example 1, namely ambient temperature 79 degrees F, relative humidity 31%, SEA correction factor 1.18. The generated horsepower was recorded at such various RPM, with the results tabulated in Table 2 below:

Table 2

Engine RPM (Engine RPM x 1.102 = Supercharger RPM)	Horsepower Generated	% Change in Horsepower Generated over Ex. 1
6600	1334.3	+2.3%
6800	1399.4	+1.5%
7000	1430.3	-0.3%
7200	1525.8	+1.9%
7400	1566.5	+2.9%
7600	1624.3	+6.0%

7800	1681.7	+8.4%
8000	1692.9	+10.7%
8200	1727.6	+11.9%
8400	1748.8	+13.5%
8600	1772.3	+14.3%
8800	1794.5	+12.5%
9000	1796.8	+10.9%
9200	1797.9	+8.5%
9400	1800.8	+12.5%

Example 3

5 Above model 14/71 Kobelco supercharger was further modified to replace the modified end wall as shown in **Fig. 6** with a further modified rear end wall, as shown in **Fig. 8& 9**, having a cavity/plenum **60** of relative dimensions as shown in **Fig. 8 & 9** hereto.

10 Again, the cavity/plenum **60** in modified rear end wall member **33** was situated below the axis of rotation **20** of each of rotors **16a, 16b**, and was of a length slightly greater than the distance between the respective axis of rotation **20** of each of said rotors **16a, 16b**, as seen from **Fig. 9** hereto. Again, for the purpose of this test run, as regards the lower aperture **75** in rear end wall member **33**,
15 such was for this test run "blocked off" by affixing a blanking plate, so as to prevent fluid communication with air discharged from the high pressure discharge port **38** of the supercharger **10**. The volumetric size of cavity/plenum **60** utilized in rear end wall **33** of **Fig.9** with lower aperture **75** blanked off was approximately 14.7 cubic inches.

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5 The identical 369 BAE Chrysler engine, having the aforesaid Kobelco supercharger mounted thereon but with modified end wall mounted thereon as described above, was again run at various RPM. Operating conditions were substantially identical to those in Examples 1 & 2, namely ambient temperature 77 degrees F, relative humidity 40%, SEA correction factor 1.19. The generated horsepower was recorded at such various RPM, with the results tabulated in Table 3 below, showing comparison (% improvement) over the results obtained in Table 1 with the unmodified supercharger configuration:

10 **Table 3.**

Engine RPM (Engine RPM x 1.102 = Supercharger RPM)	Horsepower Generated	% Change in Horsepower Generated over Ex. 1
6600	1289.5	-1.1%
6800	1378.0	0
7000	1432.3	-0.2%
7200	1519.0	+1.5%
7400	1563.3	+2.7%
7600	1613.3	+5.3%
7800	1684.4	+8.6%
8000	1691.8	+10.6%
8200	1691.0	+9.6%
8400	1744.7	+13.3%
8600	1772.6	+14.3%
8800	1821.1	+14.2%
9000	1861.4	+14.9%
9200	1825.4	+10.2%
9400	1837.4	+14.8%

Example 4

Above model 14/71 Kobelco supercharger was further modified to replace the modified rear end wall **33** as shown in **Fig. 9** with a further modified rear end wall **33**, as shown in **Fig. 10**, having a cavity/plenum of relative dimensions as shown in **Fig. 9** hereto.

Again, the cavity/plenum **60** in modified rear end wall **33** was situated below the axis of rotation **20** of each of rotors **16a, 16b**, and was of a length slightly greater than the distance between the respective axis of rotation **20** of each of said rotors **16a, 16b**, as seen from **Fig. 9** hereto. For the purpose of this test run, fluid coupling port (ie pipe coupling means **98**) as shown in **Fig. 10** was directly coupled to the intake manifold of the Chrysler engine, so that such plenum **60** received and was in fluid communication with high pressure air discharged from the high pressure discharge port **38** of the supercharger **10**.

The identical 369 BAE Chrysler engine, having the aforesaid Kobelco supercharger **10** mounted thereon but with modified rear end wall **33** mounted thereon as described above, was again run at various RPM. Operating conditions were substantially identical to those in Examples 1 & 2, namely ambient temperature 77 degrees F, relative humidity 40%, SEA correction factor 1.19. The generated horsepower was recorded at such various RPM, with the results tabulated in Table 4 below, showing comparison (%change) over the results obtained in Table 1 with the unmodified supercharger configuration:

Table 4

Engine RPM (Engine RPM x 1.102 = Supercharger RPM	Horsepower Generated	% Change in Horsepower Generated over Ex. 1
6600	1348.5	+3.4%
6800	1401.6	+1.7%
7000	1443.9	+0.6%
7200	1527.5	+2.1%
7400	1576.9	+3.4%
7600	1663.9	+8.6%
7800	1688.6	+8.8%
8000	1719.0	+12.4%
8200	1795.9	+16.4%
8400	1792.1	+16.3%
8600	1813.9	+17.0%
8800	1861.9	+16.7%
9000	1852.3	+14.3%
9200	1843.2	+11.2%
9400	1834.0	14.6%

5 Although the disclosure describes and illustrates preferred embodiments of
the invention, it is to be understood that the invention is not limited to these particular
embodiments. Many variations and modifications will now occur to those skilled in
the art. For a complete definition of the invention and its intended scope, reference
is to be made to the summary of the invention and the appended claims read
10 together with and considered with the disclosure and drawings herein.

