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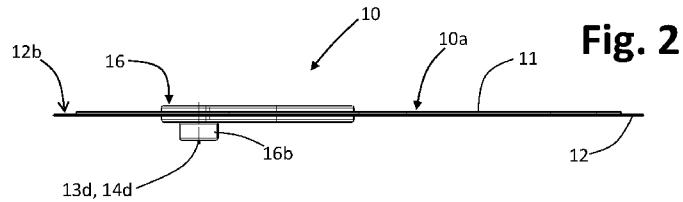


Fig. 2

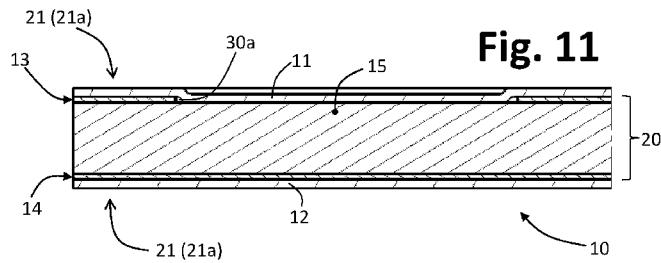


Fig. 11

(57) Abstract: An electrical heating device (10) comprises: a first electrode layer (13), made of electrically conductive material, a second electrode layer (14), made of electrically conductive material, a heating layer (15) made of at least one polymer-based material, the heating layer (15) having two opposite major sides, a casing (10a) made at least in part of polymer-based electrically insulating material. The first electrode layer (13) and the second electrode layer (14) are each associated at a respective major side of the heating layer (15), with at least one part (15') of the heating layer (15) that is set between the first electrode layer (13) and the second electrode layer (14), in contact with them. The casing (10a) comprises at least one first casing layer (11) and one second casing layer (12), each facing a respective major side of the heating layer (15) and being made at least in part of a polymer-based material. At least one from among the first electrode layer (13), the second electrode layer (14) and the heating layer (15) is prearranged in such a way that at



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least one part of the polymer-based material of at least one of the first casing layer (11) and the second casing layer (12) adheres to a corresponding part of the polymer-based material of the heating layer (15) at at least one of the opposite major sides of the heating layer (15).

Electrical heating device, in particular with PTC effect

DESCRIPTION

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Field of the invention

The present invention relates to electrical heating devices, in particular devices based upon the use of materials distinguished by an electrical resistance with positive temperature coefficient (PTC), namely, ones having a PTC effect, 10 preferably materials comprising at least one polymer.

The invention has been developed with particular reference to electrical heating devices designed to be associated to, or integrated in, vehicle components, such as heaters for tanks, heaters for filters, heaters for batteries or electrical accumulators, heaters for substances subject to freezing, heaters for devices or 15 substances that change their properties or characteristics as the temperature varies, or again heaters used for heating aeriform fluids, such as air for environments or air subject to forced circulation on the surface of such heaters.

The invention finds a preferred application in the sector of components or tanks designed to be in contact with, or contain, a fuel, or water, or a liquid that 20 contains water, or a liquid additive, or a reducing agent, in particular a liquid necessary for operation of an internal-combustion engine and/or for operation of a system for treatment of exhaust gases of an internal-combustion engine, including ADI (Anti-Detonant Injection) systems. The heating devices according to the invention can in any case be applied also in sectors other than the preferential 25 ones referred to above.

Prior art

Exhaust-gas-emission systems of some types of vehicles must be devised with a view to reducing the release of nitrogen oxides (NO_x) into the atmosphere. A system particularly widespread for this purpose is based upon the process 30 known as SCR (Selective Catalytic Reduction), which enables reduction of nitrogen oxides of the gases by means of injection of a reducing agent into the exhaust line. These treatment systems presuppose that the reducing agent is dosed and injected into the flow of the exhaust gases in order to convert nitrogen oxide (NO_x) into nitrogen (N_2) and water (H_2O). For this purpose, the vehicle is 35 equipped with a tank containing the reducing agent, associated to which are

suitable means for carrying out dosed injection of the agent itself into the SCR system.

The reducing agent is typically constituted by urea in aqueous solution, which is liable to freeze when the tank is exposed to low temperatures 5 (indicatively temperatures lower than -11°C). For this reason, the tank must be equipped with a heating device so that, in the case of freezing, the liquid agent can be liquefied and then injected into the exhaust line. The heating device is in general mounted inside the tank, or else integrated in, or associated to, a component of the tank that is sealingly mounted in an opening of the tank itself. 10 The heating device is in general of the type that bases its own operation on the use of a material having a PTC effect, this material possibly being a ceramic-based or else a polymer-based material.

In general, known heating devices comprise a plurality of heating elements, each having an electrical resistor formed by a solid mass of the material 15 with PTC effect, typically a mass of ceramic material shaped like a small disk. In some solutions, each heating element comprises a PTC resistor set between two respective metal electrodes, and the electrodes of the various heating elements are connected together, for example in parallel and/or in series with one another, for the purposes of electrical supply. In other solutions, a plurality of PTC resistors 20 are arranged between two electrodes in common, typically in the form of metal plates or disks. In applications of this type, the heating device is generally without a casing of its own, and the body that houses it – for example, the body of a component of the tank or of a functional module associated to the tank – must be shaped for defining seats or housings for the various parts of the heating device 25 (see, for example, EP 2 650 497 A1).

Provision of heating devices equipped with a casing of their own in general entails problems linked to deformations (for example, expansion and contraction) of the PTC-effect material and/or of the corresponding metal electrodes due to the heating and cooling cycles. Such deformations lead to 30 relative movements between the parts made of different materials, including the material or materials of the casing, with possible risks of failure. This problem is particularly felt in the case of laminar electrodes that cover the opposite surfaces of the mass of PTC-effect material practically entirely.

For this reason, it is advisable to provide a casing that covers the heating 35 element (the PTC-effect material with the corresponding electrodes), but that is

distinct from or independent of the latter (see, by way of simple, CN202455551U), at times with suitable empty spaces that will enable also relative movements to counter the aforementioned deformations. In the case of heaters with a sealed casing, however, the presence of air in these empty spaces
5 reduces propagation of the heat generated given that the air operates as thermal insulator and is itself subject to variations in volume that depend upon the temperature, and this may cause anomalies in operation of the device.

Heating devices of the type previously indicated, in particular those having PTC heating elements of a ceramic type, in general have a small extension in a
10 radial direction, since they have to be inserted into an opening of the bottom wall of the tank, at or in the proximity of an opening or a duct for outlet or delivery of the reducing agent.

This positioning is basically dictated by the need to render rapidly available a certain amount of the reducing agent, even in the case of freezing of
15 the latter. Proper operation of the system for treatment of exhaust gases presupposes in fact dosing and injection of the reducing agent into the exhaust gases substantially immediately after engine ignition.

For this reason, the emission of heat allowed by the heating device occurs in a relatively concentrated area, i.e., in the vicinity of the outlet of the tank, with
20 a consequent reduced contribution to melting of the frozen part of the reducing agent that, inside the tank, is located relatively far from the outlet of the tank itself. Certainly, the size of the heating device could be increased in a radial direction in order to heat an area substantially corresponding to the entire bottom wall of the tank. However, in addition to complicating further construction and
25 mounting of the heating device, and of the component on which the device is mounted, such an approach would lead to a considerable increase in electric power consumption, such an increase being typically proportional to the area of the heater and/or to the heated area. Similar problems may also be encountered in heating devices used in other sectors.

30 Aim and summary of the invention

The object of the present invention is basically to eliminate one or more of the drawbacks referred to above. In this context, an object of the invention is to provide an electrical heating device having a corresponding casing body that is simple and inexpensive to produce and reliable. An auxiliary aim of the invention
35 is to provide an electrical heating device that is able to heat relatively extensive

areas, but at the same time enabling a limited electric-power consumption.

One or more of the above aims, and other aims still, which will emerge clearly hereinafter, are achieved, according to the present invention, by an electrical heating device, a motor-vehicle component, and a method for obtaining 5 an electrical heating device that present the characteristics specified in the annexed claims. The claims form an integral part of the technical teaching provided herein in relation to the invention.

Brief description of the drawings

The characteristics, advantages, and further aims of the present invention 10 will emerge clearly from the ensuing detailed description, with reference to the annexed drawings, which are provided purely by way of non-limiting example and in which:

- Figure 1 is a schematic cross-sectional view of a generic container of a substance, equipped with an electrical heating device according to possible 15 embodiments of the invention, represented in side elevation;

- Figures 2 and 3 are schematic views, namely, a side elevation and a top plan view, respectively, of an electrical heating device according to possible embodiments of the invention;

- Figures 4 and 5 are partially exploded schematic views of an electrical 20 heating device according to possible embodiments of the invention;

- Figures 6 and 7 are schematic perspective views from different angles of an electrical heating device according to possible embodiments of the invention;

- Figure 8 is a schematic perspective view of electrical-connection elements that can be used in an electrical heating device according to possible 25 embodiments of the invention;

- Figure 9 is a schematic perspective view of an electrode of an electrical heating device according to possible embodiments of the invention, with associated thereto the electrical-connection elements of Figure 8;

- Figure 10 is a schematic perspective view of an electrode of an electrical 30 heating device according to possible embodiments of the invention;

- Figure 11 is a partial and schematic cross-sectional view of an electrical heating device according to possible embodiments of the invention;

- Figure 12 is a partial and schematic cross-sectional view aimed at representing the pattern of electrical and heat-emission paths and in the portion of 35 the heating device of Figure 11;

- Figure 13 is a partial and schematic cross-sectional view of an electrical heating device according to possible embodiments of the invention;
- Figure 14 is a partial and schematic cross-sectional view aimed at representing the pattern of electrical and heat-emission paths in the portion of the heating device of Figure 13;
- Figures 15, 16, 17, 18, 19, 20, and 21 are schematic perspective views of electrodes of electrical heating devices according to possible embodiments of the invention;
- Figure 22 is a detail at a larger scale of Figure 21;
- Figure 23 is a partial and schematic sectioned view of an electrical heating device according to possible embodiments of the invention;
- Figure 24 is a detail at a larger scale of Figure 23;
- Figures 25, 26, and 27 are partial and schematic cross-sectional views of electrical heating devices according to possible embodiments of the invention;
- Figures 28, 29, and 30 are partial and schematic cross-sectional views, with corresponding details at a larger scale, of electrical heating devices according to possible embodiments of the invention;
- Figure 31 is a schematic top plan view of an electrical heating device according to possible embodiments of the invention;
- Figure 32 is a schematic perspective view of the heating device of Figure 30, with a part of casing removed;
- Figure 33 is a schematic cross-sectional view according to the line XXXIII-XXXIII of Figure 31;
- Figure 34 illustrates at a larger scale the detail XXXIV of Figure 33;
- Figure 35 is a partial and schematic cross-sectional view aimed at representing the pattern of electrical and heat-emission paths in the portion of the heating device of Figure 34;
- Figure 36 is a partial and schematic cross-sectional view of an electrical heating device according to possible embodiments of the invention;
- Figure 37 is a schematic cross-sectional view according to the line XXXVII-XXXVII of Figure 31;
- Figure 38 illustrates at a larger scale the detail XXXVIII of Figure 37;
- Figure 39 is a partial and schematic cross-sectional view of a step of assembly of an electrical heating device according to possible embodiments of the invention;

- Figure 40 is a partial and schematic cross-sectional view of the heating device following upon the step of assembly of Figure 39;
- Figures 41 and 42 are partial and schematic cross-sectional views of respective steps of assembly of an electrical heating device according to possible embodiments of the invention;
- Figure 43 is a partial and schematic cross-sectional view of the heating device following upon the step of assembly of Figure 42;
- Figure 44 is a partial and schematic representation aimed at highlighting possible problems of assembly and/or operation of an electrical heating device;
- 10 - Figures 45, 46, 47, 48, and 49 are schematic perspective views of pairs of electrodes of electrical heating devices according to possible embodiments of the invention;
- Figures 50 and 51 are schematic perspective views of an electrical heating device according to possible embodiments of the invention, combined 15 with a different functional device;
- Figure 52 is a schematic cross-sectional view of a generic container of a substance, equipped with the combined devices of Figures 50-51, represented in side elevation;
- Figure 53 is a schematic perspective view of a heating layer of a device 20 according to possible embodiments of the invention;
- Figure 54 is a partial and schematic cross-sectional view of a heating element that includes the heating layer of Figure 53;
- Figure 55 is a partially exploded schematic view of an electrical heating device according to possible embodiments of the invention, which uses a layer of 25 the type illustrated in Figure 53;
- Figure 56 is an exploded schematic view of a heating layer of a device according to possible embodiments of the invention;
- Figure 57 is a partial and schematic cross-sectional view of a heating element that includes a heating layer of the type illustrated in Figure 56;
- 30 - Figures 58 and 59 are partial and schematic cross-sectional views of heating elements that include a heating layer according to possible variant embodiments of the invention;
- Figure 60 is a schematic perspective view of an electrical heating device according to possible embodiments of the invention;
- 35 - Figures 61 and 62 are schematic perspective views of the heating device

of Figure 60 combined with a different functional device;

- Figure 63 is a schematic top plan view of an electrical heating device according to possible embodiments of the invention;

5 - Figure 64 is a schematic cross-sectional view according to the line LXIV-LXIV of Figure 63;

- Figure 65 illustrates the detail LXV of Figure 63 at a larger scale;

- Figures 66 and 67 are schematic representations of equipment that can be used for moulding a casing of the electrical heating device of Figure 63; and

10 - Figures 68, 69, and 70 are partial and schematic cross-sectional views of heating devices according to possible variant embodiments of the invention.

Description of preferred embodiments of the invention

Reference to “an embodiment” or “one embodiment” in the framework of the present description is intended to indicate that a particular configuration, structure, or characteristic described in relation to the embodiment is comprised in 15 at least one embodiment. Hence, phrases such as “in an embodiment” or “in one embodiment” and the like that may be present in various points of this description do not necessarily refer to one and the same embodiment. Moreover, particular conformations, structures, or characteristics defined in this description may be combined in any adequate way in one or more embodiments, which may even be 20 different from the ones represented. The reference numbers and spatial references (such as “upper”, “lower”, “top”, “bottom”, “up”, “down”, etc.) provided herein are used only for convenience and hence do not define the sphere of protection or 25 the scope of the embodiments. In the present description and in the attached claims, the generic term “material” must be understood as comprising also mixtures, compositions, or combinations (for example, multilayer films) of a number of different materials.

With initial reference to Figure 1, designated as a whole by 1 is a generic container, for example a tank of a vehicle: as already mentioned, on the other hand, the component 1 may also be a duct or a container of some other type, for 30 example the container of a filter or the casing of an electrical accumulator.

In what follows, it is assumed that the above container is a tank that is designed to contain a liquid, such as an additive or a reducing agent, and forms part of a system on board a vehicle, for example a system for reducing emissions of an internal-combustion engine or for treatment of the exhaust gases of an 35 internal-combustion engine, represented as a whole by the block 2. In various

embodiments, the system 2 is a treatment system of the SCR type, with injection of a reducing agent into the exhaust-gas line as explained in the introductory part of the present description, which is used for abatement of emissions of nitrogen oxides and particulate matter, in particular in motor vehicles with diesel engines.

5 The aforesaid reducing agent may hence be urea in solution of distilled water, as for example the is commercially known by the name AdBlue™. In other embodiments, the treatment system 2 may be of the type that envisages injection of water directly into an internal-combustion engine, for reducing emissions and/or for preventing phenomena of spontaneous detonation, such as an ADI 10 system. The container 1 (hereinafter referred to for simplicity also just as "tank") could in any case be used for other purposes and/or in sectors other than the automotive one, and could be designed to contain a different liquid that requires heating, such as a fuel or a washing agent, or some other liquid or substance.

15 The body of the tank 1 has a bottom wall 1a, where an outlet or opening 1b for the liquid is defined. In various embodiments, the opening 1a may be sized for insertion and/or mounting of at least one further functional device, such as a device comprising sensor means, for example a module of the type known as UDM (Urea-Delivery Module).

20 In various embodiments, set on the bottom wall 1a of the tank 1 is an electrical heating device according to the invention, designated as a whole by 10. In the example, the heating device is controlled, i.e., electrically supplied, by means of the system 2.

25 An electrical heating device 10 according to possible embodiments of the invention, for example suitable for the use described with reference to Figure 1, is represented schematically in different views in Figures 2-3 and, in exploded view, in Figure 4.

30 As will be appreciated for example in Figure 4, in preferred embodiments, the heating device 10 comprises a plurality of functionally different layers, which are relatively thin and are set on top of one another so as to form a substantially planar or laminar structure, as emerges clearly from Figure 2. In various embodiments, the peripheral profile of the device 10 is shaped to follow at least in part the profile of the tank. Preferentially, the aforesaid planar structure is at least in part flexible, thanks to the small thickness and an albeit minimal elasticity or intrinsic compliance (yielding) of the layers that make it up, at the same time 35 presenting a corresponding structural stiffness that enables the device 10 to

maintain the shape assigned thereto, as will emerge hereinafter.

This type of layered structure makes it possible to provide in a simple way a device 10 even having a relatively extensive surface, at the same time with an as a whole very reduced encumbrance in height. In this way, the device 10 can be 5 easily set up against a supporting surface, for example on the bottom wall 1a of the tank 1 of Figure 1. In the case of Figure 1, the device 10 has overall perimetral dimensions and extension such as to cover substantially the entire bottom wall 1a of the tank 1, or a prevalent part thereof: for this purpose, for example, in possible 10 embodiments the heating device is previously fixed within a part of the tank 1 prior to complete formation or closing of the latter (for example, via welding of two parts of the tank).

It should be noted that, in the present description and in the attached 15 claims, the term “layer” used to identify certain components of the heating device 10 according to its preferred embodiments, is not to be understood in a limiting sense. In this perspective, in various embodiments, the components 11-15 described and identified hereinafter as “layers” may have a structure and/or shape and/or thickness other than what has been exemplified, albeit respecting the 20 functions envisaged according to the invention (for example, the components 11 and 12 could be replaced by overmoulded walls, or by deposited layers of electrically insulating material or material having a high value of electrical resistance; the components 13 and 14 could be replaced by thick plates of electrically conductive material; the component 15 could be replaced by a solid mass of any shape of a material that is at least in part resistive or semiconductor or 25 of the PTC-effect type, or in any case such as to provide a thermistor).

25 In various embodiments, the device 10 comprises a coating or casing 10a made of electrically insulating material. With reference also to Figure 4, such a casing comprises two opposite walls 11 and 12, a first electrode layer 13 made of electrically conductive material, a second electrode layer 14 made of electrically conductive material, and a heating layer 15, made of a polymeric material, 30 preferably a material having a PTC effect. The casing 10a may be omitted, for example when the device 10 does not require a specific protection in regard to the medium that is to be heated (for example, when the device is used for heating air or other fluid that is not aggressive from the chemical standpoint).

35 The two electrode layers 13 and 14 are arranged facing, preferably substantially parallel to one another and with respect to the heating layer 15, with

5 at least one part of the heating layer 15 that is set between the two electrode layers 13 and 14 in contact with these. This layered structure provides a heating element, designated as a whole by 20 in Figure 5, which in various embodiments is sealingly enclosed in the casing 10a of Figures 2-3, the opposite walls of which are here constituted by two casing layers 11 and 12.

10 In various embodiments, the casing layers 11 and 12, i.e., the two opposite walls of the casing 10a, are set on top of the two electrode layers 13 and 14, respectively. Preferably, the casing layers 11 and 12 have a larger width than the electrode layers 13 and 14, in order to provide peripheral areas of respective 15 contact and/or superposition of the casing layers 11 and 12. In various embodiments, the casing layers 11 and 12 are sealingly joined together in respective peripheral superposition areas, designated by 11b and 12b, for example via gluing or welding, such as thermal welding or laser welding.

15 In various embodiments, the layers 11, 12, 13, 14, and 15 each have a through opening, the openings being designated, respectively, by 11a, 12a, 13a, 14a, and 15a in Figure 4, and preferably having substantially the same diameter, and the layers 11-15 being set on top of one another in such a way that the through 20 openings 11a-15a are substantially coaxial with one another or at least in part face one another.

25 In various embodiments, on the openings 11a-13a a body for providing fluid-tightness or sealing, designated as a whole by 16, is applied, preferably via overmoulding (or possibly via elastic mounting), the body 16 being configured for insulating the device 10 with respect to the outside also at the openings 11a-13a. As will emerge from what follows, the body 16 can also perform the function of 30 protection of some electrical-connection elements of the device 10, and for this purpose the body 16 is preferentially made of electrically insulating material.

35 In various embodiments, also the body 16 defines a through opening, designated by 16a. The presence of the opening 16a of the body 16 and of the openings 11a-15a of the layers 11-15 is particularly advantageous, for example in applications of the type represented in Figure 1, where the device 10 is set up against a wall 1a provided with a passageway for the fluid, here represented by the outlet 1b of the tank 1. It may be noted that the device 10 could also be associated on the outside of the wall 1a of Figure 1, or else be associated to a wall other than the bottom one, not necessarily provided with an opening. As will be seen, according to possible embodiments, the through opening 16a of the body 16, or a

seat defined by said body, can also be used for coupling of the heating device 10 to another functional device, for example a UDM device (typically defining a duct for the liquid, and/or a pump, and/or sensors, and/or a further heater), or another similar device for fuel tanks.

5 The presence of a passage or of an axial opening that traverses the device 10 in the direction of its thickness (i.e., with reference to the example illustrated, the ensemble of the through openings 11a-16a) does not constitute an essential characteristic of the invention. In the same way, also the presence of the body 16 must be understood as optional. A sealing, and/or electrically insulating body 10 applied or overmoulded on the casing 10a can in any case be provided in embodiments in which the electrical-connection terminals of the device 10 are positioned in a different way from the embodiments exemplified herein.

15 In various embodiments, at least part of the casing 10a, preferably the entire casing 10a, can be provided via moulding or overmoulding of a polymer on the layers 13, 14, and 15. Such a casing can advantageously be shaped for providing one or more further elements, such as at least one of the following: a body of an electrical connector, elements for fixing the device 10 to the tank 1, a passageway for the fluid, at least part of the outlet of the tank 1, a seat for coupling with some other device (such as a UDM), etc.

20 As will be seen, in the non-limiting examples provided herein, the electrical-connection terminals 13d, 14d of the device 10 project in a substantially axial direction (or vertical direction, as viewed in the figures), but in possible variant embodiments – for example one in which the device is without the aforesaid axial passage – the connection terminals may be located in some other position, for example in the proximity of the outer profile or of the peripheral areas 11b and 12b, or else could project from the casing 10a in a substantially radial direction (or horizontal direction, as viewed in the figures), preferably coated at least in part by a sealing, and/or electrically insulating body, i.e., by a body of an electrical connector.

30 The casing layers 11 and 12 or, more in general, the casing 10a, are preferentially made of a material chemically resistant to the environment where the device 10 is installed or to the medium that is to be heated, for example the reducing agent contained in the tank 1 of Figure 1. The material in question, preferably a polymeric material, is moreover of the type capable of withstanding the operating temperatures of the heating device 10, roughly comprised between -

40°C and +90°C. Similar considerations apply to the material used for the body 16 possibly present, which is preferably a thermoplastic material.

In preferential embodiments, as has been said, the casing 10a is formed by the two layers 11 and 12, set on top of one another and sealingly joined at least in 5 the respective perimetral regions 11b and 12b, with the heating element 20 set in between, as exemplified in Figure 5; the layers 11 and 12 may possibly be sealingly joined together also in intermediate areas or openings.

In various embodiments, the casing layers 11 and 12 are constituted by 10 respective films of polymeric material. Preferred materials are, for example, polypropylene (PP), polyethylene (PE), high-density polyethylene (HDPE), thermoplastic polyurethane (TPU), ethylene vinyl alcohol (EVOH), polyoxymethylene (POM), and thermoplastic elastomer (TPE).

According to possible embodiments, the layers 11 and 12 in turn have a multilayer structure; i.e., they are themselves constituted by a plurality of layers of 15 different materials, which possibly have different technical characteristics (for example, in terms of thermal conductivity, electrical insulation, barrier properties in regard to the external environment, flexibility, etc.); for example, the layers 11 and/or 12 may comprise two or more layers, each made of one and the same material, preferably chosen from the ones referred to above (PP, PE, HDPE, TPU, 20 EVOH, POM, TPE), or else may comprise combinations of two or more layers of different materials, preferably chosen from the ones referred to above (PP, PE, HDPE, TPU, EVOH, POM, TPE); in the case of a multilayer structure, the layers 11 and/or 12 may also include at least one metal layer to provide a barrier to the penetration of liquid, and/or vapour, and/or gas.

25 In general, the layers 11 and 12 may each have a thickness of between 0.1 mm and 2 mm, in particular when they are in the form of films.

In possible variant embodiments, instead of being obtained using films 11, 12 of polymeric material, the casing 10a may be obtained using protective layers 30 consisting of resins, coatings, or other substances deposited or overmoulded at least in part on the electrode layers 13, 14 and/or on the heating layer 15: in these cases, the thickness of the layers 11, 12 (or of the walls that perform their function) may, for example, be up to 3 or 4 mm.

It will be appreciated that, in various preferential embodiments, the casing 10a is very simple and inexpensive to produce in so far as the casing layers 11 and 35 12 may, for example, be obtained via simple operations of blanking or dinking,

starting from webs or films of the material of interest. The layers 11, 12 thus obtained can be laid on the two opposite major faces of the heated element 20, for example via lamination. As has been said, when necessary, the layers 11 and 12 can be sealingly joined along their peripheral superposition areas 11b and 12b, for 5 example via welding or gluing (they may, however, be joined via moulding, also in a single piece). The body 16 may possibly be overmoulded on the semifinished product thus obtained.

In various embodiments, the layers 11 and 12 are arranged so as to adhere in part to the electrode layers 13, 14 and in part to the heating layer 15, in 10 particular, at edges or parts of the latter that project from the electrode layers, or else directly at the opposite major faces of the heating layer 15 when, as will be seen, the electrode layers 13-14 are englobed in the material of the layer 15 itself. Consequently, in accordance with the invention, a polymeric material of the casing 10a of the device 10 is directly in contact with at least part of the material 15 of the heating layer 15, in particular when the heating layer itself comprises a polymeric material, preferably a polymer of the casing 10a and a polymer of the heating layer 15, that are compatible with one another or are such as to form bonds with one another, such as chemical and/or structural bonds between the polymeric chains: thanks to this characteristic, the adhesion or fixing of the casing 20 on the heating element, including the electrode layers and heating layer, is improved.

The electrode layers 13 and 14 are preferentially, but not necessarily, made of one and the same electrically conductive material, such as a metal material (for example, selected from among stainless steel, brass, bronze, aluminium, or alloys 25 thereof) or an electrically conductive polymeric material. In various embodiments, at least one of the electrode layers 13 and 14 is formed by a material in sheet or laminar form, or a meshed material, or again a fabric material (including electrically conductive non-woven fabrics). One or both of the electrode layers 13 and 14 may possibly be obtained also by depositing an electrically conductive 30 material directly on the heating layer 15 or on the casing layers 11 and 12, on a respective face, for example using silk-screen techniques or else overmoulding or co-moulding techniques. Of course, it is also possible to use or combine different materials and types of electrode (for example, one electrode layer may be obtained starting from a metal lamina, and the other electrode layer may be obtained 35 starting from an electrically conductive fabric). Also the electrode layers 13 and

14 may possibly have a multilayer structure.

In general, the electrode layers 13 and 14 can each have a thickness of from a few microns (for example, in the case of a deposition process) up to 3 mm (for example, in the case of a blanking or photo-etching process). It will be
5 appreciated that, by virtue of their preferably small thickness, the electrode layers 13, 14 may also be relatively flexible or deformable. Also the electrode layers 13 and 14 may, for example, be obtained via simple blanking or dinking operations, starting from sheets, or webs, or laminas, or films, or pieces of the material of interest or else, as has been said, using known deposition techniques.

10 In preferred embodiments, the heating layer 15 is made of a material having a PTC effect. In various embodiments, the material constituting the layer 15 is a polymer-based material (i.e., comprising at least one polymer), for example a composite material having a matrix formed by a polymer or by a mixture of a number of polymers and by a corresponding filler, for example an
15 electrically conductive filler and/or a thermally conductive filler.

In various embodiments, the material of the layer 15 is a co-continuous
20 polymeric composite with PTC effect, having a matrix that comprises at least two immiscible polymers and at least one electrically conductive filler in the matrix. In preferred embodiments of this type, at least one of the immiscible polymers is high-density polyethylene (HDPE) and at least another one of the immiscible polymers is polyoxymethylene (POM). The electrically conductive filler is
25 preferentially constituted by particles having micrometric or nanometric dimensions, preferably comprised between 10 nm and 20 μ m, very preferably between 50 nm and 200 nm, possibly aggregated to form chains or branched aggregates of dimensions comprised between 1 μ m and 20 μ m. Preferential materials for the electrically conductive filler are carbonaceous materials, such as carbon black, or graphene, or carbon nanotubes, or mixtures thereof.

The HDPE and the POM are preferentially in relative percentages of between 45% and 55% of the sum of their weights. Preferentially, the electrically
30 conductive filler is confined or mostly confined in the HDPE, in a weight percentage of between 10 wt% and 45 wt%, preferably between 16 wt% and 30 wt%, taking to be 100 the sum of the weights of the HDPE and of the electrically conductive filler. For this purpose, the HDPE and the electrically conductive filler can be mixed together, in particular via extrusion, prior to
35 subsequent mixing with the POM, which also in this case can be obtained

preferentially via extrusion.

The high melting point of the POM enables, during extrusion of the composite, the two HDPE-POM phases to be kept better separated, reducing the possibility of migration of the carbonaceous filler into the POM (contributing to 5 this effect is the fact that the filler is preferentially previously mixed with just the HDPE). The higher melting point of the POM as compared to other known polymers likewise enables a more stable final structure to be obtained: the PTC effect of the composite material limits self-heating to a maximum temperature of approximately 120°C. POM moreover has a high crystallinity, roughly comprised 10 between 70% and 80%: this means that, in the proposed preferential co-continuous composite, any migration of filler from the HDPE to the POM is more unlikely to occur, thereby preventing loss of performance of the PTC-effect material, for example due to heating and passage of electric current. The higher crystallinity of POM also renders the composite particularly resistant from the 15 chemical standpoint and bestows high stability thereon. On the other hand, the crystallinity of HDPE is typically comprised between 60% and 90%: in this way, a high concentration of the conductive filler is obtained in the amorphous domains, with corresponding high electrical conductivity.

In various preferential embodiments, the composite that forms the heating 20 layer 15 includes a thermally conductive filler, preferably comprising a material having a value of thermal conductivity higher than 200 W/(m·K) at 25°C. A preferred material in this sense is, for example, boron nitride (NB). Preferentially, with reference to the example HDPE + POM referred to previously, the thermally conductive filler is confined or mostly confined in the POM, in particular in a 25 weight percentage comprised between 5 wt% and 70 wt%, preferably between 15 wt% and 30 wt%, taking to be 100 the sum of the weights of the POM and of the electrically conductive filler. For this purpose, the POM and the thermally conductive filler can be mixed together, in particular via extrusion, prior to mixing with the HDPE, which is possibly pre-mixed with a corresponding electrically 30 conductive filler.

