

(12) STANDARD PATENT
(19) AUSTRALIAN PATENT OFFICE

(11) Application No. **AU 2007249192 C1**

(54) Title
Composite spark plug

(51) International Patent Classification(s)
H01T 13/00 (2006.01) **F02P 13/00** (2006.01)

(21) Application No: **2007249192** (22) Date of Filing: **2007.05.14**

(87) WIPO No: **WO07/134296**

(30) Priority Data

(31) Number	(32) Date	(33) Country
11/747,714	2007.05.11	US
60/799,926	2006.05.12	US

(43) Publication Date: **2007.11.22**

(44) Accepted Journal Date: **2010.12.02**

(44) Amended Journal Date: **2014.05.22**

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(56) Related Art
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US 4460847 A
US 2005/0168121 A1
US 2007/0116976 A1
US 6559578 B1
US 6132277 A
US 2005/0110382 A1
US 6329743 B1

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
22 November 2007 (22.11.2007)

PCT

(10) International Publication Number
WO 2007/134296 A3

- (51) International Patent Classification:
H01T 13/00 (2006.01) *F02P 13/00* (2006.01)
- (21) International Application Number:
PCT/US2007/068897
- (22) International Filing Date: 14 May 2007 (14.05.2007)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
60/799,926 12 May 2006 (12.05.2006) US
11/747,714 11 May 2007 (11.05.2007) US
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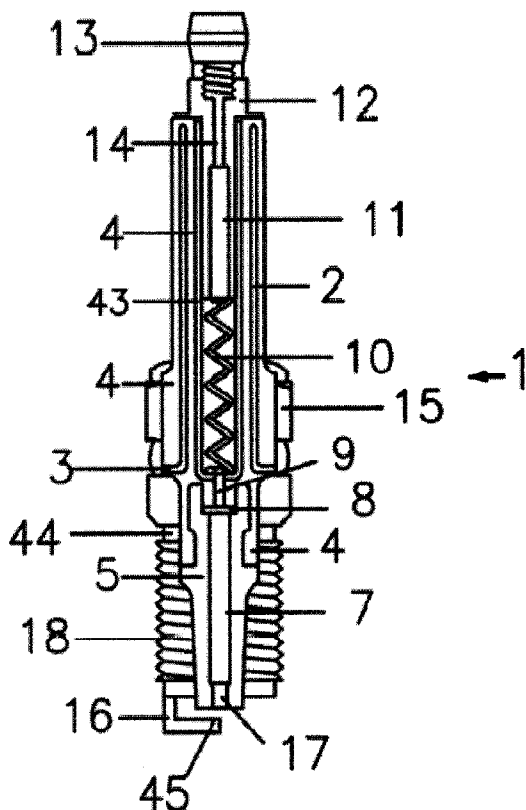
(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BH, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RS, RU, SC, SD, SE, SG, SK, SL, SM, SV, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, MT, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Declaration under Rule 4.17:
— of inventorship (Rule 4.17(iv))

[Continued on next page]

(54) Title: COMPOSITE SPARK PLUG



(57) Abstract: A composite ignition device includes a positive electrode having a tip formed thereon that is bonded to a first insulator to form a firing cone assembly. A second insulator having a negative capacitive element embedded therein is attached to the firing cone assembly. A positive capacitive element is disposed in the second insulator and is separated from the negative capacitive element by the second insulator. The positive capacitive element is coupled to the positive electrode. The positive and negative capacitive elements form a capacitor. A resistor is coupled to the positive capacitive element. An electrical connector is coupled to the resistor and attached to the second insulator. A shell including a negative electrode having a tip is attached to the second insulator and the firing cone assembly and coupled to the negative capacitive element. The negative electrode tip is spaced apart from the positive electrode tip.

WO 2007/134296 A3



Published:

- with international search report
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(88) Date of publication of the international search report:

10 January 2008

COMPOSITE SPARK PLUG

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CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims priority to and the benefit of the filing of U.S. Provisional Patent Application Serial No. 60/799,926, entitled "Composite Spark Plug", filed on May 12, 2006, and the specification thereof is incorporated herein by reference.

10

BACKGROUND OF THE INVENTION

The present invention relates to spark plugs used to ignite fuel in internal combustion spark-ignited engines. Present day spark plug technology dates back to the early 1950's with no dramatic
15 changes in design except for materials and configuration of the spark gap electrodes. These relatively new electrode materials such as platinum and iridium have been incorporated into the design to mitigate the erosion common to all spark plugs electrodes in an attempt to extend the useful life. While these materials will reduce electrode erosion for typical low power discharge (less than 1 ampere peak discharge current) spark plugs and perform to requirements for 10^9 cycles, they
20 will not withstand the high coulomb transfer of high power discharge (greater than 1 ampere peak discharge current). Additionally, there have been many attempts at creating higher capacitance in the spark plug or attaching a capacitor in parallel to existing spark plugs. While this will increase the discharge power of the spark, the designs are inefficient, complex and none deal with the accelerated erosion associated with high power discharge. There has been no attempt to create an
25 insulator of the spark plug using dissimilar materials in a modular assembly.

U.S. Patent No. 3,683,232, U.S. Patent No. 1,148,106 and U.S. Patent No. 4,751,430 discuss employing a capacitor or condenser to increase spark power. There is no disclosure as to the electrical size of the capacitor, which would determine the power of the discharge. Additionally, if
30 the capacitor is of large enough capacitance, the voltage drop between the ignition transformer output and the spark gap could prevent gap ionization and spark creation.

U.S. Patent No. 4,549,114 claims to increase the energy of the main spark gap by incorporating into the body of the spark plug an auxiliary gap. The use of two spark gaps in a
35 singular spark plug to ignite fuel in any internal combustion spark ignited engine that utilizes electronic processing to control fuel delivery and spark timing could prove fatal to the operation of the engine as the EMI/RFI emitted by the two spark gaps could cause the central processing unit to malfunction.

In U.S. Patent No. 5,272,415, a capacitor is disclosed attached to a non-resistor spark plug. Capacitance is not disclosed and nowhere is there any mention of the electromagnetic and radio frequency interference created by the non-resistor spark plug, which if not properly shielded against EMI/RFI emissions, could cause the central processing unit to shut down or even cause permanent damage.