We claim:

1. A gear compressor for compressing compressible fluids such as air, comprising:

a housing defining first and second mutually adjacent, parallel, elongate overlapping cylindrical chambers, having a front end and a rear end and a low pressure inlet port and a high pressure discharge port thereon;

a pair of juxtaposed rotors, each disposed in a respective cylindrical chamber and oppositely rotatable, each having a plurality of radially outwardly extending lobes thereon equidistantly circumferentially spaced about a periphery of each rotor and intermeshed along a side thereof with lobes of an opposite rotor of said pair of rotors, each of said lobes on said rotors twisted about a respective longitudinal axis of rotation of each rotor in a helix angle, each helix angle of each of said lobes on a first of said pair of rotors being equal and opposite to said helix angle of each of said lobes on said other of said pair of rotors, said rotors within said respective cylindrical chambers each adapted to transfer volumes of compressible low pressure fluid from said low pressure inlet port via spaces created between walls of said respective cylinder chambers and unmeshed lobes of each rotor axially along said respective cylindrical chambers from said front end to said rear end of said gear compressor and then axially back along said gear compressor to a location proximate said front end of said gear compressor and thereafter to said high pressure discharge port;

said high pressure discharge port situated on a bottom of said gear compressor proximate said front end thereof;

said low pressure inlet port situated on a top surface of said gear compressor proximate said front end thereof;

a front end wall situated at said front end of said gear compressor;

a rear end wall situated at said rear end of said gear compressor;

and

a plenum at said rear end of said gear compressor situated rearwardly of said rotors and below said respective axis of rotation of each of said rotors, which spans at least a distance between said respective longitudinal axis of rotation of each of said rotors.

2. The gear compressor as claimed in claim 1, wherein said plenum is in fluid communication with high pressure fluid which is discharged from said high pressure discharge port.
3. The gear compressor as claimed in claim 1, said plenum at said rear end of said gear compressor of a height so as to span substantially a radial height of each individual lobe of each rotor.
4. The gear compressor as claimed in claim 2 wherein piping fluidly connects said plenum with said high pressure discharge port.
5. The gear compressor as claimed in claim 2, said rear end wall having pipe coupling means thereon in communication with said plenum, said pipe coupling means adapted to permit fluid communication via piping connected thereto to high pressure fluid exiting from said high pressure discharge port.

6. The gear compressor as claimed in claim 1 further comprising an aperture area on a lower point of intersection of said mutually adjacent chambers, proximate said rear end of said gear compressor, which aperture is in fluid communication with said plenum.
7. The gear compressor as claimed in claim 6, wherein said aperture area is a 'v'-shaped area, having its largest area proximate said rear end of said gear compressor.
8. The gear compressor as claimed in claim 1, wherein each of said rotors has three lobes, and said helix angle is between 55 ° and 130°.
9. A gear compressor for compressing compressible fluids such as air, comprising:
 - a housing defining first and second mutually adjacent, parallel, elongate overlapping cylindrical chambers, having a front end and a rear end and a low pressure inlet port and a high pressure discharge port thereon;
 - a pair of juxtaposed substantially identically configured rotors, each disposed in a respective cylindrical chamber and oppositely rotatable, each having a plurality of radially outwardly extending lobes thereon equidistantly circumferentially spaced about a periphery of each rotor and intermeshed along a side thereof with lobes of an opposite rotor of said pair of rotors, each of said lobes on said rotors twisted about a respective longitudinal axis of rotation of each rotor in a helix angle, each helix angle of each of said lobes on a first of said pair of rotors being equal and opposite to said helix angle of each of said lobes on said other of said pair of rotors, said rotors within said respective cylindrical chambers each adapted to transfer

volumes of compressible low pressure fluid from said low pressure inlet port via spaces created between walls of said respective cylinder chambers to said high pressure outlet port;

said high pressure discharge port situated on a bottom of said gear compressor proximate said front end thereof;

said low pressure inlet port situated on a top surface of said gear compressor proximate said front end thereof;

a front wall situated at said front end of said gear compressor;

a rear wall situated at said rear end of said gear compressor; and

a cavity in said rear wall situated below said respective axis of rotation of each of said rotors spanning at least a distance between said longitudinal axis of rotation of said rotors, to permit transfer volumes of fluid given rearward momentum via said helical lobes and to re-inject said transferred volumes intermediate said lobes when said lobes rotate to a position to allow delivery of said transferred volumes axially back to said high pressure discharge port.

10. The gear compressor as claimed in claim 9, wherein said cavity is in fluid communication with compressed fluid from said high pressure discharge port on said gear compressor.

11. The gear compressor as claimed in claim 10 further comprising an aperture area on a lower point of intersection of said mutually adjacent chambers, proximate said rear end of said gear compressor, which aperture

is in fluid communication with said cavity.

- 12.** The gear compressor as claimed in claim 11, wherein said aperture area is a 'v'-shaped area, having its largest area proximate said rear wall of said gear compressor.
- 13.** The gear compressor as claimed in claim 9, said cavity at said rear end of said gear compressor of a height so as to span substantially a radial height of each individual lobe of each rotor.
- 14.** The gear compressor as claimed in claim 10 wherein piping fluidly connects said rear cavity means with said high pressure discharge port.
- 15.** The gear compressor as claimed in claim 14, said rear end wall having pipe coupling means thereon to permit fluid communication via piping to high pressure fluid exiting from said high pressure discharge port.
- 16.** The gear compressor as claimed in claim 9, wherein each of said rotors has three lobes, and said helix angle is between 55 ° and 130°.
- 17.** A supercharger for an internal combustion engine, comprising:
- a housing defining first and second mutually adjacent, parallel, elongate overlapping cylindrical chambers, having a front end and a rear end and a low pressure inlet port and a high pressure discharge port thereon;
- a pair of juxtaposed rotors, each disposed in a respective cylindrical chamber and oppositely rotatable, each having a plurality of

radially outwardly extending lobes thereon equidistantly circumferentially spaced about a periphery of each rotor and intermeshed along a side thereof with lobes of an opposite rotor of said pair of rotors, each of said lobes on said rotors twisted about a respective longitudinal axis of rotation of each rotor in a helix angle, each helix angle of each of said lobes on a first of said pair of rotors being equal and opposite to said helix angle of each of said lobes on said other of said pair of rotors, said rotors within said respective cylindrical chambers each adapted to transfer volumes of compressible low pressure fluid from said low pressure inlet port via spaces created between walls of said respective cylinder chambers and unmeshed lobes of each rotor axially along said respective cylindrical chambers from said front end to said rear end of said supercharger and then axially back along said supercharger to a location proximate said front end of said gear compressor and thereafter to said high pressure discharge port;

said high pressure discharge port situated on a bottom of said supercharger proximate said front end thereof;

said low pressure inlet port situated on a top surface of said supercharger proximate said front end thereof;

a front end wall situated at said front end of said gear compressor;

a rear wall situated at said rear end of said gear compressor; and

a plenum at said rear end of said gear compressor situated rearwardly of said rotors, said rear end wall having an aperture therein situated below said respective axis of rotation of each of said rotors adjacent a rear face of each of said rotors, wherein said aperture spans a distance between said respective

longitudinal axis of rotation of each of said rotors and is in fluid communication with said plenum.