For further details as regards to the preferred polymeric co-composite indicated for providing the heating layer 15, i.e., having a matrix that comprises HDPE and POM, the reader is referred to the Italian patent application No. IT102017000038877, the teachings of which are incorporated herein for 35 reference.

In general, the heating layer 15 can have a thickness of between 0.5 mm and 5 mm. Also in this case, considering its small thickness and its basically polymeric nature, the heating layer 15 may, if need be, present a certain bending capacity.

5 Also the heating layer 15 may possibly be obtained via simple operations of blanking or dinking, starting from a sheet or web of the starting PTC-effect polymer. However, as already mentioned, according to possible variant embodiments of the invention, the layer 15 can be overmoulded on or co-moulded with the layers 13-15.

10 Provision of the heating layer 15 by means of a polymer-based material (i.e., a material comprising at least one polymer) is advantageous in order to improve adhesion or fixing between the heating element 20, which integrates the layer 15, and the corresponding casing 10a. In this perspective, in various embodiments, the material of the layer 15 and the material of the casing are 15 mutually compatible or such as to form bonds, such as chemical or structural or mechanical bonds, or comprise one or more materials or components in common. For instance, with reference to a material of the heating layer 15 that includes HDPE and/or POM, the material of the casing 10a, i.e., of the casing layer 11 and/or layer 12, may itself comprise PE or HDPE and/or POM: in this way, on the 20 parts of casing that are set on top of the heating layer a better adhesion or bonding will be obtained between the corresponding materials, for example between the chains of the polymer that is in common. More in general, the materials of the layer 11 and/or 12 and the material of the layer 15 comprise polymers designed to melt at least in part and bond to one another, for example in the course of a hot 25 lamination or of an overmoulding, and/or designed to bind to one another, for example chemically and/or mechanically (as in the case exemplified previously of the layers 11, 12, and 15 that include PE or HDPE and/or POM).

In preferential embodiments, the electrode layers 13 and 14 have substantially similar overall perimetral dimensions, i.e., the shape and perimetral 30 dimensions of the electrode layer 13 are substantially similar to the shape and perimetral dimensions of the electrode layer 14. More in general, preferentially, the electrode layers 13 and 14 define respective superposition areas that are substantially similar, whereby it is meant that the facing areas of the two electrode layers, with at least part of the heating layer set in between, are substantially 35 similar. It should be noted, for this purpose, that the terms "superposition areas"

or “facing areas” are meant to designate a “theoretical” area, i.e., without considering the electrically non-conductive (or substantially electrically insulating) sites described hereinafter.

At least one part of the heating layer 15, preferably a part having a substantially constant thickness, is set between the two electrode layers 13 and 14. Preferentially, also the layer 15 has overall perimetral dimensions substantially similar to those of the electrode layers 13 and 14, but not excluded is the case of a part of the layer 15 that projects beyond the edges of the layers 13, 14 or else that does not reach as far as the aforesaid edges. Moreover, as will be seen, in possible embodiments, the electrode layers 13, 14 are at least in part embedded in the heating layer 15, or else the latter is shaped so as to define recesses for housing the aforesaid layers 13, 14. Hence, in these embodiments, only a part of the layer 15 is effectively set between the layers 13 and 14: in these cases, preferably, part of the material of the casing 10a is directly in contact with part of the material of the heating layer 15.

The casing layers 11 and 12, in the embodiments that envisage them, preferentially have a peripheral profile substantially similar to that of the layers 13-15 (or at least to the profile of the one from among the layers 13-15 that has largest dimensions), but of larger dimensions in order to enable definition of the corresponding superposition areas 11b and 12b for peripheral sealing of the casing 10a.

In Figures 6 and 7, the heating element 20 is represented in isolation, viewed from two opposite sides, in an embodiment in which the layers 13-15 are provided with the respective through openings (13a-15a, Figure 4). In embodiments of this type, it may prove advantageous to envisage that the electrical-connection terminals of the device 10 are located in the proximity of the corresponding through opening and/or extend in an axial direction. For this purpose, in various embodiments, associated to each electrode layer 13 and 14 is a corresponding connection element 13c and 14c made of electrically conductive material, which may, for example, be obtained by shaping part of the corresponding electrode, or else be welded or glued via an electrically conductive adhesive on the face of the corresponding electrode layer opposite to the heating layer 15.

The connection elements 13c and 14c may, for example, be arranged in such a way that a part thereof projects at a corresponding passage close to the

through openings 13a and 14a, for instance, a passage constituted by a radial extension of the through openings 13a and 14a. These passages or radial extensions of the openings 13a and 14a are designated by 13a₁ and 14a₁ in Figure 4. Similar passages or extensions 12a₁ and 15a₁ are defined also around the profile 5 of the openings 12a and 15a of the layers 12 and 15. The radial extensions or passages 12a₁-15a₁ are in positions that coincide on the corresponding layers 12-15, i.e., so that they are superimposed. In various embodiments, these passages or extensions 12a₁, 14a₁, and 15a₁ are sealed, for example, via the sealing body 16.

The connection elements 13c and 14c preferably have a small thickness 10 and are, for example, in the form of a shaped metal lamina, shaped, for instance, as an open ring, with an internal diameter substantially corresponding or close to the diameter of the through opening 13a and 14a of the corresponding electrode layer 13 and 14. In various embodiments, the elements 13c and 14c are substantially designed to provide an electrical-distribution element, which is 15 particularly useful in the case of connection to electrode layers made of fabric or meshwork. In various embodiments, the connection elements 13c and 14c, preferably in the form of a shaped metal lamina, are welded to the respective electrode layers 13 and 14, for example when the latter are in the form of a wire mesh in such a way as to guarantee mutual electrical connection and mechanical 20 fixing.

As may be noted, in particular in Figures 6-7, a portion of the elements 13c and 14c projects in an area corresponding to the respective extension 13a₁ and 14a₁ and, on this portion, the elements 13c and 14c are electrically connected to a respective terminal 13d and 14d that extends in an axial direction, either directly 25 or with a part of the respective electrode layer set in between.

In the example of Figure 8, the terminal 13d presents a right-angled bend, to define a base that is fixed to the aforesaid projecting portion of the corresponding connection element 13c, for example by means of a rivet 13e or the like. The aforesaid arrangement may be similar for the element 14c and the 30 corresponding terminal 14d, which here will have, however, a length slightly smaller than that of the terminal 13d (the difference in length is substantially equal to the thickness of the layers 13-15 and of the element 14c). As may be appreciated in Figures 6-7, the two terminals 13d and 14d are mounted so as to extend substantially alongside one another, without coming into contact with one 35 another, with the terminal 13d that traverses the radial extensions of the layers 13-

15, preferably to form an electrical connector, in particular a male connector, or connection terminals for electrical wiring.

The heating element 20 thus obtained is then equipped with the casing 10a if the presence of the casing is necessary or preferable in view of the application
5 for which the heating device is designed (for example, it is useful for protecting the device from chemically aggressive liquids or agents, whereas, if the device is used for heating a forced flow of air or some types of fuel, the casing may be omitted). Hence, with reference to the examples illustrated so far, the casing layers 11 and 12 are set on top of the two opposite major faces of the heating
10 element 20, for example via lamination, with the terminals 13d and 14d that pass also through the radial extension 12a₁ of the opening 12a of the layer 12. The layers 11 and 12 are then joined (sealingly, if this is necessary in view of the application of the device 10) in the respective peripheral superposition areas 11b and 12c. Next, the body 16 is applied to the semifinished product, in particular via
15 overmoulding and/or resin bonding. The body 16, in addition to sealing the layered structure at the through openings 11a-15a, as already mentioned above, is preferentially also shaped for defining a portion 16b (Figures 2 and 5) that partially encloses and electrically insulates the terminals 13d and 14d from one another. These terminals project axially from the aforesaid portion 16b, for their
20 connection to a corresponding wiring or supply and control circuit, for example belonging to the system 2 of Figure 1.

In preferred embodiments the heating device is configured so as to present areas with diversified emission of heat. In general, the definition "emission of heat" may here be understood as an emission of heat referred to a unit surface or
25 to a surface of predefined area, or else as a power or heating density or else as an emittance, for example, expressed in W/cm² or W/dm² or other unit of measurement suitable for the purpose. In this perspective, the phrase "areas with diversified emission of heat" may be understood as referring to areas subject to a different distribution or intensity of heat emission, or to a different power or
30 heating density, or to a different emittance, referred to a unit surface or a predefined surface. The emission of heat may regard each of the electrode layers 13, 14 and/or the heating layer 15 given that the electrode layers can behave as dissipator of the heat emitted by the heating layer, in particular in the case of metal electrodes or electrodes that are in any case thermally conductive.

35 The solution of providing areas of diversified heat emission is based upon

the consideration that, in various applications, it may prove convenient to provide a heating device that enables a different distribution of heat emission to be obtained, such as an higher, or more concentrated, heat emission in at least one first area to be heated, and at the same time a lower, or less concentrated, heat emission also in at least one further area to be heated.

An example of such an application is the preferential one previously mentioned with reference to Figure 1, i.e., a tank 1 in which it is necessary to guarantee a fast heating of a certain area, for example an area close to an outlet 1b of the tank itself, and at the same time ensure also a certain degree of heating in at least one other area, for example an area peripheral with respect to the outlet 1b. In this way, for example in the case of a tank 1 that contains a frozen liquid, the heating performed in the vicinity of the outlet 1b ensures rapid melting of the liquid in this area, and hence a fast or better supply to the corresponding system on board the vehicle, such as the treatment system 2. On the other hand, the milder heating in the areas of the bottom 1a of the tank 1 further away from the outlet 1b in any case enables a faster melting of the contents of the tank 1 as a whole.

Of course, a known heating device could be sized for heating uniformly an area substantially corresponding to that of the entire bottom 1a of the tank 1, but this, in addition to complicating construction of the device, would imply an excessive use of electric power in proportion to the actual needs. Considering that the flow rate of the reducing agent or other liquid at outlet from the tank 1 may be limited, is in fact sufficient to heat and melt the liquid rapidly just in the area close to the outlet 1b, it being possible to heat and melt the liquid more slowly in the other areas of the tank.

According to a different approach, the tank 1 could be equipped with a number of heating devices, of which a first heater with higher thermal emission in a first area in the vicinity of the outlet 1b and at least one second heater in a second area peripheral with respect to the first area, with the second heater distinguished by a lower heat emission, and then by a lower consumption: also in this case, however, construction of the heating system would be as a whole complicated and costly, as likewise its control.

Hence, in preferred embodiments, the differentiated emission of heat by the device 10 is obtained via a particular structuring of at least one from among the electrode layer 13, the electrode layer 14, and the heating layer 15.

According to a first aspect, at least one of the first and second electrode layers 13 and 14 has at least one region in contact with a corresponding region of the heating layer 15, and the region of the layer 13 and/or of the layer 14 and/or of the layer 15 is provided with a plurality of electrically non-conductive sites. The 5 electrically non-conductive sites are prearranged for bringing about an emission of heat by the heating device 10 in the aforesaid region that is different from the emission of heat by the heating device 10 in at least another region of the first electrode layer 13 and/or of the second electrode layer 14 and/or of the heating layer 15, or else that is different from the emission of heat by the heating device 10 at the other one of the first and second electrode layers 13 and 14.

In this way, within each electrode layer 13 and 14 and the heating layer 15 homologous regions may be provided distinguished by a different emission of heat, or else the emission of heat at one electrode layer may be different from the emission of heat at the other electrode layer.

15 For instance, in the first case mentioned, with a preferably substantially parallel and stacked arrangement of the layers 13-15, in each of the electrode layers 13 and 14 a plurality of regions may be identified in contact with the heating layer, in homologous positions of the two electrode layers, with these regions that are prearranged for diversified emission of heat. With reference, for 20 example, to Figures 6-7 or to Figure 10, two such regions for the electrode layer 13 comprise at least one first region and one second region, designated by 21 and 22, respectively. At least the first region 21 of the electrode layer 13 has a plurality of first electrically non-conductive sites, prearranged for defining in the aforesaid first region 21 of the electrode layer 13 an overall area of contact thereof 25 with the heating layer 15 that is smaller than the overall area of the first region 21 itself. On the other hand, in the non-limiting example illustrated, the second region 22 of the electrode layer 13 is substantially completely electrically conductive (i.e., devoid of the aforesaid electrically non-conductive sites), and is prearranged for having an overall area of contact with the heating layer 15 that is 30 substantially the same as or close to the overall area of the second region 22 itself. It should be noted that, by "overall area" is meant a "theoretical" area, i.e., without considering the aforesaid electrically non-conductive sites, whereas by "overall area of contact" is meant the area of the electrode layer effectively in contact with the heating layer (i.e., basically, the difference between the aforesaid 35 theoretical area and the sum of the areas of the individually electrically non-

conductive sites). In the non-limiting examples of Figures 6-7, or of Figure 10, the aforesaid electrically non-conductive sites are constituted by through holes or cavities of the electrode layer 13, some of which are designated by 30a, 30b and 30c.

5 In this way, as will emerge more clearly hereinafter, the emission of heat (or heating power density or emittance, measured in W/cm^2 or W/dm^2) by the heating device 10 in the first region 21 is lower than the emission of heat in the second region 22. Moreover, the emission of heat in the first region 21 of the electrode layer 13 and in the corresponding first region 21 of the second electrode 10 layer 14 is lower than the emission of heat in the second region 22 of the electrode layer 13 itself and in the corresponding second region 22 of the electrode layer 14.

15 In other embodiments, described hereinafter, the electrode layers and the electrically non-conductive sites may be prearranged in such a way that the emission of heat by one electrode layer is different from the emission of heat by the other electrode layer.

With reference to the case of Figure 10 (or of Figures 6-7), it will be appreciated how the region 21 is distinguished by the presence of a plurality of electrically non-conductive sites 30a, 30b, and 30c, i.e., of openings or through holes in the layer 13, whereas the region 22 is substantially devoid of electrically 20 non-conductive sites, i.e., devoid of openings or through holes in the layer 13 (without obviously considering the openings 13a and 14a, which are not defined for the purposes of a variation of heat emission). In what follows, for reasons of brevity and where not otherwise specified, the electrically non-conductive sites will also be defined as "holes".

25 Basically, then, the holes are arranged or distributed on at least one electrode layer so as to be absent or in a smaller number in the areas where it is desired to obtain greater heating (i.e., a higher power density), as for example the area close to the outlet 1b of Figure 1, and be in a larger number, or have larger dimensions in the area or areas where it is desired to obtain less heating (i.e., a 30 lower power density), as, for example, the peripheral areas of the bottom 1a of Figure 1. As explained hereinafter, a similar behaviour occurs at the other electrode layer, even when this is without holes.

Figure 10 lends itself also to illustrating the case where one and the same region configured as a whole for a lower heat emission, here represented by the 35 region 21, can in turn be divided into a plurality of subregions, designated by 21a,

21b, and 21c. From another standpoint, hence, in the electrode 13 of Figure 10 there may be identified a region 22 with higher heat emission and three regions 21a, 21b and 21c with lower heat emission, where in turn the heat emission is differentiated in the regions 21a, 21b and 21c.

5 In the example, the subregion 21a is the one distinguished by the lowest heat emission and is provided with holes 30a with largest cross section, whereas the subregions 21b and 21c are distinguished by respectively increasing heat emissions: this is obtained, in the case of the subregion 21c, by holes 30c that are in a number a little greater than in the subregion 21a, but that have a decidedly 10 smaller cross section than the holes 30a; the subregion 21b has instead holes 30b with an intermediate cross section as compared to the holes 30a and 30c, but in a decidedly higher number.

15 In more general terms, the greater the ratio between the total area of the holes of a given region (i.e., the sum of the areas of the individual holes) of an electrode layer and the overall or “full” area of the same region (i.e., its theoretical area in the absence of holes), the lower the emission of heat in this region.

20 The above concept may be clarified with reference to Figures 11 and 12, which illustrate schematically in cross-sectional view a portion of a heating device 10. In the case of Figure 11, a portion of the electrode layer 13 of Figure 10 is visible, corresponding to a hole 30a of its region 21 (or subregion 21a). The electrode layer 14 is devoid of holes, albeit itself identifying a region 21 (or subregion 21a) in a homologous position with respect to that of the electrode layer 13. In the example, the casing layer 11 is shaped so as to come into contact with, and preferably be fixed to, the heating layer 15 in an area corresponding to the 25 hole designated by 30a, for example locally glued on the layer 15 at the hole 30a.

Figure 12 represents schematically the distribution of the electric current in the case of the configuration of Figure 11, with the consequent distribution and intensity of heat generated by the layer 15. Represented schematically within the layer 15 – via broken-line arrows – are generic paths of the electric current (from 30 the electrode layer 13 to the electrode layer 14). Corresponding to the greater length of an electrical path is a higher electrical resistance, and hence a lower current intensity, with consequent lower heating power: the heat emission (i.e., the different distribution of the heating power) is represented schematically by the wavy arrows present on the outside. As may be noted, in the full areas of the two 35 electrode layers 13 and 14 that are parallel to one another and in contact with the

layer 15, the heat emission is maximum, whereas it is lower in the perimetral area of the hole 30a of the electrode layer 13, and is substantially absent in the hole 30a itself; on the other hand, the emission of heat decreases with approach to the centre of the area of the electrode layer 14 defined by the hole 30a.

5 Figures 13 and 14 illustrate in a similar way the case of a heating device 10 in which both of the electrode layers 13 and 14 present at least one region 21 (or subregion 21a) provided with holes; for example, they are both similar to the electrode layer 13 of Figure 10. In this case, both of the casing layers 11 and 12 may be shaped so as to come into contact with the heating layer 15, and preferably 10 be locally fixed to the latter, in the area of the respective holes 30a. Figure 14 represents schematically the distribution of the electric current in the case of the configuration of Figure 13, as already described above in relation to Figures 11- 12. There may be noted, in this case, a substantially similar heat emission at the two electrode layers 13 and 14. In the full areas of the two electrode layers 13 and 15 14 that are parallel to one another and in contact with the layer 15, heat emission is maximum; it is lower at the perimetral area of the hole 30a of the respective electrode layer 13 and 14, and is substantially absent around the hole 30a itself for the two electrode layers 13 and 14. It will be appreciated that, in various embodiments, the two electrode layers 13 and 14 may be the same as one another, 20 also as regards the configurations of the respective holes or electrically non-conductive sites provided.

Of course, the holes provided in the various regions 21 and 22 could also differ for the electrode layer 13 and the electrode layer 14, for example by envisaging in the region 21 of the layer 14 holes that have a shape, and/or size, 25 and/or density different from those of the holes provided in the corresponding region 21 of the layer 14.

With reference, for example, to Figures 6-7, it will be appreciated that, in a device 10 that includes an electrode layer 13 substantially configured as in Figure 10 and the other electrode layer devoid of holes, heat emission will be maximum 30 in the regions 22 of the two electrode layers 13 and 14 (these regions being devoid of holes, and thus presenting as a whole a behaviour substantially similar to what is represented at right-hand and left-hand ends of Figure 12); instead, heat emission will be lower in the regions 21 of the two electrode layers 13 and 14, which have a behaviour similar to what is represented as a whole in Figure 12. 35 The same may be said in the case where both of the electrode layers 13 and 14 are

configured as in Figure 10 (i.e., as in Figures 13 and 14), with the difference that in this case, in the regions 21 of the two electrode layers, heat emission will be lower still.

Of course, the holes provided in the electrode layer 13 and/or in the 5 electrode layer 14 may be configured in multiple different ways or be combined with one another according to various configurations, according to the production requirements, for example in terms of shape, and/or arrangement, and/or size, and/or density on the electrode layer. For instance, exemplified in Figure 15 is the case of an electrode layer 13 divided in a transverse direction into two regions 21 10 and 22, where the region 21 is provided with a substantially orderly array of holes 30 that have a square or quadrangular cross section, whereas the region 22 is substantially devoid of holes.

Figure 16 illustrates, instead, the case of an electrode layer 13, the region 22 of which is surrounded practically entirely by the region 21, here provided with 15 small holes 30 arranged in a substantially orderly way. Likewise, Figure 17 illustrates the case of an electrode layer 13, the region 21 of which surrounds the region 22, but the latter is provided with holes 30b, which have a smaller cross section and a lower density than the holes 30a of the region 21. Figure 18 exemplifies the case of an electrode layer 13 having three different regions 21, 22, 20 and 23 configured for corresponding differentiated heat emissions, which have holes 30 of substantially equal cross section, but distributed in a different way, i.e., with maximum density in the region 21, intermediate density in the region 22, and minimum density in the region 23, with these regions 21, 22, and 23 that will consequently have a lower heat emission, an intermediate heat emission, and a 25 higher heat emission, respectively. Likewise, in the case of Figure 19 three regions 21, 22, and 23 are provided, having respective holes 30a, 30b, and 30c with a homogeneous shape, but with different dimensions of cross section and density.

As has been mentioned previously, the electrode layers 13 and 14 may be 30 formed via blanking or dinking, in particular when they are obtained starting from material in the form of a sheet, or web, or plate, for example from a metal sheet or a mesh or an electrically conductive fabric. Obviously, the operation of blanking or dinking will be prearranged so as to obtain also the necessary holes on the electrode layer considered. For instance, operations of blanking or dinking are 35 suitable for providing electrodes according to Figures 6-7, 10, 15-19.

Figure 20 illustrates the case of an electrode layer 13 made of an electrically conductive fabric, obtained from interwoven straps, for example metal straps or strips of electrically conductive fibre, for example carbon fibre, where both of the regions 21 and 22 are provided with holes 30a, 30b – corresponding to 5 the openings between the warp and weft – where the larger dimensions of the holes 30a that constitute electrically non-conductive sites can be obtained by spacing differently some straps in the region 21 as compared to the region 22, as in the case exemplified in the figures for the region 21, or else by varying the width of the straps in the two regions 21 and 22, and maintaining their centre-to-10 centre distance substantially constant.

Figure 21 illustrates a further example of electrode layer 13 formed substantially like a fabric, with warp and weft formed by wires or similar elements of electrically conductive material, for example a metal material or an electrically conductive fibre, such as carbon fibre.

15 In various embodiments, the warp and weft are arranged so as to define regions provided with differently sized holes. In the example illustrated, for instance, the warp and weft are arranged so as to define a sort of frame, with a central region 21 practically corresponding to a single hole 30a of maximum dimensions, and four angular regions 23 in which the warp and weft define holes 20 30c of minimum dimensions. The regions 22 that extend between the regions 23 are defined by just weft yarns or else just warp yarns, thus obtaining holes 30b of intermediate dimensions with respect to the central hole 30a and the holes 30c. As may be appreciated, heat emission will hence be minimum in the region 21, maximum in the regions 23, and intermediate in the regions 22.

25 In various embodiments in which at least one electrode layer is formed by a fabric (not necessarily according to the configuration of Figure 21), the fabric itself may be formed using a double-warp structure, i.e., one in which a first warp alternates with a second warp, in the opposite direction. Such a case is exemplified in Figure 22, where a weft yarn is designated by W₁, while two 30 double warp yarns are designated by W₂. The use of such a double warp – known also as “English gauze” in the textile sector – is particularly advantageous in the application here proposed in order to stabilise the warp itself, in particular during the steps of coupling the corresponding electrode layer 13 and/or 14 with the heating layer 15. This advantage is maximised in the case of a coupling by 35 overmoulding of the layer 15 on the layer 13 and/or on the layer 14, in so far as

the force of the plastic material injected under pressure in a mould, in the course of overmoulding of the layer 15 on the electrode layer, would tend to shift the threads that make up the latter, with consequent faulty operation of the heater, for example owing to a wrong distribution of the holes and/or areas with different 5 heat emission.

As has been said, what has been described and exemplified in the figures with reference to the electrode layer 13 may apply also in relation to the electrode layer 14.

In various embodiments, at least one of the electrode layers 13 and 14, 10 preferably both, is in the form of grid or mesh, for example obtained by making through incisions (staggered cuts) in a length of metal web and then deforming or stretching the lengths until passages 30d (Figure 24) are obtained having a substantially rhomboidal or square shape.

In a meshed structure of this type, there may hence be made the specific 15 holes 30e provided according to the teachings provided herein, i.e., the electrically non-conductive sites specifically provided for determining the type of heat emission, i.e., ones having a function different from that of the regular series of passages that are typically provided in common meshed structures or in certain fabrics. As may be seen in Figure 23 and in the corresponding detail of Figure 24, 20 the holes 30e – which constitute the sites specifically provided for determining the type of heat emission – are additional to the passages 30d proper of the meshed structure of the electrode layer 13, and have a larger size and/or a different distribution.

In various embodiments, at least one of the electrode layers, preferably 25 both of the layers 13 and 14, is at least partially embedded in the material of the heating layer 15, in such a way that the corresponding casing layer 11 or 12 will adhere directly on at least part of the surface of the heating layer 15, at one of the two opposite major faces of the latter. This solution is particularly advantageous 30 in so far as the layer 15 has its two opposite major faces substantially plane, thereby guaranteeing a better adhesion of the casing layers 11 or 12. In embodiments of this type, as exemplified in Figures 25-27, the material of the layer 15 may be overmoulded on the layers 13 and/or 14, as for example for the meshed electrode layers of the type exemplified in Figures 23-24, or else the electrode layers 13 and/or 14 may be embedded in a heating layer 15 produced 35 previously, for example after the respective surfaces thereof have been heated or

melted and the layers 13 and/or 14 have been made to penetrate therein. As already mentioned, the possible compatibility between the materials of the electrode layer 15 and of the layers 11 and 12 and/or bonding and/or welding between them improve fixing of the casing of the device.

5 Figures 25-27 illustrate the case of meshed electrode layers 13 and 14 embedded in the material of the layer 15, with the casing layers 11 and 12 that extend directly on the outer surfaces of the layer 15, that are preferably plane surfaces that cover externally the layers 13 and/or 14, or else surfaces that extend at the same height as the layers 13 and/or 14, or again surfaces that extend beyond 10 the outer profile of the layers 13 and/or 14.

The cross-sectional view of Figure 25 substantially corresponds to a region of the electrode layers 13 and 14 devoid of holes or sites aimed at determining the type of heat emission, according to the teachings provided herein. As may be noted, the internal electrical paths represented schematically by the broken-line 15 arrows are of a small length, substantially equal to or a little greater than the distance between the electrode layers 13 and 14. Corresponding to the smaller length of the electrical paths is a lower electrical resistance, and hence a higher current intensity, with consequent greater heating power: also in this case, the heat emission (or heating power density or emittance) is represented schematically by 20 the wavy arrows present on the outside. As may be noted, in these cases, just a part of the layer 15 – designated by 15' only in Figure 25 – is set between the electrode layers 13 and 14, where in particular this part 15' of the layer 15 forms the active portion for the purposes of heating. According to the preferential 25 example, there is moreover present at least one outer part 15" of the layer 15 set between the layer 13 and the layer 11 and/or one outer part 15" of the layer 15 set between the layer 14 and the layer 12, where the outer part 15" transfers the heat emitted by the part 15' towards the respective casing layer 11 or 12, i.e., towards the outside of the device. The outer parts 15", if present, are of small thickness, 30 for example of between 0.01 mm and 1 mm, to prevent or hinder transmission of heat towards the outside.

According to an aspect in itself inventive, the transfer of heat between the electrode layer 13 and/or 14 and the respective casing layer 11 and/or 12 may be improved via the addition of a thermally conductive filler present in the material of the layer 15, for example, in the part 15' and/or the parts 15".

35 The cross-sectional view of Figure 26 substantially corresponds to a region

in which the electrode layer 13 is provided with holes 30e, i.e., electrically non-conductive sites, whereas the corresponding region of the electrode layer 14 is devoid of holes 30e. As may be noted, the pattern of the electrical paths and the heat emission resemble those already described above with reference to Figure 12,
5 i.e., with a low or absent heat emission in the area of the holes 30e of the layer 13.

The cross-sectional view of Figure 27, instead, substantially corresponds to the homologous regions of two electrode layers 13 and 14 that are both provided with holes 30e. The pattern of the electrical paths and the heat emission hence resemble the ones already described above with reference to Figure 14.

10 As an alternative to overmoulding of the layer 15 on the layers 13 and 14, meshed electrode layers may be made to penetrate at least in part into the material of the layer 15 previously moulded in the form of a sheet, in particular by heating the layer 15 and then pressing the electrode layers into it. Such a case is exemplified in Figure 28, where the electrode layers 13 and 14 with meshed
15 structure, for example of the type illustrated in Figures 23-24, are made to penetrate into the layer 15, on the opposite faces of which the coating layers 11 and 12 are then applied, for example in the form of hot-laminated polymer films or layers or else in the form of overmoulded layers. As has been mentioned, this proves advantageous for the purposes of a better adhesion or bonding or welding
20 between the casing 10a and the heating element constituted by the electrode layers and the heating layer, on the major faces of the latter.

Figure 29 illustrates the case of meshed electrode layers 13 and 14 that are made to penetrate only partially in the heating layer 15, i.e., that slightly project therefrom (it should be noted that the cross-sectional view of Figure 29 and the
25 corresponding detail A are represented schematically to clarify the arrangement of the layers 13 and 14). In embodiments of this type, the casing layers 11 and 12, which also in this case, for example, are in the form of hot-laminated polymer films or layers or else in the form of overmoulded layers, may be shaped so to adapt and be fixed to the profile of the layer 15 and of the layers 13, 14. With this
30 solution, part of the electrode layers 13 and 14 remains on the outside of the material of the heating layer 15, thereby determining the presence of parts in relief (corresponding to the projecting parts of the layer 13 and/or 14), which makes it possible to improve further fixing of the casing of the heating device. Part of the material of the casing layers 11 and 12 (or of the overmoulded walls that replace
35 them) may penetrate locally between the meshes of the meshed layers 13 and 14,

and within the electrically non-conductive sites (such as the holes 30e, with reference for example to Figure 24), thus fixing or welding also to at least part of the material of the heating layer 15 that is also present between the aforesaid meshes of the meshed structure (as highlighted in the detail B of Figure 29, which 5 represents a cross section in an area corresponding to the passages 30d of the layer 13 – see Figure 24) and within the electrically non-conductive sites (namely, the holes 30e, with reference for example to Figure 24).

In various embodiments, defined on the two opposite faces of the heating layer 15 are recesses for housing and positioning at least part of the electrode 10 layers, not necessarily electrode layers in the form of a mesh: an example of this type is illustrated in Figure 30, where the aforesaid recesses are designated by 15₁. In embodiments of this type, the electrode layers 13 and 14 may be set only in contact with the layer 15a, for example glued thereto or else held in position by exploiting the casing layers 11 and 12, whether these are in the form of 15 overmoulded films or walls. In the case of use of electrode layers 13 and/or 14 with meshed structure, for example of the type illustrated in Figures 23-24, it is also possible to provide a layer of glue or resin that covers the meshed structure, for example by pouring or moulding the glue or resin on the layer 13 and/or 14, to prevent any presence of air: such a layer of glue or resin is represented 20 schematically only in the detail of Figure 30, where it is designated by R (in Figure 30, the representation of the layer R has been omitted for clarity of representation). The presence of the glue or resin R may advantageously be exploited also for defining a substantially plane surface for the layers 11 and 12, in the areas corresponding to the recesses 15₁, i.e., to the electrode layers. The 25 glue or resin R is preferably of the thermally conductive type, such as a resin and/or an adhesive with a low value of thermal resistance. It will be appreciated that, also in embodiments of this type – even in the absence of the glue or resin R –, the casing layers 11, 12, in the form of applied films or else overmoulded walls, are preferably at least in part in contact with and/or fixed to the material of the 30 heating layer 15, for example in areas that delimit the aforesaid recesses 15₁ peripherally, such as the areas designated by 15₂. The possible resin R is preferably a polymer of the type designed to fix and/or bind chemically and/or structurally to the material or polymer that forms the heating layer 15 and/or the casing layers 11, 12.

