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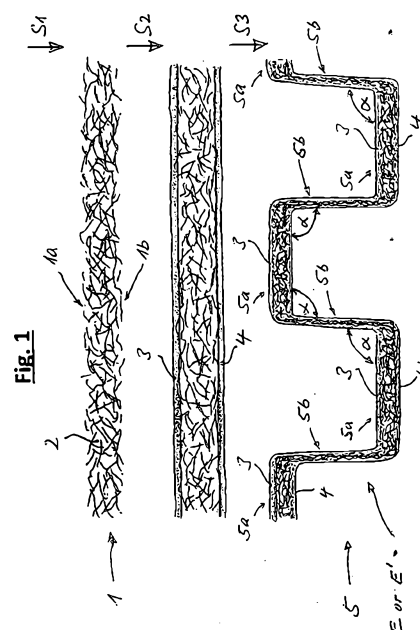
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54 Titre: "Enthalpy exchanger element, enthalpy exchanger comprising such elements and method for their production".

57 Abrégé :

The present invention provides enthalpy exchanger elements (E, E') and enthalpy exchangers comprising such elements. Furthermore, the invention discloses a method for producing such enthalpy exchanger elements and enthalpy exchangers, comprising the steps of a) providing an air-permeable sheet element (1); b) laminating at least one side (1a, 1b) of the sheet element (1) with a thin polymer film (3, 4) with water vapor transmission characteristics; and c) forming the laminated sheet element (1) into a desired shape exhibiting a three-dimensional corrugation pattern (5, 5, ...).



**Enthalpy exchanger element, enthalpy exchanger comprising such elements
and method for their production**

5 The present invention refers to enthalpy exchanger elements and enthalpy exchangers comprising such elements. Furthermore, the invention discloses a method for producing such enthalpy exchanger elements and enthalpy exchangers.

It is well known to use different kinds of heat exchangers for different purposes. Usually, heat exchangers are used to recover heat energy from one fluid or medium
10 into another one. This kind of heat energy is called sensible energy. The heat energy or sensible energy of one fluid, normally air, is recovered into another one which is running adjacent, e.g. parallel, counter or cross flow, to the first where the fluid is at lower temperature. By inverting fluid flows, the exchange between the two will generate a cooler fluid. Heat exchangers used for sensible energy recovery are
15 usually made of metal or polymer elements. There are different types, as there can be cross flow, parallel flow or counter flow configurations. The elements are defining flow channels between themselves so that the fluids can flow between the elements. Such devices are e.g. used in residential and commercial ventilation (HRV).

20 Another type of energy exchangers refers to the so called latent energy which includes the moisture in the air. To exchange the latent energy it is known to use desiccant coated metal or polymer substrates or membranes made from desiccant impregnated cellulose or polymer. Between plates made from cellulose or polymer, air passages are defined or created to allow the fluids to pass along the surface of the
25 plates, thereby transferring moisture from one fluid to the other one. As the

membranes usually have no structural strength, it is known to combine the membranes with frames or grids which thereby define spacings between the membranes.

In case of a combination of the above, i.e. heat exchange and moisture exchange, the energy exchangers are called enthalpy exchanger. Those enthalpy exchangers allow for the exchange of sensible and latent energy, resulting in total energy recovery.

Membrane materials as currently available are delivered by the roll. The membrane material is the most critical part of an enthalpy exchanger. The membrane must be fixed and sealed to a kind of grid or frame and arranged in a way to allow for a fluid to flow between each membrane layer. So, it is obvious that enthalpy exchangers of the known art are a compromise. They will usually lose in sensible energy exchange to gain in latent energy exchange as a result of the selective scope and characteristics of currently used membranes.

Such an enthalpy exchanger built from respective elements is e.g. WO 02/072242 A1. On grids, respective membranes made of fibers are positioned. Grids containing a membrane or spacers between adjacent membranes, i.e. spacers and membranes in alternating sequence, are stapled or stacked, thereby altering the direction of the plates in order to create different air flow directions.

In view of the mentioned state of the art, it is an object of the invention to provide enthalpy exchanger elements and enthalpy exchangers as well as a method for their production which allow for the creation of enthalpy exchangers where the efficiency of both sensible energy exchange and latent energy exchange in each enthalpy exchanger element is increased and where the manufacturing cost of enthalpy exchanger elements and enthalpy exchangers made of such elements is reduced.

It is another object of the invention to provide enthalpy exchanger elements and

enthalpy exchangers with a high specific exchange area for water vapor, as well as a method for their production.

In order to achieve this object, the invention provides a method for producing enthalpy exchanger elements comprising the steps of

- 5 a) providing an air-permeable sheet element;
b) laminating at least one side of the sheet element with a thin polymer film with water vapor transmission characteristics; and
c) forming the laminated sheet element into a desired shape exhibiting a three-dimensional corrugation pattern.

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As a result, an enthalpy exchanger element is obtained which allows both the transfer of heat and water molecules in the form of vapor across the element from one side of the element to the other side of the element almost throughout the entire surface area of the element which now has a higher specific exchange area than such
15 elements in the prior art. In contrast, molecules larger or less polar than water molecules, such as carbon dioxide and odor-related molecules, are barred from passing across the element. In addition, the sheet element and the selectively water vapor transmissible barrier material laminated to at least one side of the sheet element are formed into the desired corrugated shape using only one forming step
20 (“one-step forming”). Thus, in the enthalpy exchanger element according to the invention, total (i.e. sensible plus latent) energy transfer efficiency is increased on the one hand while manufacturing cost is reduced on the other hand.

Alternatively, the sequence of steps b) and c) in the method may be switched, i.e.
25 forming the (not yet laminated) sheet element into a desired shape exhibiting a three-dimensional corrugation pattern and then laminating at least one side of the formed sheet element with a thin polymer film with water vapor transmission characteristics (“two-step forming”).

Water vapor transmission characteristics means a water vapor transmission rate of at least 500 g/m²/24h, preferably of at least 1000 g/m²/24h, even more preferably of at least 1500 g/m²/24h and most preferred of at least 2000 g/m²/24h, as measured using the upright cup method according to modified ASTM E 96-66 B; modifications:

5 $T_{\text{water}} = 30^{\circ}\text{C}$, $T_{\text{air}} = 21^{\circ}\text{C}$, rel. humidity = 60%, air flow = 2m/s.

Step c) of forming the laminated sheet element into a desired shape exhibiting a three-dimensional corrugation pattern may include a first step c1) and a second step c2).

Step c1) comprises forming a first corrugation pattern or reinforcing corrugation
10 pattern with corrugations extending in a first direction and having a relatively fine structure. The first corrugation pattern may have a sinusoidal, rectangular or triangular periodic profile. Preferably, this first periodic profile of the first corrugation pattern has a period of 0.5 mm to 2 mm and an amplitude of 0.5 mm to 1 mm. The first corrugation pattern may comprise adjacent ridges. There may be a
15 spacing between neighboring ridges, i.e. the space of the laminated or not yet laminated sheet element between neighboring ridges is a substantially flat region and the neighboring ridges may protrude in the same or in opposite directions from the sheet element. The height or depth as well as the width of these individually located ridges may be 0.2 mm to 1 mm. The ridge spacing may be 1 to 10 times the
20 ridge width.

This optional first step c1) contributes to the overall stiffness of the enthalpy exchanger element.

Step c2) comprises forming a second corrugation pattern or main corrugation pattern
25 with corrugations extending in a second direction and having a relatively coarse structure defining the heat exchanger plate channel cross section geometry. Again, the second corrugation pattern may have a sinusoidal, rectangular or triangular

periodic profile, but with larger dimensions than the first corrugation pattern. Preferably, this second periodic profile of the second corrugation pattern has a period of 2 mm to 10 mm and an amplitude of 2 mm to 10 mm. As a result, the optional first step c1) and the necessary second step c2) provide an
5 enthalpy exchanger element with double corrugation and enhanced rigidity.