- 18.** The supercharger as claimed in claim 17, wherein said aperture span is approximately equal to said distance between said respective longitudinal axis of rotation of each of said rotors.
- 19.** The supercharger as claimed in claim 17 wherein said plenum is further adapted to be in fluid connection with compressed fluid from said high pressure discharge port on said supercharger.
- 20.** The supercharger as claimed in claim 19, said rear end wall having pipe coupling means thereon in fluid communication with said plenum to permit fluid communication with high pressure fluid exiting from said high pressure discharge port.
- 21.** The supercharger as claimed in claim 20 further comprising an aperture area on a lower point of intersection of said mutually adjacent chambers, proximate said rear end of said gear compressor, which aperture is in fluid communication with said plenum.

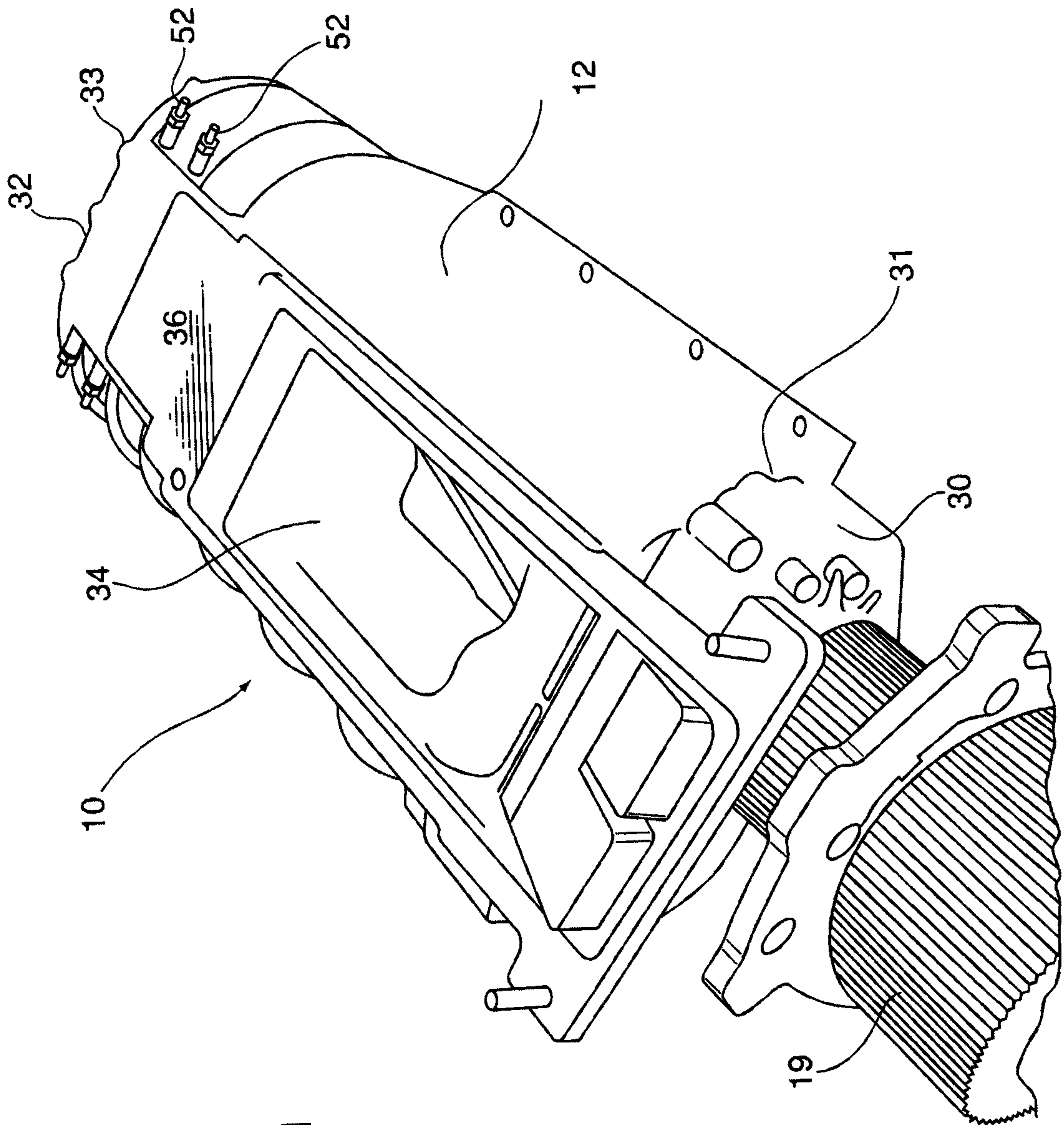


Fig.1

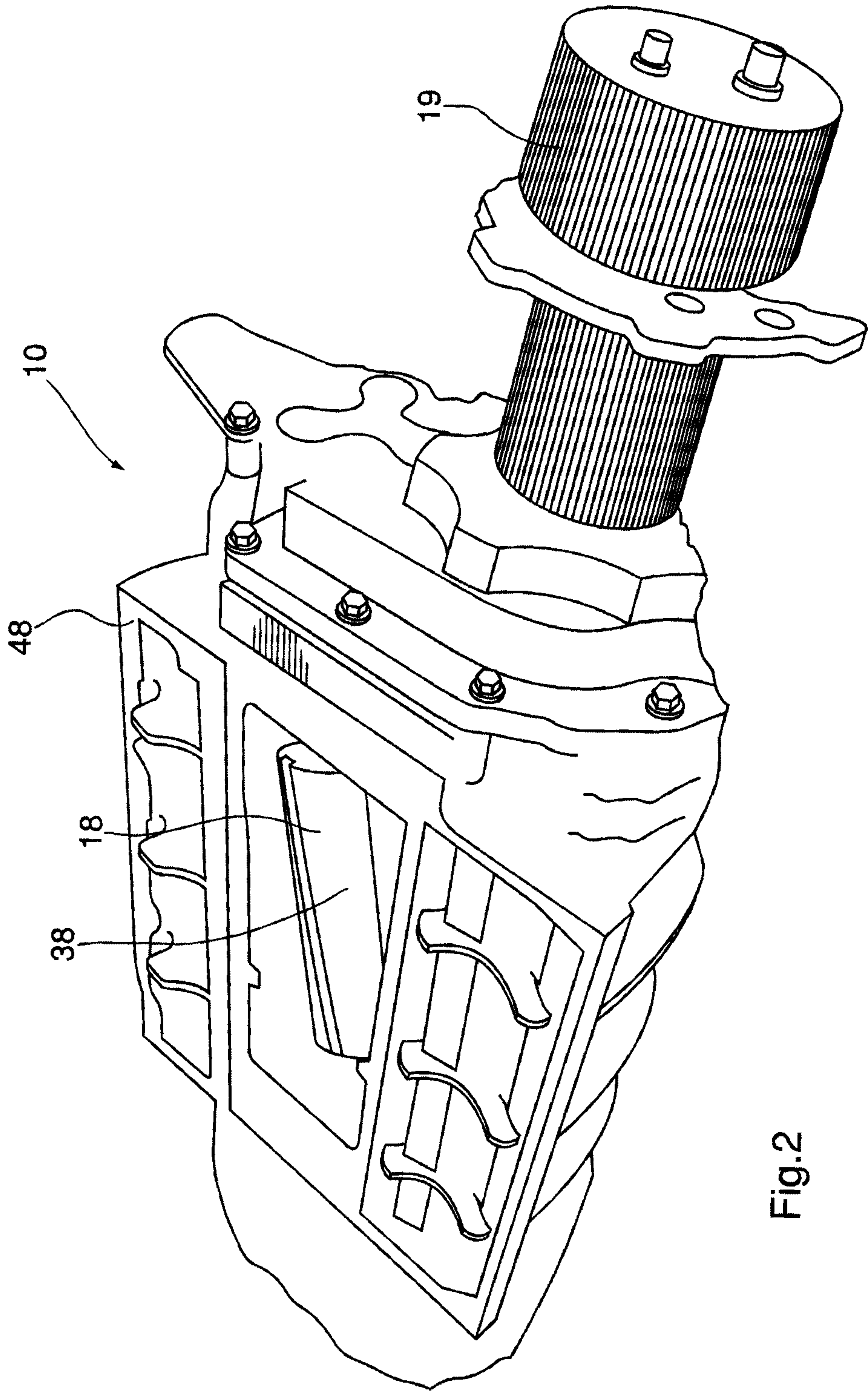


Fig.2

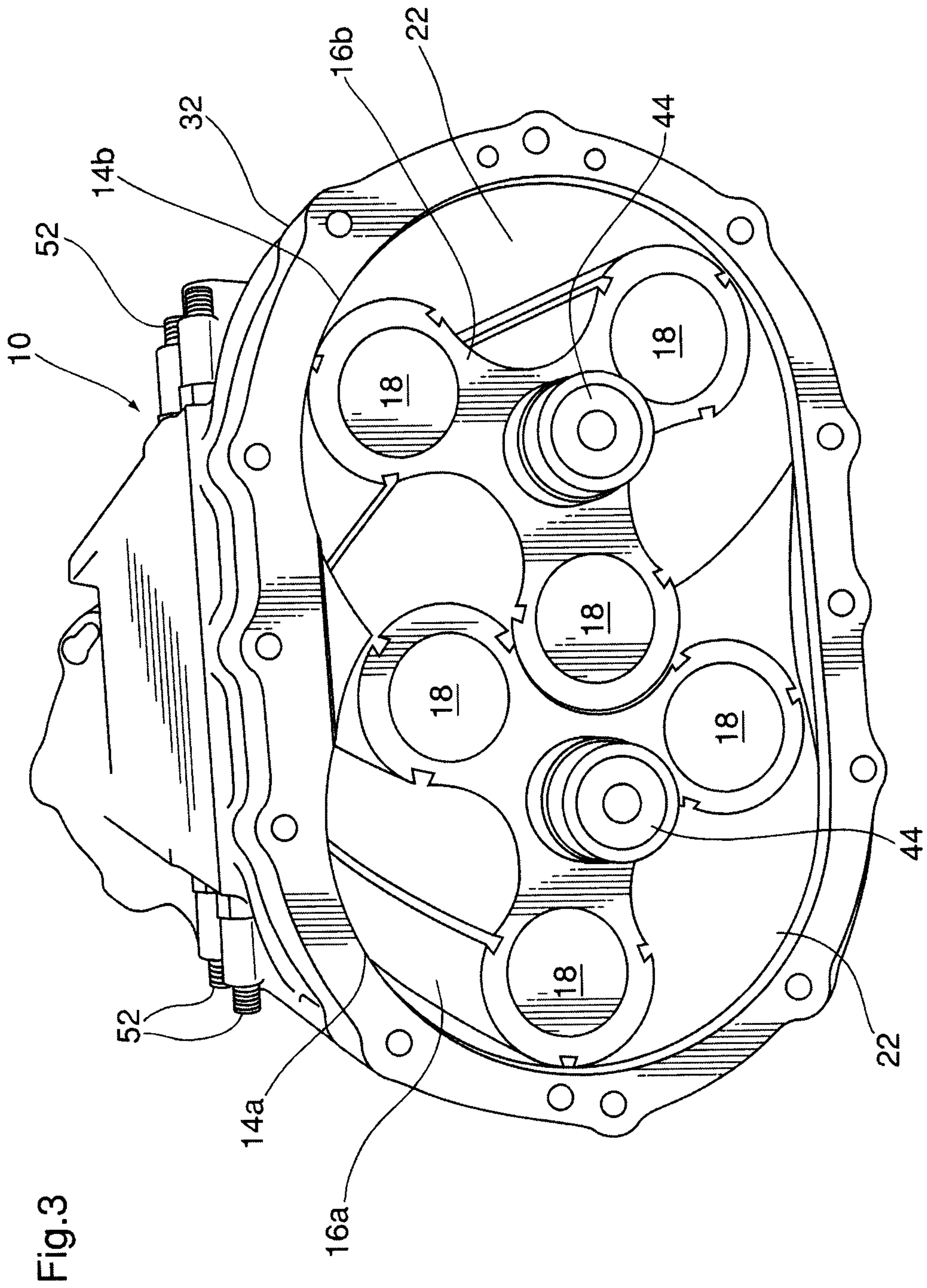


Fig.3

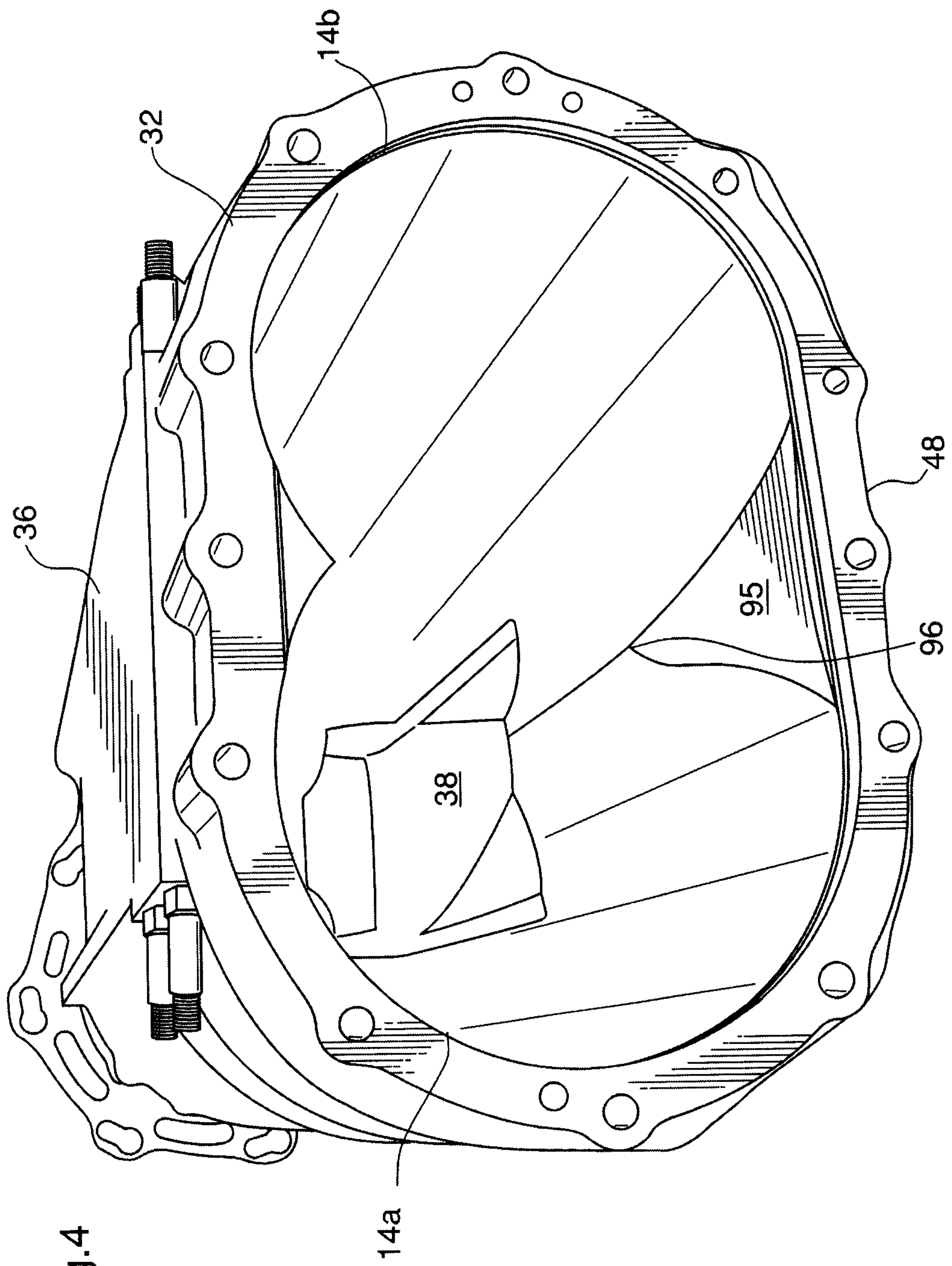


Fig.4

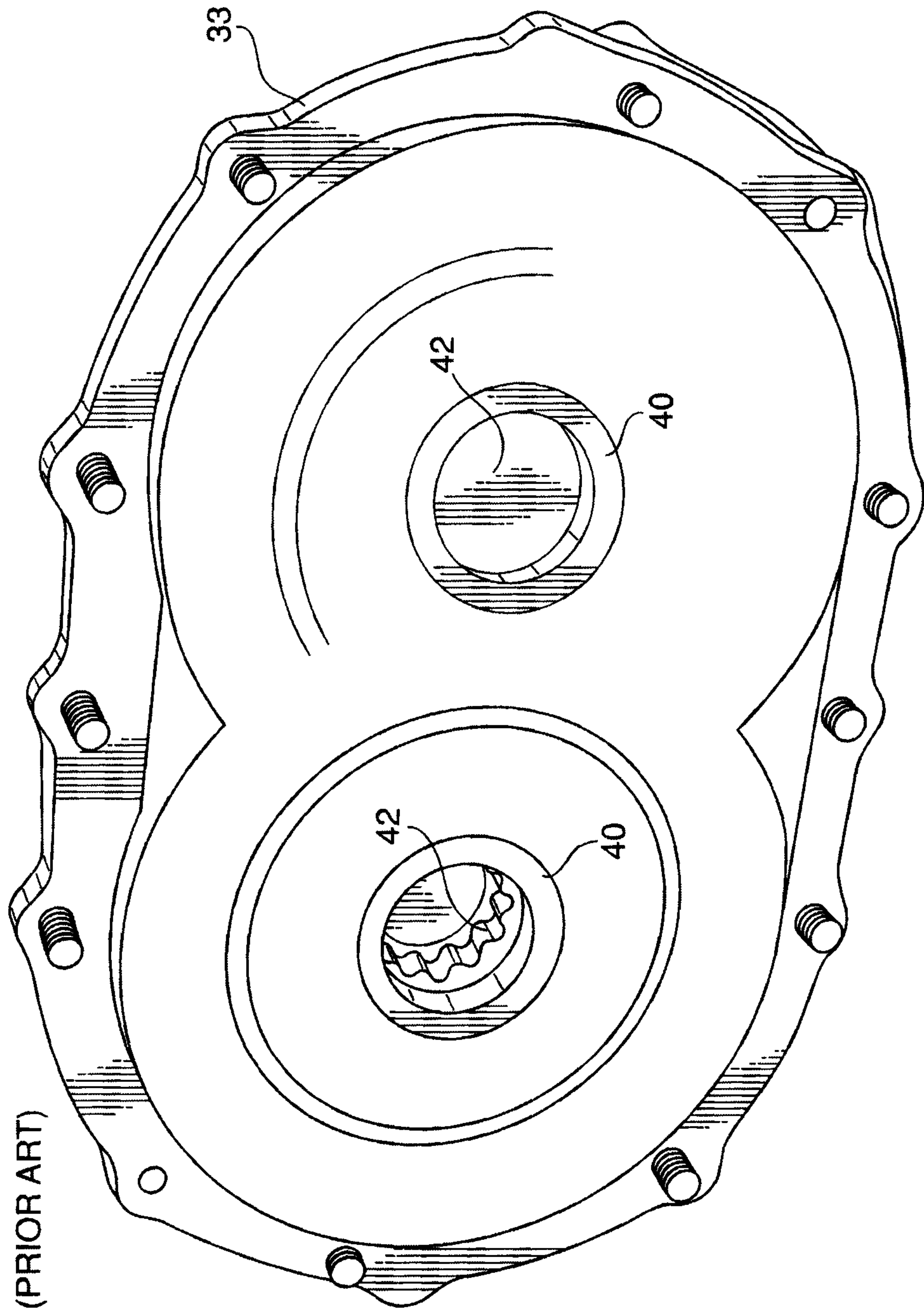


Fig.5 (PRIOR ART)