U.S. Patent No. 5,514,314 discloses an increase in size of the spark by implementing a magnetic field in the area of the positive and negative electrodes of the spark plug. The invention also claims to create monolithic electrodes, integrated coils and capacitors but does not disclose the resistivity values of the monolithic conductive paths creating the various electrical componentry. Electrical components conductive paths are designed for resistivity values of 1.5-1.9 ohms/meter ensuring proper function. Any degradation of the paths by migration of the ceramic material inherent in the cermet ink reduces the efficacy and operation of the electrical device. In addition, there is also no mention of the voltage hold off of the insulating medium separating oppositely charged conductive paths of the monolithic components. If standard ceramic material such as Alumina 86% is used for the spark plug insulating body, the dielectric strength, or voltage hold off is 200volts/mil. The standard operating voltage spread for spark plugs in internal combustion spark ignited engines is from 5Kv to 20Kv with peaks of 40Kv seen in late model automotive ignitions, which might not insulate the monolithic electrodes, integrated coils and capacitors against this level of voltage.

U.S. Patent No. 5,866,972 and U.S. Patent No. 6,533,629 speak to the application, by various methods and means, electrodes and or electrode tips consisting of platinum, iridium or other noble metals to resist the wear associated with spark plug operation. These applications are likely not sufficient to resist the electrode wear associated with high power discharge. As the electrode wears, the voltage required to ionize the spark gap and create a spark increases. The ignition transformer or coil is limited in the amount of voltage delivered to the spark plug. The increase in spark gap due to accelerated erosion and wear could be more than the voltage available from the transformer, which could result in misfire and catalytic converter damage.

U.S. Patent No. 6,771,009 discloses a method of preventing flashover of the spark and does not resolve issues related to electrode wear or increasing spark discharge power.

U.S. Patent No. 6,798,125 speaks to the use of a higher heat resistance Ni-alloy as the base electrode material to which a noble metal is attached by welding. The primary claim is the Ni-based base electrode material, which ensures the integrity of the weld. The combination is said to reduce electrode erosion but does not claim to either reduce erosion in a high-power discharge condition or improve spark power.

U.S. Patent NO. 6,819,030 for a spark plug claims to reduce ground electrode temperatures but does not claim to reduce electrode erosion or improve spark power.

In accordance with one aspect of the present invention there is provided a composite ignition device for an internal combustion engine, including: a positive
5 electrode bonded to a first insulator said positive electrode having a tip formed on an end thereof, said positive electrode further including a coating of conductive ink on an exterior surface thereof; a second insulator; a negative capacitive element; a positive capacitive element separated from said negative capacitive element by said
10 second insulator, said positive capacitive element coupled to said positive electrode, said positive capacitance element and said negative capacitive element forming a capacitor; a resistor disposed in a resistor insulator and coupled to said positive capacitive element by a resistor connector without said resistor reducing current from said capacitor to a spark gap of said ignition device, said resistor disposed in a
15 position to reduce charging current of said capacitor; and a shell, said shell including a negative electrode having a tip formed thereon and spaced apart from said positive electrode tip.

Alternatively, the second insulator is attached to the firing cone assembly and the negative capacitive element is embedded in the second insulator by injection molding or by insert molding. Alternatively, the second insulator comprises an
20 engineered polymer. The engineered polymer may comprise liquid crystal polymer or polyetheretherketone and may have a dielectric constant from between about 5 to about 10.

Alternatively, the first insulator comprises an alumina material. The alumina material may comprise from about 88 percent to about 99 percent pure alumina.
25 Alternatively, the resistor connector comprises a spring member. Alternatively, the positive and negative electrode tips comprise a sintered rhenium and tungsten material. The material may be formed from about 50 percent rhenium and about 50 percent tungsten or from about 75 percent rhenium and about 25 percent tungsten. Alternatively, the positive electrode further comprises a coating of conductive ink on
30 an exterior surface thereof, the coating having a predetermined thickness. The conductive ink may comprise a precious metal or precious metal alloy. Alternatively, the capacitor has a predetermined capacitance in the range from about 30 to about

100 pf. Alternatively, the positive capacitive element is coupled to the positive electrode by an interference fit.

5 In accordance with another aspect of the present invention there is provided a circuit for an ignition device for an internal combustion engine, including: a power source operable to intermittently activate said circuit; a positive electrode having a tip on an end thereof; a ground electrode connected to ground and having a tip on an end thereof, said ground electrode tip spaced apart from said positive electrode tip by a predetermined spark gap; at least one resistor connected in series with said power source and said positive electrode; and at least one capacitor directly connected to
10 said resistor and connected in parallel with said positive electrode and ground, said resistor not in parallel with said capacitor, at least one plate said capacitor including a conductive ink.

15 Alternatively, the at least one resistor reduces radio frequency interference (RFI) when the circuit is active. Alternatively, the at least one capacitor increases peak current to the spark gap when the circuit is active. Alternatively, the positive and negative electrode tips comprise a sintered rhenium and tungsten material. The material may be formed from about 50 percent rhenium and about 50 percent tungsten or from about 75 percent rhenium and about 25 percent tungsten. Alternatively, the resistor has a predetermined resistance in the range from about 2
20 kohms to about 20 kohms. Alternatively, the capacitor has a predetermined capacitance in the range from about 30 to about 100 pf.

Alternatively, the step of embedding a negative capacitive element in a second insulator and attaching the second insulator to the firing cone assembly comprises injection molding or insert molding. Alternatively, the second insulator comprises an engineered polymer. The engineered polymer may comprise liquid crystal polymer or polyetheretherketone and may have a dielectric constant from between about 5 to about 10.

Alternatively, the first insulator comprises an alumina material. The alumina material may comprise from about 88 percent to about 99 percent pure alumina. Alternatively, the resistor connector comprises a spring member. Alternatively, the method further comprises forming the positive and negative electrode tips by sintering rhenium and tungsten to form a sintered material. The material may be formed from about 50 percent rhenium and about 50 percent tungsten or from about 75 percent rhenium and about 25 percent tungsten. Alternatively, the capacitor has a predetermined capacitance in the range from about 30 to about 100 pf. Alternatively, the step of coupling the positive capacitive element to the positive electrode is performed by an interference fit.