The first direction, i.e. the direction of the ridges of the first corrugation pattern, forms an angle with respect to the second direction, i.e. the direction of the ridges of the second corrugation pattern, preferably an angle of 45° to 90°, more preferably an
10 angle of 85° to 90° and most preferably about 90°.

The sheet material of the sheet element may comprise a polymer, preferably a thermoplastic polymer. Thus, the sheet element lends itself for instance to thermal processing in the forming step c). Preferably, polystyrene (PS), polyvinyl chloride
15 (PVC), viscose or polyester, such as polyethylene terephthalate (PET), or copolyester are selected as thermoplastic polymer. Preferably, the polymer of the sheet material does not include any plasticizer. The polymer of the sheet material may include a biocide (bactericide and/or fungicide).

In a preferred embodiment, the sheet element is a fabric, preferably a nonwoven
20 fabric. The fabric may include thermoplastic fibers only or a combination of thermoplastic fibers and thermoset fibers or a combination of thermoplastic fibers and a resin or a combination of thermoplastic fibers and inorganic fibers. Most preferably, the fabric includes multicomponent or bicomponent fibers together with standard thermoset and/or thermoplastic fibers. Preferably, the fabric includes more
25 than 50 wt. % multicomponent or bicomponent fibers and may include multicomponent or bicomponent fibers only. In addition, the fabric may include metal fibers and/or wick fibers providing high thermal conductivity together with mechanical strength and high capillary action ("humidity conductivity"),

respectively. The inorganic fibers may be glass fibers, silicon carbide fibers or any mineral fiber.

Alternatively, the sheet element is a woven fabric, preferably having an anisotropic structure and anisotropic properties resulting therefrom. For instance, the woven
5 fabric may have thicker polymer fibers in a first fiber direction and thinner polymer fibers in a second fiber direction. The second fiber direction may be between 90° and 100° , preferably about 90° , with respect to the first fiber direction. Due to the thicker polymer fibers in the first fiber direction, the anisotropic woven fabric can
10 withstand more stretching along the first fiber direction without being mechanically weakened (or even damaged) than along the second fiber direction with thinner polymer fibers.

Alternatively, the sheet element may comprise a nonwoven fabric which may have an anisotropic structure and anisotropic properties resulting therefrom, and a woven
15 fabric, preferably having an anisotropic structure and anisotropic properties resulting therefrom.

The sheet element may comprise additional reinforcement fibers for providing extra strength. These reinforcement fibers may be at least one of metal fibers, carbon fibers or thermoplastic polymer fibers. The reinforcement fibers may extend in a first general direction within the sheet element. Preferably, the reinforcement fibers
20 are non-straight. In particular, they may have a wave-like pattern, e.g. with a triangular or sinusoidal flat pattern, preferably having periods of 1 mm to 3 mm and amplitudes of 1 mm to 3 mm. Alternatively, they may have a curly shape, e.g. a helical shape, preferably having a helix diameter of less than 1 mm.

The reinforcement fibers may be continuous fibers or staple fibers with minimum
25 length of 5 mm. The metal fibers may be selected from aluminum, copper, silver or

steel fibers having a diameter between 10 μm and 200 μm , preferably between 20 μm to 100 μm .

5 Preferably, the first general direction of the wave-like pattern and/or the curly shape of the reinforcement fibers form an angle with respect to the direction of the second corrugation pattern defining the heat exchanger plate channel cross section geometry. Preferably, they form an angle of 45° to 90° , more preferably an angle of 85° to 90° and most preferably an angle of about 90° with respect to each other.

10 During step c) or in particular during steps c1) and c2), but primarily during step c2), the non-straight reinforcement fibers are straightened out. In particular, the wave-like pattern and/or the curly shape is stretched and thus flattened in profile, i.e. the amplitude of the wave-like pattern is reduced and its period is increased and/or the diameter of the curly/helical shape is reduced and its period (or pitch) is increased. Once the non-straight carbon and/or metal fibers are completely straightened out, the sheet element will be prevented from further stretching along
15 the first general direction.

In addition, if the sheet element is heated beyond the softening temperature of the thermoplastic polymer fibers before or during step c) or in particular before or during steps c1) and/or c2), the thermoplastic fibers will be deformed by undergoing local stretching and/or bending. After the forming step c) or the forming steps c1) and c2), the permanent deformation of the thermoplastic polymer fibers will
20 contribute to the dimensional stability, i.e. shape retention, of the enthalpy exchanger element.

Preferably, if carbon fibers are included within the sheet element, they extend along the second direction of the second (main) corrugation pattern. Thus, during forming
25 step c) or during forming sub step c2), the carbon fibers will not undergo any

bending. However, they contribute to the overall strength of the sheet element before and after the forming step c) or c2).

Preferably, if metal fibers are included within the sheet element, they may extend along whatever directions within the sheet element. Thus, during forming step c) or
5 during forming sub step c2), the metal fibers will undergo bending under metal cold deformation conditions even if the sheet element is heated beyond the softening temperature of thermoplastic polymer fibers. After the forming step c) or the forming steps c1) and c2), the permanent deformation of the metal fibers will contribute to the dimensional stability, i.e. shape retention, of the enthalpy
10 exchanger element.

Preferably, the fibers of the fabric have fiber diameters between 1 μm and 40 μm , more preferably between 3 μm and 40 μm and most preferably between 5 μm and 20 μm . As a result, when the fabric is laminated with the thin polymer film with water vapor transmission characteristics in the laminating step b), the fabric fibers in
15 direct contact with the thin polymer film will cover only a small portion of the surface of the thin polymer film, thus minimizing any blocking of the thin polymer film. In addition, even if not permanently deformed as described above for thermoplastic polymer fibers or metal fibers, any fabric fibers undergoing elastic bending during step c) will have a high degree of flexibility which helps make the
20 forming step c) easier to perform.

Preferably, the fibers or fabric filaments within the sheet element and in particular those at a non-laminated surface of the sheet element, may have linear mass densities (filament weights) between 1 and 10 dtex (1 tex = 1 g/1000m; 1 dtex = 1g/10000m). Such fine fibers exhibit a strong wicking effect allowing them to
25 transport humidity faster. In addition, when used at a sheet surface or at both sheet surfaces, they provide a smoother and less abrasive surface. First, this helps reduce

the risk of damage to a very thin adjacent functional membrane layer laminated to the respective surface. Second, this helps prevent the formation any air boundary layer at a non-laminated sheet surface.

5 The fibers of the fabric may have substantially circular, triangular or oval cross-sections. Also, the fibers of the fabric may have X-type or star-like cross-sections. The fabric may include fibers having different cross-sections, preferably chosen from the mentioned types of cross-sections.

In addition, the fabric may include a surface impregnant, preferably a thermoplastic or thermoset polymer, in order to improve structural stability after the forming step.
10 In addition or as an alternative, the fabric may include a surface impregnant which can be cross-linked after the forming step c), preferably a resin which can be cured by UV irradiation after the forming step c).

The fabric or the enthalpy exchanger element may include a hydrophobically treated layer on one of its sides and a thin polymer film on the other side, i.e. a single water
15 repellent impregnation.

This can be achieved by laminating only one side of the fabric with a thin polymer film with water vapor transmission characteristics in step b) and providing the other side of the fabric with a hydrophobization treatment before, during or after the laminating step b). The hydrophobization treatment may be carried out even after the
20 forming step c).

Preferably, the hydrophobization treatment of the fabric is carried out before the laminating step b). i.e. before, during or after the providing step a). This prevents the thin polymer film with water vapor transmission characteristics to be accidentally rendered hydrophobic on its surface facing the fabric.