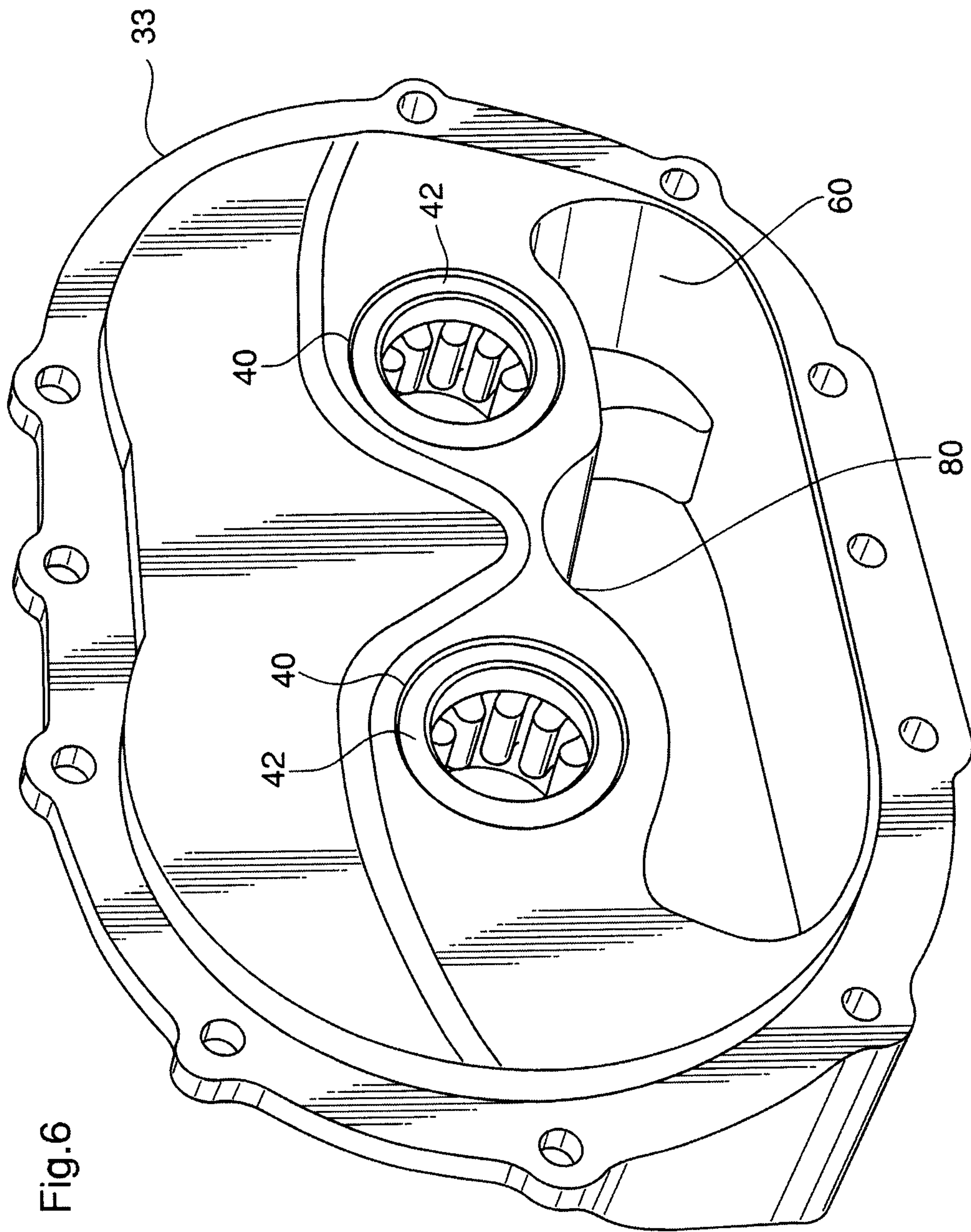


Fig.6