35 In various embodiments, even in the absence of the openings 11a-15a and

of the body 16 of Figure 4, the heating device 10 may be provided with intermediate areas of joining or fixing between the layers 11 and 12, preferably in a fluid-tight way, aimed, for example, at improving the packing between the stacked layers and/or facilitating mounting in position of the layered structure.

5 For instance, illustrated schematically in Figure 31 is a sort of “quilt” structure, i.e., of the type in which the device 10 has intermediate areas of joining or fixing, represented as a whole by 40, where the casing layers 11 and 12 are fixed to one another, in addition to their perimetral joining areas 11b, 12b. For this purpose, the layers 13-15 are provided with openings arranged substantially 10 coaxially to, or at least in part facing, one another. In Figure 32, where the representation of the casing layer 11 has been omitted, designated by 40a are through openings 40a of the layer 13 provided in the region 22 (similar through openings are provided in the layer 14), and designated by 40b are through openings of the layer 15, here substantially coaxial to, or facing at least in part, 15 respective openings 30 of the region 21 of the layer 13 (and also substantially coaxial to through openings of the underlying layer 14).

Figures 33 and 34 illustrate the configuration of an intermediate area 40 located in the regions 21 of the electrode layers 13 and 14, in this case both of which are provided with holes 30. As may be noted, thanks to the presence of 20 these holes 30 and of the holes 40b of the heating layer 15, the casing sheets 12 and 14 – purposely shaped or deformed – can be brought locally into contact with one another so as to be joined together, for example via welding or gluing. Preferentially, the edge 15b of the heating layer 15 around the openings 40b is substantially tapered in order to facilitate mutual contact between the layers 11 25 and 12, as well as for the purposes clarified hereinafter. In various embodiments, the above edge has at least one wall that is inclined, in particular towards the inside of the hole 30. Preferentially, two such inclined walls of the heating layer 15 are provided, inclined in opposite directions and designed to form an angle with one another, such as an angle of between 30° and 120°, preferably of 30 between 45° and 75°. The at least one inclined wall, or each inclined wall, of the edge 15b may be considered as belonging to a corresponding major face of the heating layer 15, forming in fact a sort of prolongation thereof.

In the case exemplified, in the intermediate area 40 illustrated, also the casing layers 11 and 12 have substantially coaxial or at least partially facing 35 through openings 11d and 12d, respectively, which may, for example, be

exploited for fixing the device, or again for enabling passage of a fluid between the two opposite faces of the heating device. In the presence of the openings 11d and 12d, joining between the layers 11 and 12 in the area 40 will preferably be fluid-tight; however, in addition or as an alternative to fixing between the casing 5 layers 11 and 12, tightness in regard to infiltration of liquids or other fluids within the heating device may be obtained via a sealed fixing between the casing layers 11 and the heating layer 15 (at least at its edge 15b), in particular via welding or gluing or overmoulding. In the case of welding or overmoulding, it is preferable to use polymers for the layers 11, 12, and 15 that are to melt at least in part and 10 weld to one another, or polymers that are bind to one another, such as a layer 15 and at least one layer 11 and/or 12 comprising PE or HDPE and/or POM. The presence of the openings 11d and 12d must in any case be understood as optional and hence not indispensable.

Figure 35 represents the pattern of the electrical paths and of heat emission 15 in the area 40 of Figure 34. As may be noted, the operating condition resembles the one already described above with reference to Figure 14. Figure 36 illustrates, instead, the case of an intermediate area 40' in a region of the electrode layer 13 that is provided with holes 30, whereas the corresponding region of the electrode layer 14 is instead devoid of such holes. Here the heating layer 15 has its own 20 through openings 40b, one or more of which are substantially coaxial to, or face, respective holes 30 of the layer 13, as represented precisely in Figure 36. As may be noted, in this case, the upper casing layer 11 may be set directly up against the lower electrode layer 14, and secured to this, for example via gluing or some other type of adhesion or bonding. Also in this case, the edge 15b of the openings 40b is 25 substantially tapered, in particular by means of a wall inclined towards the inside of the hole 30. Also this case, the inclined wall of the edge 15b may be considered as belonging to a corresponding major face of the heating layer 15, here its upper face.

As may be appreciated, also in the case of Figure 36 the pattern of the 30 electrical paths and heat emission in the area 40' resembles the one already described above with reference to Figure 12.

In various embodiments, the heating layer 15 defines one or more edges, which have a substantially tapered profile, and the casing 10a of the device has one or more portions shaped in a substantially corresponding or complementary 35 way. This characteristic has already been previously highlighted in relation to the

intermediate fixing areas 40 of Figures 31-37, where the layer 15 has through openings 40b having preferentially edges 15b with a tapered shape, for example distinguished by one or two inclined walls, and with one or both of the casing layers 11, 12 shaped to adapt to this shape. In preferred embodiments, however, 5 even in the absence of intermediate areas 40, at least one, and preferably all, of the peripheral edges of the heating layer 15, has/have a substantially tapered shape or a shape with decreasing thickness, for example by means of at least one inclined wall. Peripheral edges of this type are, for example, highlighted in Figures 23, 28, 10 29, and 30 and are designated by 15c. What has been exemplified previously in relation to the inclined walls of the edge 15b of Figures 34 and 36 may in general apply to the peripheral edges 15c of the layer 15. Also in this case, the at least one inclined wall, or each inclined wall, of the peripheral edge 15c may be considered 15 as belonging to a corresponding major face of the heating layer 15.

As may be seen also with reference to Figures 37-38, the tapered or inclined shape of the edges 15c of the layer 15 enables an improved adhesion of the casing layers 11 and 12, in particular when these are in the form of polymeric sheets or films. The peripheral areas of the layers 11 and 12 close to the superposition areas 11b and 12b may in this way adapt and follow an inclined profile, which prevents, for example, formation of right-angle bends.

20 The tapered or inclined peripheral profile of the edges 15c may be bestowed upon the layer 15 in the course of its production, for example in the course of its moulding, as highlighted in Figure 39 (or in Figure 23), with subsequent application of the casing layers 11 and 12 that adapts to the above profile, which is already shaped, the casing layers 11 and 12 being then sealingly 25 joined together at the superposition areas 11b and 12b, as highlighted in Figure 40, possibly also with fixing between the edge 15c of the layer 15 and the casing layers 11 and 12, for example via surface re-melting and/or bonding between the layers 11, 12, and 15 in the areas of mutual contact.

30 Alternatively, the layer 15 may be initially formed with squared edges or edges of a different shape, for example having sharp corners, as highlighted in Figure 41. In embodiments of this type, the layer 15 may subsequently undergo deformation, for example via heating after it has been obtained in order to enable a certain mouldability thereof, and in this condition the layers 11 and 12 are applied thereon by exerting thereon pressure or compressive force: such a step is 35 represented schematically in Figure 42. Application of the aforesaid compressive

force enables a certain deformation of the layer 15 to be obtained, that brings it to assume the tapered profile 15c, with part of the material that translates and “fills” the corresponding tapered profile of the casing layers 11 and 12, as represented schematically in Figure 43.

5 The presence of tapered edges in the layer 15 presents the further advantage of preventing formation of significant empty spaces (air bubbles) between the layers 11, 12 and the peripheral edge 15c of the layer 15, and risks of failure following upon high degrees of expansion during the operating cycles of the device 10, at the same time enabling proper propagation of the heat towards 10 the outside.

Highlighted in part A of Figure 44 is the case of two layers 11 and 12 bent at right angles at a squared edge of the heating element (electrode layers and heating layer). The casing layers 11 and 12 adhere precisely against the squared profile, i.e., against the wall of the heating layer 15 orthogonal to the electrode 15 layers 13 and 14, and are then again bent at right angles to define the superposition areas 11b, 12b. This structure must, however, be deemed substantially theoretical, in so far as it is difficult to implement practically given that, in the course of production, it is unlikely for the layers 11 and 12 to be positioned perfectly in the way illustrated, on account of the risk of air remaining 20 trapped between the layers 11 and 12 and/or between the latter layers and the layer 15. Moreover, the likelihood of the layers 11 and 12 maintaining the position represented is extremely low, considering the inevitable expansion and contraction of the material of the layers 11 and 12 and/or of the layer 15 during operation of the heating device.

25 The structure illustrated in part B of Figure 44 is more realistic, i.e., with the layers 11 and 12 that could be arranged so as not to adhere to the aforesaid squared profile of the heating element (electrode layers and heating layer), for example determining the presence of an albeit reduced a “fillet” of air or sac of air, designated by G. It should be noted that this condition could be assumed also 30 in the case of an initial structure as the one illustrated in part A of Figure 44 where, following upon the cycles of heating and cooling (and/or the cycles of expansion and contraction) of the material of the layer 15 and/or of the layers 11 and 12, there could occur a detachment of the layers 11 and 12 from the vertical peripheral wall of the layer 15, the structure thereby assuming a configuration 35 similar to that of part B of Figure 44.

Part C of Figure 44 highlights a condition of heating of the structure of the part B of Figure 44, where the sac of air G expands, creating a greater detachment between the two layers 11 and 12 and/or between each layer 11 or 12 and the corresponding electrode layer 13 or 14, with consequent risks of failure and

5 infiltration of a medium external to the heating device. It should be noted that the presence of the sac of air G has also the effect of reducing in this area heat emission towards the outside of the device, the heat emission being also here represented schematically by the wavy arrows. The heat must in fact propagate through the air of the sac G, which notoriously operates as thermal insulator.

10 As has been mentioned previously, at least one of the electrode layers 13, 14 and/or the heating layer 15 and/or the electrically non-conductive sites may be prearranged in such a way that heat emission is as a whole different from one electrode to another. This measure may be adopted, for example, in applications where it is desired to have a maximum heat emission from a major face of the

15 heating device, corresponding for example to the electrode layer 13, and a lower heat emission from the other major face of the device, corresponding, for example, to the electrode layer 14.

In this perspective, in various embodiments, a first electrode layer, for example the layer 14, has a plurality of electrically non-conductive sites, and the

20 second electrode layer, for example the layer 13, is substantially devoid of electrically non-conductive sites, or else comprises one or more respective electrically non-conductive sites prearranged in such a way that the overall surface of contact between the heating layer 15 and the first electrode layer 14 is smaller than the overall surface of contact between the heating layer 15 and the second electrode layer 13, the emission of heat at the first electrode layer 14 thereby

25 being smaller than the emission of heat at the second electrode layer 13.

Figure 45 highlights, for example, the case of an electrode layer 13 that is devoid of electrically non-conductive sites obtained according to the teachings provided herein, and an electrode layer 14 that has, instead, such sites, designated

30 by 30, here in the form of gaps between the warp and weft of a sheet of fabric with electrically conductive strips. It should be noted that in Figure 45, as in the subsequent Figures 46-49, the electrode layers 13 and 14 are represented in reverse order as compared to the previous figures, i.e., with the layer 13 at the bottom and the layer 14 at the top. It will be appreciated that, according to the

35 principles set forth previously, heat emission will be greater at the electrode layer

13.

Likewise, Figures 46 and 47 illustrate the cases of an electrode layer 13 devoid of the electrically non-conductive sites and a corresponding electrode layer 14 provided with such sites 30, here in the form of quadrangular and round 5 through holes, respectively. As may be noted, also with reference to Figure 46, the sites 30 may be distributed in a more or less regular way substantially over the entire area of the layer 14, even though this is not strictly indispensable, as already highlighted for the previous embodiments. It is also possible to use two electrode layers with different general structure, for example one electrode layer meshed 10 and the other electrode layer in the form of lamina devoid of electrically non-conductive sites.

In various embodiments, the two electrode layers 13 and 14 may both have a plurality of respective electrically non-conductive sites, where the two pluralities of sites are, however, different one another, for example in terms of shape, and/or 15 size, and/or arrangement, and/or number, and/or density of the corresponding electrically non-conductive sites. For instance, Figure 48 illustrates the case of electrode layers 13 and 14 both provided with electrically non-conductive sites, for example in the form of through holes, where the sites 30a of the layer 13 have a cross section smaller than that of the sites 30b of the layer 14, to obtain a greater 20 emission of heat at the electrode layer 13. The general concept according to which the ratio between the total area of the electrically non-conductive sites 30a and the overall or “full” area of the electrode layer 13 is smaller than the ratio between the total area of the electrically non-conductive sites 30b and the area of the electrode layer 14 hence applies also to Figure 48.

25 Figure 49 highlights a case similar to that of Figure 48, where, however, the array of sites 30a occupies just one region 21 of the electrode layer 13, another region 22 thereof being instead devoid of such sites, whereas both of the homologous regions 21 and 22 of the electrode layer 14 are occupied by an array 30 of sites 30b. It will be appreciated that also in this case the emission of heat from the layer 13 will be as a whole higher than the emission of heat from the layer 14 30 and that the emission of heat will be higher in the regions 22 and less high in the regions 21.

In the embodiments described previously, the heating device 10 has been exemplified as a stand-alone component, designed for being mounted in a 35 container or on a generic supplied device, such as a tank. It will be appreciated,

however, that a heating device according to the invention may also be integrated in, or associated to, devices prearranged to perform functions different from heating or containment or conveying of a generic medium, such as functions of detection, for example, for detecting the level, and/or characteristics, and/or 5 pressure of a substance, or else again functions of management of the aforesaid substance, such as dosing thereof.

In this perspective, in particularly advantageous embodiments, the heating device 10 forming the subject of the invention may be associated or coupled to a functional device used in combination with a container or tank, for example a 10 device comprising a plurality of functional elements, such as a duct for a liquid and/or a pump, and/or sensors, and/or a further heater. Such a functional device may, for example, be a device for a fuel tank, or for managing an additive or a reducing agent used in an internal-combustion engine. Functional devices of this 15 type, for example the ones known as UDM, are frequently mounted in a fluid-tight way at an opening of a tank containing a liquid reducing agent and in general comprise a pump and sensor means for detecting one or more characteristics of the liquid. As already highlighted, given that the liquid, in particular if it comprises water, is liable to freeze when the tank is exposed to low temperatures (indicatively temperatures lower than -11°C), provision of a heating device 20 according to the invention enables melting of the frozen liquid to be achieved.

Figures 50-52 illustrate, in a merely schematic way, the case of combination of a heating device 10 according to the invention to another functional device, designated as a whole by 50, for example of the type responsible for detection of characteristics of a liquid, including its level. In the 25 case exemplified, the device 50 is preferably mounted in a sealed way at an opening or seat of the device 10, such as the through opening (16a, Figure 3) of the body 16 of the device 10, with the latter that is in turn mounted in a fluid-tight way at an opening of the bottom wall 1a of a tank 1 (the outlet of the tank 1, not visible in Figure 52, may be set in a position different from what is represented in 30 Figure 1). As may be noted, the body of the device 50 has, in its lower part, a respective body portion that may project on the outside of the tank 1 and is provided with an electrical connector 50a with electrical-connection terminals 50b of its own.

Preferably, the electrical-connector body 16b of the heater 10 and the 35 electrical-connector body 50a of the device 50 and/or the respective terminals

13d, 14d, and 50b are arranged in a position where they are close to one another and/or arranged in such a way as to facilitate electrical connection, preferably via a single connector or electrical wiring of the vehicle.

In various inventive embodiments, also the heating layer alone of a device
5 according to the invention may be prearranged for bringing about differentiated heat emission in at least one region thereof. In various embodiments of this type, for example, the heating layer has at least one region set between the respective electrode layers that is provided with electrically non-conductive sites, for example in the form of holes or cavities. This solution may be implemented in
10 addition or as an alternative to the presence of electrically non-conductive sites in one or both of the electrode layers, in order to bring about differentiated heat emission by the heating device.

An inventive implementation of this type is illustrated schematically in Figure 53, which illustrates a heating layer 15 having a region 21 provided with electrically non-conductive sites, some of which are designated by 30', and a region 22 devoid of such sites. Also in the case of the non-limiting example illustrated, the electrically non-conductive sites 30' comprise through seats or through holes or through cavities 30' of the heating layer 15, here arranged according to a substantially orderly array. The non-conductive sites 30' preferentially have a circular cross section, even though other shapes are not excluded (for example, triangular or quadrangular or polygonal shapes or shapes with profiles comprising curved stretches and/or linear stretches, the sites possibly being in the form of through holes or holes closed at one end).

Figure 54 illustrates, in partial cross-sectional view, a portion of a heating element 20 comprising electrode layers 13 and 14 with a heating layer 15 of the type illustrated in Figure 53 set in between. As may be noted, in implementations of this type, each non-conductive site or hole 30' of the layer 15 has the two ends closed by means of the electrode layers 13 and 14, i.e., at each hole 30' the electrode layers 13 and 14 are not in contact with the material of the layer 15.

30 In various embodiments, when the sites 30' comprise through holes of the layer 15, at least some of the holes 30' are connected to at least one other hole 30', by means of voids or connection passages, some of which are designated by 30" in Figure 53. Obviously, the electrode layers 11 and 12 will not be in contact with the material of the layer 15 even in the area of the passages 30", which themselves
35 constitute electrically non-conductive sites.

The connection passages 30" may be provided in order to facilitate formation of the holes 30' in the production stage, for example in the course of an operation of injection moulding of the layer 15, or else when the holes themselves are blanked or dinked from a layer 15 formed previously. The presence of the 5 passages 30" proves advantageous also in those embodiments in which the holes 30' and the passages themselves are provided for being occupied by a different material, for example a material that is electrically insulating, and possibly also thermally insulating, or else a second heating material, such as a second resistive or PTC-effect material, in particular of the type having a different heating 10 temperature and/or heat-emission capacity as compared to a first heating or PTC-effect material, as described hereinafter.

It should, however, be noted that, in various embodiments, the holes that constitute electrically non-conductive sites of the layer 15 may be separate holes or holes not connected to one another, i.e., formed even in the absence of 15 connection passages 30".

Figure 55 illustrates, in exploded view, a heating device according to the invention having a structure substantially similar to that of Figure 4, where, however, the electrode layers 13 and 14 are devoid of electrically non-conductive sites and the heating layer 15 has an array of holes 30' and passages 30" in its 20 region 21. As will be appreciated, on the basis of the same principles described previously, the presence of the holes 30' and of the passages 30" (i.e., the absence of PTC-effect material at these holes and passages) brings about in the region 21 of the heating layer 15 a heat emission (or heating power density or emittance) lower than in the region 22 of the layer 15 itself, and consequently a heat emission 25 (or heating power density or emittance) in the regions 21 of the two electrode layers 13 and 14 lower than in the respective regions 22.

Of course, the electrode layer 13 and/or the electrode layer 14 of Figure 55 could also be provided with electrically non-conductive sites, according to what has been explained previously.

30 Figure 56 illustrates in exploded view a heating layer 15 of a conception similar to that of Figure 53, but where the holes 30' and the connection passages 30" are designed to be occupied by a second material different from the material of the layer 15, such as a second electrically insulating and/or thermally insulating (or substantially electrically insulating and/or substantially thermally insulating) 35 material, designated as a whole by 300. As will be seen, on the other hand, the

material 300 could itself be a heating or PTC-effect material.

In the case exemplified, the second material 300 is shaped so as to provide a shape substantially complementary to that of the array of holes 30' and of the corresponding connection passages 30"; for example it comprises an array of 5 elements or inserts 300' – here substantially disk-shaped – joined together by means of connection portions 300" – here substantially rectilinear.

The material 300 may be configured as a whole as a single body, as in the case exemplified in the figures, distinct or obtained separately with respect to the heating layer 15 and defining the inserts 300' and the portions 300", which is 10 subsequently applied or fitted, preferably with slight interference, on the layer 15, so as to occupy the corresponding holes 30' and passages 30". In other embodiments, the material 300 may be applied directly on the layer 15, filling the holes 30' and the passages 30" of the layer 15 itself with the material 300: this filling may, for example, be obtained by overmoulding or co-moulding of the 15 material 300 on or with the layer 15, or else by pouring the material 300 (for example, a resin) into the holes 30' and passages 30". For this purpose the passages 30" may advantageously serve to get the second material to flow and distribute between the various holes 30'. However, the passages 30" could also be totally or in part absent, as explained hereinafter.

20 Of course, it is also possible to mould first a single body made of the material 300 and, subsequently, overmould thereon or co-mould therewith the material designed to provide the remaining part of the heating layer 15 (i.e., the part defining the holes 30' and passages 30").

Figure 57 illustrates, in partial cross-sectional view, a portion of a heating 25 element 20 comprising electrode layers 13 and 14, with a heating layer 15 provided with a single body made of the second material 300, according to an example that substantially amounts to what is illustrated in Figure 56. As may be noted, in implementations of this type, each hole 30' of the layer 15 is occupied by a respective insert or second material 300, the two ends of which are in contact 30 with the electrode layers 13 and 14. Preferably, the material 300 is a polymer-based material (i.e., a material comprising at least one polymer), for example a material compatible with a polymeric material of the layers 11 and 12 and/or with the material of the layer 15, in particular to enable mutual re-melting and surface welding thereof and/or to enable mutual chemical and/or mechanical bonding (for 35 example, the material 300 and the material of the layers 11, 12 and/or of the layer

15 could have common components, for example PE, or HDPE, and/or POM).

In the case of a heating layer 15, the sites 30' of which are constituted by distinct holes (i.e., without the connection passages 30''), the inserts 300' may be configured as bodies distinct from one another, or else the corresponding material 5 may be moulded or poured into the individual holes 30' of the layer 15. The embodiment illustrated in Figure 56, with holes 30' and passages 30'', as well as inserts 300' and connection portions 30'', must, however, be deemed preferable. In the case of moulding or pouring of the material 300, in fact, there is allowed the presence of just one point of injection or pouring of the material 300, or of a few 10 injection or pouring points, with the passages 30'' that then enable the material in the fluid state to flow into all the holes 30' and fill them. On the other hand, a single body, made of the material 300 separately from the layer 15, that defines the inserts 300' joined together by means of the portions 30'', is easier to handle in the production stage, for example when such a single body is moulded apart 15 and/or stored and/or applied on the layer 15 provided with holes 30' and passages 30'', or when the layer 15 is overmoulded on the aforesaid single body.

As may be appreciated, operation of a heating device integrating a heating layer 15 of the type illustrated in Figures 56-57 is similar to what has been described with reference to Figures 53-55.

20 In the embodiments exemplified, with a relatively thin heating layer 15, the holes 30' and possible passages 30' are preferentially holes and passages formed through the layer 15. In other embodiments, when the heating layer 15 has a sufficient thickness, the holes 30' and possible passages 30' may, instead, be configured as blind cavities, i.e., provided with a bottom. Embodiments of this 25 type are exemplified also in the partial cross-sectional views of Figures 58 and 59, which regard heating elements 20 similar to the ones of Figures 54 and 57, respectively, but where the sites 30' are constituted by blind holes, i.e., by cavities having a respective bottom.

It will be appreciated that the solution of providing electrically non- 30 conductive sites in the form of blind cavities or cavities with a bottom may be implemented also in relation to the electrode layers 13 and/or 14, when these layers have a thickness sufficient for the purpose.

According to a different aspect, the heating layer provided in a device according to the invention is prearranged for differentiated heat emission obtained 35 with the use of at least two different materials having a PTC effect, or else two

different thermistor materials, distinguished by heating temperatures and/or heat-emission capacity that are different from one another. In solutions of this type, in a heating layer formed prevalently with a first PTC-effect material there made be provided one or more areas or islands made of a second PTC-effect material,

5 distinguished by a heat-emission capacity higher or lower than that of the first material.

For instance, and as previously designated by reference to Figures 56, 57, and 59, the material 300 designed to fill the holes 30' and the possible passages 30" of the layer 15 does not necessarily have to be an electrically insulating material, itself possibly being a PTC-effect material, such as a second PTC-effect material having a heating temperature and/or a heating power different (higher or lower) from that of another first PTC-effect material that forms the layer 15. For instance, the material 300 may be a PTC material having a base structure similar to that of the heating layer 15 (for example, both materials comprising a mixture of polymers), but distinguished by a different coefficient of thermal expansion and/or by the possible presence of a thermally conductive filler, which is instead absent or different in the material of the layer 15, thus being able to emit or dissipate more heat when electrically supplied.

A similar effect may be obtained by providing in a PTC-effect material 20 300 an electrically conductive filler in a different proportion (for example, a lower proportion) with respect to the material of the layer 15, so as to vary or increase its electrical resistance. Yet another possibility is to use a PTC-effect material 300 similar to that of the layer 15 (for example, both materials being HDPE + POM), but distinguished by a higher amount of filler constituted by electrically 25 conductive particles so as to reduce its electrical resistance and thus develop less heat. As has been said, the PTC materials used may differ from one another also for the specific composition of the material of the matrix or of its electrically conductive filler, for example in the sense that the polymer or polymers of a first PTC material may differ from the polymer or polymers of a second PTC material. 30 Similar considerations apply to the materials constituting the possible electrically conductive and/or thermally conductive fillers.

What has been described previously with reference to Figures 53-59 in relation to the material 300 and to its inclusion in the layer 15 also applies in the case where the material is itself a resistive material or a material having a PTC 35 effect.

From the foregoing description, the characteristics of the present invention emerge clearly, as likewise its advantages. The electrical heating device according to the invention is as a whole simple and inexpensive to produce, and reliable in operation.

5 The protective casing of a heating element of a device according to the invention is itself simple to produce and reliable, at the same time guaranteeing an increased adhesion, and/or fixing, and/or bonding thereof to the corresponding heating element. The characteristics of adhesion, and/or fixing, and/or bonding of the casing to the corresponding heating element, and in particular adhesion, and/or 10 fixing, and/or bonding of the casing to the heating material, at least in part set between the electrodes, make it possible to improve and guarantee in time contact between the casing and the heater, and/or prevent corresponding detachment, and/or prevent formation of albeit minimal air gaps or voids between the casing and the heater. It is thus possible in this way to prevent an increase in the thermal 15 resistance and/or a reduction in the propagation of heat from the heater to the casing, and hence to the fluid to be heated. Preferably, the protective casing described enables total elimination or in any case reduction of the risk of stagnation of air that might possibly have negative effects.

20 The protective casing described makes it possible, wherever necessary, to provide a heating device that is more protected from the medium that is to be heated, such as chemically aggressive or corrosive liquids; i.e., it makes it possible to provide a heating device that can be appropriately insulated from the medium to be heated, in particular in order to prevent any contamination of the medium itself by the materials of the heating device.

25 The intrinsic elasticity of the casing according to various embodiments, and of the heating device as a whole, contributes to reducing the risks of failure due to the thermal cycles of the heating device and to the consequent expansion/contraction of the materials involved.

30 In accordance with several preferred embodiments described herein, the heating device is able to heat relatively extensive areas, but with limited power consumption, by virtue of the possibility of differentiating heat emission from the device, i.e., of defining one or more regions with high heat emission and one or more other regions with low heat emission. The invention enables a heating 35 device to be obtained having at least two areas with different distribution of the

heating power and/or with different electric-power consumption and/or with different temperature, without the use of electronic control circuits and without having to associate the areas to different electrical connections.

It is clear that numerous variations may be made by the person skilled in 5 the branch to the electrical heating device described by way of example, without thereby departing from the scope of the invention as defined in the ensuing claims.

In the preferential versions, the electrically non-conductive sites provided 10 in one or both of the electrode layers are constituted by holes prearranged in a specific way for the purposes of the invention. However, in variant embodiments, 15 the aforesaid sites could be obtained in some other way, in particular by providing the specific areas of one or each electrode layer with pads or spots of electrically insulating or substantially insulating material, on the face of the electrode layer that is to be set on top of the heating layer. In this perspective, the phrase 20 “electrically non-conductive sites”, which is present in various points of this description and in the attached claims, is hence to be understood as comprising also substantially electrically insulated or insulating sites, as well as sites with high electrical resistance, i.e., distinguished by an electrical resistance significantly higher than the electrical resistance of the electrode layers 13 and 14 25 and/or of the heating layer 15 (or, conversely, distinguished by an electrical conductivity lower than the electrical conductivity of the electrode layers 13 and 14 and/or of the heating layer 15). In this perspective, also the phrase “substantially electrically insulating” and the like (used also previously, for example in relation to the material 300) is meant to include the case of materials 30 with high electrical resistance (or low electrical conductivity) as compared to the material of the electrode layers and of the heating layer.

According to the above variants, and with reference, for example, to Figure 10, the holes designated by 30a, 30b and 30c could be replaced by elements or pads of electrically insulating or substantially electrically insulating 35 material, for example a polymeric material, deposited or mounted on the face of the electrode 13 that is to be set on top of the heating layer, with these elements or pads having, for example a surface or perimetral profile similar to that of the holes 30a, 30b, and 30c. Possibly, the material used may also be thermally insulating. A solution of this type may be used, in principle, in all the embodiments illustrated previously. Deposition or application of the electrically insulating or substantially

electrically insulating spots or pads on the corresponding electrode layer, for example in the form of laminas, fabric, or meshwork, may be made using any known technique suitable for the purpose, for example silk-screen printing, overmoulding, spraying, fixing of pre-formed electrically insulating elements, etc.

5 The solution considered may also be applied when – as has been mentioned previously – one or both of the electrode layers is/are provided with blind cavities, in which case the (substantially) electrically and/or thermally insulating material may be applied so as to fill or coat the blind cavities at least in part.

The same concept may be implemented also in the case of electrode layers 10 obtained via deposition or fixing of material directly on the heating layer, in which case there will be envisaged deposition of a first electrically insulating or substantially electrically insulating material for formation of the electrically non-conductive sites, and deposition of a second electrically conductive material for formation of the electrode layers. In the same way, the electrically non-conductive 15 sites may be defined in electrode layers made of fabric, using for the warp and weft either electrically conductive wires or strips or electrically insulating or substantially electrically insulating wires or strips, or else wires or strips or fabrics that are electrically conductive but coated locally with electrically insulating or substantially electrically insulating material. It will be appreciated that, by 20 appropriately weaving such wires or strips, it is possible to define in the final fabric both electrically conductive areas and electrically insulating (and possibly also thermally insulating) areas.

Figure 60 illustrates a variant embodiment in which the device 10 is not provided with a through opening, as in embodiments described previously, but its 25 casing 10a is instead shaped so as to define a lateral seat 16a'. In the example represented, the casing 10a is made of a polymeric material overmoulded on a heating element including layers 13-15 and the corresponding electrical-contact elements, which will have in this case profiles different from those of the previous embodiments. In particular, with reference to the example illustrated, the through 30 openings 13a, 14a and 15a of the previous embodiments will be replaced by peripheral recesses of the layers 13-15 (here recesses with arched profile), with the electrical-contact elements that comprise axial terminals connected to the respective electrode layers. In embodiments of this type, the sealing body 16 of the embodiments described previously may be defined directly by a portion 16' of the overmoulded coating: in the example illustrated, the portion 16' is 35

substantially arched, shaped so as to define the lateral seat 16a', and preferably also an electrical-connection body or connector body.