The fabric or the enthalpy exchanger element may include a hydrophobically treated layer on both of its sides and a thin polymer film inside extending in between and “in parallel” to the first hydrophobically treated layer and to the second hydrophobically treated layer of the fabric or the enthalpy exchanger element, i.e. a double water repellent impregnation.

This can be achieved by the following steps:

First, providing one side of a first fabric or the entire first fabric with a hydrophobization treatment before, during or after any laminating step b).

Second, providing one side of a second fabric or the entire second fabric with a hydrophobization treatment before, during or after any laminating step b).

Third, laminating one side of the first fabric with a first side of a thin polymer film with water vapor transmission characteristics.

Fourth, laminating one side of the second fabric with a second side of the thin polymer film with water vapor transmission characteristics producing a sandwich structure having the thin polymer film sandwiched between the first fabric and the second fabric.

Finally, according to step c), this laminated sheet element having a first fabric / thin film / second fabric type sandwich structure is formed into a desired shape exhibiting the three-dimensional corrugation pattern.

Preferably, steps three and four are carried out at the same time, i.e. co-laminating or one-step laminating the first fabric and the second fabric with the one thin polymer film with water vapor transmission characteristics producing the sandwich structure with the thin polymer film sandwiched between the two fabric sheets.

Preferably, the hydrophobization treatment of the first fabric and/or the second fabric is carried out before any laminating step b). i.e. before, during or after the fabric providing step a). Again, this prevents any thin polymer film with water vapor transmission characteristics to be accidentally rendered hydrophobic on its surface
5 facing the fabric, i.e. first fabric or the second fabric.

Instead, the hydrophobization treatment of the first fabric and/or the second fabric may be carried out after the forming step c).

The sheet element may be composed of one layer of fabric comprising any of the combinations of fibers mentioned in the previous paragraph. Alternatively, the sheet
10 element may be composed of several, preferably two or three, stacked layers of fabric attached to each other and each comprising a different one of the combinations of fibers mentioned in the previous paragraph.

The several stacked layers of fabric may have different filament weights. They may comprise a first layer having relatively fine filaments, e.g. 1 to 10 dtex, and a second
15 layer having relatively coarse filaments, e.g. 10 to 40 dtex.

Preferably, the second layer with the coarser or heavier filaments is attached to the thin polymer film (membrane), providing a small direct contact area between the sheet element surface and the thin polymer film attached to it, thus increasing the active membrane surface area of the thin polymer film. Preferably, at least a portion
20 of the heavier filaments are bicomponent fibers allowing the thin polymer film to be attached to the sheet element surface with less glue or no glue at all.

Alternatively, depending on the type of filaments, it can be advantageous if the first layer with finer filaments is contacted with and attached to the thin polymer film (membrane), providing a smooth surface at the sheet element / thin polymer film
25 interface that does not damage the polymer film during the forming step c) of

forming the corrugation pattern or during the forming sub step c2) of forming the second corrugation pattern or during end use.

Irrespective of its position within the sheet element, the second layer with heavier or thicker filaments will provide an open and highly air and vapor permeable layer of
5 the sheet element.

In addition, the sheet element may comprise fine filaments or fibers with strong wicking properties to enhance transport of humidity through the sheet element. Preferably, the fine filaments or fibers, when measured according to DIN 53924, exhibit rising heights of at least 30 to 60 mm after 30 seconds and more preferably
10 rising heights of at least 40 to 60 mm after 30 seconds.

If the forming in step c) or in step c2) is done by vacuum forming with the support of an upper pleating tool, the sheet element may have an asymmetric structure across its thickness. In particular, it may have a layer with relatively fine filaments on the vacuuming side, providing good replication of the mold geometry, and relatively
15 coarse filaments facing the upper pleating tool, providing the required structural strength to the sheet element.

The sheet element may comprise a layer of nonwoven fabric and a layer of woven fabric attached to each other. Preferably, the woven fabric has an anisotropic structure and anisotropic mechanical properties resulting therefrom, as described
20 above.

A portion of the fibers within the sheet element, preferably 5 to 60 wt.%, may be hollow fibers. A portion of the fibers within the sheet element, preferably 20 to 70 wt.%, may be bicomponent fibers. These bicomponent fibers may have circular and/or non-circular cross sections.

A portion of the fibers within the sheet element, preferably 5 to 60 wt.%, may be hydrophilic fibers showing strong wicking properties to increase transport of humidity. Preferably, such wicking fibers are hydrophilic on their surface and hydrophobic in their center.

- 5 A portion of the fibers within the sheet element, preferably 5 to 30 wt.%, may be water absorbing fibers, preferably hydro polymers, to create a water buffer for excess humidity.

The sheet element may have a textured surface and/or an integrated grid structure. As a result, this type of sheet element will cover a minimum surface area of the adjacent thin polymer film attached to the sheet element. The integrated grid structure may be the above-described first or reinforcing corrugation pattern formed in the first forming step c1).

In addition or as an alternative to the above-described measures for increasing the structural strength of the sheet element,

- 15 1) hydroentanglement and/or spunlacing; and/or
 2) surface texturing; and/or
 3) integration of a grid structure with a pattern adapted to the geometry of the second or main corrugation pattern may be applied to the not yet laminated sheet element before subsequent lamination.

- 20 In addition or as an alternative to the above-described measures for increasing the structural strength and the formability of the sheet element, the sheet element may be made with an anisotropic fiber distribution providing higher overall strength of the sheet element and/or higher strength in a preferred direction of the sheet element. In particular, as mentioned above, the anisotropic fiber distribution may be provided
 25 by at least one of carbon fibers, metal fibers or thermoplastic polymer fibers

included in at least one of the several layers of the sheet element.

Preferably, the metal fibers and/or thermoplastic polymer fibers are oriented in close-to-orthogonal relationship with respect to the second direction of the second (main) corrugation pattern or they may extend along whatever directions within the sheet element. Preferably, the carbon fibers are oriented in parallel to the second direction of the second (main) corrugation pattern.

The laminating step b) may comprise bonding, preferably heat bonding, welding and/or gluing, of the thin polymer film to the sheet element. Preferably, a thermoplastic adhesive (hot melt adhesive), a thermoset adhesive or a UV-curable adhesive is used for the bonding between the polymer film and the sheet element.

In a preferred embodiment, the thin polymer film is a monolithic membrane, i.e. a poreless membrane exhibiting a solution-diffusion transport mechanism for individual water molecules. Preferably, this monolithic membrane has a maximum elongation between 100% and 300%, more preferably between 150% and 200%.

In a further preferred embodiment, the thin polymer film is a multilayer film comprising a sequence of polymer layers of different polymer types. Thus, with a few given polymer types, thin polymer films of different water vapor transmission characteristics can be designed and produced.

Preferably, the polymer type of each polymer layer is selected from the group consisting of polyether ester, polyether amide and polyether urethane.

Preferably, the total thickness of the thin polymer multilayer film is between 5 μm and 200 μm , more preferably between 10 μm and 150 μm .

The thickness of each individual polymer layer within the thin polymer multilayer

film may be between 1 μm and 20 μm , preferably between 4 μm and 20 μm and most preferably between 4 μm and 15 μm .

In general, the polymer film(s) or polymer layer(s) should be as thin as possible for high transport rates. In the setup of the enthalpy exchanger element according to the invention, the limiting layer for transport of water vapor is the three-dimensional sheet element located next to the one polymer laminate or between the two polymer laminates. In order to achieve mechanical strength and robustness of the laminate(s) on the one hand and high transport rates on the other hand, a setup is chosen with a polymer film (laminate) thickness between 1 μm and 20 μm , preferably between 4 μm and 20 μm and most preferably between 4 μm and 15 μm . Also, the three-dimensional sheet element is as thin as possible and as permeable as possible. Preferably, the sheet element is a fabric having a thickness between 200 μm and 600 μm , preferably between 300 μm and 500 μm . Preferably, the sheet element is a fabric having a fiber volume portion between 10% and 65% of the fabric volume, preferably between 20% and 50% of the fabric volume.