The present invention provides an ignition device or spark plug for spark ignited internal combustion engines which, comprises a capacitive element or capacitor formed with or integral to the insulator for the purpose of peaking the electrical current and thereby electrical power of the spark during the streamer phase of the spark event. The additional increase in spark power creates a larger flame kernel and ensures consistent ignition relative to crank angle, cycle-to-cycle. With circuitry properly employed, there is no change to the breakdown voltage of the spark gap, no change to the timing of the spark event, nor is there any change to total spark duration.

In operation, the ignition pulse is exposed to the spark gap and the capacitor of the spark plug simultaneously as the capacitor is connected in parallel to the circuit. As the coil rises inductively in voltage to overcome the resistance in the spark gap, energy is stored in the capacitor as the resistance in the capacitor is less than the resistance in the spark gap. Once resistance is overcome in the spark gap through ionization, there is a reversal in resistance between the spark gap and the capacitor triggering the capacitor to discharge the stored energy very quickly, between one to ten nanoseconds, across the spark gap peaking the current and thereby the power of the spark.

The capacitor charges to the voltage level required to breakdown the spark gap. As engine load increases, vacuum decreases, increasing the air pressure at the spark gap. As pressure increases the voltage required to break down the spark gap increases causing the capacitor to charge to a higher voltage. The resulting discharge is peaked to a higher power value. There is no delay in the timing event as the capacitor is charging simultaneously with the rise in voltage of the coil.

The capacitive elements preferably comprise two oppositely charged, electrically conductive cylindrical plates, of which the ground plate is completely encased in an engineered polymer during an insert or over molding process. The negative plate is exposed in a small circumferential area at the major diameter of the composite insulator making contact with the conductive steel shell of the spark plug. This exposure allows physical, mechanical and electrical contact thereby effectively placing the plate in the ground circuit of the electrical system.

The positive plate of the capacitive element is also the center conductor of the spark plug connected, through a resistor or inductor, to the high-tension lead from the ignition coil or the coil directly. The conductor is inserted, with an interference fit, into the central cavity of the composite insulator formed during the molding process. An interference fit of .0005"-.001" is preferably required to fix the relationship of the conductive plates, thereby establishing a consistent capacitance value. The insertion of the center conductor also establishes electrical and mechanical contact with the center electrode of the spark gap.

The molding process, using the engineered polymer, aligns and secures the ceramic combustion cone, which contains the center electrode of the spark gap to the negative plate of the capacitive element of the spark plug. Preferably, the molding process is an injection molding process or an insert molding process, as will be appreciated by those skilled in the art. Inserting the center conductor completes the capacitor and provides a connection between the spark plug and the ignition coil. Capacitance can vary from 10 picofarads to as much as 100 picofarads dependant on the geometry of the plates, their separation and the dielectric constant of the insulating engineered polymer.

The ends of capacitor plates are preferably offset to prevent enhancing the electrical field at the termination of the plates, which could compromise the dielectric strength of the engineered polymer insulator and could result in catastrophic failure of the spark plug. The electrical charge of the ignition could break down the insulator at this point with the pulse going directly to ground, bypassing the spark gap and causing permanent spark plug failure.

The present invention also provides a spark plug for spark ignited internal combustion engines, which provides an electrode material comprised primarily of Rhenium sintered with Tungsten. Sintered compound percentages can range from 50% Rhenium and 50% Tungsten to 75% Rhenium and 25% Tungsten. Pure Tungsten would be a very desirable electrode material due to its conductivity and density but is not a good choice for internal combustion engine applications as it oxidizes at temperatures lower than the combustion temperatures of fossil fuels. Additionally, newer engine design is employing lean burn, which has a higher combustion temperature making Tungsten an even less acceptable electrode material. During the oxidation process the Tungsten

electrode will erode at an accelerated rate due to its volatility at oxidation temperature, thereby reducing useful life. By sintering tungsten with rhenium protects tungsten against the oxidation process and allows for the desired effect of reducing erosion in a high-power discharge application

5 Using noble metals for electrodes, as is current industry practice to meet federal guidelines, will not survive the required mileage requirement under high spark power operation. The increased power of the discharge will increase the erosion rate of the noble metal electrode and cause misfire. In all cases of misfire, damage or destruction of the catalytic converter will occur.

10 While the use of the rhenium/tungsten sintered compound will mitigate the oxidation erosion issue, the very high power of the spark discharge will still erode the electrode at a much faster rate than conventional ignition. Electrode placement in the insulator, fully embedded in the insulator with just the extreme end and only the face of the electrode exposed, takes advantage of a spark
15 phenomena described as electron creep. When the electrode embedded in the insulator is new, spark occurs directly between the embedded electrode and the rhenium/tungsten tip or button attached to the ground strap of the negative electrode. As the embedded electrode erodes from use under high power discharge, the electrode will begin to draw or erode away from the surface of the insulator. In this condition, electrons from the ignition pulse will emanate from the positive electrode and creep up the side of the exposed electrode cavity, jumping to the negative electrode once
20 ionization occurs and creating a spark.

 The voltage required for electrons to creep along, or ionize, the inside surface of the electrode cavity is very small. This design allows the electrode to erode beyond operational limits of the ignition system but maintain the breakdown voltage of a much smaller gap between the
25 electrodes. In this fashion, the larger gap, eroded from sustained operation under high power discharge, performs like the original gap in the sense that voltage levels are not increased beyond the output voltage of the ignition system thereby preventing misfire for the required mileage.

 The invention also provides a mechanism by which high power discharge is effected and
30 radio frequency interference, generally associated with high power discharge, is suppressed. Utilizing a capacitor that is connected in parallel across the spark gap to charge to the breakdown voltage of the spark gap and then discharge very quickly during the streamer phase of the spark, will increase the power of the ignition spark exponentially as compared to the spark power of conventional ignition. The primary reason for this is the total resistance in the secondary circuit of
35 the ignition.