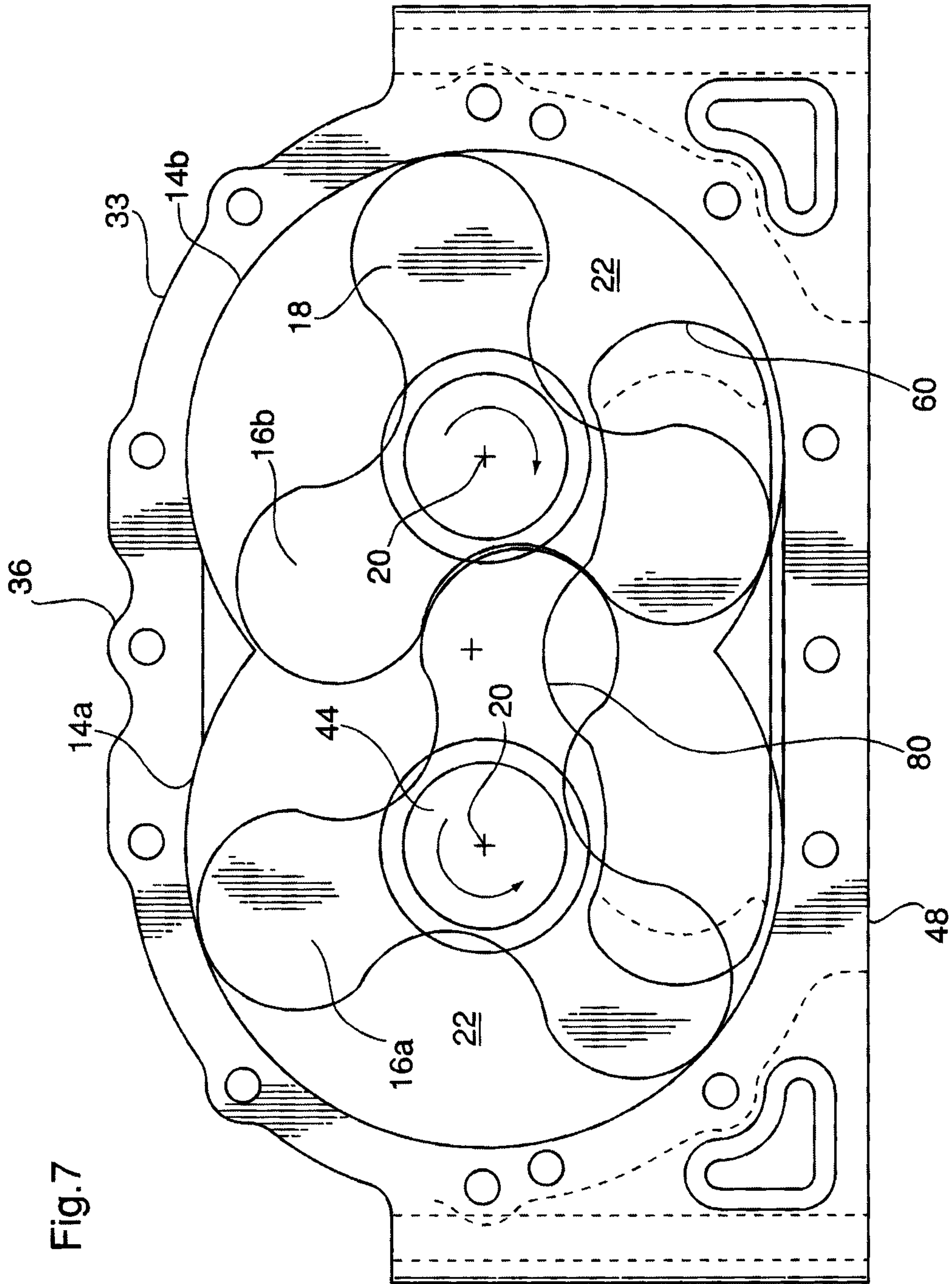


Fig. 7

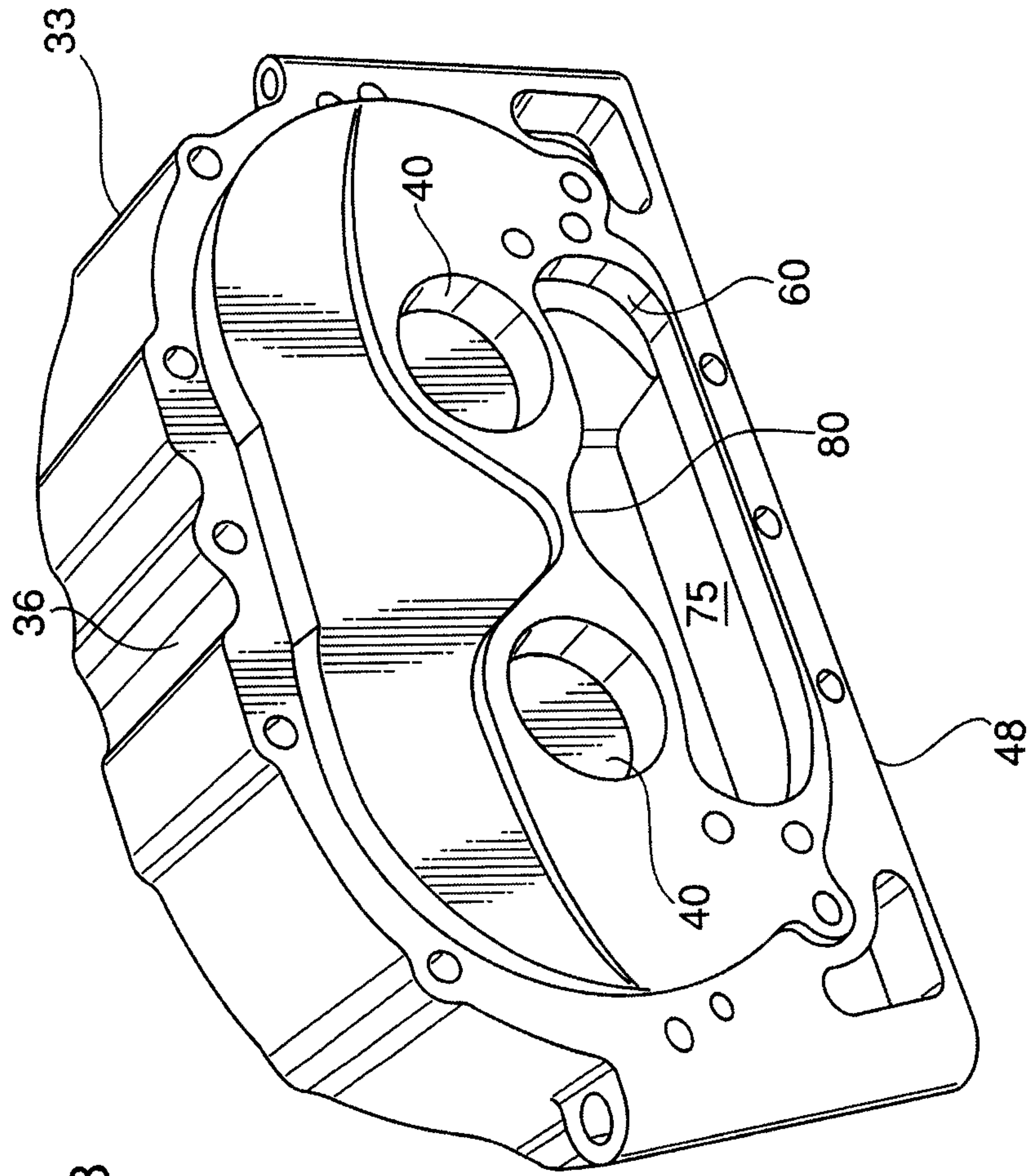