Preferably, the thermoplastic polymer(s) of the thin polymer film does not include any plasticizer. Instead, the thin polymer film may include a biocide (bactericide and/or fungicide). The biocide will help prevent growth of bacteria and fungi on the polymer and thus achieve longer operation periods without cleaning.

As mentioned above with respect to the thermoplastic polymer, the forming step c) may be a pleating step or thermoforming step, preferably a vacuum forming step. At least a first mold part (e.g. lower tool) having first corrugation formations co-defining the predetermined corrugation pattern of the enthalpy exchanger element to be manufactured, is provided in the thermoforming step. In addition to the at least first mold part, a second mold part (e.g. upper tool) having second corrugation formations complementary to the first corrugation formations and/or a forming

vacuum co-defining the predetermined corrugation pattern of the enthalpy exchanger element to be manufactured, is/are provided in the thermoforming step.

Preferably, prior to the actual forming operation of the laminated sheet element at a specific predetermined forming temperature of the first mold part or at specific
5 predetermined forming temperatures of the first and second mold parts, the laminated sheet element is preheated to a preheating temperature a few degrees below the forming temperature. For pleating, the preheating temperature may be lower.

10 Preferably, the forming temperature is provided by internally heated first and/or second mold parts.

Preferably, the preheating temperature is provided by exposing the not yet formed laminated sheet to electromagnetic radiation (e.g. at infrared or microwave
15 frequencies) and/or to mechanical waves (e.g. at ultrasonic frequencies).

The invention also provides an enthalpy exchanger element, preferably produced using the method as defined in the previous paragraphs, including a sheet element and a predetermined corrugation pattern, wherein a first thin polymer film is
20 laminated to a first side of the sheet element and/or a second thin polymer film is laminated to a second side of the sheet element, both thin polymer films having water vapor transmission characteristics.

The first thin polymer film and the second thin polymer film may be identical to
25 each other. If both sides of the sheet element are laminated, an enthalpy exchanger element having excellent hygienic properties is obtained. If only one side of the sheet element is laminated, the thermoplastic polymer of the sheet material preferably undergoes a hydrophobization treatment and/or includes a biocide

(bactericide and/or fungicide) and again, an enthalpy exchanger element having excellent hygienic properties is obtained.

5 The first thin polymer film and the second thin polymer film may be different from each other. This provides additional freedom to adjust and optimize the heat and moisture transfer characteristics of the enthalpy exchanger element.

10 Finally, the invention provides an enthalpy exchanger having at least three sheet-like or plate-like enthalpy exchanger elements as defined in any of the previous paragraphs, which are stacked onto and fixed to each other with their respective corrugation patterns in parallel orientation to form parallel fluid paths allowing fluids to flow there through. The individual enthalpy exchanger elements may be fixed to each other and sealed by welding, preferably using laser welding, and/or gluing, preferably using epoxy.

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A non-limiting embodiment of the invention is described in further detail below with reference to the drawings, wherein:

20 Fig. 1 is a schematic representation of the method for producing enthalpy exchanger elements according to the invention;

Fig. 2 is a schematic representation of an enthalpy exchanger according to the invention or a portion thereof including a plurality of enthalpy exchanger elements according to the invention;

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Fig. 3 is a SEM (scanning electron microscope) micrograph of a cross-sectional view of a portion of an intermediate product produced during the method for producing an enthalpy exchanger element according to the invention;

Fig. 4 is a SEM micrograph of a cross-sectional view of a portion of an enthalpy exchanger element produced by the method according to the invention;

5 Fig. 5 is a SEM micrograph similar to the one of Fig. 3 showing of a larger scale cross-sectional view of a smaller portion of an intermediate product produced during the method for producing an enthalpy exchanger element according to the invention; and

10 Fig. 6 is a SEM micrograph similar to the one of Fig. 4 showing of a smaller scale cross-sectional view of a larger portion of an enthalpy exchanger element produced by the method according to the invention.

15 In Fig. 1, a schematic representation of the method for producing enthalpy exchanger elements according to the invention is shown. Cross-sections of the intermediate products, i.e. the results of each of steps S1, S2 and S3, are shown.

In a first step S1, an air-permeable sheet element 1 having voids or openings 2 is provided.

20 In a second step S2, both sides 1a, 1b of the sheet element 1 are laminated with a thin polymer film 3, 4 with water vapor transmission characteristics.

In a third step S3, the laminated sheet element 1 is formed into a desired shape exhibiting a three-dimensional corrugation pattern 5.

25 The sheet element 2 is a non-woven fabric including thermoplastic fibers only or a combination of thermoset fibers and thermoplastic fibers. The fabric may include bicomponent fibers together with standard thermoset and/or thermoplastic fibers.

The thin polymer film 3, 4 is a multilayer film which may comprise a sequence (not shown) of polymer layers of different polymer types.

The forming step S3 is a thermoforming step, preferably a vacuum forming step. At least a first mold part (e.g. lower tool, not shown) having first corrugation formations co-defining the predetermined corrugation pattern 5 of the enthalpy exchanger element E, E' to be manufactured, is used in the thermoforming step S3.

- 5 In addition to the at least first mold part, a second mold part (e.g. upper tool, not shown) having second corrugation formations complementary to the first corrugation formations and/or a forming vacuum co-defining the predetermined corrugation pattern of the enthalpy exchanger element E, E' to be manufactured, is/are used in the thermoforming step S3.
- 10 The resulting enthalpy exchanger element E having a first thin polymer film 3 on the first side 1a of the sheet element 1 and a second thin polymer film 4 on the second side 1b of the sheet element 1 comprises a corrugated structure 5 with alternating squeezed portions 5a and squeezed/stretched portions 5b. The squeezed portion 5a extend in a first direction (horizontal direction in Fig. 1) and the squeezed/stretched portions 5b extend in a second direction different from the first direction. Preferably, the angle α between the first direction and the second direction in the corrugation pattern 5 of the enthalpy exchanger element E is between 90° and 120° , preferably between 95° and 105° , an example of which is shown in Fig. 1. Alternatively, unlike the example shown in Fig. 1, the angle α between the first direction and the second direction in the corrugation pattern 5 of the enthalpy exchanger element E is between 80° and 90° , preferably between 85° and 90° .
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- 20

In Fig. 2, a schematic representation of a first type enthalpy exchanger E1-E2-E3 or second type enthalpy exchanger E1'-E2'-E3' according to the invention is shown. The first type E1-E2-E3 includes a plurality of enthalpy exchanger elements E1, E2, E3 where the first thin polymer film 3 and the second thin polymer film 4 (Fig. 1) are films of the same type. The second type E1'-E2'-E3' includes a plurality of enthalpy exchanger elements E1', E2', E3' where the first thin polymer film 3 and

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the second thin polymer film 4 (Fig. 1) are films of different types including the case where one of the two films 3, 4 has zero thickness, i.e. the enthalpy exchanger element has only one thin polymer film 3 or 4 on one side 1a or 1b of the sheet element 1.

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In Fig. 2, the outer walls of the housing/packaging of the enthalpy exchanger E1-E2-E3 or E1'-E2'-E3' is not shown. The air inlet/outlet portions (not shown) of the enthalpy exchanger E1-E2-E3 or E1'-E2'-E3' are provided with air distribution patterns such that the air flow direction in adjacent air ducts in the enthalpy exchanger E1-E2-E3 or E1'-E2'-E3' are in opposite directions, as shown by the O symbol indicating air flow towards the viewer and the X symbol indicating air flow away from the viewer.