 Advances have been made in the secondary circuit of the ignition by eliminating the high voltage transmission lines between the coil and the spark plug, and by utilizing one coil per cylinder allowing for greater electrical transfer efficiency. However, there still exists significant resistance in

the spark plug, which brings the transfer efficiency of the typical automotive ignition below 1%. By replacing the resistor spark plug with one of zero resistance, electrical transfer efficiency of ignition energy rises to approximately 10%. The addition of an appropriately sized capacitor further elevates the transfer efficiency to over 50%. The greater the electrical transfer efficiency, the greater the amount of ignition energy coupled to the fuel charge, the greater the combustion efficiency, which likely requires the use of a non-resistor spark plug to enable the very high transfer efficiency. The use of a non-resistor plug, however, produces radio frequency and electromagnetic interference (RFI), which is magnified by the very hard discharge of the capacitor. This is unacceptable because RFI at these levels and frequencies is incompatible with the operation of automotive computers, which is why resistor spark plugs are universally used by the original equipment manufacturers.

The present invention also provides a circuit that includes a preferably $5K\Omega$ resistor that will suppress any high frequency electrical noise while not affecting the high power discharge. Critical to the suppression of RFI is the placement of the resistor in proximity to the capacitor within the secondary circuit of the ignition system. One end of the resistor is connected directly to the capacitor with the other end connected directly to the terminal, which connects to the coil in a coil-on-plug application or to the high voltage cable from the coil. In this way the driver-load circuit has been isolated from any resistance, the driver now being the capacitor and the load being the spark gap. Once discharged, the coil pulse bypasses the capacitor and goes directly to the spark gap, as the resistance in the capacitor is greater than the resistance of the spark gap. This placement allows for the entirety of the high voltage pulse to pass through the spark gap unaffected spark duration.

The present invention also provides a connection of the negative capacitor plate to the ground circuit. Any inductance or resistance in the capacitor connections will reduce the efficacy of the discharge resulting in reduced energy being coupled to the fuel charge. During the molding process a circumferential ring of the cylindrical plate at the major diameter of the insulator is left exposed. The ring makes positive mechanical and electrical contact with the shell of the spark plug. The metal conductive shell is provided with appropriate threads to allow installation into the head of the internal combustion engine. As the head is mechanically attached to the engine block, and the engine block is connected to the negative terminal of the battery by means of a grounding strap, grounding of the negative plate of the capacitor is advantageously accomplished by the positive mechanical contact to the spark plug shell.

The present invention also provides a connection to the positive plate of the capacitor providing a resistance free path from the ignition pulse to the center, positive electrode of the spark gap. This is accomplished by utilizing the center conductor of the spark plug as the positive plate. The center conductor, preferably constructed of a tubular highly conductive material such as aluminum or copper, is inserted into the central cavity of the insulator using an interference fit and engages the extension of the positive electrode upon full insertion.

The present invention also provides a positive gas seal for the internal components of the spark plug against gasses and pressures resulting from the combustion process. The ceramic cone of the insulator exposed to the combustion chamber is provided with a center cone into which the center electrode is positioned. The electrode is provided with an extension opposite the end exposed to the combustion chamber for engagement with the center conductor and positive plate of the capacitor. At the base of this extension is a circular boss or flange fitting into the ceramic cone that allows the electrode to be sealed against combustion gasses using a ceramic epoxy, copper glass frit or other suitable high temperature sealant.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

The objects and features of the present invention will become clearer from the following description of the preferred embodiments given with reference to the attached drawings, wherein:

FIG. 1 is a cross sectional view of an embodiment of an ignition device for internal combustion spark ignited engines of the present invention;

FIG. 2A is a partially exploded cross sectional view of the individual components that are over-molded with the engineered polymer to create the insulator of the spark plug;

FIG. 2B is a top view of the capacitive element shown in FIG. 2A;

FIG. 3 is a cross sectional view of a composite insulator of the present invention;

FIG. 4 is a partially exploded cross sectional view of the individual components comprising the positive plate of the capacitor element and the central electrode assembly;

FIG. 5 is a cross sectional view of an insulator assembly of the ignition device of the present invention; and.

Fig. 6 is a circuit diagram for an ignition device in accordance with the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Referring now to the drawings, in particular FIG. 1, a spark plug or ignition device for spark ignited, internal combustion engines in accordance with the present invention is shown generally as 1. The spark plug or ignition device 1 consists of a preferably metal casing or shell 15 having a substantially cylindrical base 44, which may have external threads 18, formed thereon for engagement with the cylinder head (not shown) of the spark ignited internal combustion engine (not

shown). The cylindrical base 44 of the spark plug shell has a generally flattened surface perpendicular to the longitudinal axis of the spark plug 1 to which a ground electrode 16 is affixed, preferably by conventional welding. In an embodiment of the invention, the ground electrode 16 has a preferably rounded tip 45 of Rhenium/Tungsten sintered compound, which resists the erosion of the electrode 16
5 clue to high power discharge, as further disclosed herein.

The spark plug or ignition device 1 includes a preferably hollow, composite insulator 4 disposed concentrically within the shell 15, incorporating a combustion cone 5, preferably formed from ceramic or the like. The center or positive electrode 7 is disposed concentrically within the 10 ceramic cone 5 that is disposed in the combustion chamber when installed in the engine (not shown).

10 The center electrode 7 is preferably constructed of a thermally and electrically conductive material with very low resistivity values such as, but not limited to, a copper or copper alloy, with or 15 without an outer coating, cladding or plating preferred in a nickel alloy. The center electrode 7 preferably includes formed thereon, by weldment or by other suitable attachment, an electrode tip 17 preferably constructed of a Rhenium/Tungsten alloy (50%-75% Rhenium), which is highly resistant to
15 erosion under high power discharge, as further disclosed herein.

The spark plug 1 includes a highly conductive spring 10 that is a component of the center conductor assembly and positive plate 43 of the capacitive element. The spring 10 is connected to one end of a preferably 5Ko (or suitable resistance) resistor or inductor 11 and electrically and
20 mechanically contacts the positive plate 43 of the capacitor, which is connected to the center electrode 7 by means of an interference fit of the stud 9 of the electrode 7 into the positive plate 43. Preferably, the resistor or inductor 11 is connected to a high voltage terminal 13 for further connection to an
ignition coil (not shown) by a penetrating rod 14 of the terminal 13, as further disclosed herein.