Fig.8

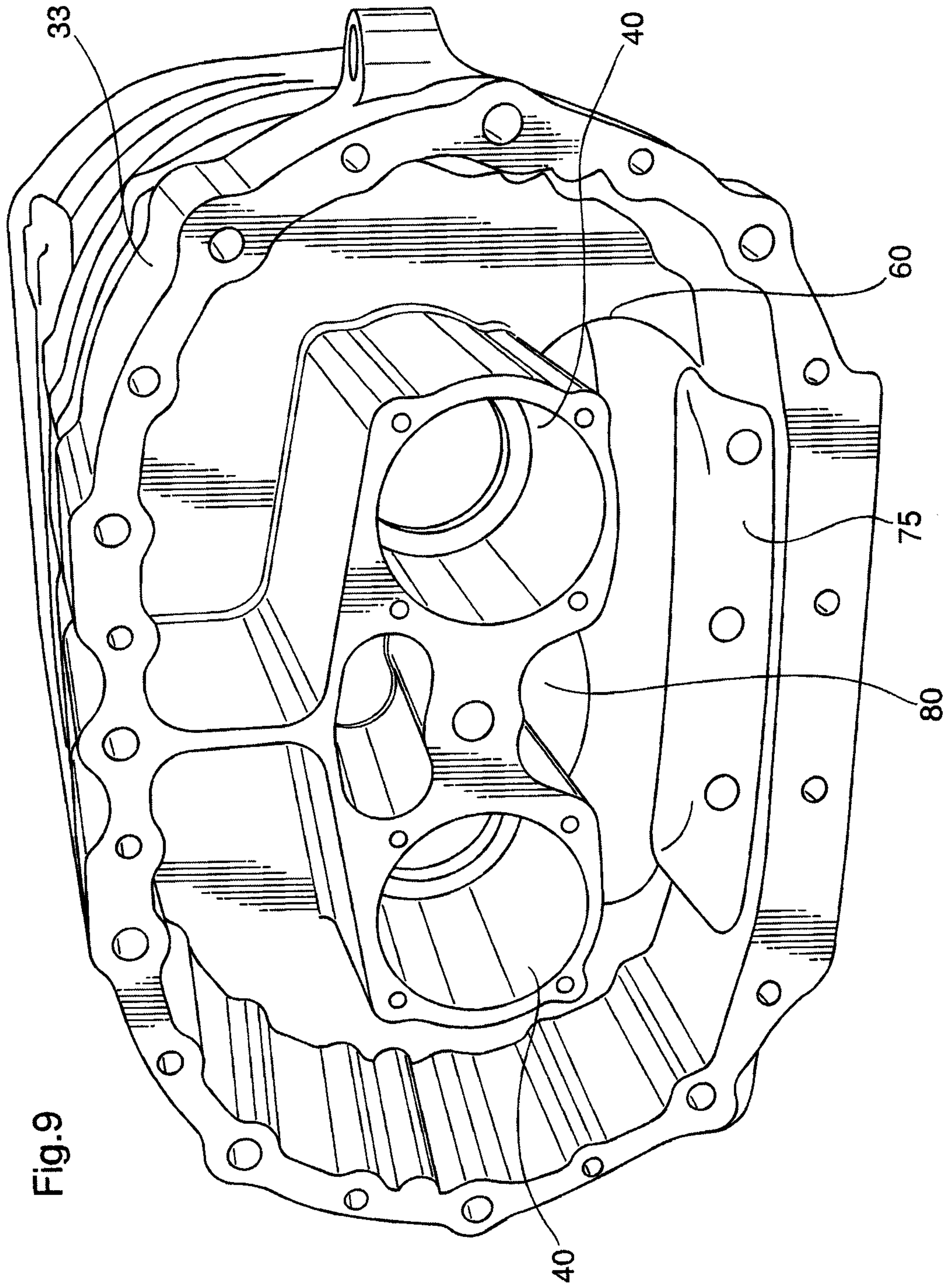


Fig.9