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Fig. 3 shows a SEM (scanning electron microscope) micrograph of a cross-sectional view of an air-permeable sheet element 1 laminated on its upper side 1a with a first thin polymer film 3 and laminated on its lower side 1b with a second thin polymer film 4 as a result of step b) of the method according to the invention.

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The laminating step b) may comprise bonding, preferably heat bonding and/or gluing, of the thin polymer films 3, 4 to the sheet element 1. A thermoplastic adhesive (hot melt adhesive) may be used for the bonding between the polymer film 3 and 4 and the sheet element 1.

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The sheet element 1 is a nonwoven fabric comprising a plurality of fibers 6. The fibers 6 may be thermoplastic fibers only or a combination of thermoset fibers and/or mineral fibers on the one hand and thermoplastic fibers on the other hand. Most preferably, the fabric includes multicomponent or bicomponent fibers together with standard thermoset and/or thermoplastic fibers. As can be best seen by comparing Fig. 3 with Fig. 4, the fibers 6 of the nonwoven fabric sheet element 1

shown in Fig. 3 are less densely packed than the fibers 6 of the nonwoven fabric sheet element 1 of the enthalpy exchanger element shown in Fig. 4.

Fig. 4 shows a SEM micrograph of a cross-sectional view of a portion of an enthalpy exchanger element E produced by forming the laminated sheet element 1 of Fig. 3 into a desired shape exhibiting a three-dimensional corrugation pattern as a result of step c) of the method according to the invention.

The forming step c) may be a pleating step or thermoforming step, preferably a vacuum forming step. At least a first mold part (e.g. lower tool, not shown) having first corrugation formations defining or co-defining the predetermined corrugation pattern of the enthalpy exchanger element E, E' to be manufactured, is provided for and used in the thermoforming step. In addition to the at least first mold part, a second mold part (e.g. upper tool, not shown) having second corrugation formations complementary to the first corrugation formations and/or a forming vacuum co-defining the predetermined corrugation pattern of the enthalpy exchanger element E, E' to be manufactured, may be provided in the thermoforming step.

The first mold part (e.g. lower tool) may comprise nozzles or through holes pneumatically connected to a vacuum source providing a vacuum for the vacuum forming step.

In addition to the first mold part and/or the second mold part used in the forming step c), preferably for supporting the vacuum action in the vacuum forming step, nozzles connected to a pressurized air source may be provided. These nozzles may be provided in the vicinity of, preferably adjacent to, the first mold part and/or the second mold part. Preferably, the pressurized air source comprises an air heating device for heating the pressurized air.

The combined use of the first tool and the vacuum source in the thermoforming step c) can be supplemented by the second tool and/or the pressurized air source, preferably with air heating device. As a result, using at least some of these supplements, a sheet element 1 laminated with a first thin polymer film 3 and an optional second thin polymer film 4 can be pressed more strongly against the first corrugation formations of the first mold part, thus producing an enthalpy exchanger element E with a better copy of the first corrugation formations of the first mold part defining or co-defining the predetermined corrugation pattern of the enthalpy exchanger element E to be manufactured.

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The sheet element 1 of the enthalpy exchanger element E has its fibers 6 much more densely packed than the sheet element 1 of Fig. 3. During the pleating or thermoforming step c), the fabric sheet element 1 with its first thin polymer film 3 and its second thin polymer film 4 is compressed and heated. At least the thermoplastic fibers or the multicomponent or bicomponent fibers of the plurality of fibers 6 are softened or partly melted during the pleating or thermoforming step c). As a result, after cooling and hardening of the thermoplastic fibers or the multicomponent or bicomponent fibers of the plurality of fibers 6, the fabric sheet element 1 with its first thin polymer film 3 and its second thin polymer film 4 is transformed into an enthalpy exchanger element E according to the invention with a more compact fiber structure in the fabric sheet element 1 and with a three-dimensional corrugation pattern.

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Fig. 5 shows a SEM micrograph similar to the one of Fig. 3 showing of a larger scale cross-sectional view of a smaller portion of the air-permeable fabric sheet element 1 laminated on its upper side 1a with the first thin polymer film 3 and laminated on its lower side 1b with the second thin polymer film 4 as a result of step b) of the method according to the invention.

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Fig. 6 shows a SEM micrograph similar to the one of Fig. 4 showing of a smaller scale cross-sectional view of a larger portion of the enthalpy exchanger element E produced by the method according to the invention.

5

Reference numerals:

- 1 fabric sheet element
- 1a first surface
- 1b second surface
- 5 2 voids or openings
- 3 first thin polymer film
- 4 second thin polymer film
- 5 corrugation
- 5a squeezed portion
- 10 5b squeezed and/or stretched portion
- S1 providing step
- S2 laminating step
- S3 forming step (co-forming)
- O air flow direction towards viewer
- 15 X air flow direction away from viewer
- 6 fiber
- α angle (in corrugation pattern)

Claims

1. A method for producing enthalpy exchanger elements (E, E') comprising the steps of:
- 5 a) providing an air-permeable sheet element (1);
- b) laminating at least one side (1a, 1b) of the sheet element (1) with a thin polymer film (3, 4) with water vapor transmission characteristics;
- c) forming the laminated sheet element (1) into a desired shape exhibiting a three-dimensional corrugation pattern (5, 5, ...).
- 10 2. The method according to claim 1, wherein the sheet material of the sheet element (1) comprises a polymer.
3. The method according to claim 1 or 2, wherein the sheet element (1) is a fabric, preferably a nonwoven fabric.
4. The method according to claim 3, wherein a fraction, preferably at least 50% by
- 15 weight, of the fibers (6) of the fabric are multi-component, preferably bi-component fibers.
5. The method according to any of claims 1 to 4, wherein the laminating step b) comprises at least one of bonding, preferably heat bonding, welding and gluing, of the thin polymer film (3, 4) to the sheet element (1).
- 20 6. The method according to any one of claims 1 to 5, wherein the at least one thin polymer film (3, 4) on the at least one side (1a, 1b) of the sheet element (1) is an air-impermeable polymer film.

7. The method according to any of claims 1 to 6, wherein the thin polymer film (3, 4) is a multilayer film comprising a sequence of polymer layers of different polymer types.
8. The method according to claim 7, wherein the polymer type of each polymer layer is selected from the group consisting of polyether ester, polyether amide and polyether urethane.
9. The method according to claim 7 or 8, wherein the total thickness of the thin polymer multilayer film is between 5 μm and 200 μm , more preferably between 10 μm and 150 μm .
10. The method according to any of claims 7 to 9, wherein the thickness of each individual polymer layer within the thin polymer multilayer film is between 1 μm and 20 μm , preferably between 4 μm and 20 μm , and more preferably between 4 μm and 15 μm .
11. The method according to any of claims 1 to 10, wherein the forming step c) is a thermoforming step, preferably a vacuum forming step or a pleating step.
12. The method according to claim 11, wherein at least a first mold part having first corrugation formations defining or co-defining the predetermined corrugation pattern of the enthalpy exchanger element (E, E') to be manufactured, is provided for and used in the thermoforming step c).
13. The method according to claim 12, wherein a second mold part having second corrugation formations complementary to the first corrugation formations co-defining the predetermined corrugation pattern of the enthalpy exchanger element (E, E') to be manufactured, is provided for and used in the thermoforming step c).

14. The method according to any of claims 10 to 13, wherein nozzles connected to a pressurized air source provided for and used in the thermoforming step c).

15. The method according to claim 14, wherein the nozzles are provided in the vicinity of the first mold part and/or the second mold part.