The composite insulator 4 of the spark plug is inserted into the shell 15 and preferably crimped for positive alignment and seal against combustion gasses, as is customary practice in the
25 industry. Preferably, during an over molding process of creating the insulator 4, a flange 3 of a negative plate 2 is left exposed. The exposed flange 3 of the negative plate of the capacitor 2 makes physical and electrical contact with the conductive shell 15 of the spark plug when the shell 15 is crimped with sideward and downward pressure onto the insulator 4 using conventional industry 35 practice. The mechanical contact between the shell 15, which is electrically connected to the ground circuit of the engine ignition circuit and the negative plate 2 of the capacitor advantageously ensures
30 that the negative plate 2 is electrically connected to the ground circuit of the ignition system.

Referring now to FIG. 2, the negative plate is shown generally at **2** and includes at least one flange **20** extending therefrom. During the molding process, the negative plate **2** is encased in the engineered polymer of the insulator **4** and the tips of flange **20** are left exposed in order that they make mechanical and electrical contact with the shell of the spark plug (not shown) thereby ensuring the plate **2** is electrically connected to the ground of the ignition system. A scallop **21** of the flange **20**, ensures a complete flow of the engineered polymer of the insulator **4** around the plate **19** during the molding process to encase and locate the plate **2** concentric to the ceramic cone **5**.

The preferably ceramic cone **5** has an integral and concentric locking detent **27** wherein during the molding process, the engineered polymer of the insulator **4** flows into, which locks and locates the cone **5** in relation to and separated from the negative plate **2**. A concentric cavity **26** in the ceramic cone **5** is formed to nestle the center or positive electrode **7**.

The center electrode **7** is provided with a boss **23**, stud **9** and an electrode tip **17** that is resistant to high power discharge. The boss **23** of the center electrode **7** nestles in the cavity **26** provided in the ceramic cone **5**. During the manufacturing process, the cavity **26** is preferably filled with copper glass, ceramic epoxy or other suitable permanently sealing material on top of the installed center electrode **7** and boss **23** thereof, which provides a gas seal to protect the interior of the spark plug **1** from combustion pressures. The stud **9** of the electrode **7** is provided to engage the assembled positive plate of the capacitor (shown as **43** in Fig. 4) with an interference fit ensuring completion of the positive side of the ignition circuit.

Referring now to Fig. 3, the center electrode **7** is provided with an erosion resistant electrode tip **17** that is preferably formed from a Rhenium/Tungsten alloy of between about 50%-75% Rhenium. An end of the highly erosion resistive electrode tip **17** is preferably flush with the end **30** of the ceramic cone **5**.

Within the ignition or spark gap pulsed-power industry, it is well-known that increasing the power (Watts) of the spark increases the erosion rate of the electrodes, with the spark-emanating electrode eroding faster than the receiving electrode. Industry standard has been to utilize precious or noble metals such as gold, silver, platinum and lately iridium as the electrode metal of choice to abate the electrode erosion of common ignition power. These metals, however, will not suffice to reduce the elevated electrode erosion rate of the high power discharge of the current invention. The electrode tip **17** of a sintered compound of rhenium by about 50% to 75% by mass sintered with tungsten in a preferably cylindrical configuration of .025"- .060" in diameter and .100" in length is preferably affixed to the center electrode **7** by means of plasma, friction or electron welding or other suitable method by which permanency is achieved while delivering a low resistance juncture.

The use of pure tungsten as an electrode in a spark gap application is well documented within the pulsed-power industry as a preferred erosion resistant material. However, as used in an internal combustion engine where combustion temperatures reach beyond the oxidation temperature of tungsten, the electrode disadvantageously erodes at a faster rate than noble metals.

5 Tungsten may be utilized as an electrode material in an automotive application by the isolation of the tungsten to the oxygen present in the combustion chamber. This is partially accomplished by the sintering of tungsten with rhenium and an appropriate binding agent such as, but not limited to, a non-oxidizing metal that melts at a temperature below that of rhenium and tungsten. The sintering process blends the two preferably powdered base metals with the binding agent and during the

10 refractory process melts the binder and sinters the base materials into a form held together by the binder. The form, preferably rectangular in shape, is then extruded into wire of .025" to .060" in diameter to form the electrode tips **17** and **45**. The bonding agent provides protection against the oxidation of the tungsten component by covering that portion of the tungsten not in contact with the rhenium.

15 While this offers some protection for the tungsten against oxidation, the bonding metal erodes during the high-power discharge process, exposing the raw tungsten of the electrode tips **17** and **45** to ambient oxygen in the combustion chamber and thereby accelerating tungsten erosion. However, the erosion rate due to oxygen exposure is significantly reduced by the use of the bonding

20 agent. Additionally, as the tungsten erodes, the rhenium is now closer to the opposing or negative electrode, and as proximity and field effect dictate where the spark emanates from, the rhenium, also highly resistant to high-power erosion, becomes the source of the spark streamer.

Additionally, tungsten may be utilized as an electrode material in an automotive application

25 by the placement of the electrode tip **17** with respect to the ceramic cone **5**. In this placement, only the extreme end of the electrode tip **17** is exposed to the elements in the combustion chamber. The remainder of the cylindrical electrode tip **17** has been bonded to the ceramic cone **5**, sealing off the electrode tip **17** against any combustion gasses including oxygen. In this fashion, only the extreme end of the electrode tip **17** will erode, as it will under the high power discharge of the current

30 invention.

As the electrode tip **17** gradually wears away, electrons from the ignition pulse will emanate from the recessed electrode tip **17** and ionize the ceramic cone wall **31** and creep to the edge **30** of the ceramic cone **5** before ionizing the spark gap (not shown) and creating a spark (not shown) to

35 the ground electrode **16**. The voltage required to ionize the ceramic cone wall **31** just above the eroding electrode tip **17** is very small resulting in the total voltage required to breakdown the spark gap and create a spark being minimally more than the voltage required to break down the original, un-eroded spark gap.

In this fashion, the electrode tip **17** can erode to the point where the distance from the ground electrode **16** to the center or positive electrode tip **17** has doubled, while the voltage required to break down the doubled gap is slightly more than the breakdown voltage of the original spark gap and well under the available voltage from the original equipment manufacturer ignition system. This advantageously assures proper operation of the engine for a minimum of 10^9 cycles of the spark plug or 100,000 equivalent miles.