Figures 61 and 62 illustrate, in different views, the condition of coupling of the heating device 10 of Figure 60 with a functional device 50 similar to that of Figures 50-52, but here also equipped with a level sensor 50c (Figure 61). As may be appreciated, the body of the device 50 is coupled to the device 10 at the peripheral seat 16a' of Figure 60, defined by the portion 16' of the overmoulded casing 10a. As may be noted from Figure 62, the portion 16b of the casing of the device 10 is here shaped to define also at least part of an electrical-connector body, which surrounds corresponding connection terminals.

Figures 63-65 illustrate schematically a heating device 10 according to the invention, the casing 10a of which is formed via overmoulding, i.e., by coating a heating element (for example, of the type designated by 20 in Figures 6-7) with a suitable electrically insulating polymeric material. In embodiments of this type, the functions of the sealing body designated by 16 with reference to the embodiments represented in Figures 1-59 may be provided directly by a part of the overmoulded casing, such as the part designated by 16' in Figures 63-65, which defines a respective through opening 16a in a position corresponding to through openings 13a, 14a, and 15a of the layers 13, 14 and 15, respectively.

It will be appreciated that, also in the case of the overmoulded casing 10a, one or both of the overmoulded walls that form the casing layers 11 and 12 may be locally in contact with the material of the heating layer 15, for example at the through holes (electrically non-conductive sites) of a corresponding electrode layer 13 and/or 14, and/or at the openings between the meshes of a meshed electrode layer, as already mentioned previously, to improve thereby fixing and adhesion of the casing 10a to the heating element 20. Preferentially, the material of the overmoulded casing 10a is in any case in contact with the material of the layer 15 at least at the peripheral edge of the latter. What has been described previously in relation to the use of compatible polymers for providing the layer 15 and the layers 11 and 12 applies, of course, also to the case of an overmoulded casing 10a. The aforesaid characteristics and/or technologies for producing the casing could be combined together in different ways, for example by providing a casing 10a in part obtained using a film or laminate and in part overmoulded, or else a casing 10a in part moulded separately and in part overmoulded.

Figures 66 and 67 illustrate, merely by way of example, possible

equipment that can be used for moulding a casing 10a on a heating element 20. In the example, the equipment basically consists of two mould parts M1 and M2, which have respective impressions I1 and I2, shaped for receiving within them the heating element 20 and defining the outer shape of the casing 10a (it should be 5 noted that in Figure 67 the mould part M2 is represented turned upside down, in order to highlight the corresponding impression I2). As may be noted, the impressions I1 and I2 have respective parts I1a-I2a for defining the general shape of the casing 10a (i.e., of the layers or walls 11 and 12), as well as parts I1b-I2b for defining the portion 16' of the casing 10a with the corresponding connector 10 body 16b (see Figure 62), and parts I1c-I2c for defining a through opening 16a in an area corresponding to the portion 16'.

As has been said, the material 300 used for filling the holes 30' of the layer 15 (see Figures 56, 57 and 59) is preferentially a polymer-based material (i.e., a material comprising at least one polymer) compatible with a polymeric material 15 (i.e., a material comprising at least one polymer) of the layers 11 and 12, and/or with the material of the layer 15, in particular to enable mutual re-melting and surface welding, and/or to enable a mutual chemical and/or mechanical bonding. In this perspective, in various embodiments, the electrode layers 13 and 14 have 20 one or more holes 30 that are substantially coaxial to one another and to the respective holes 30' of the layer 15, or at least in part face one another and the respective holes 30'. As exemplified in Figure 68, in embodiments of this type, both the holes 30 of the layers 13 and 14 and the holes 30' of the layer 15 may be filled with the material 300, for example via overmoulding, so that the material of the casing layers 11 and/or 12 can adhere locally also to the material 300. As may 25 be appreciated, in this way, the material 300 forms in practice "columns", at the two ends of which the casing layers 11 and 12 locally adhere, with an improved fixing of the casing 10a as a whole on the heating element. In the case of the overmoulded casing 10a, as exemplified in Figure 69, the material 300 that fills the holes 30 of the layers 13 and 14 and the holes 30' of the layer 15 may 30 advantageously be the same overmoulding material that forms the layers 11 and 12 in order to obtain a further improved fixing between the casing and the heating element 20. The concepts just set forth evidently apply also in the case where the holes 30' are of the type illustrated in Figure 58 or Figure 59, i.e., in the form of blind holes or cavities. For instance, Figure 70 illustrates the case of a layer 15 35 with two substantially facing blind cavities 30' that each open at a respective

major face of the layer 15, where the aforesaid cavities are filled with the material 300, which may be a material different from, but compatible with, that of the casing layers 11 and 12, or else the same material as that of the layers 11 and 12, as exemplified in Figure 70. Of course, with reference to Figure 70, the blind 5 cavities 30' could also be provided at just one major face of the layer 15, or else be provided at both of the faces but in axially staggered positions.

In embodiments alternative to the ones so far described, the heating layer 15 could be made of a material other than a polymer-based material, such as a 10 ceramic-based material having a PTC effect. The use of a polymer-based PTC material for the layer 15 is to be deemed preferential, in so far as its capacity for being modelled and/or adapted and/or bent slightly is higher than in the case of a ceramic-based material. This enables, for example, the device to adapt, to a certain extent, during assembly or use, to the possible tolerances or dimensional 15 variations of a tank for vehicles, which is typically made of polymer and is subject to deformations during moulding and/or during use in the various environmental conditions and/or during heating of the fluid. Also handling of the device 10 and its assembly and installation in the final working position proves less critical. The use of a polymer-based PTC material proves even more advantageous from the production standpoint, rendering modelling of the layer 15 and/or its possible 20 overmoulding on the electrode layers 13 and 14 more convenient.

The heating layer 15 may itself present a multilayer structure, i.e., be formed by a plurality of layers of material set on top of one another, such as a 25 number of heating layers (even made of different materials) fixed or bonded to one another, for example via welding, or hot lamination, or co-moulding, or overmoulding, with the various layers that form in any case a single heating layer 15 in contact with the two electrode layers 13 and 14.

At least one part of the polymer-based material of at least one of the casing 30 layers 11 and 12 may be joined, or welded, or bonded to at least one part to the material of at least one of the electrode layers 13 and 14, according to what has already been described, in particular when at least one electrode layer is made of an electrically conductive material having a polymeric base compatible with a polymer of the at least one casing layer. Likewise, at least one part of the electrically conductive polymer-based material of at least one electrode layer may be joined, or welded, or bonded to at least one part of a polymeric material 35 compatible therewith that belongs to the heating layer 15.

According to possible further variant embodiments, the heating device forming the subject of the invention may have a shape different from the one exemplified in the attached figures. In particular, what has been described with reference to adhesion, or joining, or welding, or bonding between at least one of

5 the casing layers or walls 11 and 12 and at least one of the opposite major faces of the heating layer 15 may also refer to a device having a different shape and/or a different arrangement of the electrode layers, for example with a first electrode layer and a second electrode layer arranged in the proximity or at minor opposite faces of a heating layer.

CLAIMS

- 1.** An electrical heating device (10) comprising:
 - a first electrode layer (13), made of electrically conductive material,
 - a second electrode layer (14), made of electrically conductive material,

5 a heating layer (15) made of at least one polymer-based material, the heating layer (15) having two opposite sides, in particular two opposite major sides,

10 a casing (10a) made at least in part of polymer-based electrically insulating material,

15 wherein the first electrode layer (13) and the second electrode layer (14) are each associated at a respective one said side of the heating layer (15), with at least one part (15') of the heating layer (15) that is set between the first electrode layer (13) and the second electrode layer (14), in contact with them,

20 wherein the casing (10a) comprises at least one first casing layer (11) and one second casing layer (12), each facing a respective one said side of the heating layer (15) and being made at least in part of a polymer-based material,

25 and wherein at least one from among the first electrode layer (13), the second electrode layer (14) and the heating layer (15) is prearranged in such a way that at least one part of the polymer-based material of at least one of the first casing layer (11) and the second casing layer (12) is joined or welded or bonded to a corresponding part of the polymer-based material of the heating layer (15) at at least one of said opposite sides of the heating layer (15).
- 2.** The device according to Claim 1, wherein at least one from among the first electrode layer (13) and the second electrode layer (14) has one or more through openings (30; 30a, 30b; 30a, 30b, 30c; 30e) through which the at least one part of the polymer-based material of the at least one of the first casing layer (11) and the second casing layer (12) adheres or is joined or welded or bonded to a corresponding part of the polymer-based material of the heating layer (15) at a respective one said side of the heating layer (15).
- 3.** The device according to Claim 2, wherein at least one of the first electrode layer (13) and the second electrode layer (14) has a meshed, or grid-like, or fabric structure made of electrically conductive material that is substantially or prevalently embedded in the polymer-based material of the heating layer (15) at least at a respective one said side, in such a way that the at least one part of the polymer-based material of the at least one of the first casing layer (11) and the

second casing layer (12) adheres or is joined or welded or bonded to a corresponding part of the polymer-based material of the heating layer (15) at said side of the heating layer (15).

4. The device according to Claim 2, wherein at least one of the first electrode layer (13) and the second electrode layer (14) has a meshed structure made of electrically conductive material, such as a meshed, or grid-like, or fabric structure, which is partially embedded in the polymer-based material of the heating layer (15) at least at one said side, in such a way that the at least one part of the polymer-based material of the at least one of the first casing layer (11) and the second casing layer (12) adheres or is joined or welded or bonded to a corresponding part of the polymer-based material of the heating layer (15) at said side of the heating layer (15), through the meshed structure, with another part of the polymer-based material of the at least one of the first casing layer (11) and the second casing layer (12) that adheres to a corresponding portion of the meshed structure that projects from the aforesaid side of the heating layer (15).

5. The device according to any one of Claims 1-4, wherein the heating layer (15) has at least one edge (15b, 15c) having a substantially tapered or inclined profile, and at least one of the first casing layer (11) and the second casing layer (12) defines at least one corresponding first portion having a substantially tapered or inclined profile, said profile of the at least one of the first casing layer (11) and the second casing layer (12) adhering or being joined or welded or bonded to said profile of the at least one edge (15c) of the heating layer (15).

6. The device according to Claim 5, wherein:

25 - the first casing layer (11) and the second casing layer (12) are joined or welded or bonded together at least at respective perimetral areas (11b, 12b) that extend beyond said profile of the at least one edge (15c) of the heating layer (15), and/or

30 - the first casing layer (11) and the second casing layer (12) are joined or welded or bonded together at a through opening (40b) of the heating layer (15) and at corresponding through openings (30) of the first casing layer (13) and of the second casing layer (14), the through opening (30) of the heating layer (15) defining the at least one edge (15b) having said profile, and/or

35 - the first casing layer (11), respectively the second casing layer (12), is joined or welded or bonded to the second electrode layer (14), respectively to the

first electrode layer (13), at a through opening (40b) of the heating layer (15) and a corresponding through opening (30) of the first electrode layer (13), respectively of the second electrode layer (14), the through opening (30) of the heating layer (15) defining the at least one edge (15b) having said profile.

5 **7.** The device according to any one of Claims 1-6, wherein defined on at least one of said opposite sides of the heating layer (15) is at least one housing (15₁) for the first electrode layer (13), respectively the second electrode layer (14), the at least one part of the polymer-based material of the first casing layer (11), respectively of the second casing layer (12), being joined or welded or bonded to 10 a corresponding part of the polymer-based material of the heating layer (15) at at least one area that delimits peripherally at least part of said at least one housing (15₁).

15 **8.** The device according to any one of Claims 1-7,
wherein the first casing layer (11), the second casing layer (12), the first electrode layer (13), the second electrode layer (14) and the heating layer (15) each have a through opening (11a, 12a, 13a, 14a, 15a), said through openings being substantially coaxial or at least in part facing one another, and

20 - provided at said through openings (11a, 12a, 13a, 14a, 15a) of the first casing layer (11), of the second casing layer (12), of the first electrode layer (13), of the second electrode layer (14), and of the heating layer (15) is a sealing element (16; 16'), preferably defining a respective through opening (16a).

9. The device according to any one of Claims 1-8, wherein the first casing layer (11) and the second casing layer (12) are films of polymer-based material.

25 **10.** The device according to any one of Claims 1-8, wherein the first casing layer (11) and the second casing layer (12) are layers overmoulded on a group including the first electrode layer (13), the second electrode layer (14) and the heating layer (15).

30 **11.** The device according to any one of Claims 1-10, wherein at least one part of the polymer-based material of at least one of the first casing layer (11) and the second casing layer (12) is joined or welded or bonded to the material of at least one of the first electrode layer (13) and the second electrode layer (14).

35 **12.** The device according to any one of Claims 1-11, wherein at least one of the first electrode layer (13) and the second electrode layer (14) comprises at least one of: a lamina of electrically conductive material, a mesh or grid of electrically conductive material, a fabric of electrically conductive material, an

electrically conductive material deposited on the heating layer (15).

13. The electrical device according to any one of Claims 1-12, further comprising:

- electrical-connection elements (13c-13e, 14c-14e), electrically connected to the first electrode layer (13) and to the second electrode layer (14), and
- a protective body (16), made of an electrically insulating material, that covers part of the electrical-connection elements (13c-13e, 14c-14e).

14. The electrical device according to any one of Claims 1-13, wherein the polymer-based material of the first casing layer (11) and of the second casing layer (12) and the polymer-based material of the heating layer (15) are mutually compatible materials, in particular designed to join and/or weld and/or bond together structurally.

15. The device according to any one of Claims 1-14, wherein the first electrode layer (13), the second electrode layer (14), the heating layer (15) and the casing (10a) are coupled together so as to define a structure of the electrical heater that is substantially planar and preferably at least in part flexible.

16. The device according to any one of Claims 1-15, wherein said opposite sides are opposite major sides of the heating layer (15).

17. An electrical heating device (10) comprising:

20 a first electrode layer (13), made of electrically conductive material,
a second electrode layer (14), made of electrically conductive material,
a heating layer (15) made of at least one polymer-based material, at least one part (15') of the heating layer (15) being set between the first electrode layer (13) and the second electrode layer (14), in contact with them,

25 a casing (10a) made at least in part of polymer-based electrically insulating material,

wherein at least one from among the first electrode layer (13), the second electrode layer (14) and the heating layer (15) is prearranged in such a way that at least one part of the polymer-based material of at least one of the first casing layer (11) and the second casing layer (12) is joined or welded or bonded chemically and/or structurally and/or mechanically to a corresponding part of the polymer-based material of the heating layer (15).

18. A vehicle component, in particular a container or a tank (1) or a tank component (50), having an electrical heating device (10) according to any one of 35 Claims 1-17.

19. A method for obtaining an electrical heating device (10), comprising the steps of:

5 a) associating a first electrode layer (13) at a first side of a heating layer (15) and associating a second electrode layer (14) at a second side of the heating layer (15) that is opposite to the first side, said first and second sides being preferably opposite major sides of the heating layer (15),

b) providing a casing (10a) that surrounds at least in part a group comprising the first electrode layer (13), the second electrode layer (14) and the heating layer (15),

10 wherein step a) comprises making at least part of the heating layer (15) of polymer-based material, and making at least part of the first electrode layer (13) and of the second electrode layer (14) of electrically conductive material,

15 wherein step b) comprises forming the casing (10a) with a first casing layer (11) and a second casing layer (12), each facing a respective one said side of the heating layer (15) and being made at least in part of a polymer-based material,

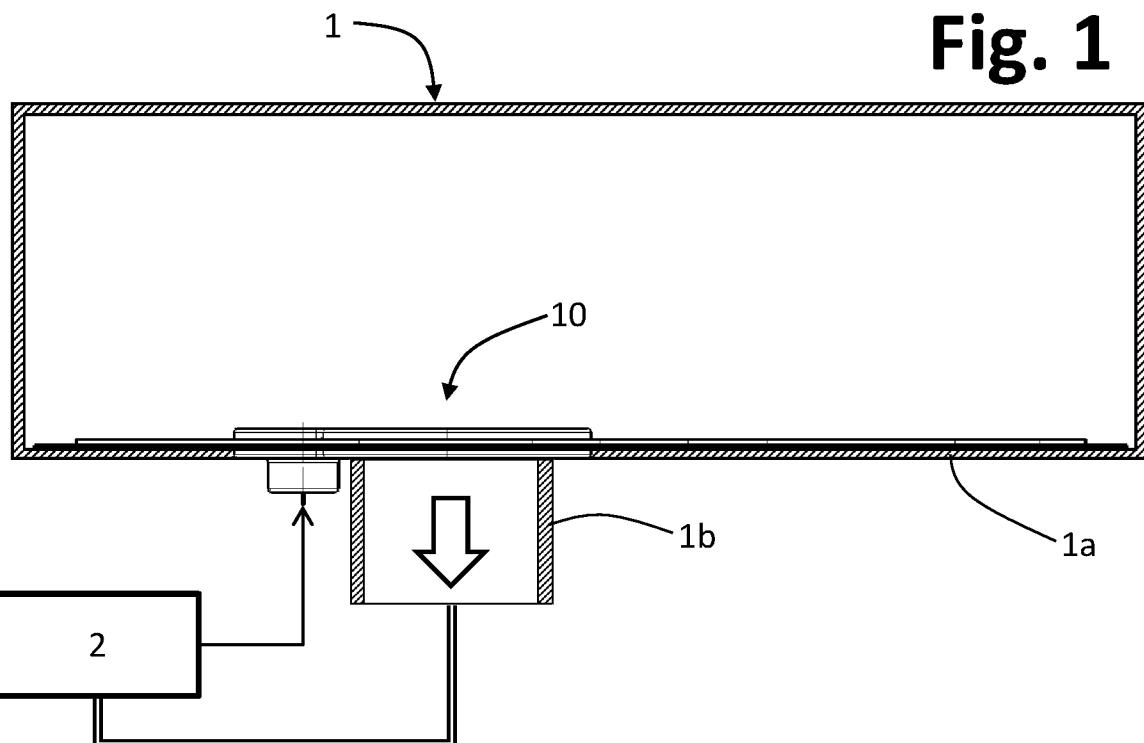
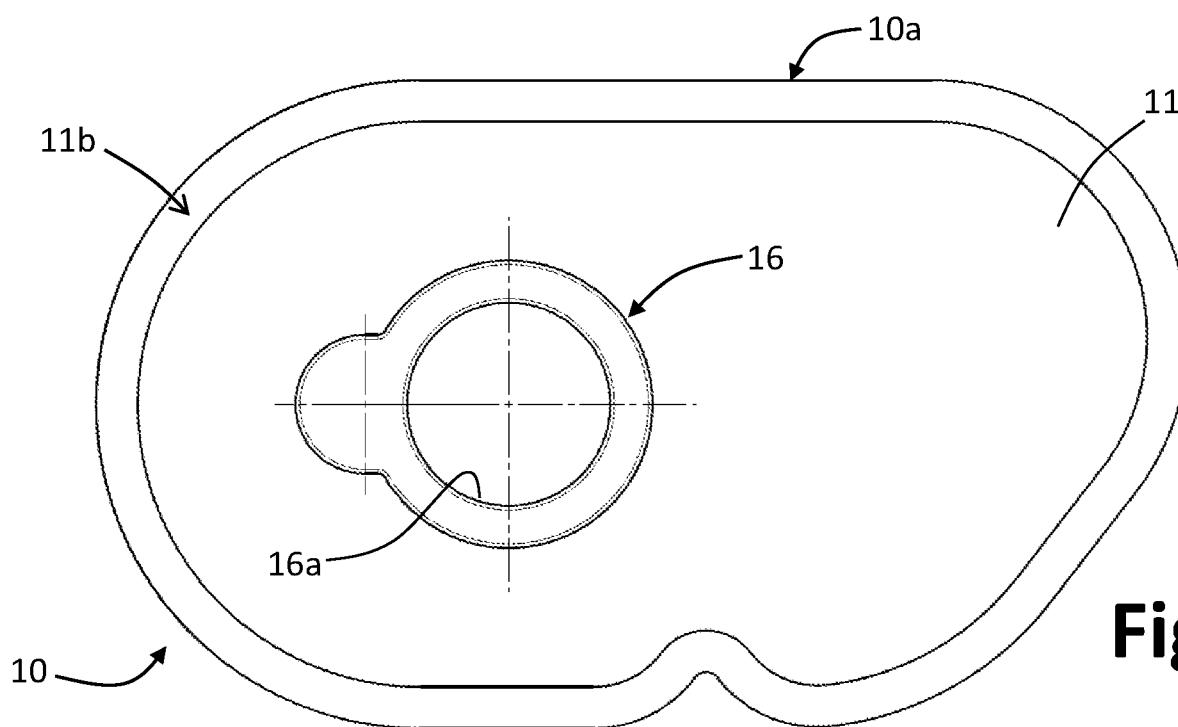
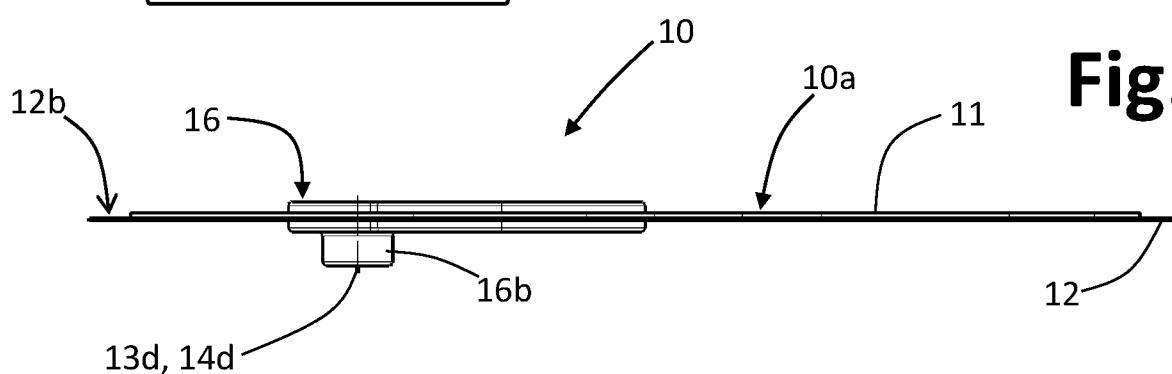
20 and wherein step a) further comprises prearranging at least one from among the first electrode layer (13), the second electrode layer (14) and the heating layer (15) in such a way that, following upon step b), at least one part of the polymer-based material of at least one of the first casing layer (11) and the second casing layer (12) joins or welds or bonds to a corresponding part of the polymer-based material of the heating layer (15) at at least one of said sides of the heating layer (15).

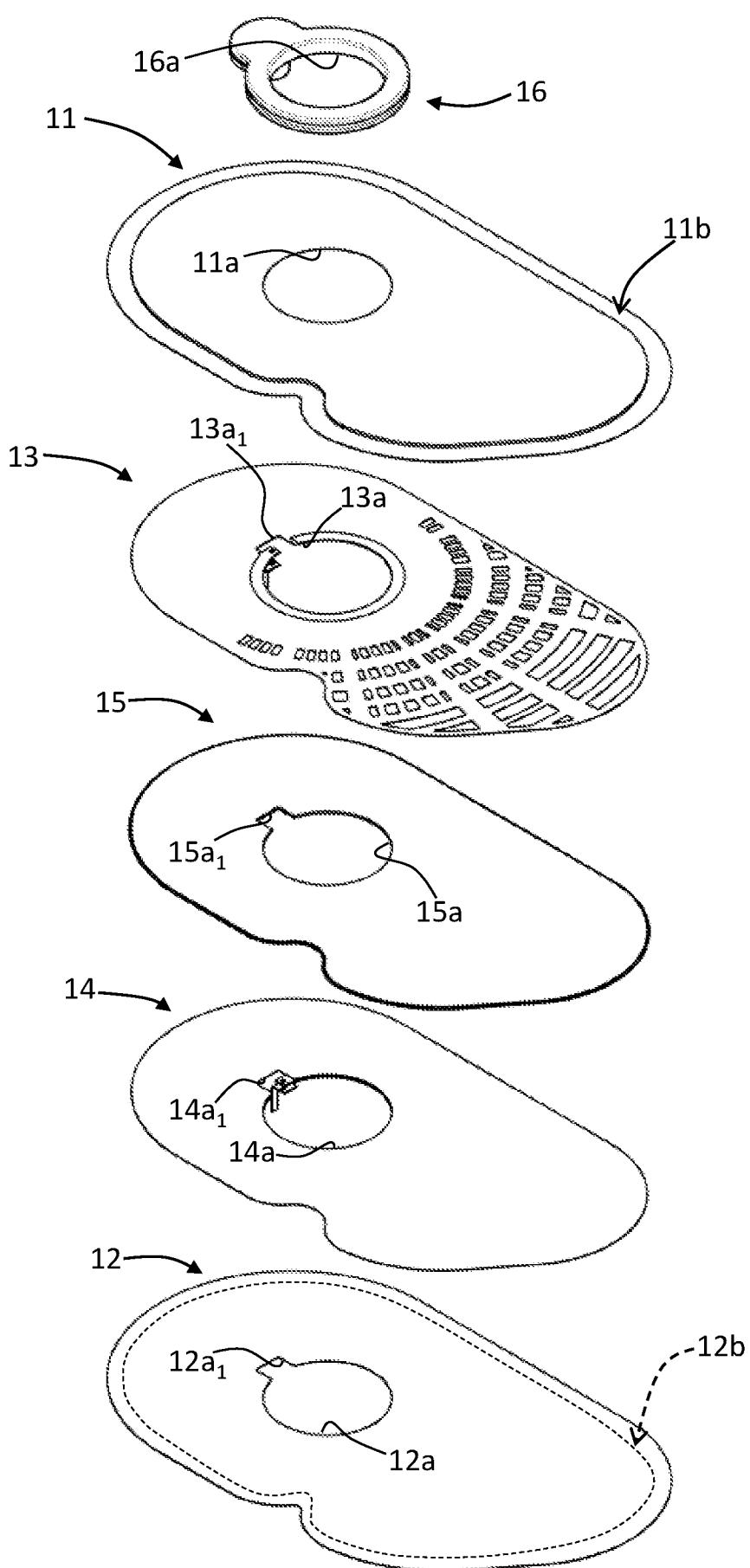
20. An electrical heating device (10) comprising a first electrode layer (13), made of electrically conductive material, a second electrode layer (14), made of electrically conductive material and a heating layer (15),

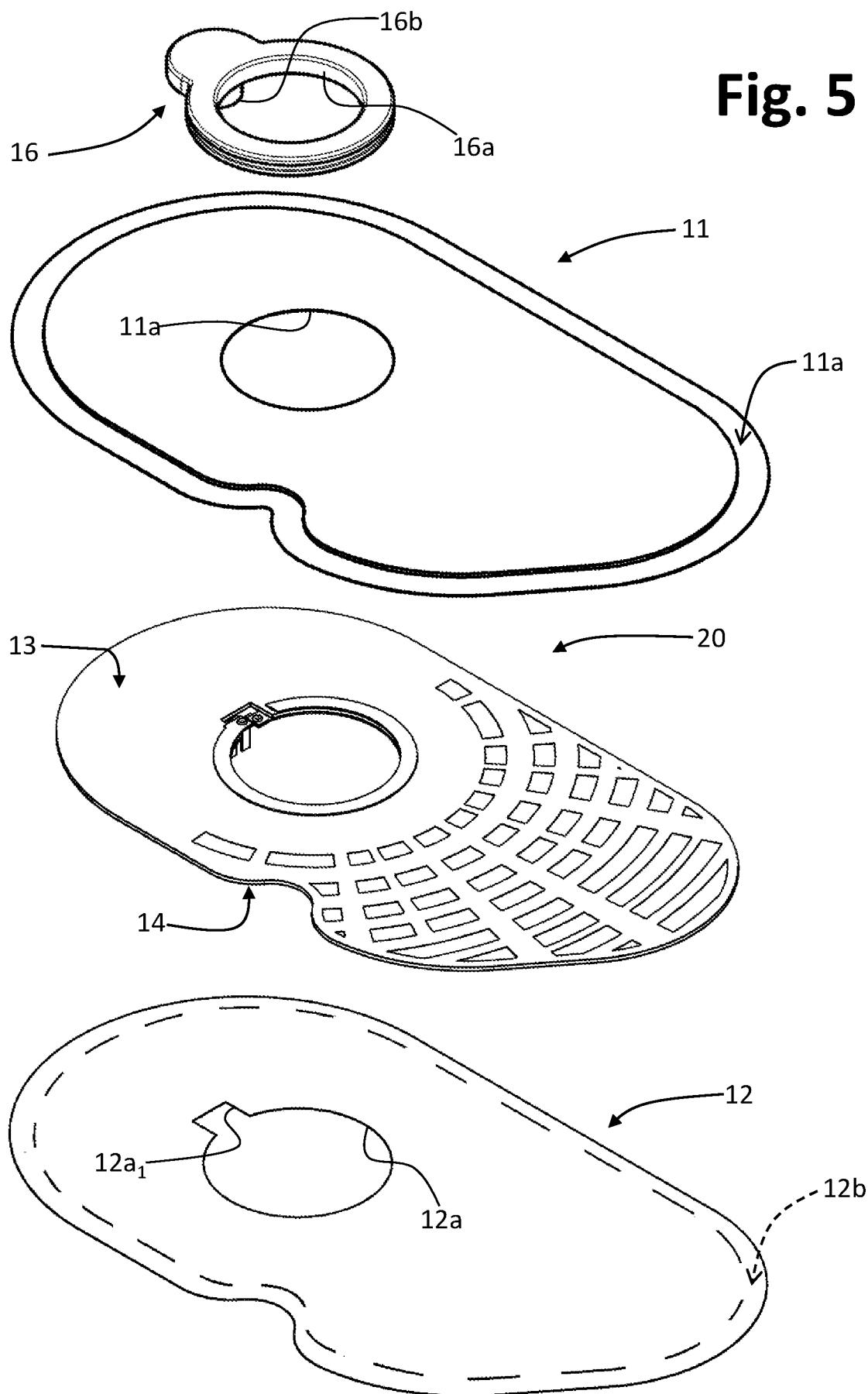
25 wherein the first electrode layer (13) and the second electrode layer (14) face one another, with at least one part (15') of the heating layer (15) that is set between the first electrode layer (13) and the second electrode layer (14), in contact with them,

30 wherein at least one from among the first electrode layer (13), the second electrode layer (14) and the heating layer (15) has a plurality of electrically non-conductive sites (30; 30a, 30b; 30a, 30b, 30c; 30e; 30', 30'') and/or is at least in part coated with at least one of a first casing layer (11) and a second casing layer (12) and/or wherein at least one part of one of the first casing layer (11) and the second casing layer (12) is joined or welded or bonded to a corresponding part of

the polymer-based material of the heating layer (15).