5 16. An enthalpy exchanger element (E; E'), preferably produced using the method as defined in any of claims 1 to 15, including an air-permeable sheet element (1) and a predetermined three-dimensional corrugation pattern (5, 5, ...), wherein a first thin polymer film (3) is laminated to a first side (1a) of the sheet element (1) and/or a second thin polymer film (4) is laminated to a second side (1b) of the sheet element
10 (1), both thin polymer films (3, 4) having water vapor transmission characteristics.

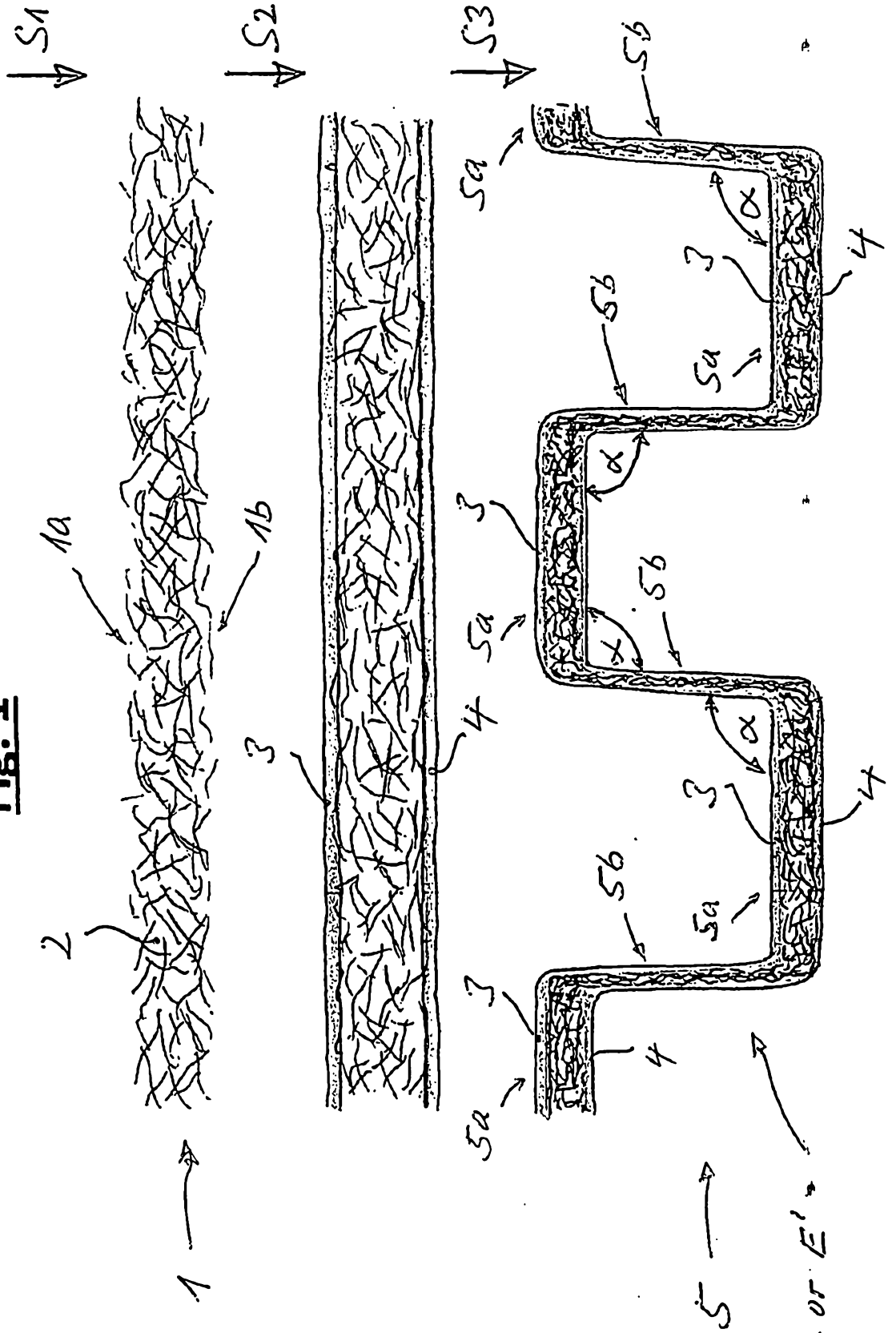
17. The enthalpy exchanger element (E) according to claim 16, wherein the first thin polymer film (3) and the second thin polymer film (4) are identical to each other.

15 18. The enthalpy exchanger element (E') according to claim 16, wherein the first thin polymer film (3) and the second thin polymer film (4) are different from each other.

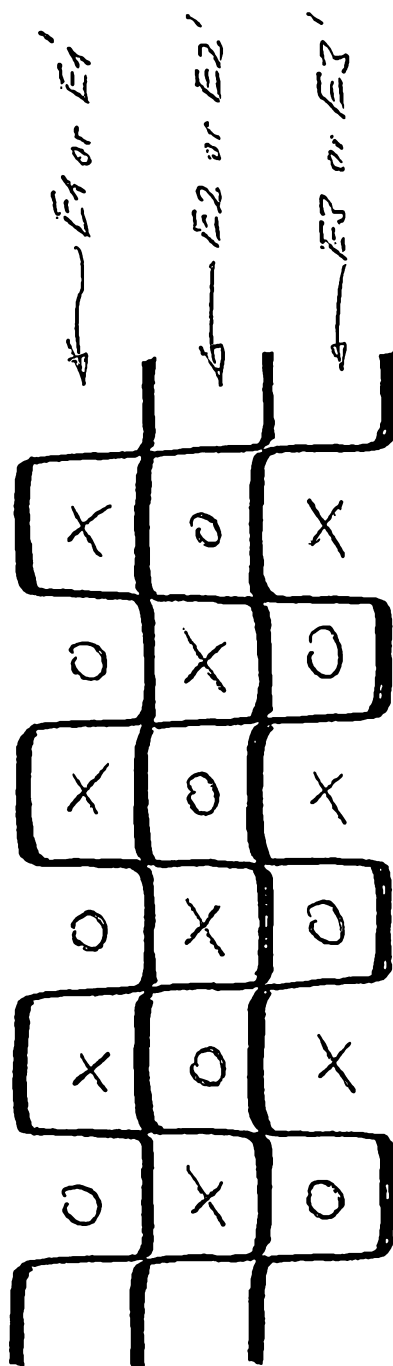
19. An enthalpy exchanger having at least three sheet-like or plate-like enthalpy
20 exchanger elements (E1, E2, E3; E1', E2', E3') as defined in any of claims 16 to 18, which are stacked onto and fixed to each other, preferably by means of welding such as laser welding or ultrasonic welding or by means of gluing, with their respective three-dimensional corrugation patterns (5, 5, ...) in parallel orientation to form parallel fluid paths allowing fluids to flow there through.