Referring again to FIG.3, there is shown a molded composite insulator assembly indicated generally at **19**, center electrode **7** with erosion resistant tip **17**, ceramic cone **5** and binding and insulating engineered polymer **4**, forming the assembly **19**. Referring now to the composite insulator **19** and center electrode **7** of FIG. 3, and the center conductor **43** of FIG.4, when the hollow center conductor **43** is inserted into the cavity **32** of the composite insulator **19**, the stud **9** of the center electrode **7** engages the undersize hole **46** of the center conductor providing a highly conductive path from the ignition coil output (not shown) to the spark plug gap (not shown). Once connected to the center electrode **7**, the center conductor **43** becomes the positive plate of the capacitive element and a capacitor or capacitive element, indicated generally at **28** in Fig. 5, is formed by definition, i.e.: a capacitor being two conductive plates (plates **43** and **2**) of opposite electrical charge separated by a dielectric, the dielectric being the engineered polymer **4**.

Capacitance can be mathematically arrived at by formula;

$$C = \frac{1.4122 \times D_c}{L_n (D_i/D_o)}$$

Where C is the capacitance per inch of cylindrical plates, D_c is the dielectric constant of the polymer **4**, L_n is the natural log, D_i is the inside diameter of the negative plate **2**, and D_o is the outside diameter of the positive plate **43** in FIG.4. Capacitance can be increased by decreasing the separation of the oppositely charged plates **43** and **2** or by increasing the surface areas of the plates **43** and **2**. Capacitance can also be affected by the dielectric constant of the engineered polymer. Dielectric constants can vary from four to over twelve depending on the material selected.

Attention is now directed in FIG. 3 to the center or positive electrode **7** and the cavity **26** of ceramic cone **5** into which the electrode **7** is embedded concentrically. Once the electrode **7** has been inserted into the ceramic cone **5**, a pressure or gas seal is accomplished by completely filling the cavity **26** with ceramic epoxy, copper glass or other suitable high temperature sealant.

Referring now to FIG. 4, a center conductor assembly is indicated generally at **33** consisting of the tubular positive plate or conductor **43**, resistor **11**, conductive spring connector **10**, terminal insert **12**, and high tension cable or coil terminal **13**. The resistor **11** is inserted into the cavity **41** of the terminal insert **12** and preferably retained by means of a high temperature ceramic epoxy or other high temperature adhesive suitable to retain the resistor **11** in place under operation of the engine. The high tension cable or coil terminal **13** is attached to the terminal insert **12** by means of a threaded portion **48** of the terminal **13** into the threaded cavity **40** of the terminal insert **12**. The pointed shaft **47** of the terminal **13** makes physical and electrical contact with the resistor **11** once the terminal **13** is installed by screwing into the terminal insert **12**. The end of the resistor **11** opposite the terminal **13** makes physical and electrical contact with the conductive spring **10**, which is under compression when the center conductor assembly is inserted into the composite insulator **19** of FIG. 3.

The spring **10** end opposite the resistor **11** makes mechanical and electrical contact with the tubular positive plate or conductor **43** completing the positive circuit for the ignition pulse. The placement of the resistor **11** in the positive circuit before the positive plate **43** of the capacitive element of the spark plug **1** allows the capacitor **28** to discharge at a very high transfer efficiency rate and deposit a very high percentage, greater than 95%, of the stored energy into the fuel charge. Normally this hard deposition of energy would create an abnormal amount of radio frequency or electromagnetic interference, which is incompatible with the operation of automobile engine management computers. Placement of the resistor **11** before the capacitor **28** in the circuit allows for the deposition while elimination the interference.

FIG. 6 illustrates an exemplary circuit **30** for the ignition device **1** of the present invention and shows a coil **35**, such as an ignition coil or the like, connected to the resistor **11** through a secondary circuit **37**. The capacitor **28** is connected to the resistor **11** and connected in parallel with the secondary circuit **37** and ground **34**. The resistor **11** advantageously suppresses high frequency electrical noise generated by the circuit **30** while not affecting the high power discharge of the capacitor **28**.

There is abundant prior experimentation with related results, see Society of Automotive Engineers Paper 02FFFL-204 titled "Automotive Ignition Transfer Efficiency", concerning the utilization of a current peaking capacitor, such as the capacitor **28** wired in parallel to the high voltage circuit such as the circuits **30** and **37** of the ignition system to increase the electrical transfer efficiency of the ignition and thereby couple more electrical energy to the fuel charge. By coupling more electrical energy to the fuel charge, consistent ignition relative to crank angle is accomplished reducing cycle-to-cycle variations in peak combustion pressure, which increases engine efficiency. An additional benefit of coupling the current peaking capacitor **28** in parallel is the resultant large robust flame kernel created at the discharge of the capacitor **28**. The robust kernel causes more

consistent ignition and more complete combustion, again resulting in greater engine performance. One of the benefits of utilizing a peaking capacitor 28 to improve engine performance is the ability to ignite fuel in extreme lean conditions. Today, modern engines are introducing more and more exhaust gas into the intake of the engine to reduce emissions and improve fuel economy. The use of the peaking capacitor 28 will allow automobile manufacturers to lean air:fuel ratios with additional levels of exhaust gas beyond levels of current automotive ignition capability.

Referring now to FIG. 5, there is shown the completely assembled composite insulator assembly indicated generally as 6, consisting of the over-molded insulator 19 with ceramic cone 5 and center electrode 7 with erosion resistant electrode tip 17, negative plate 2 of the capacitive element 28, and insulating engineered polymer 4. Also shown is a cross sectional view of the completely assembled component string of the center conductor assembly 33 shown in Fig. 4 consisting of the tubular positive plate or conductor 43 of the capacitor or capacitive element 28, resistor 11, conductive spring connector 10, terminal insert 12, and high tension cable or coil terminal 13. This view illustrates the completed assembly of the composite insulator assembly 6 prior to insertion and crimping into the spark plug shell 44 of FIG. 1.

Gas seal and ground contact washer 22 of FIG. 5 is placed into the shell 15 of FIG. 1, resting in the transition of diameters, ensuring the negative plate 43 makes contact with the shell 15 and completing the ground circuit of the capacitive element of the current invention.