Fig. 1**Fig. 2****Fig. 3**

**Fig. 4**



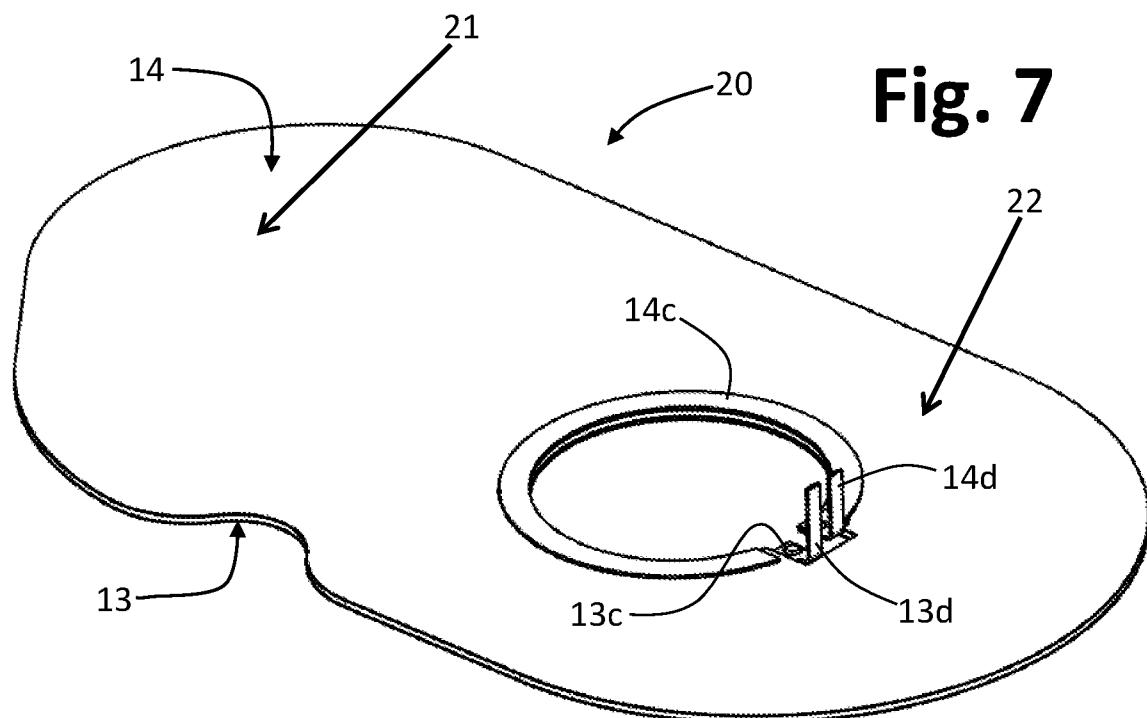
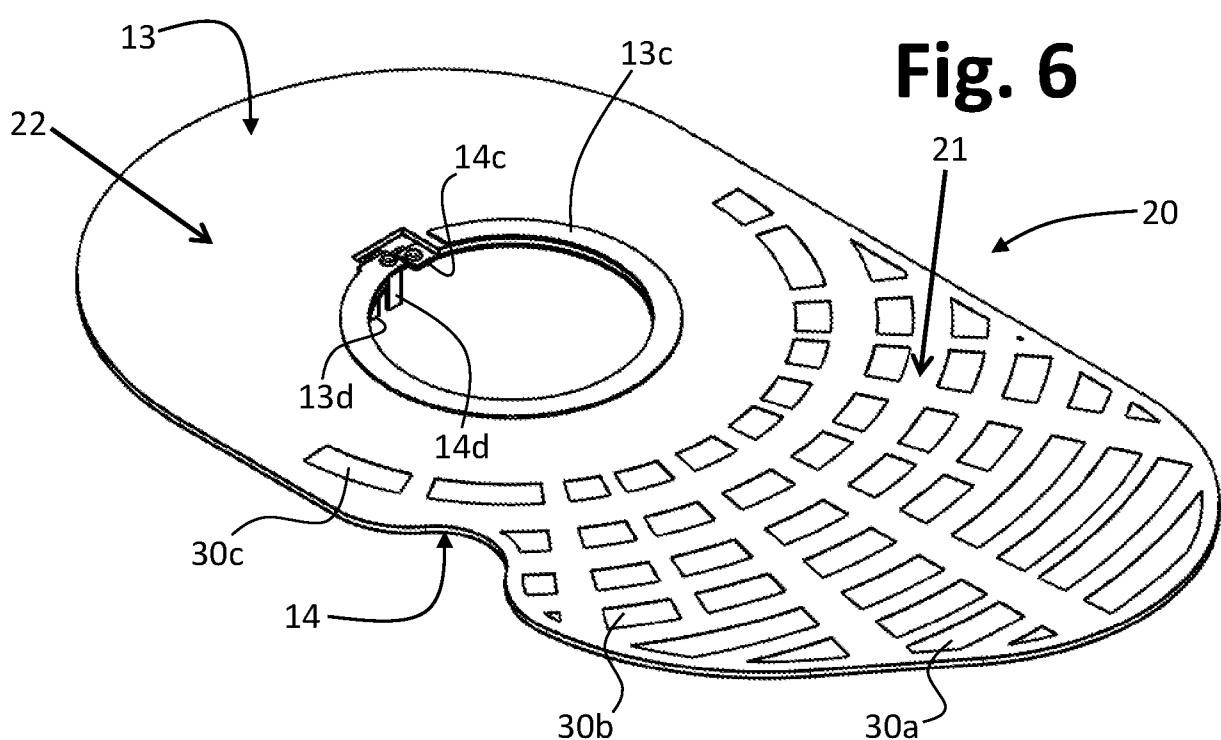
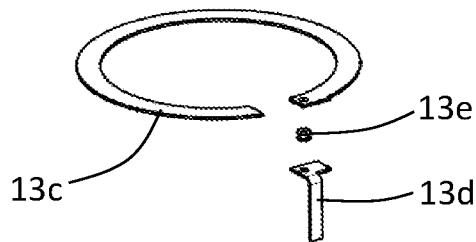
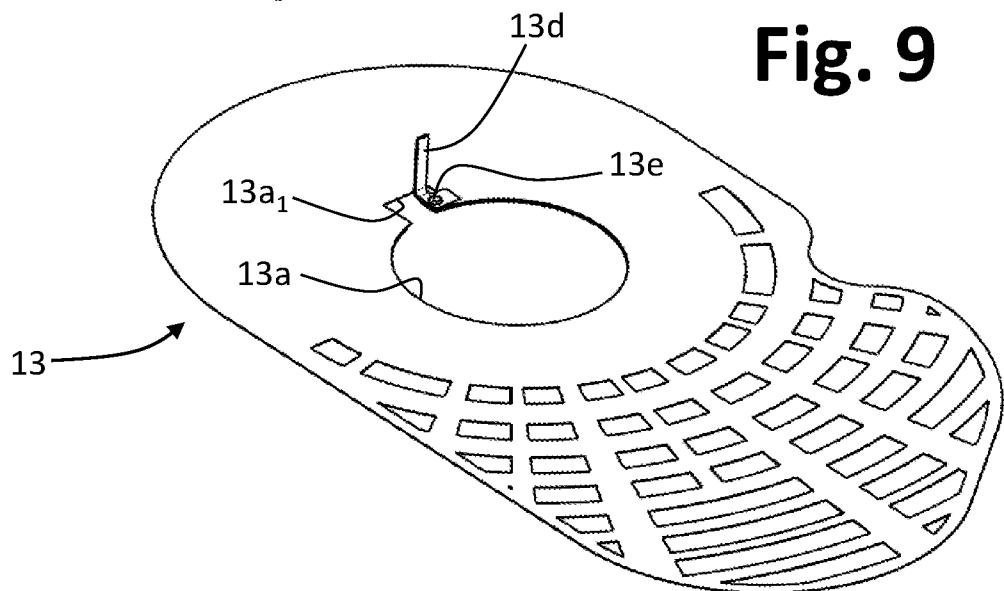
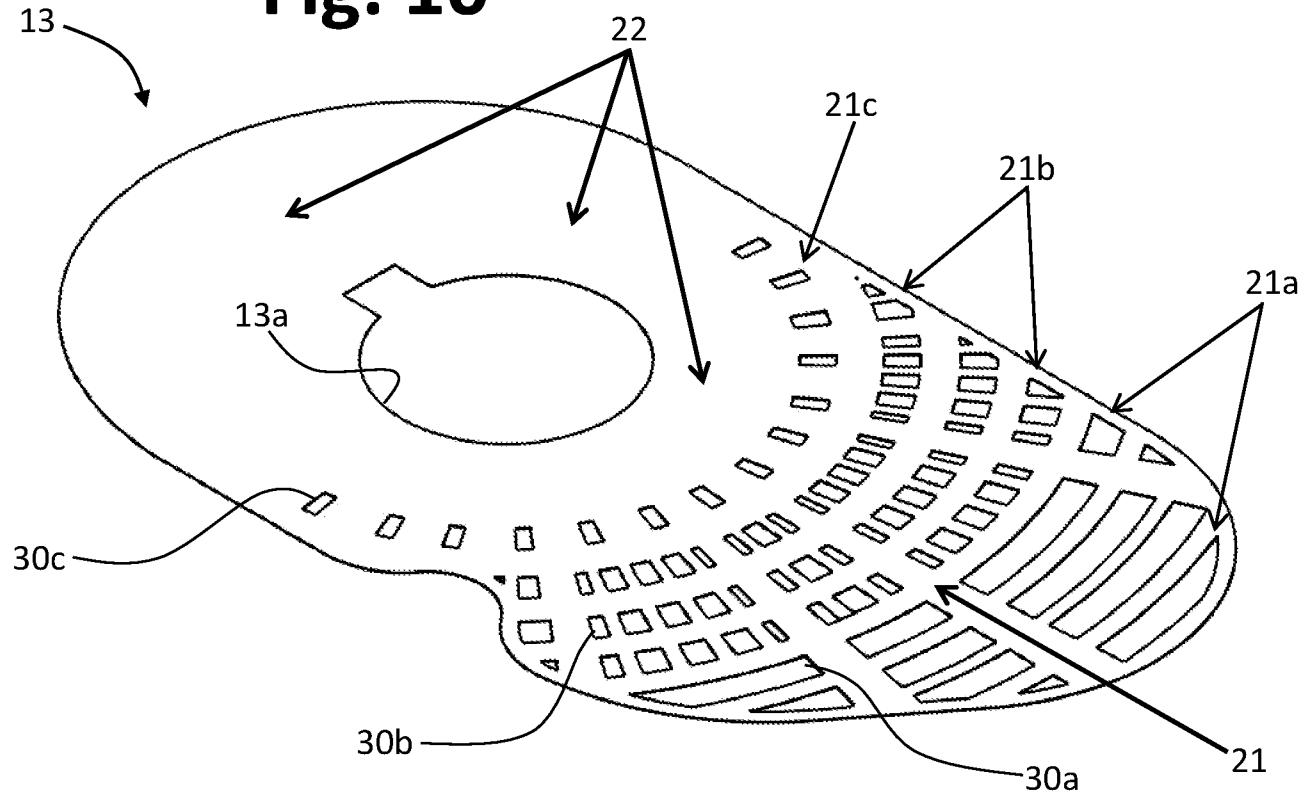


Fig. 8**Fig. 9****Fig. 10**

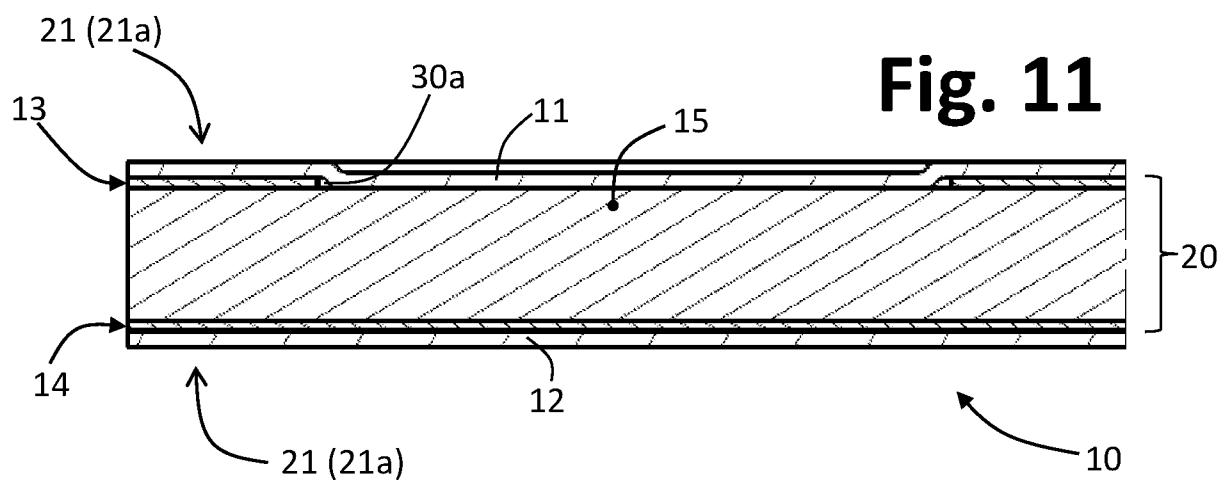
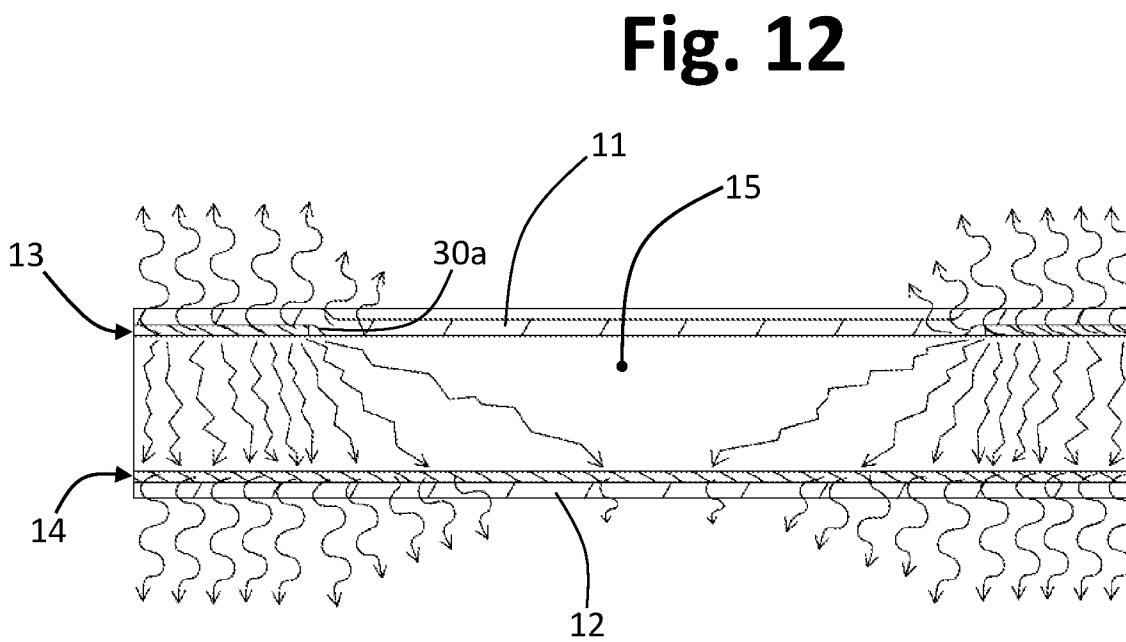
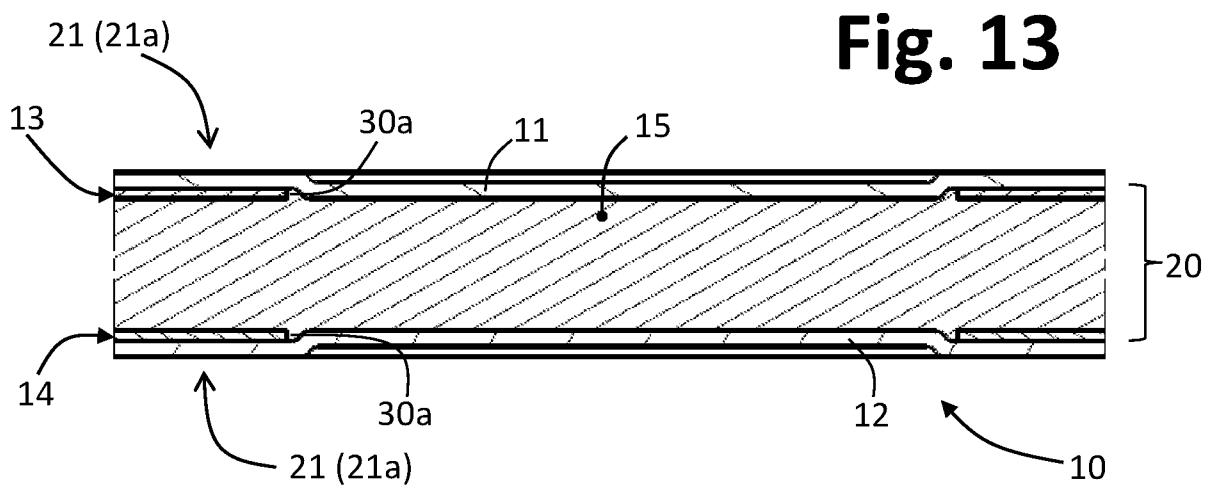
**Fig. 11****Fig. 12****Fig. 13**

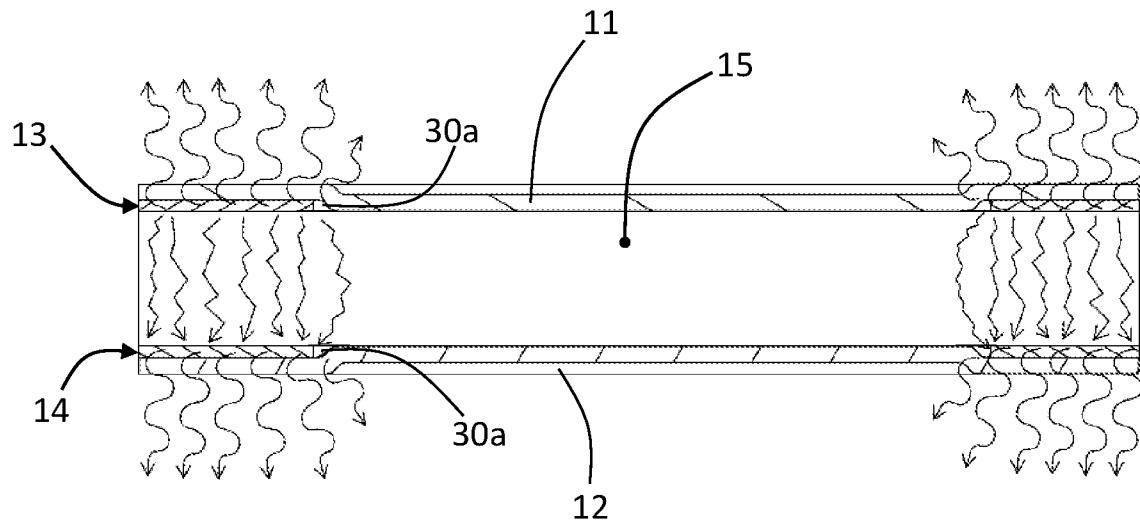
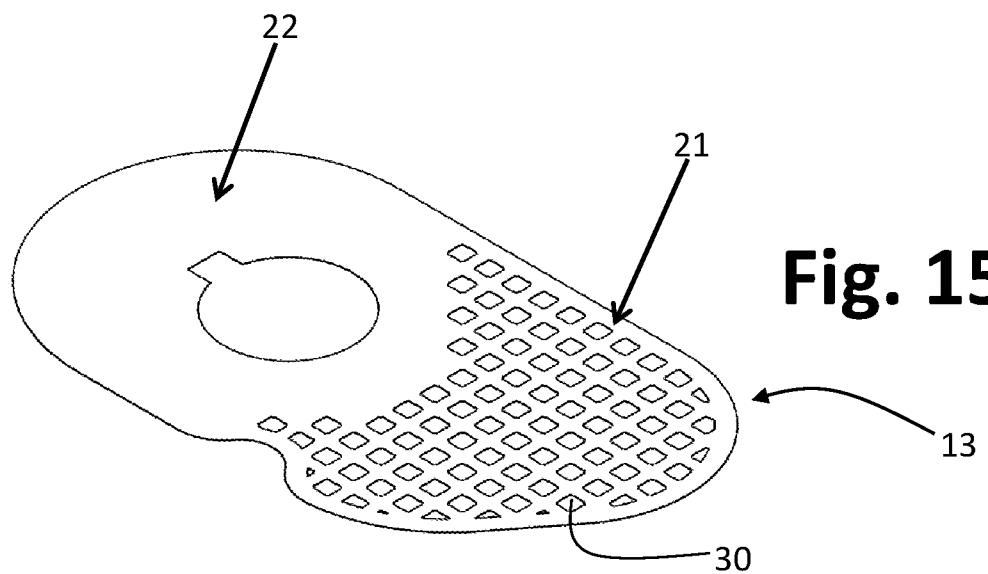
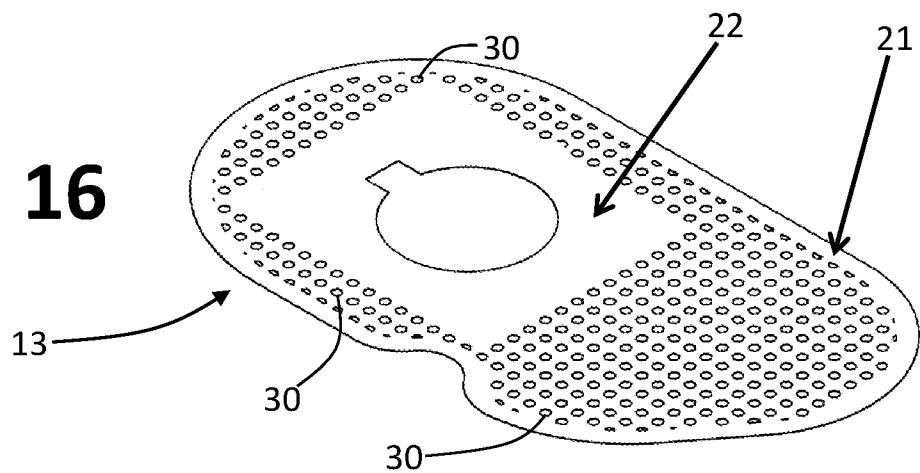
Fig. 14**Fig. 15****Fig. 16**

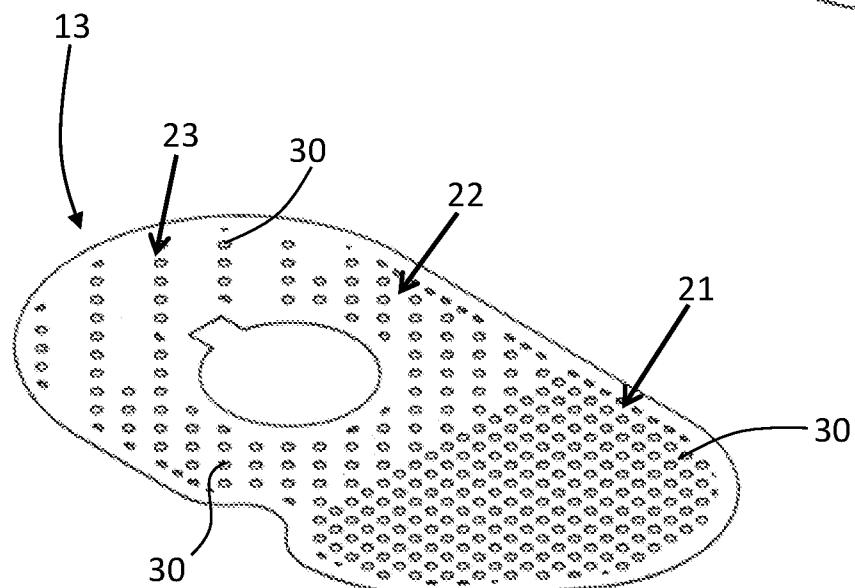
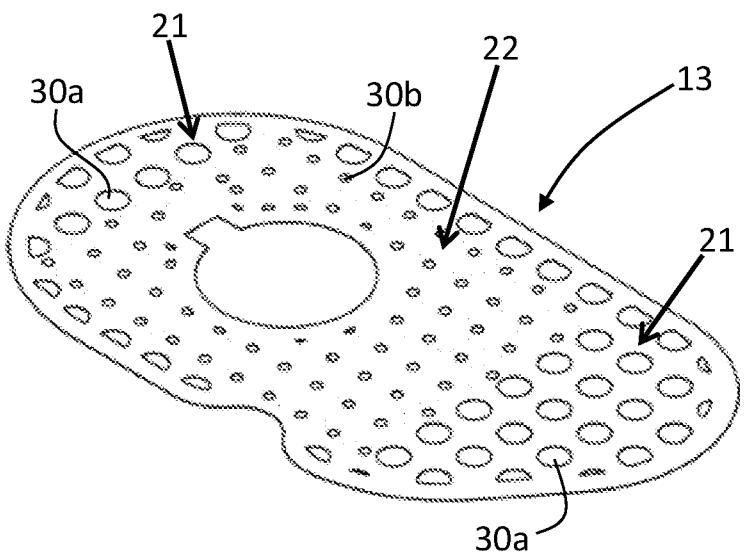
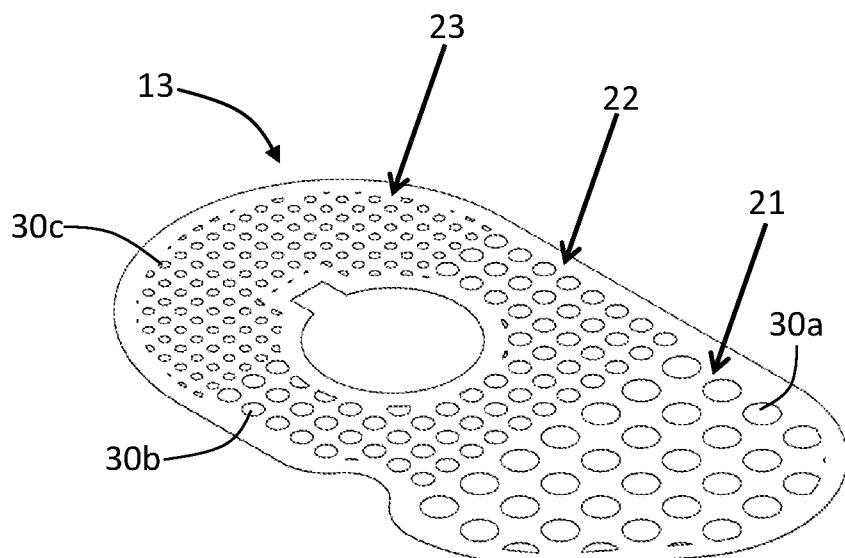
Fig. 17**Fig. 18****Fig. 19**