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Fig. 1



E or E'

Fig. 2

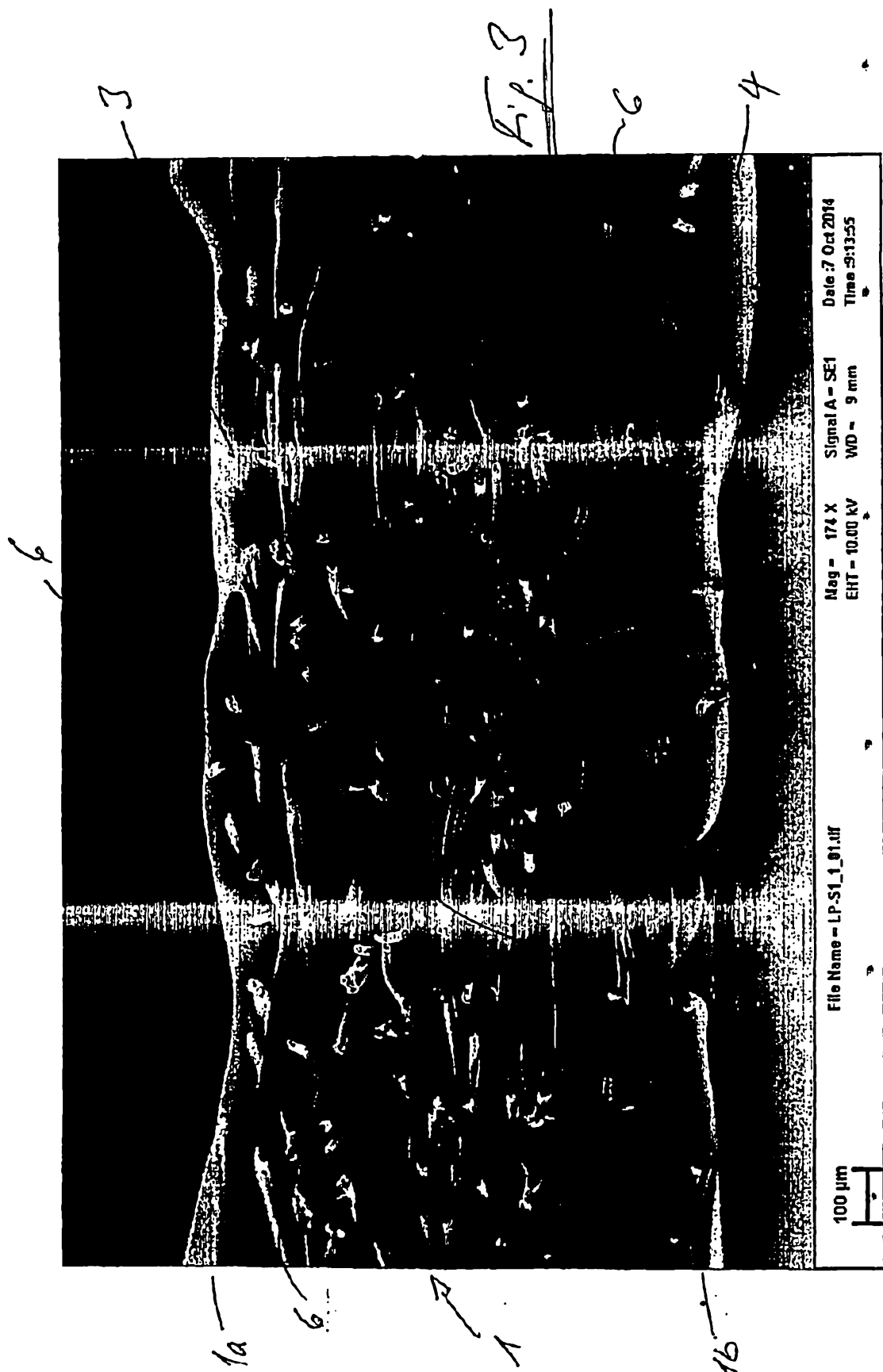


Fig. 3

1a

6

↑

1b

3

2

4

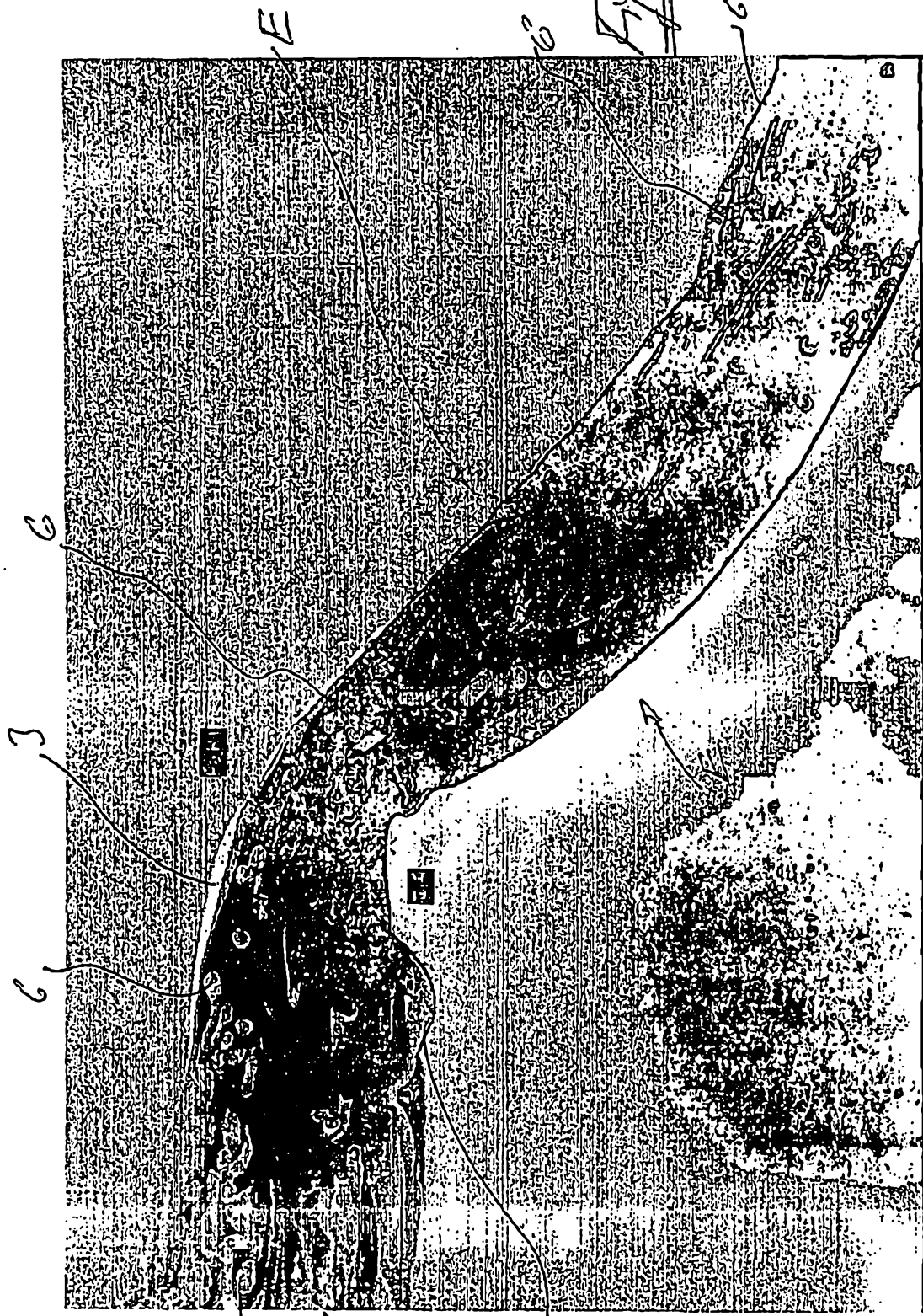
5

100 μm

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4/6

Fig. 4



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Time : 10:07:39

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Signal A = SE1
WD = 9 mm

File Name = LP.S3_06.tif

100 μm

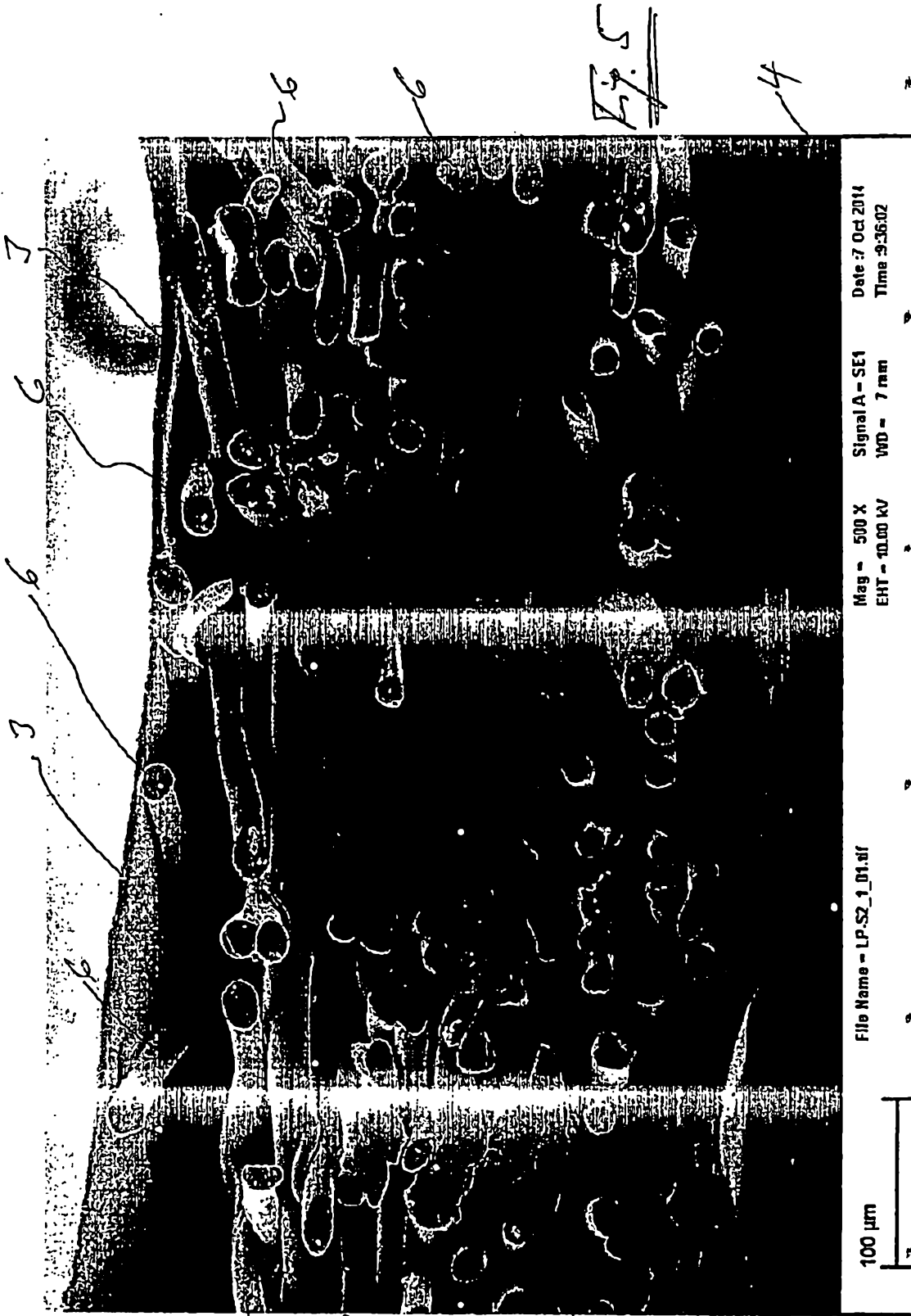
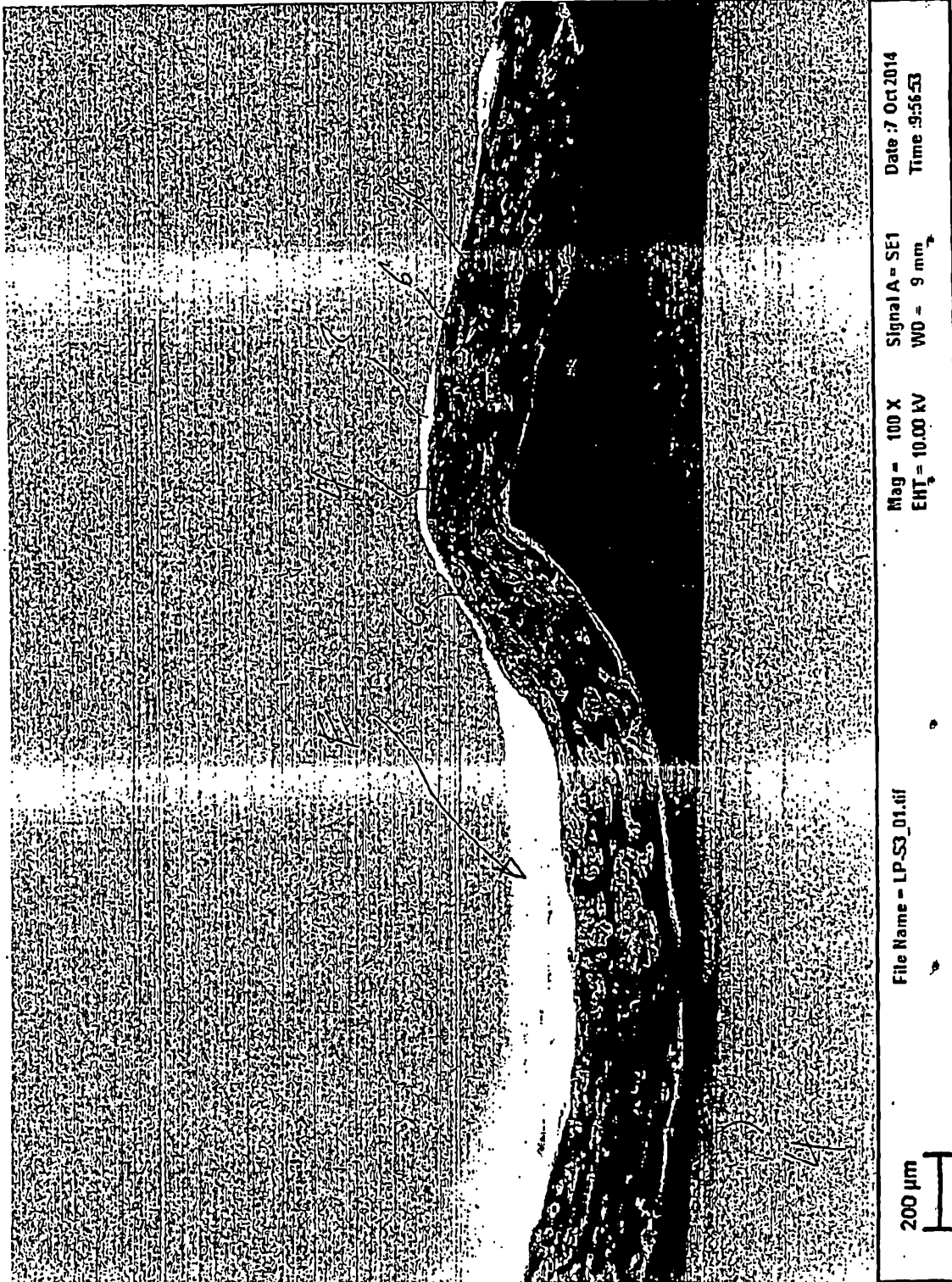


Fig 6



1 →

ABSTRACT

The present invention provides enthalpy exchanger elements (E, E') and enthalpy exchangers comprising such elements. Furthermore, the invention discloses a method for producing such enthalpy exchanger elements and enthalpy exchangers, comprising the steps of a) providing an air-permeable sheet element (1); b) laminating at least one side (1a, 1b) of the sheet element (1) with a thin polymer film (3, 4) with water vapor transmission characteristics; and c) forming the laminated sheet element (1) into a desired shape exhibiting a three-dimensional corrugation pattern (5, 5, ...).

(Figure 1)