An embodiment of the spark plug or ignition device 1 of the present invention provides a spark plug that has an insulator 4 and 5 that is a composite of dissimilar materials. An embodiment of the spark plug or ignition device 1 includes a very fine cross sectional electrode tips 17 and 45 of a material and design to effectively reduce the erosion of the electrode tips 17 and 45 prevalent in high power discharge, spark-gap devices. An embodiment of the spark plug or ignition device 1 comprises an insulator 4 constructed in such a manner as to create a capacitor 28 in parallel with the high voltage circuit 30 of the ignition system, and placement of an inductor or resistor 11 in the electrical circuit 30 of the spark plug whereby the resistor or inductor 11 suitably shields any electromagnetic or radio frequency emissions from the spark plug 1 without compromising the high power discharge of the spark. An embodiment of the spark plug or ignition device 1 also completes the capacitor 28 and high voltage circuit 30 of the ignition system to provide a path for the high power discharge to the electrode 17 of the spark plug 1.

Although the invention has been described in detail with particular reference to these preferred embodiments, other embodiments can achieve the same results. Variations and modifications of the present invention will be obvious to those skilled in the art and it is intended to cover all such modifications and equivalents. The entire disclosures of all references, applications,

patents, and publications cited above and/or in the attachments, and of the corresponding application(s), are hereby incorporated by reference.

The claims defining the invention are as follows:

1. A composite ignition device for an internal combustion engine, including: a positive electrode bonded to a first insulator said positive electrode having a tip formed on an end thereof, said positive electrode further including a coating of
5 conductive ink on an exterior surface thereof;
a second insulator;
a negative capacitive element;
a positive capacitive element separated from said negative capacitive element by said second insulator, said positive capacitive element coupled to said positive
10 electrode, said positive capacitance element and said negative capacitive element forming a capacitor;
a resistor disposed in a resistor insulator and coupled to said positive capacitive element by a resistor connector without said resistor reducing current from said capacitor to a spark gap of said ignition device, said resistor disposed in a position to
15 reduce charging current of said capacitor; and
a shell, said shell including a negative electrode having a tip formed thereon and spaced apart from said positive electrode tip.
2. The device of claim 1, wherein said second insulator is attached to a firing cone assembly and said negative capacitive element is embedded in said second
20 insulator.
3. The device of claim 1, wherein said second insulator is attached to a firing cone assembly and said negative capacitive element is embedded in said second insulator by a manner selected from the group consisting of injection molding and insert molding
- 25 4. The device of any one of claims 1 to 3, wherein said second insulator includes an engineered polymer.
5. The device of claim 4, wherein said engineered polymer includes liquid crystal polymer.
6. The device of claim 4, wherein said engineered polymer includes
30 polyetheretherketone.
7. The device of claim 4, wherein said engineered polymer has a dielectric constant from between 5 to 10.

8. The device of any one of claims 1 to 7, wherein said first insulator includes an alumina material.
9. The device of claim 7, wherein said alumina material includes from 88 percent to 99 percent pure alumina.
- 5 10. The device of any one of the preceding claims, wherein said resistor connector includes a spring member.
11. The device of any one of the preceding claims, wherein said positive and negative electrode tips include a sintered rhenium and tungsten material.
12. The device of claim 11, wherein said material is formed from about 50
10 percent rhenium and about 50 percent tungsten.
13. The device of claim 11, wherein said material is formed from about 75 percent rhenium and about 25 percent tungsten.
14. The device of any one of the preceding claims, wherein said conductive ink includes a precious metal or precious metal alloy.
- 15 15. The device of any one of the preceding claims, wherein said capacitor has a predetermined capacitance in the range from 30 to 100 pf.
16. The device of any one of the preceding claims, wherein said positive capacitive element is coupled to said positive electrode by an interference fit.
17. A circuit for an ignition device for an internal combustion engine, including:
20 a power source operable to intermittently activate said circuit;
a positive electrode having a tip on an end thereof;
a ground electrode connected to ground and having a tip on an end thereof,
said ground electrode tip spaced apart from said positive electrode tip by a
predetermined spark gap;
25 at least one resistor connected in series with said power source and said positive electrode; and
at least one capacitor directly connected to said resistor and connected in parallel with said positive electrode and ground, said resistor not in parallel with said capacitor, at least one plate said capacitor including a conductive ink.
- 30 18. The circuit of claim 17, wherein said at least one resistor reduces radio frequency interference (RFI) when said circuit is active.

19. The circuit of claim 17, wherein said at least one capacitor increases peak current to said spark gap when said circuit is active.
20. The circuit of any one of claims 17 to 19, wherein said positive and negative electrode tips include a sintered rhenium and tungsten material.
- 5 21. The circuit of claim 20, wherein said material is formed from about 50 percent rhenium and about 50 percent tungsten.
22. The circuit of claim 20, wherein said material is formed from about 75 percent rhenium and about 25 percent tungsten.
23. The circuit of any one of claims 17 to 22, wherein said resistor has a
10 predetermined resistance in the range from 2 kohms to 20 kohms.
24. The circuit of any one of claims 17 to 23, wherein said capacitor has a predetermined capacitance in the range from 30 to 100 pf.

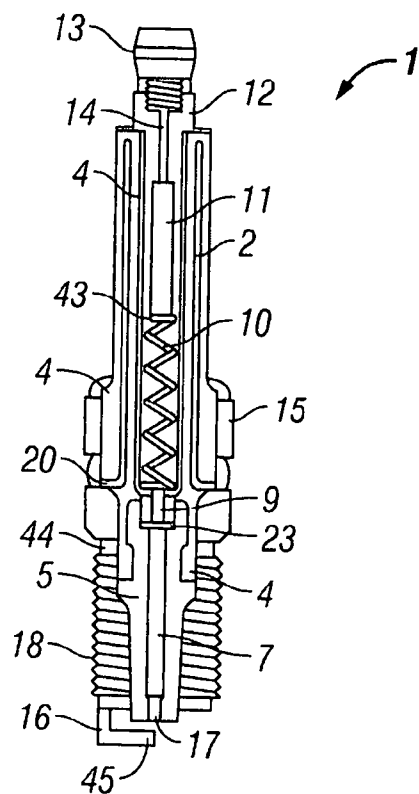


FIG. 1

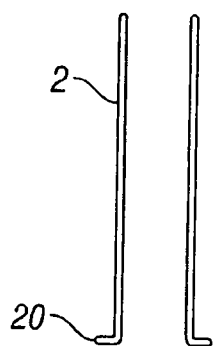


FIG. 2A

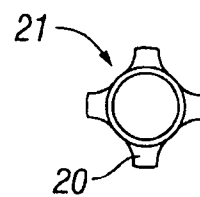
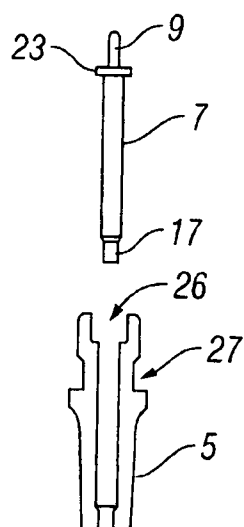