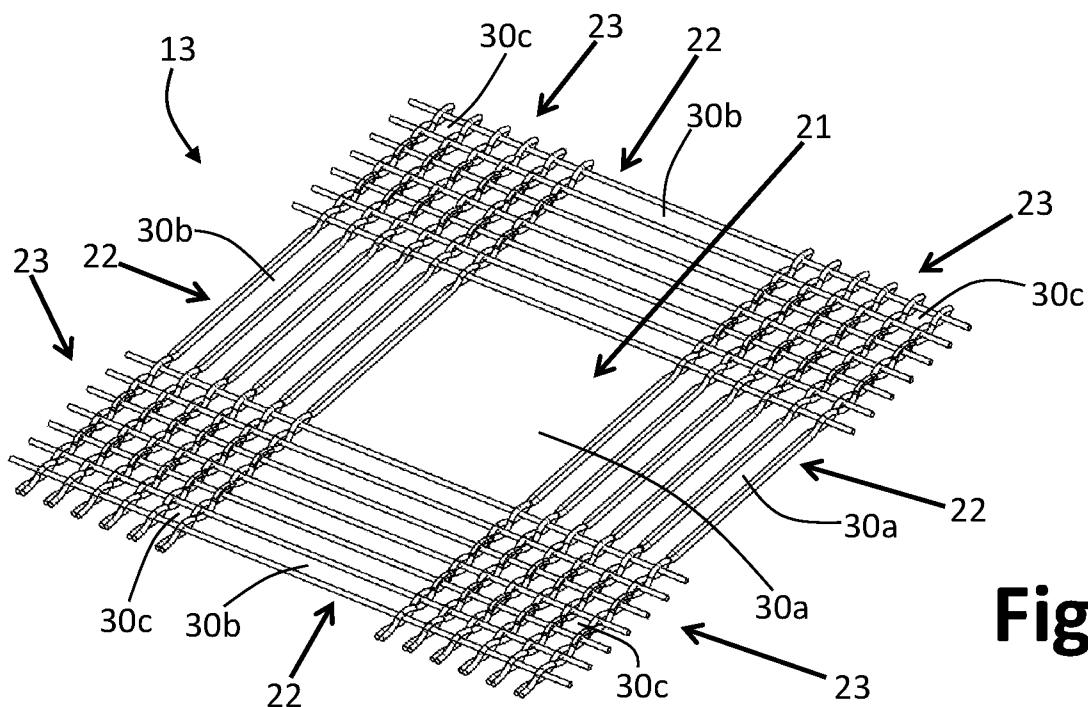
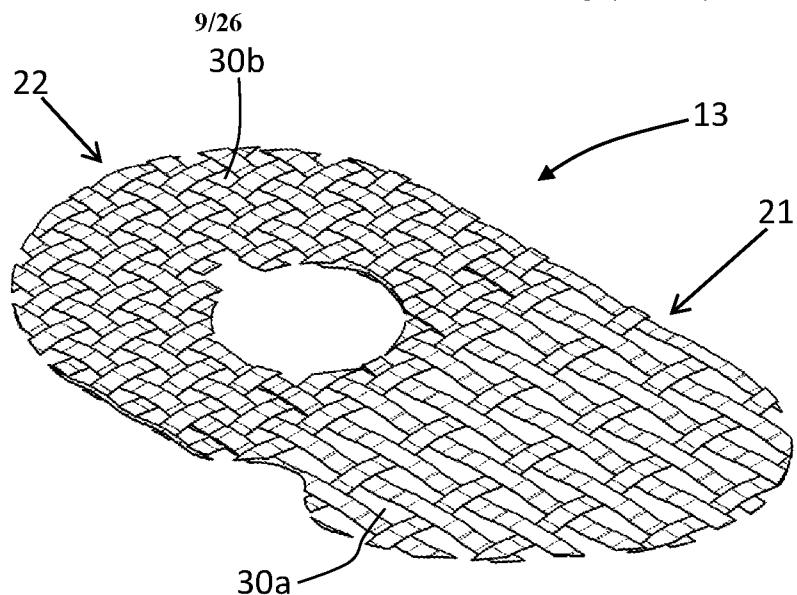
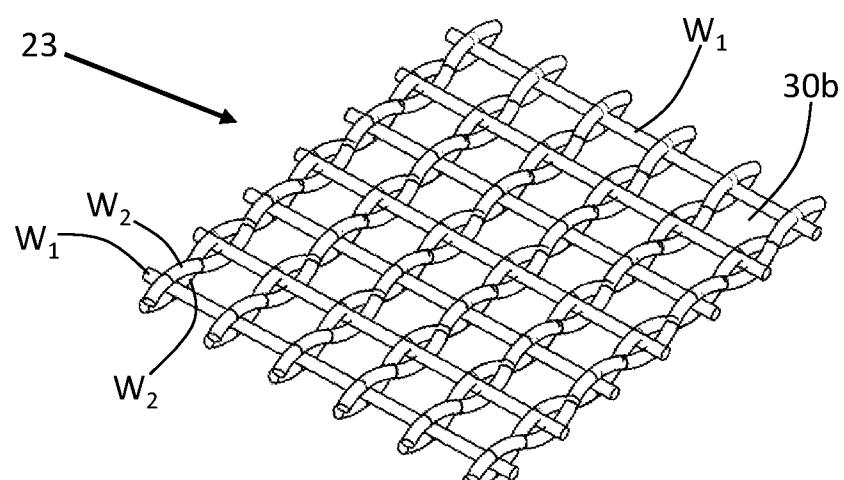
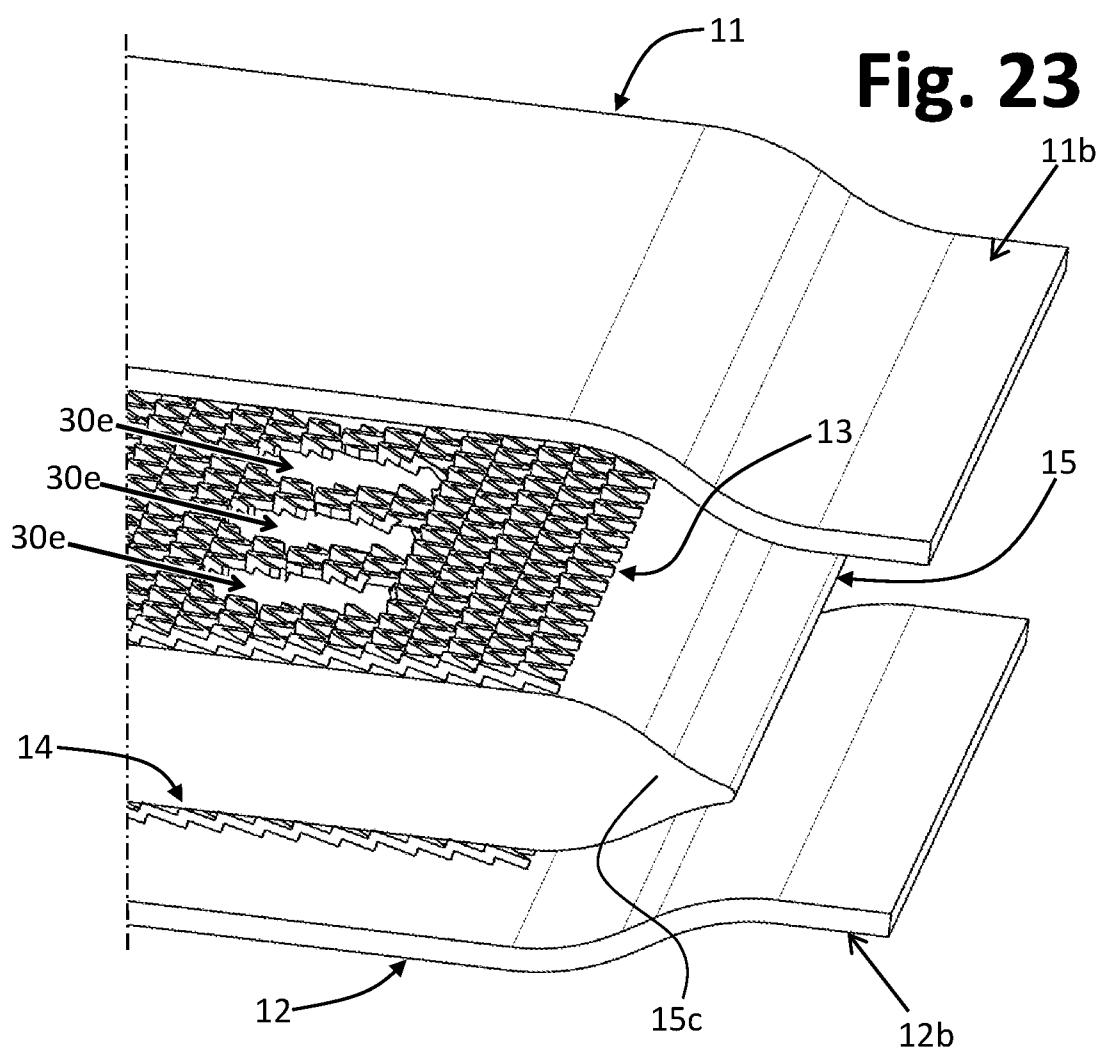
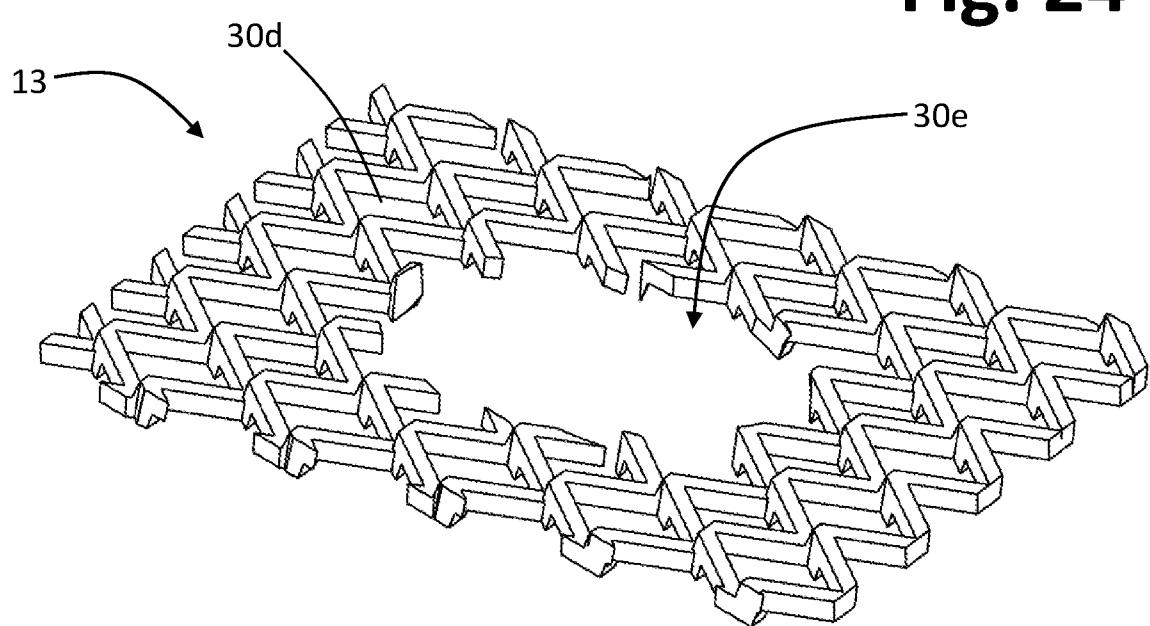
Fig. 20**Fig. 21****Fig. 22**

Fig. 23**Fig. 24**

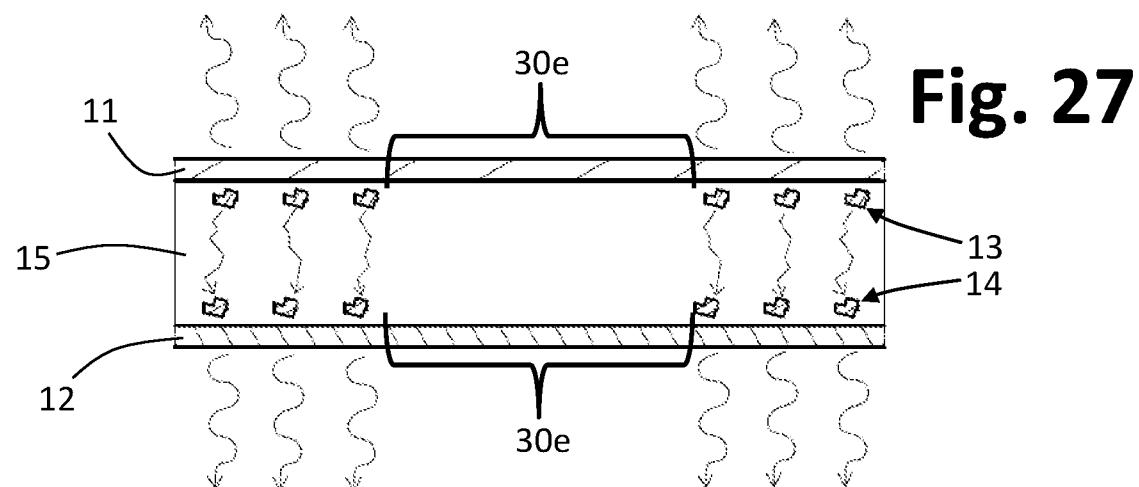
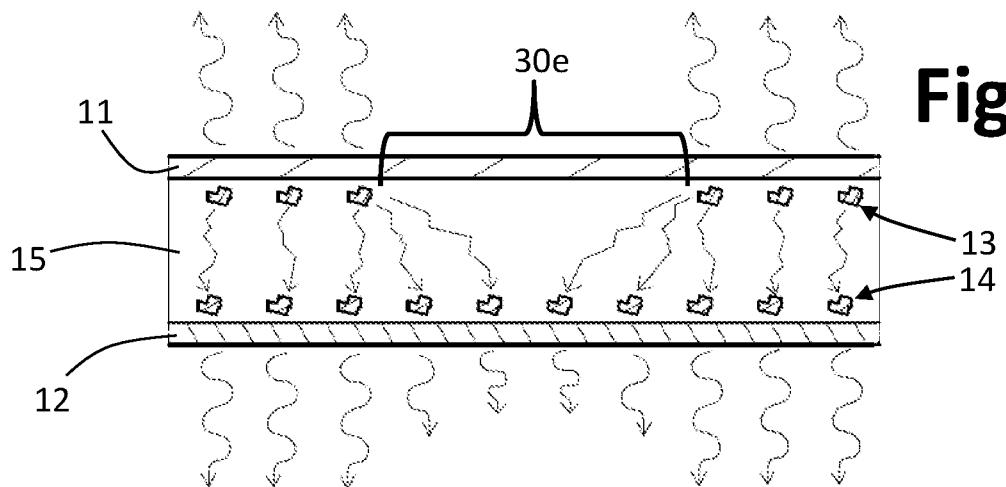
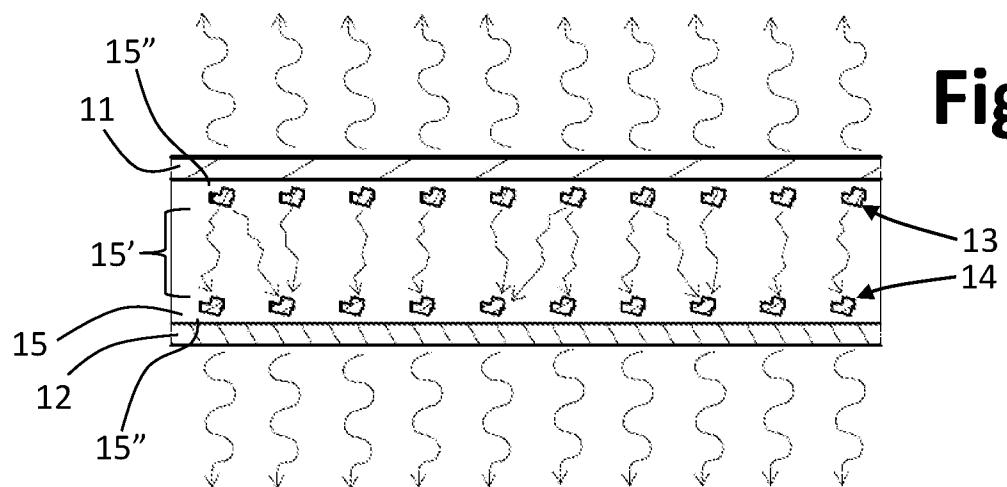


Fig. 28

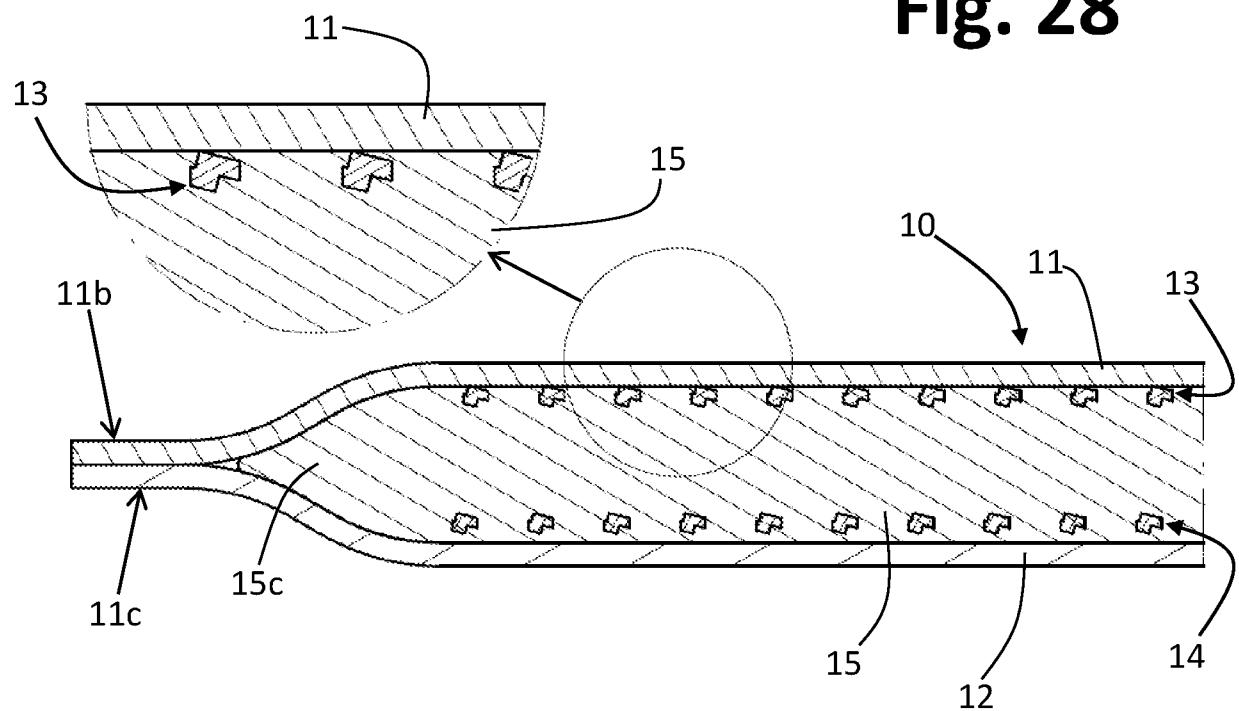


Fig. 29

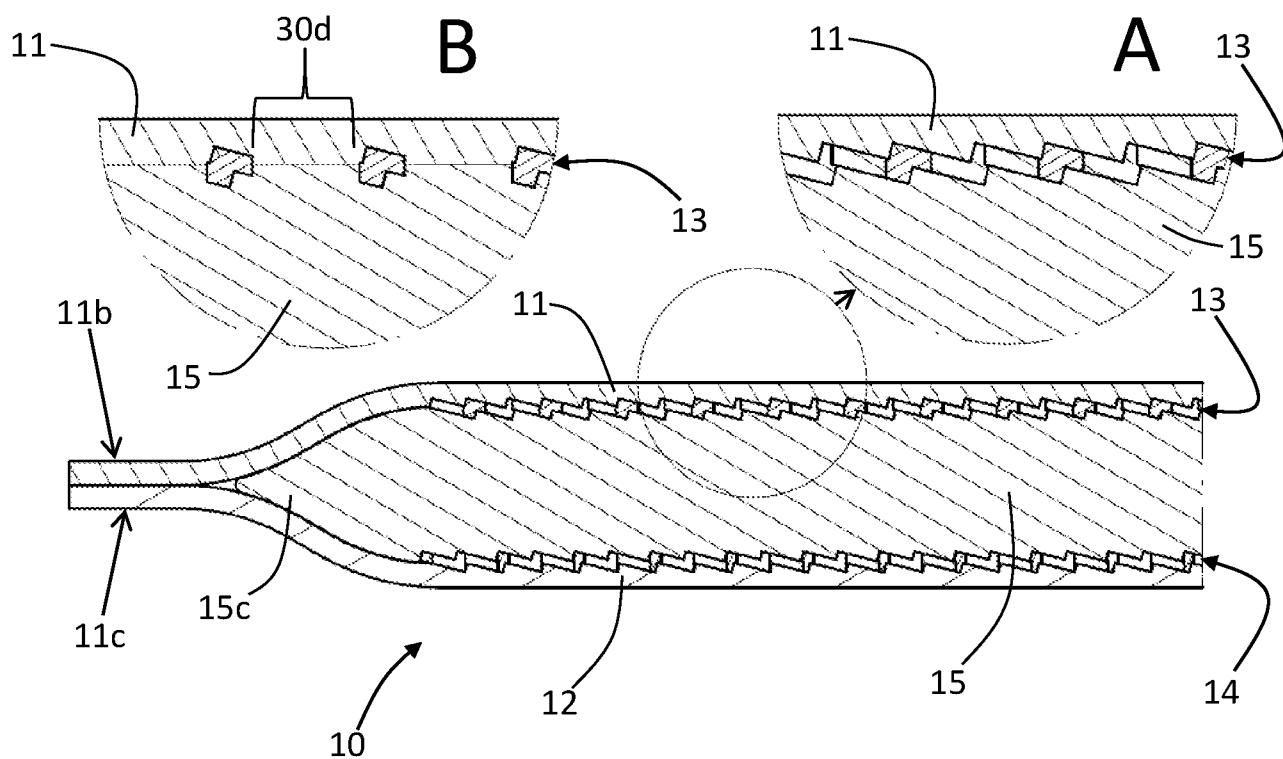
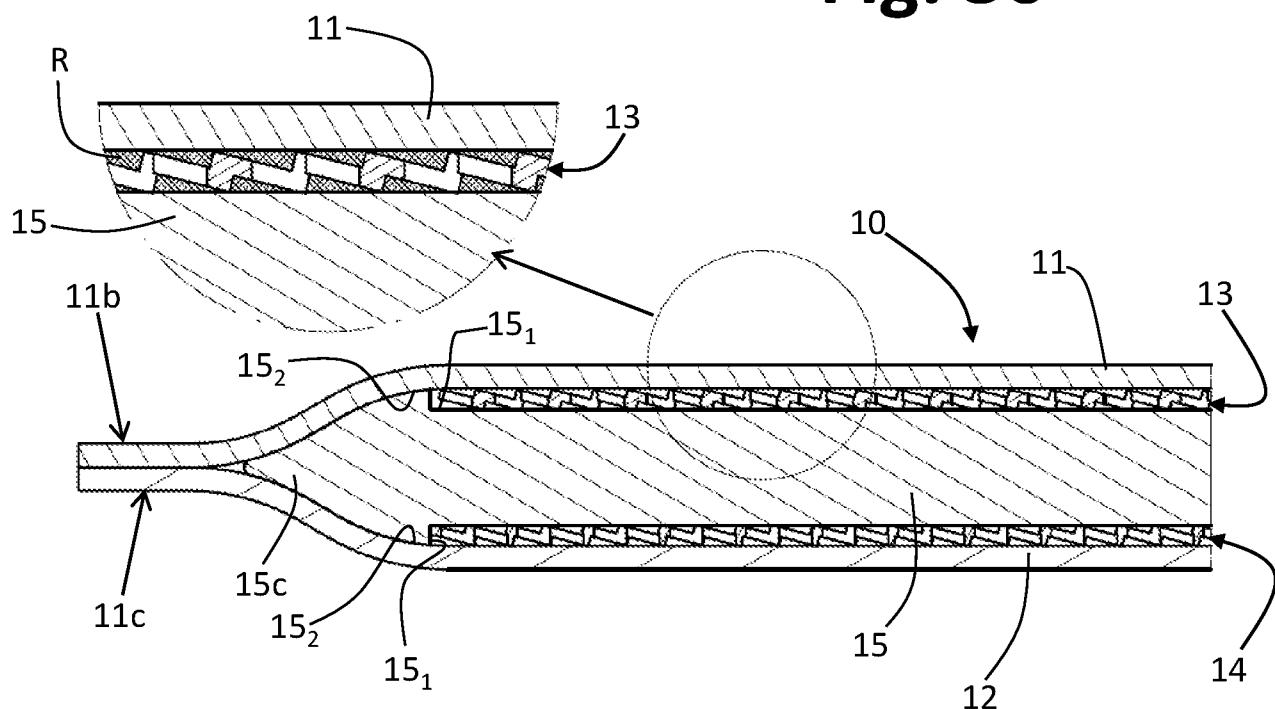
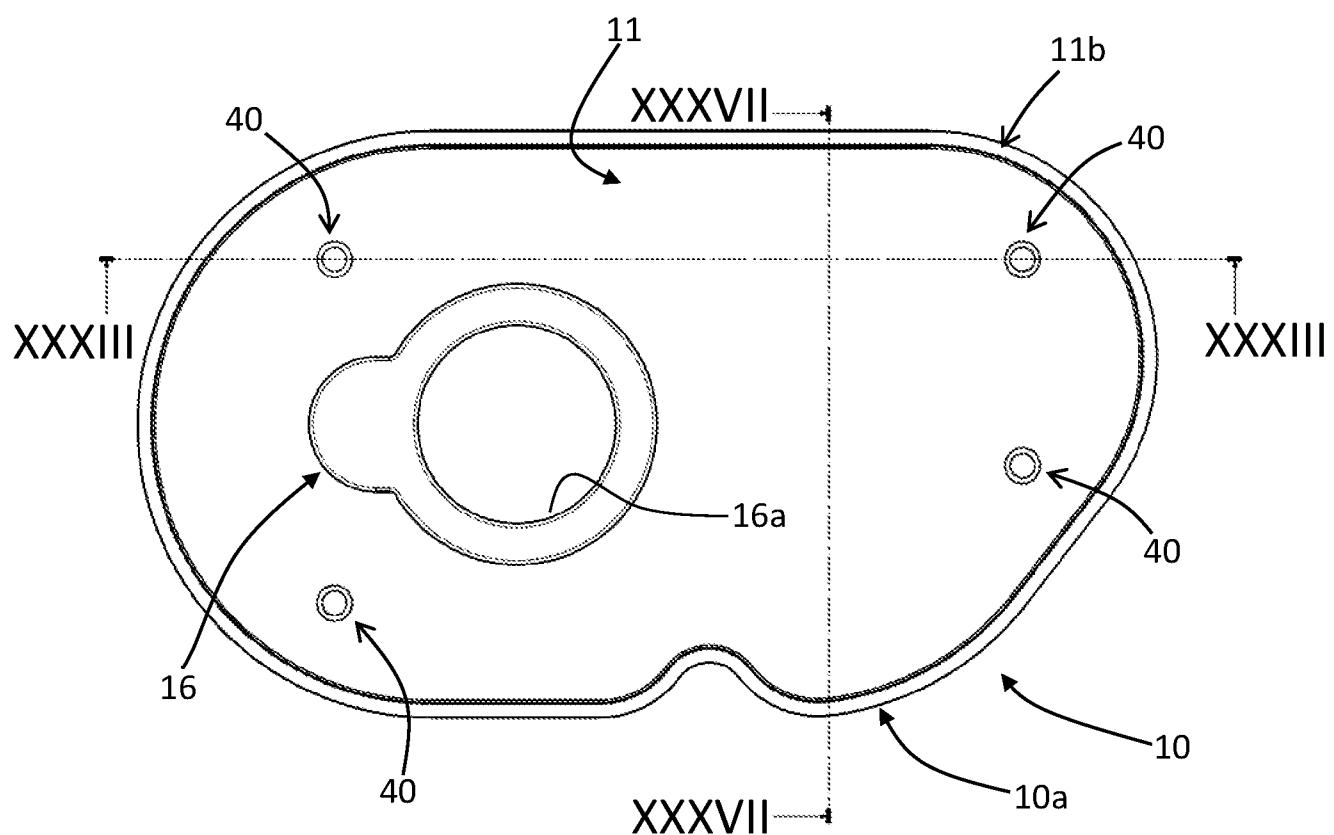
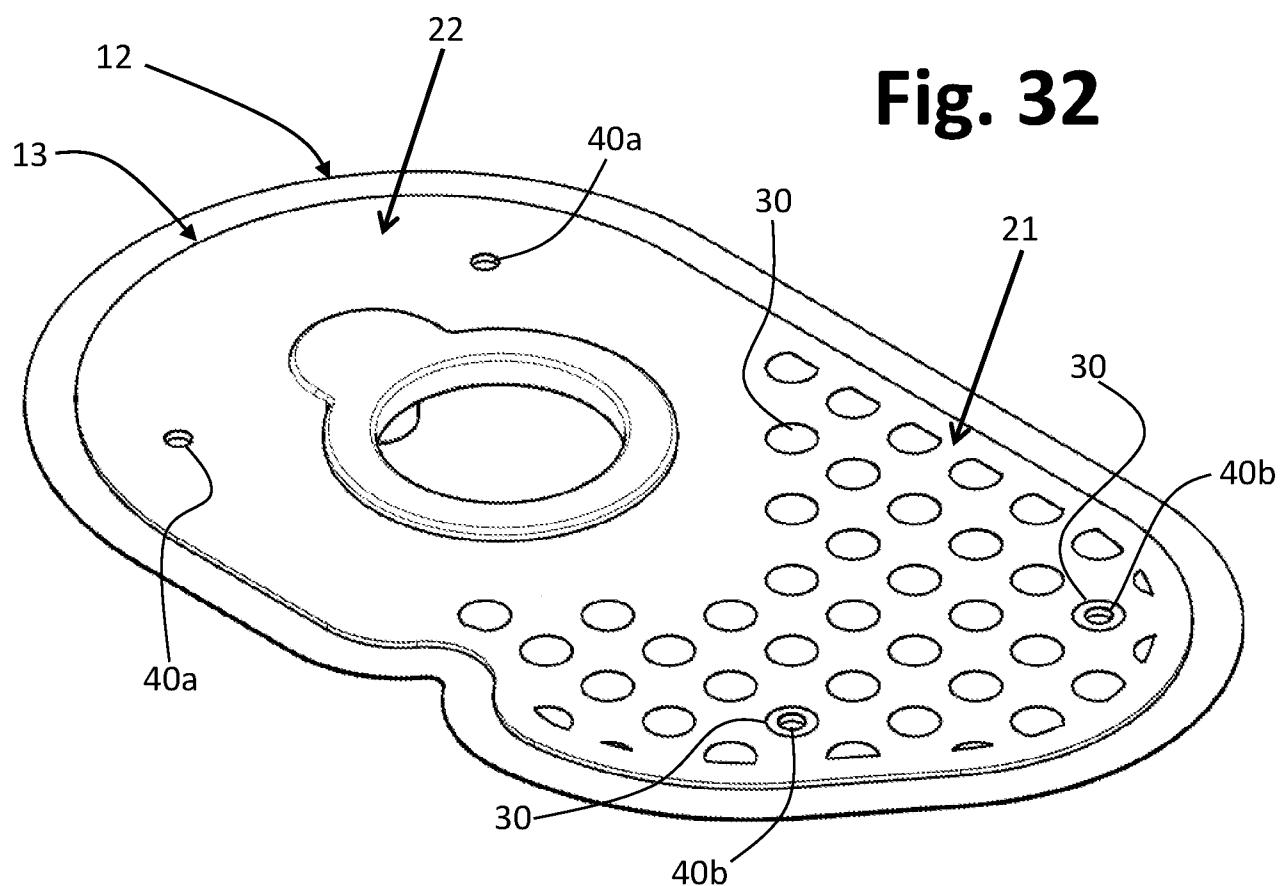
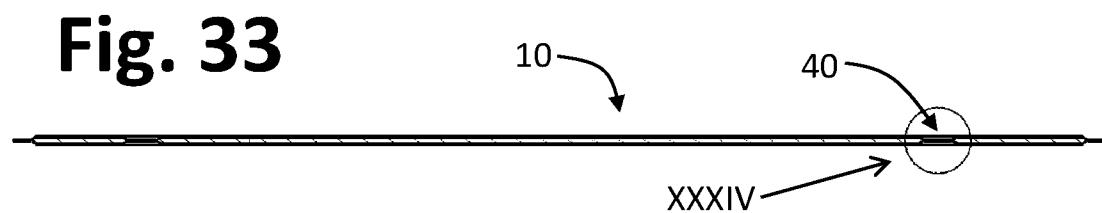
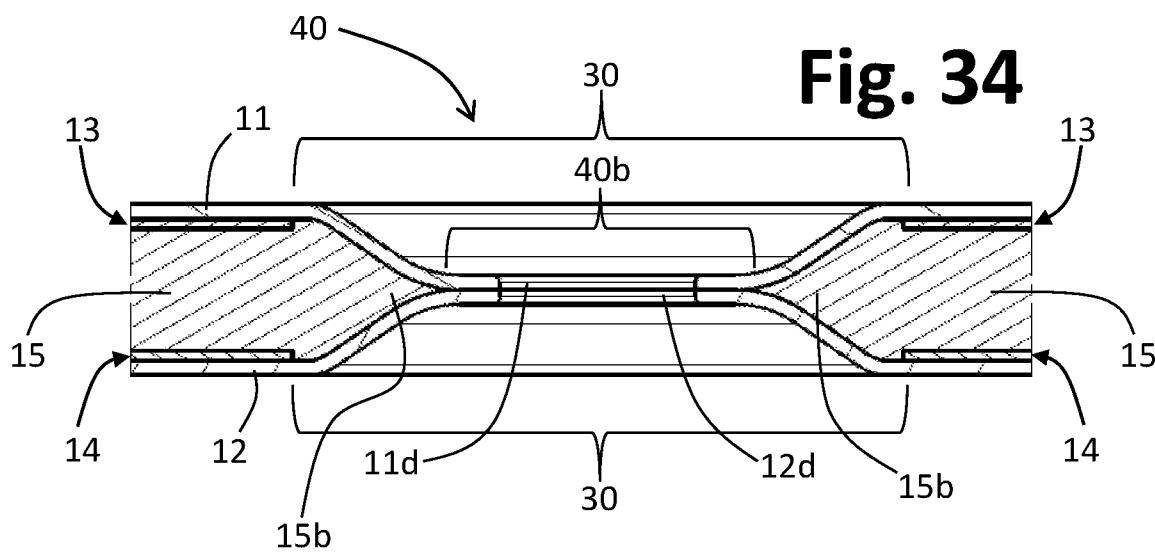
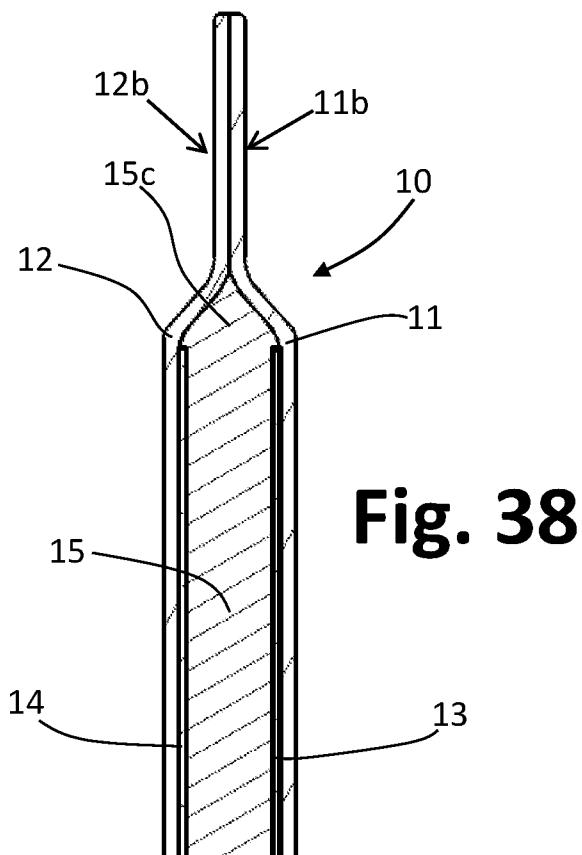
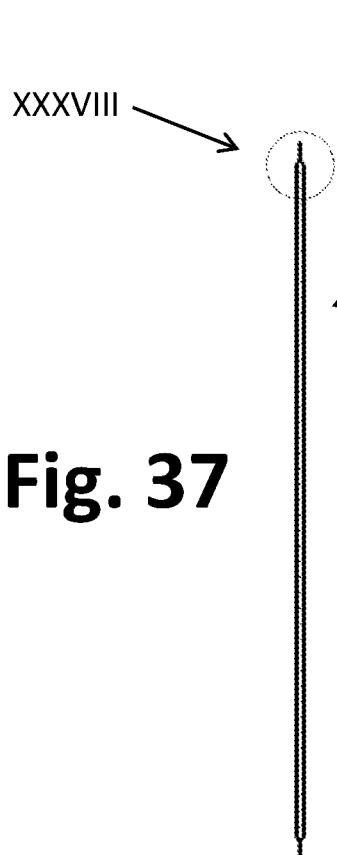
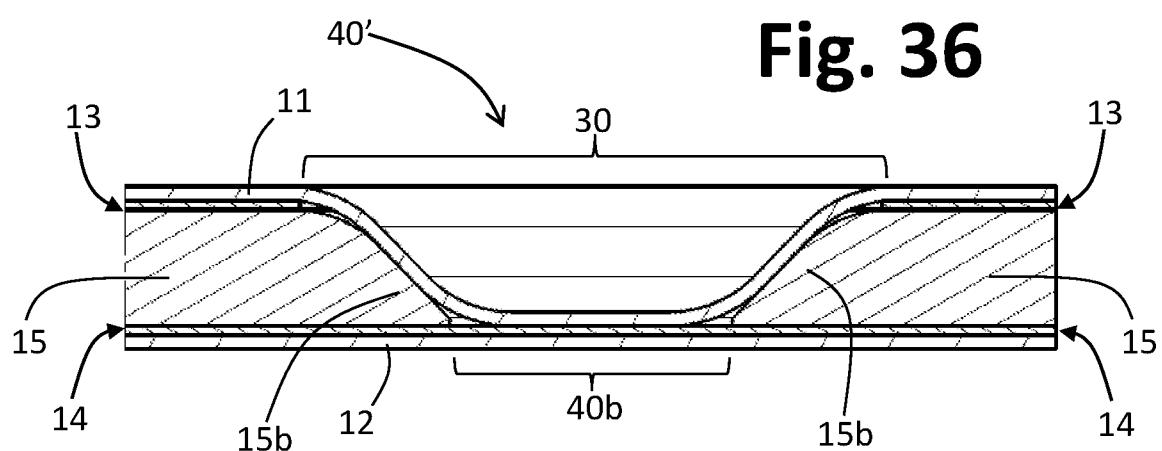
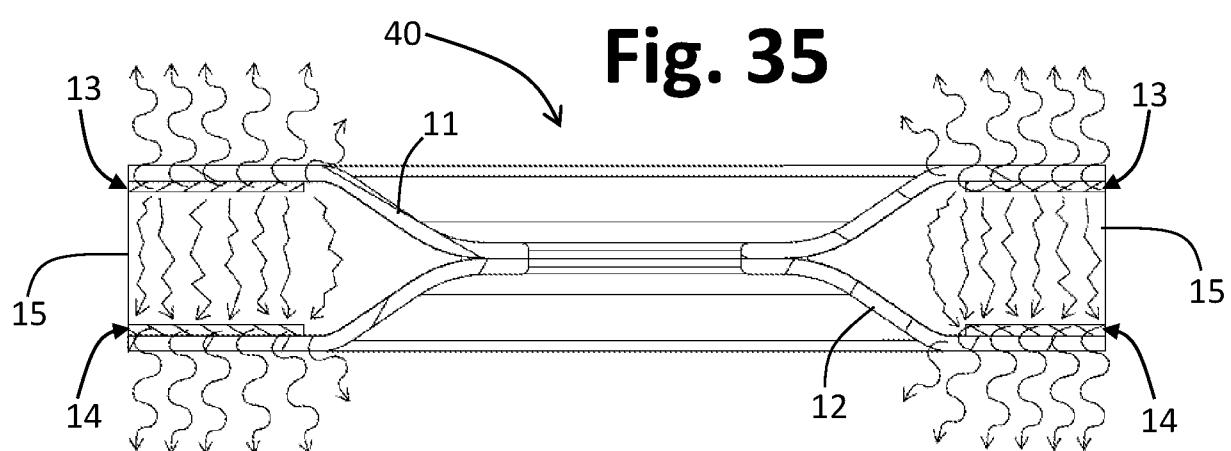


Fig. 30**Fig. 31**

**Fig. 32****Fig. 33****Fig. 34**



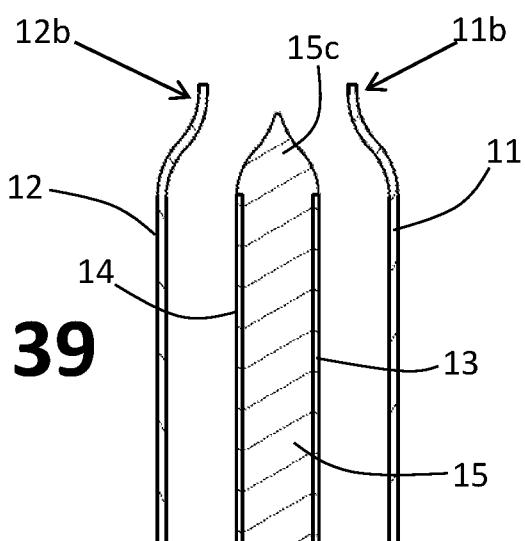
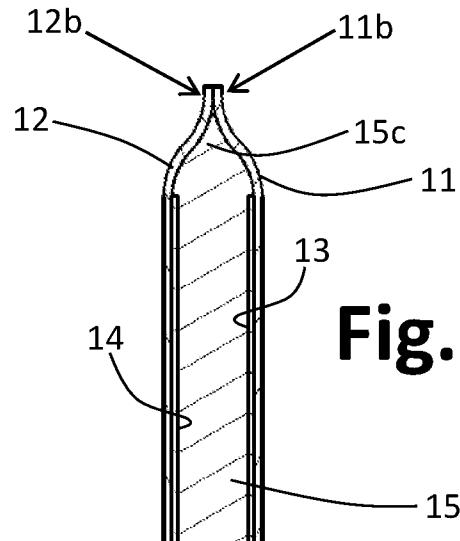
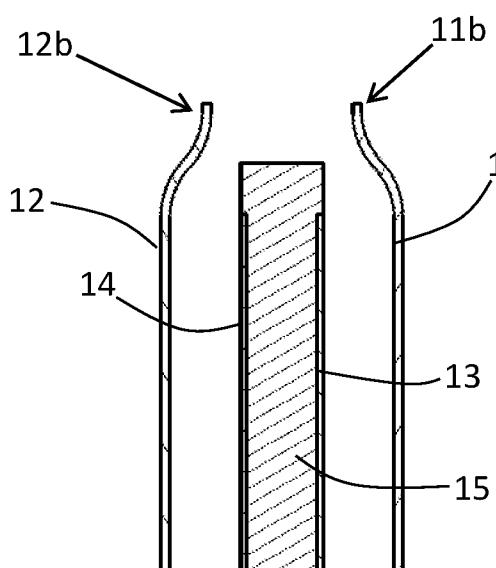
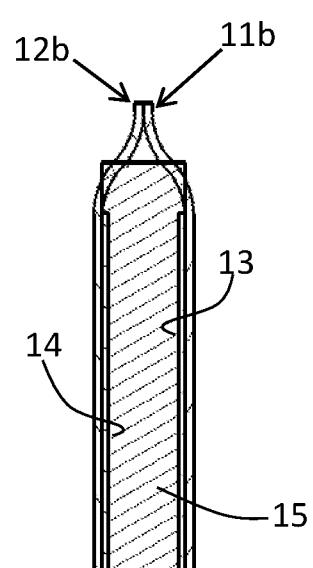
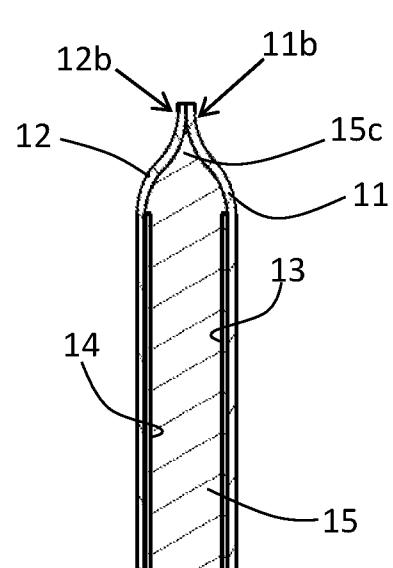
**Fig. 39****Fig. 40****Fig. 41****Fig. 42****Fig. 43**

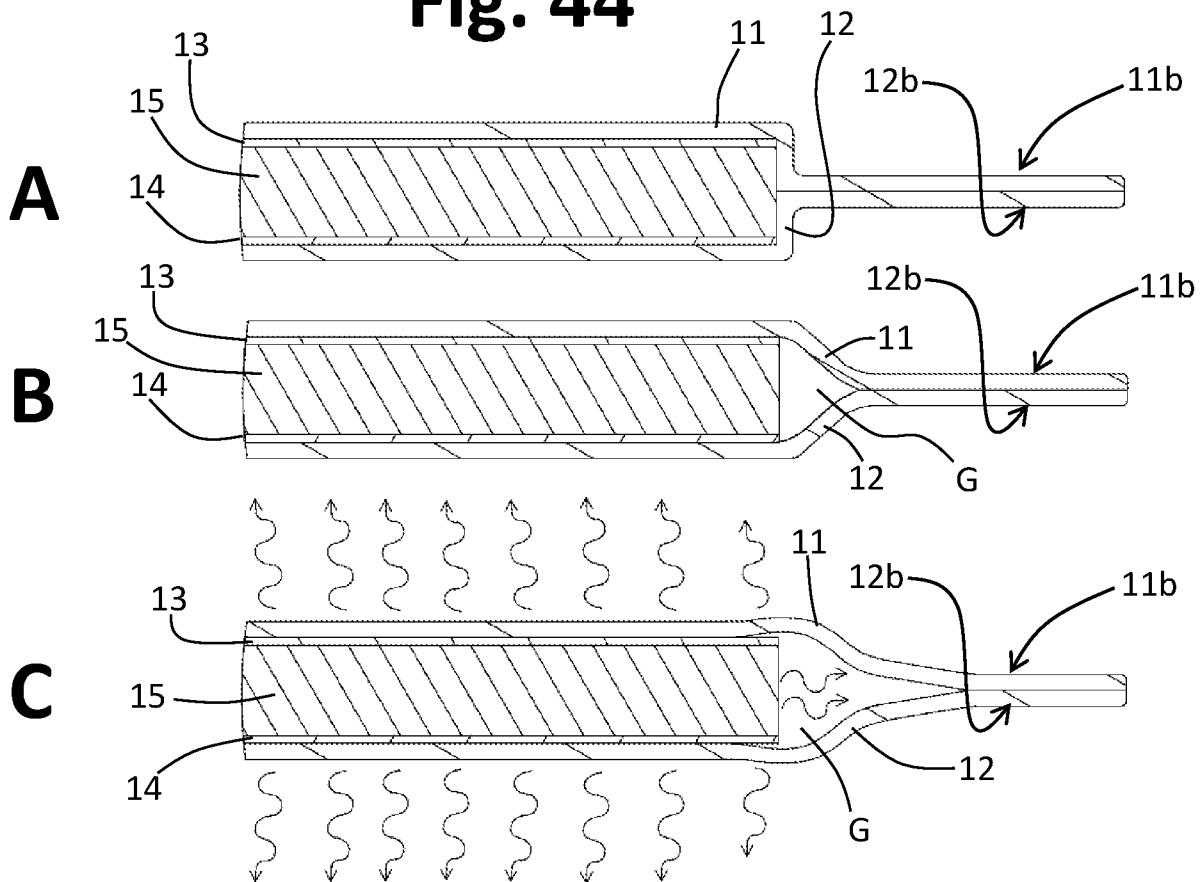
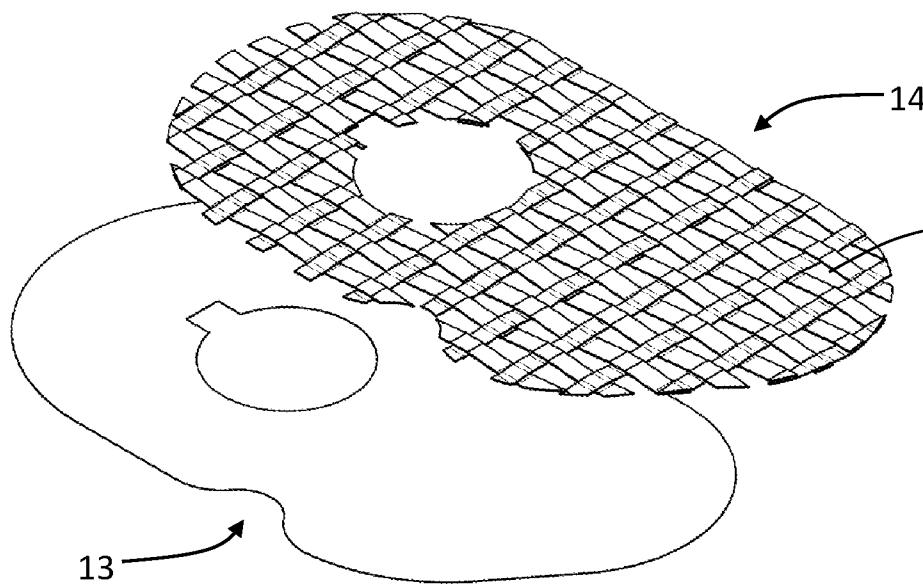
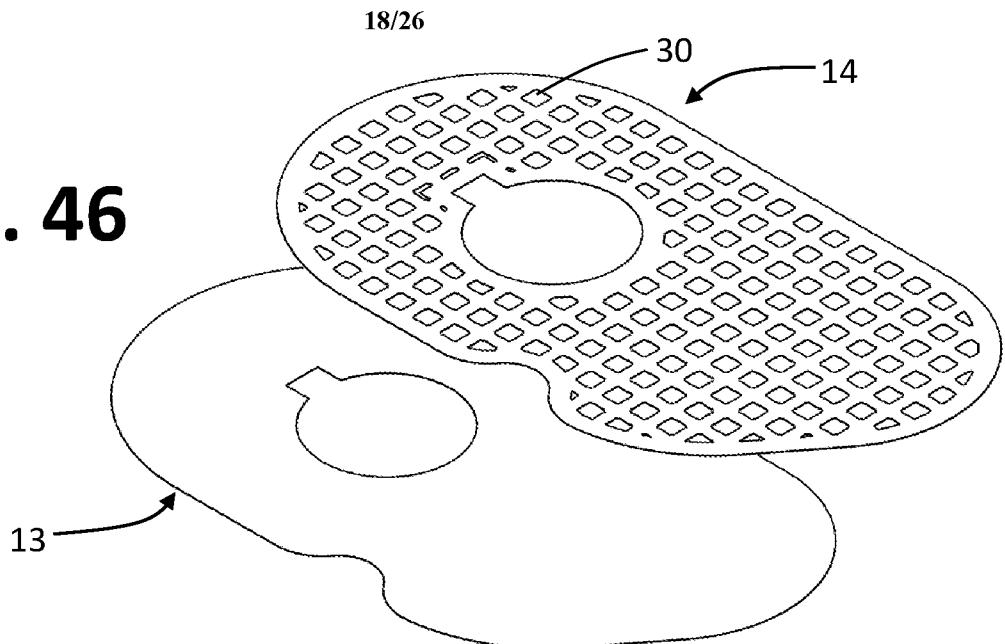
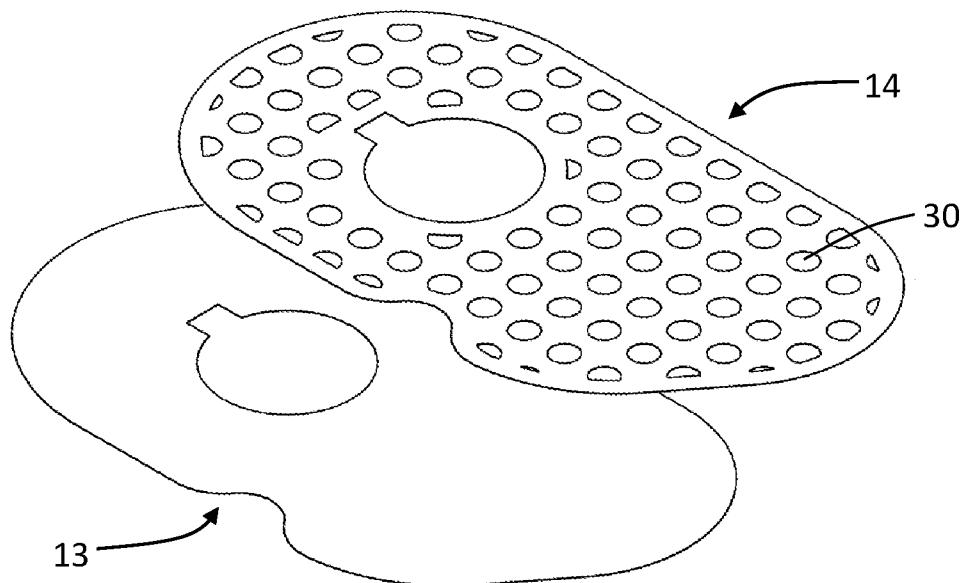
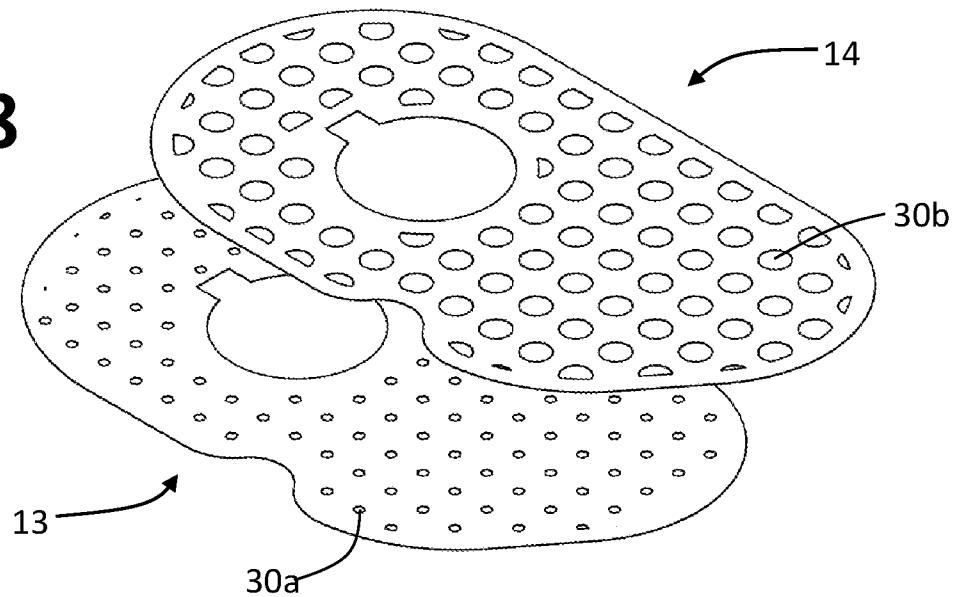
Fig. 44**Fig. 45**

Fig. 46**Fig. 47****Fig. 48**

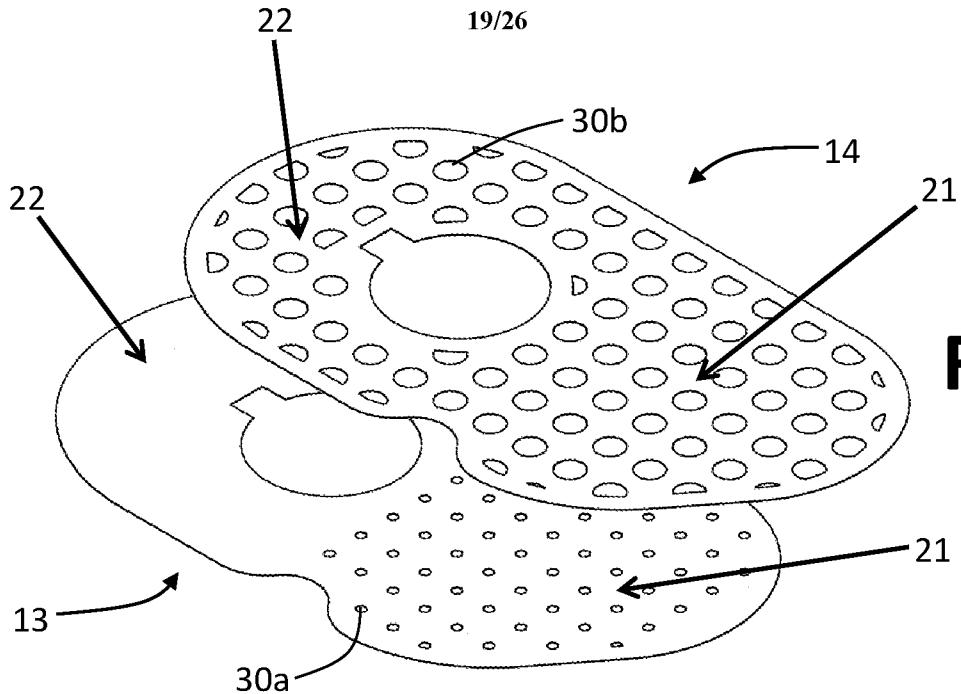
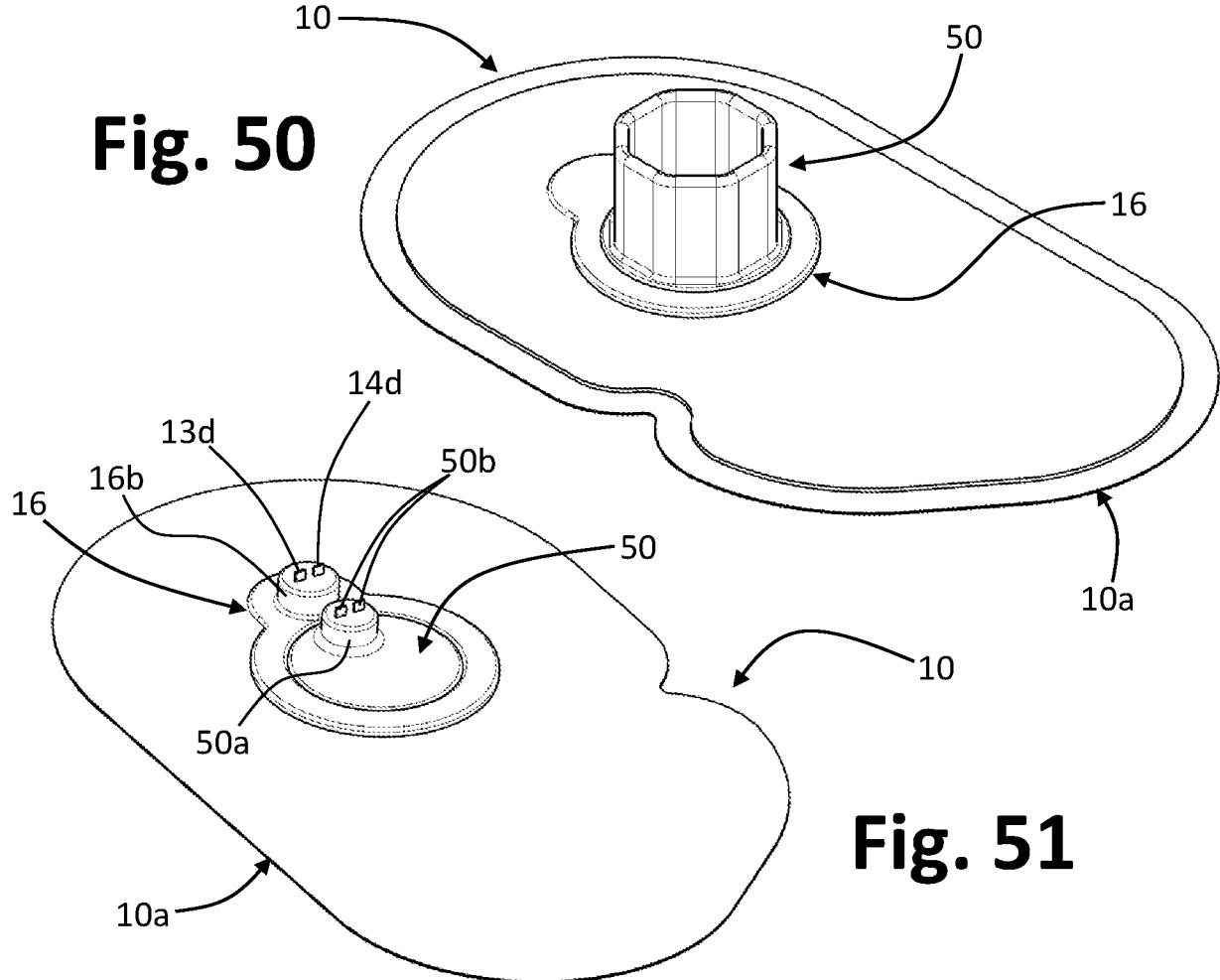
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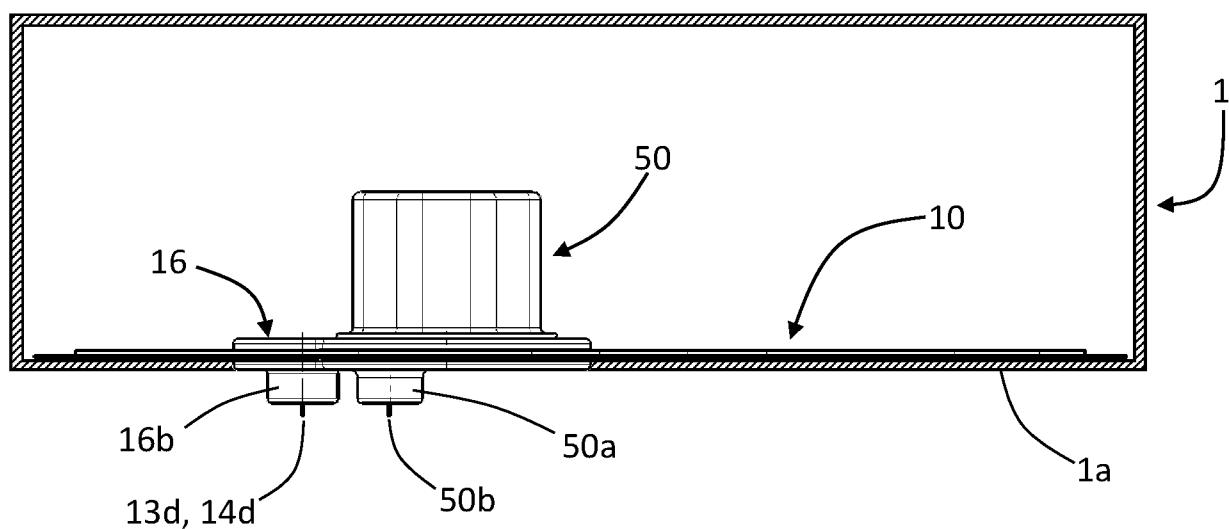
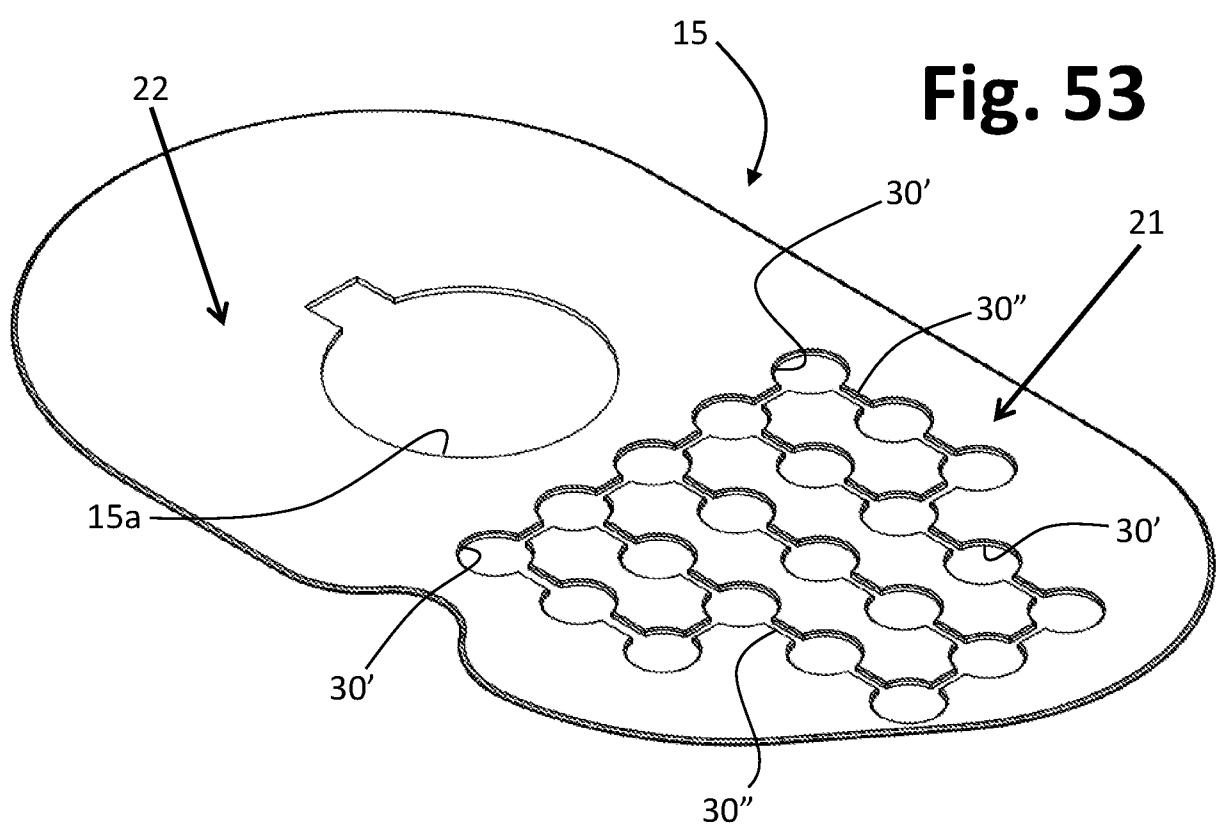
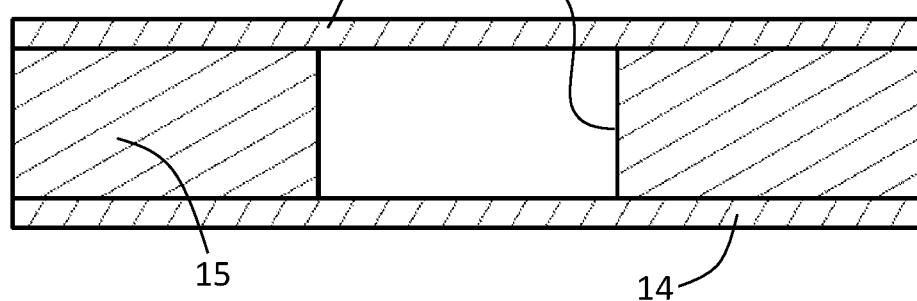
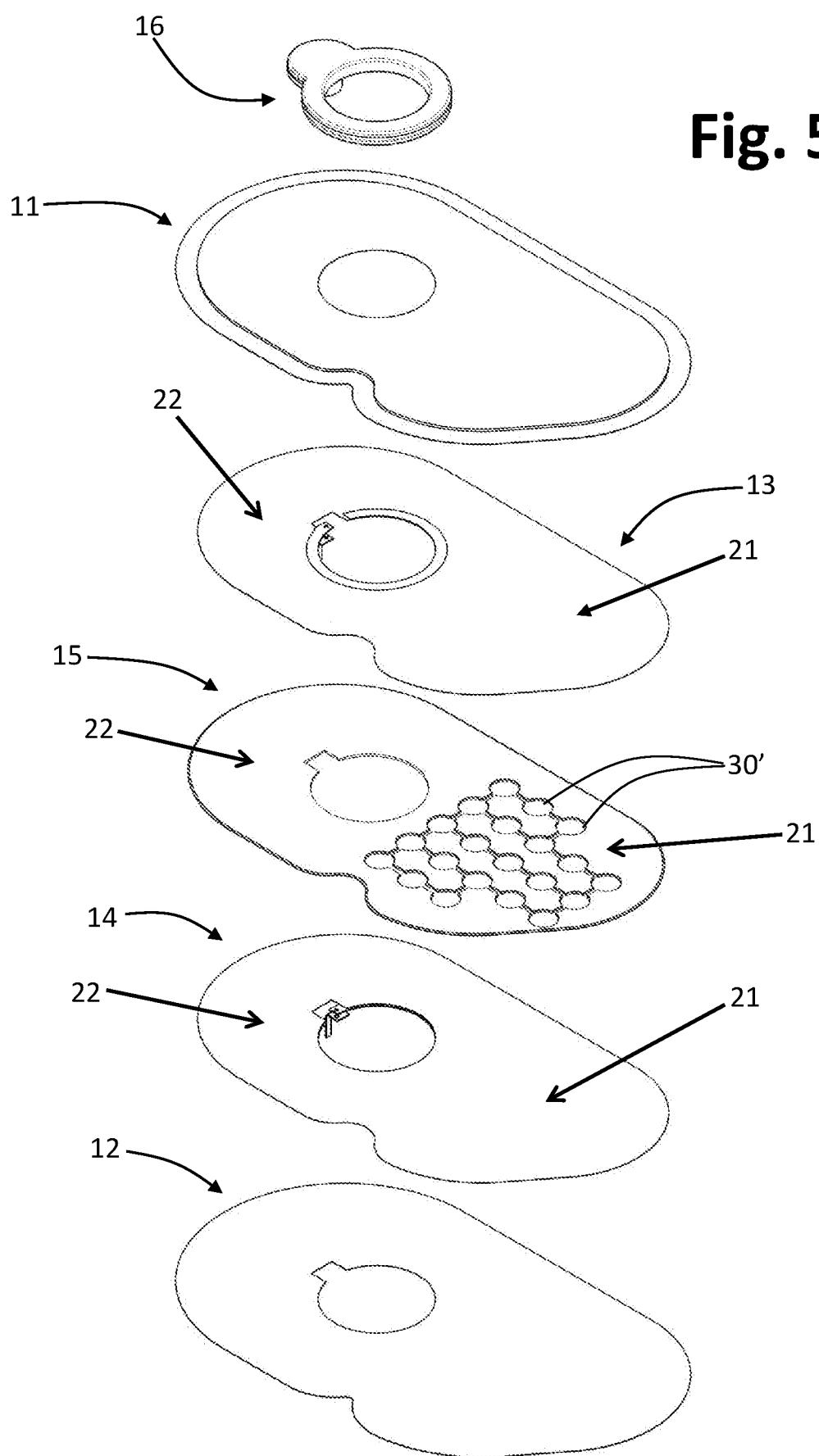
Fig. 52**Fig. 53****Fig. 54**