FIG. 2B

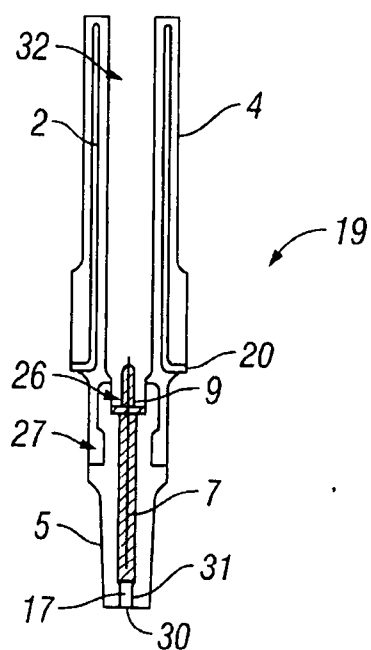


FIG. 3

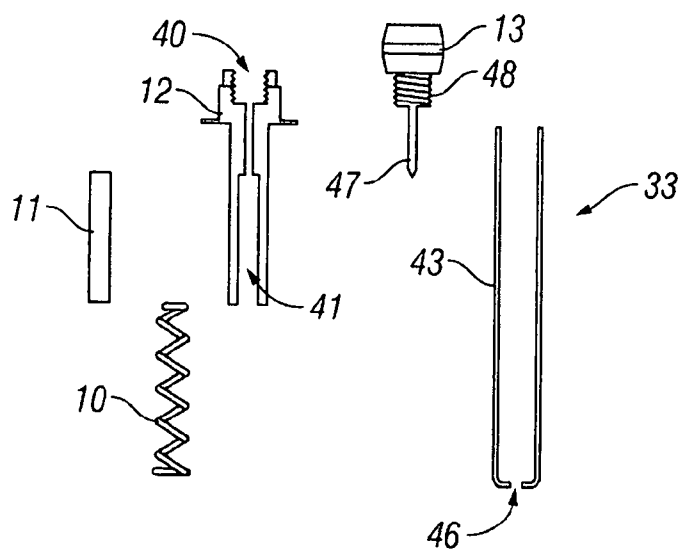
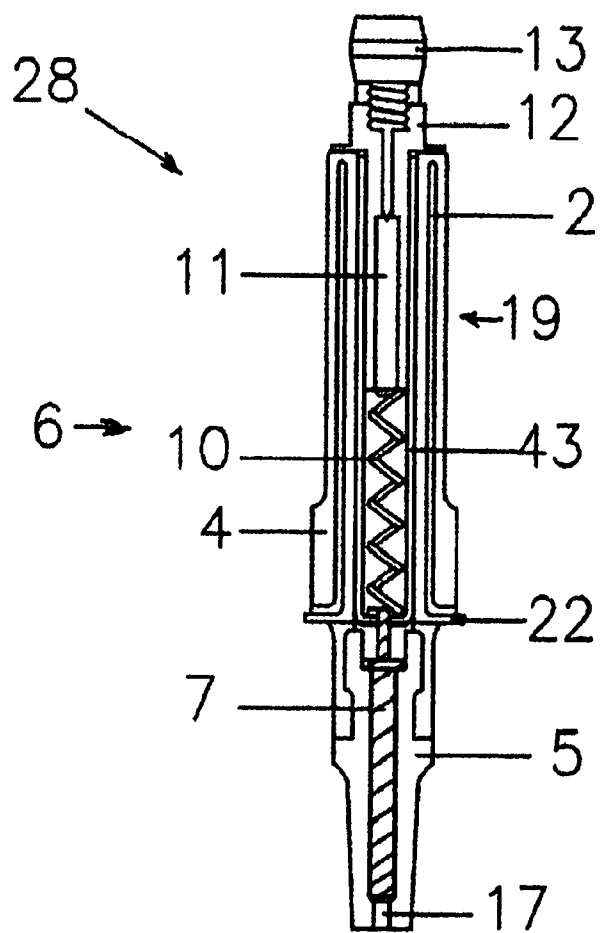


FIG. 4

FIG. 5



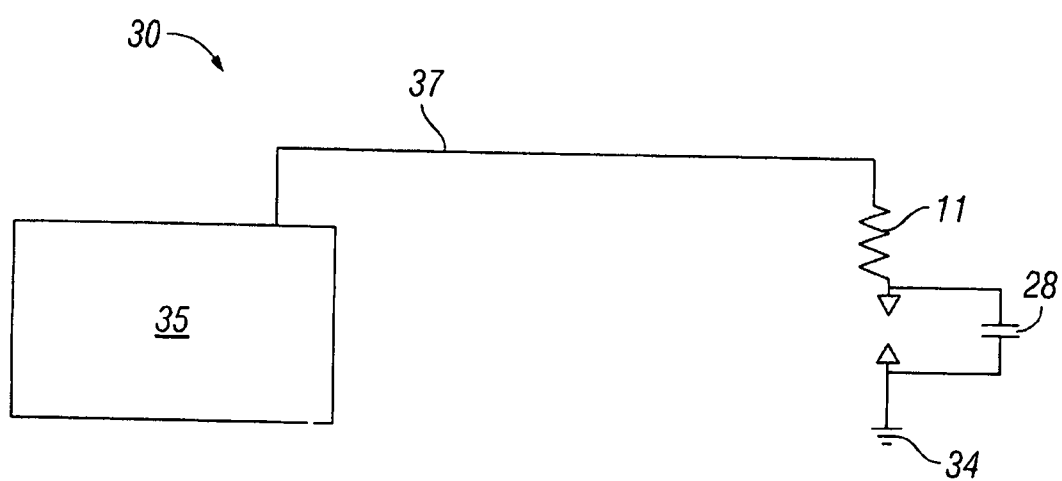


FIG. 6