Fig. 55

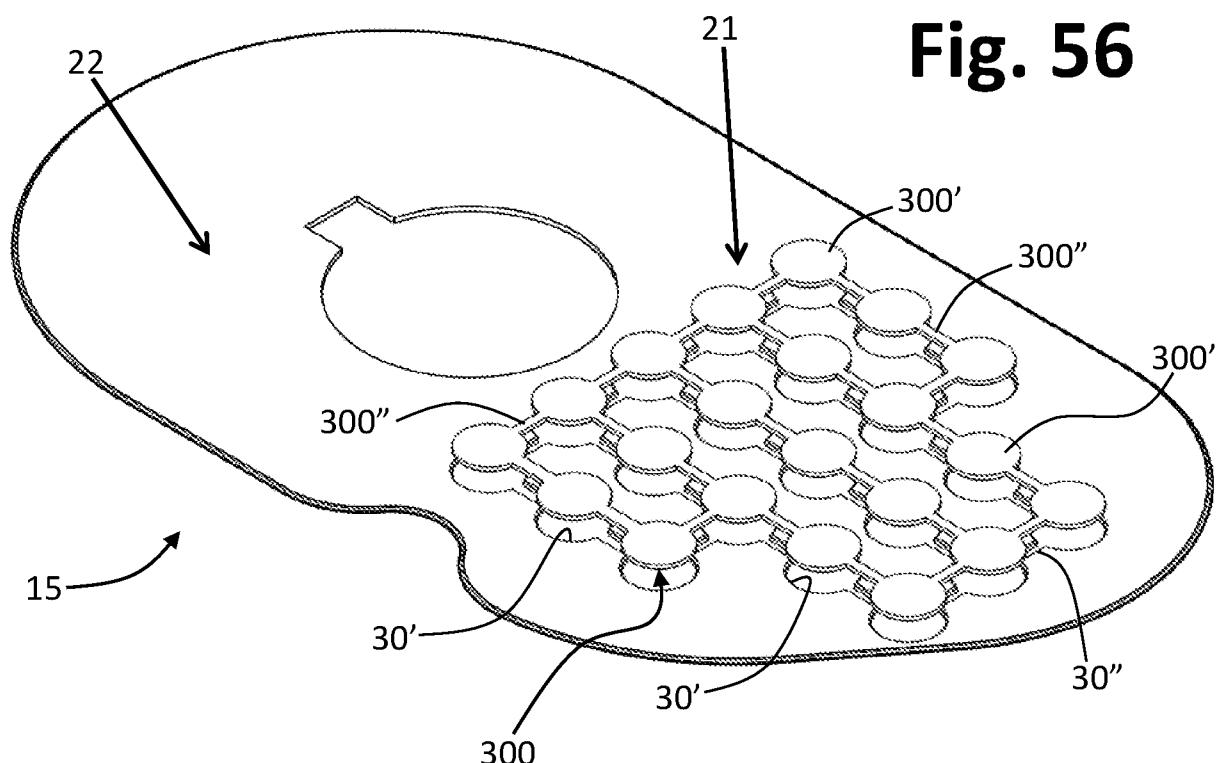
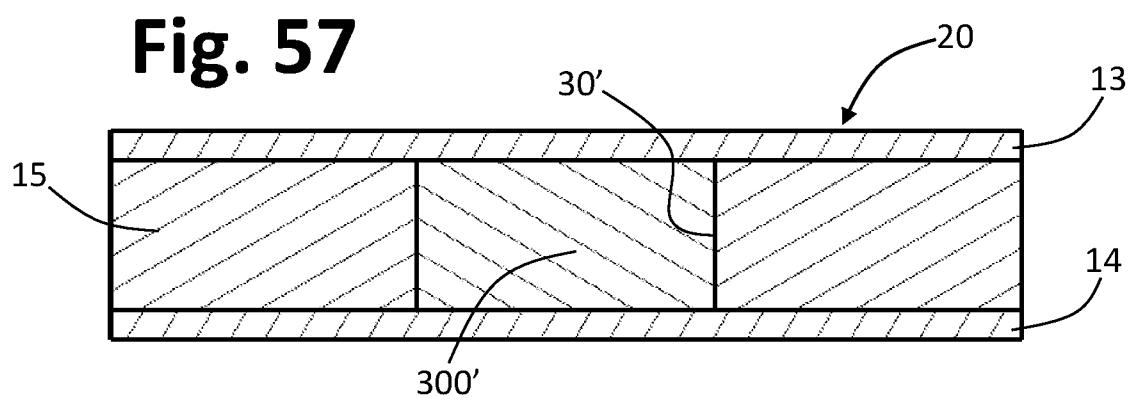
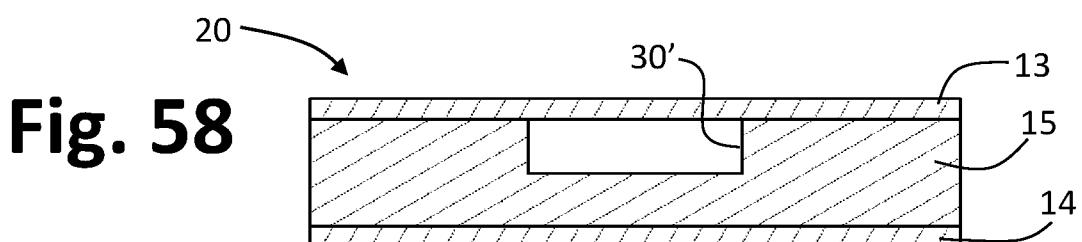
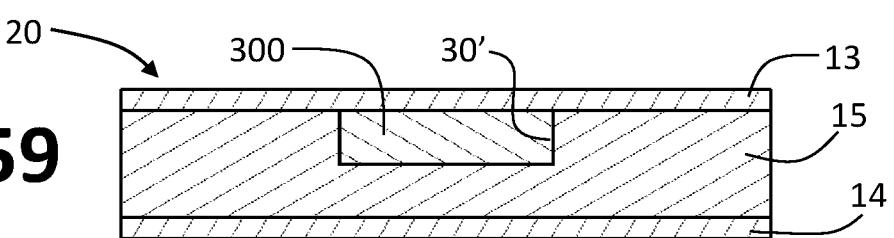
**Fig. 56****Fig. 57****Fig. 58****Fig. 59**

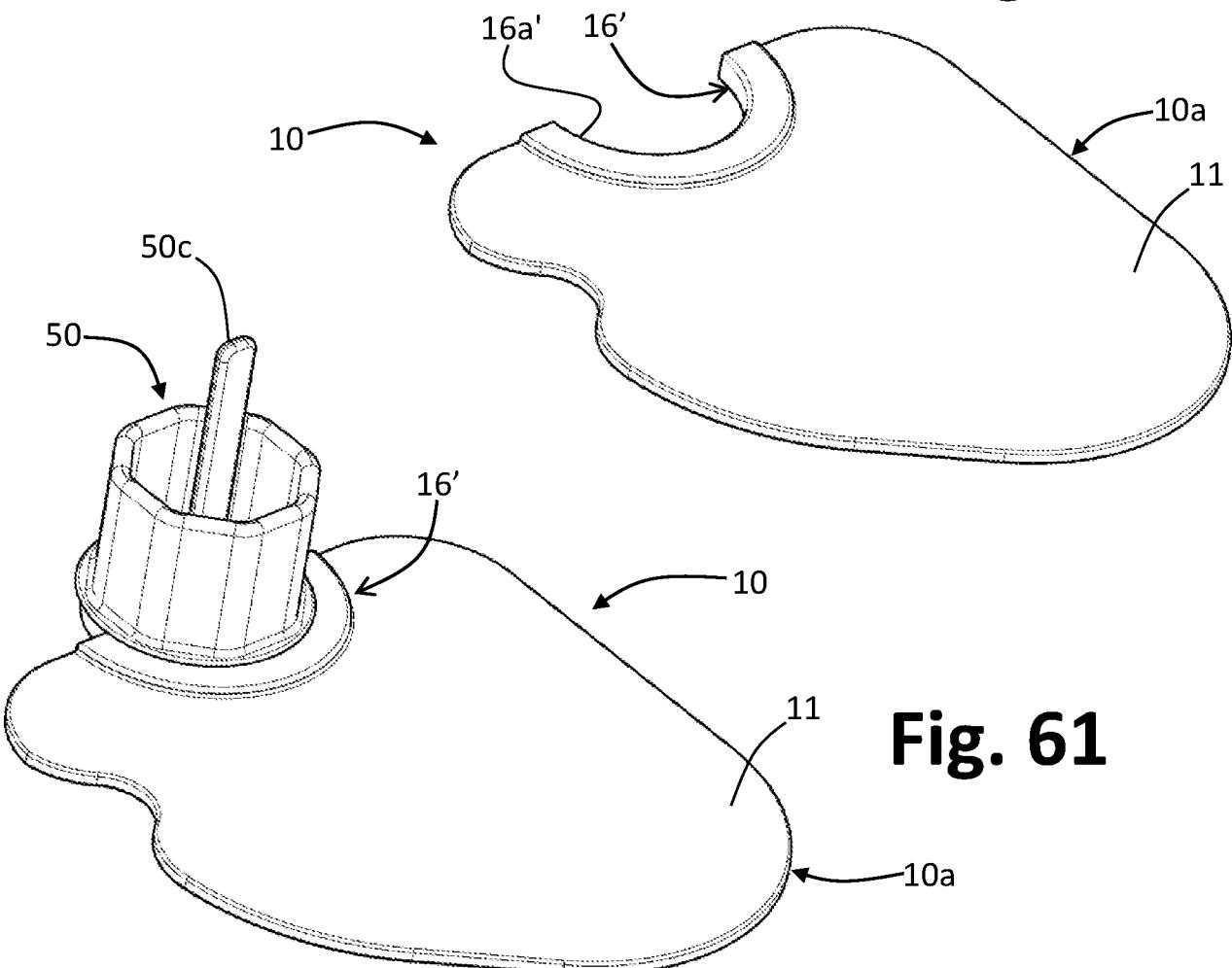
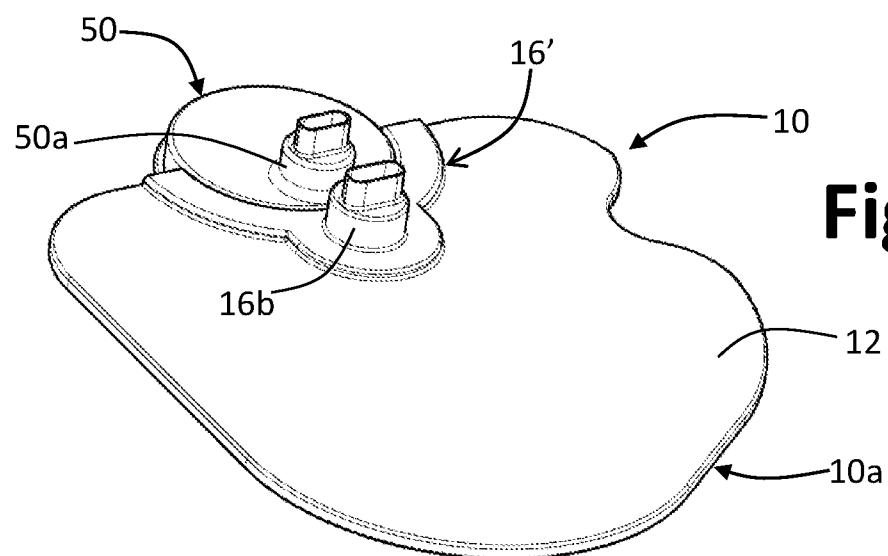
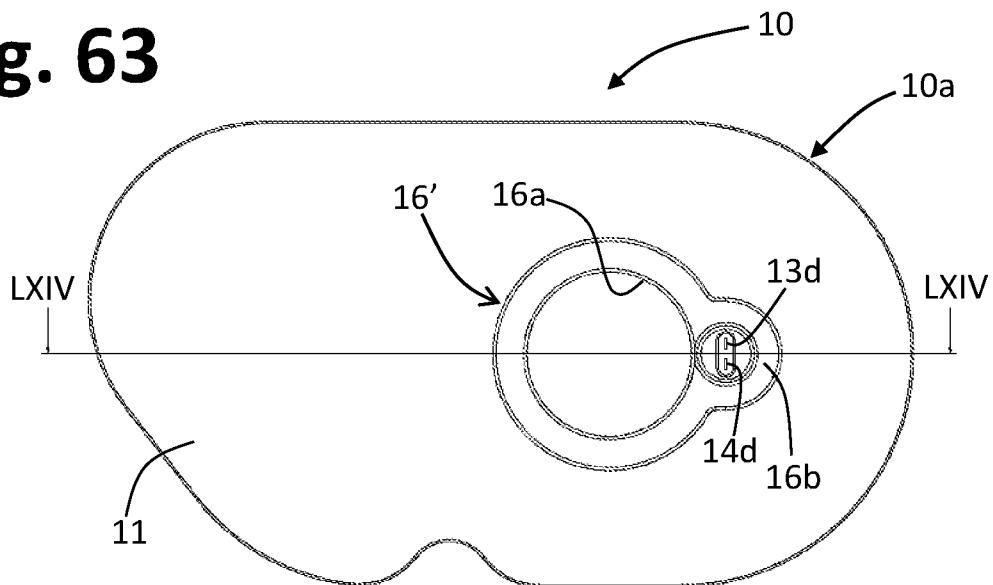
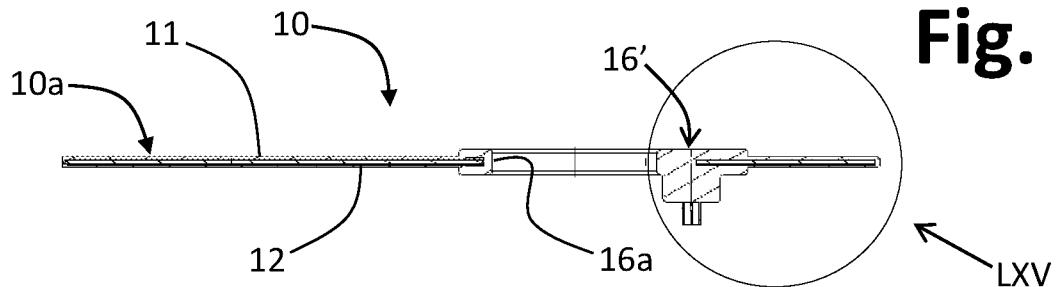
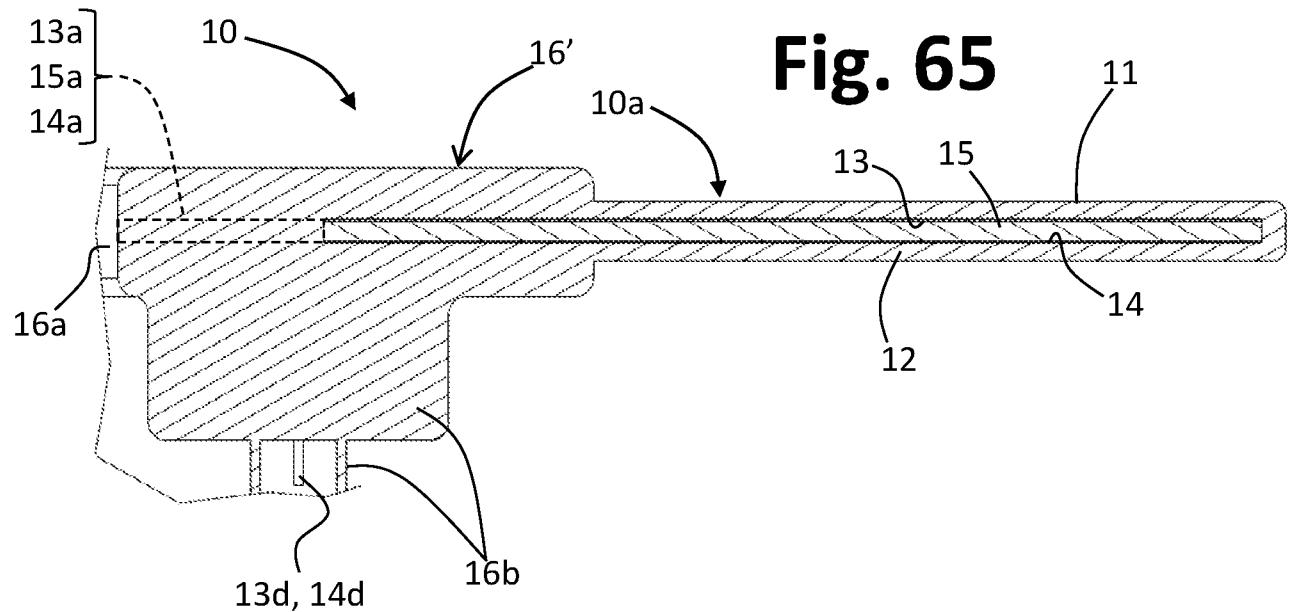
Fig. 60**Fig. 61****Fig. 62**

Fig. 63**Fig. 64****Fig. 65**

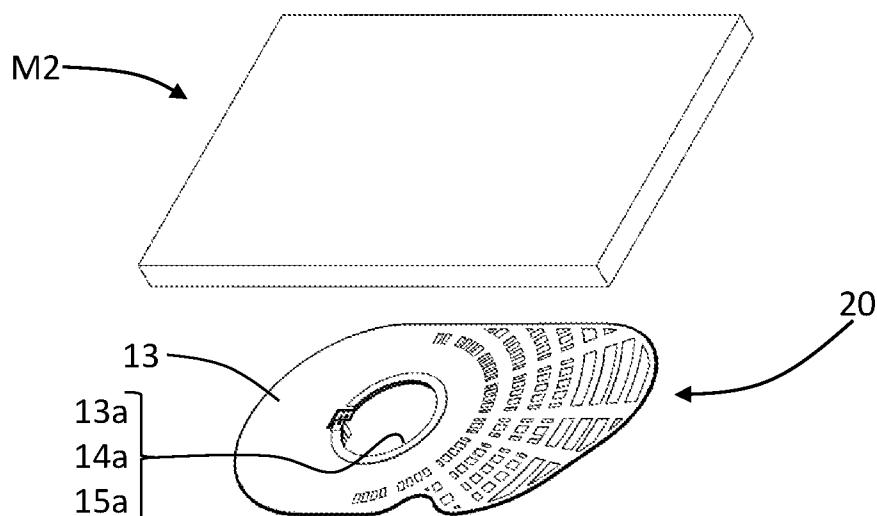
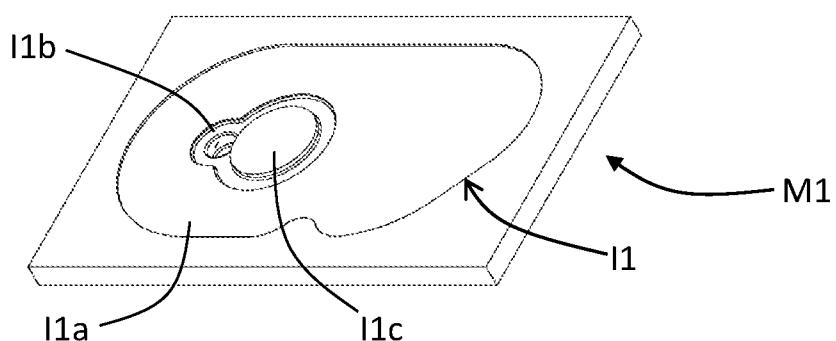
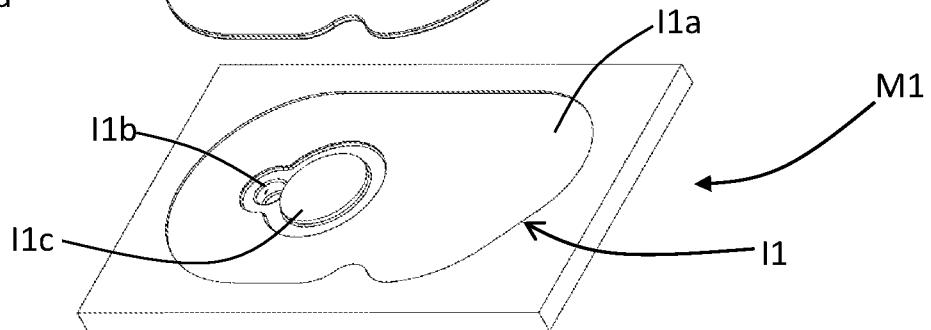
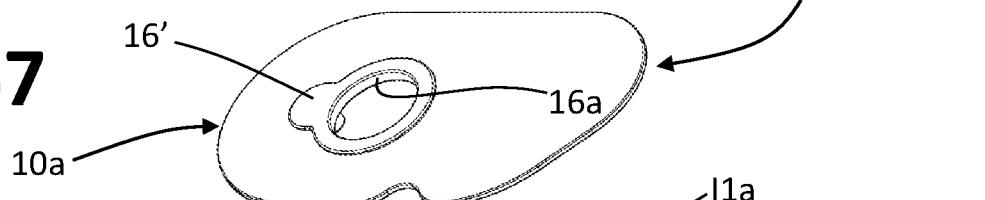
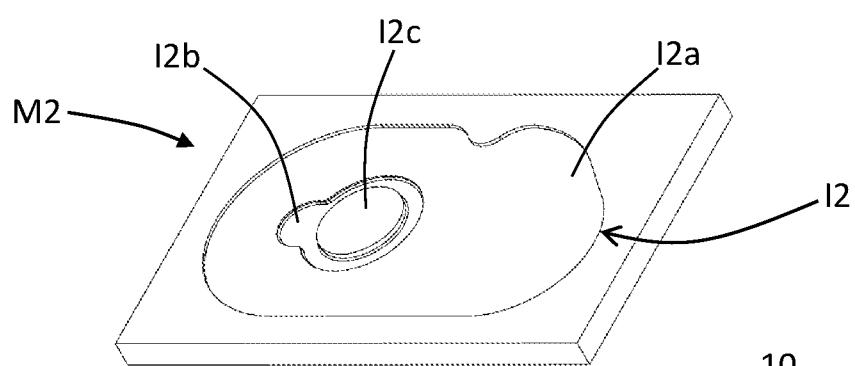
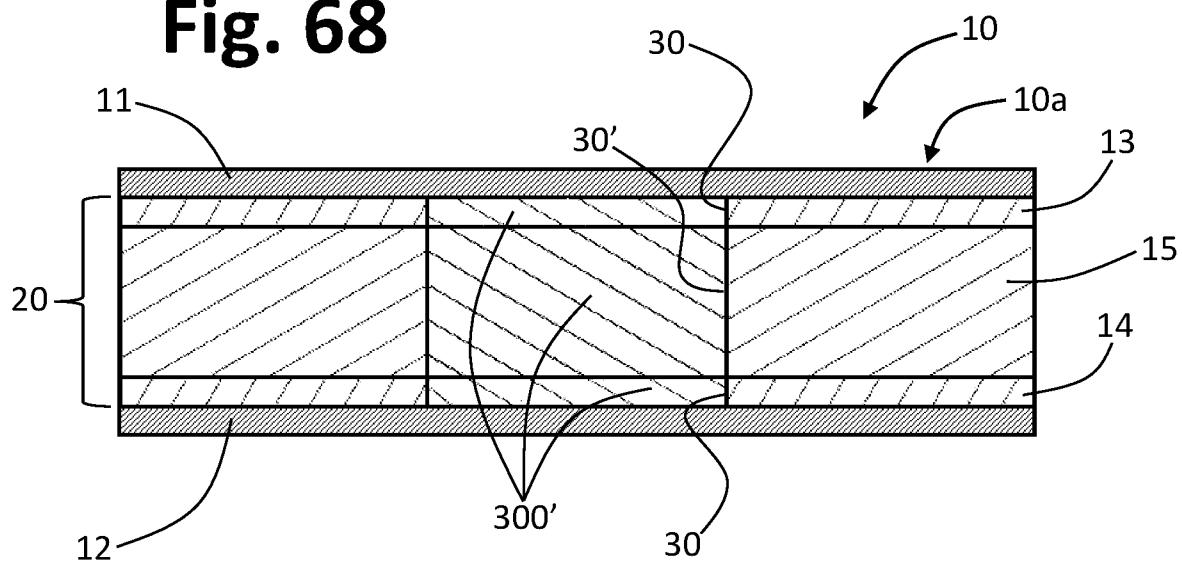
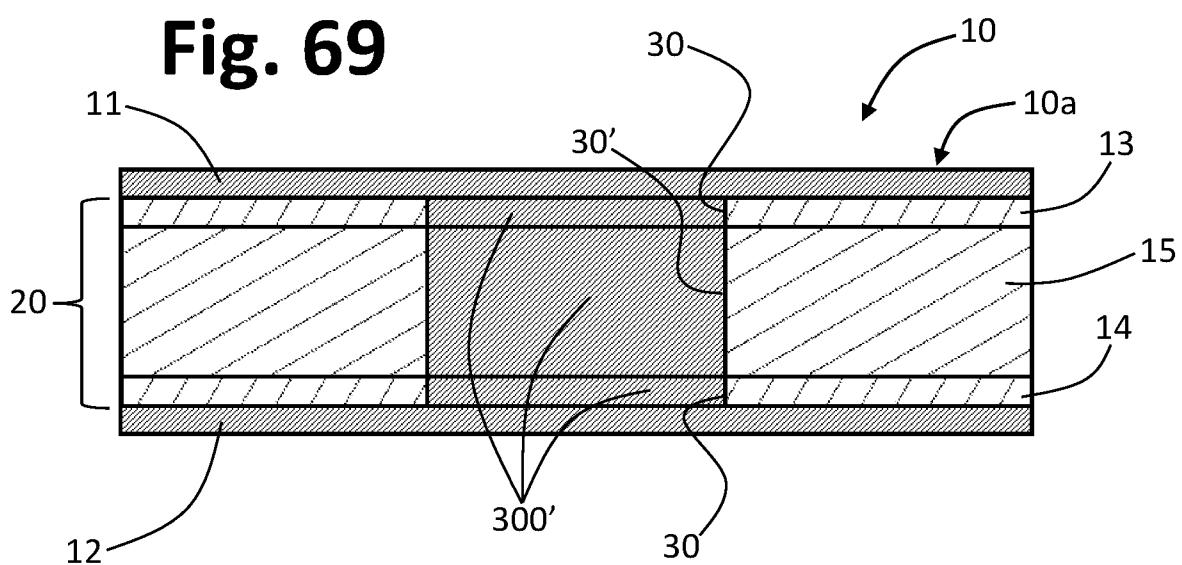
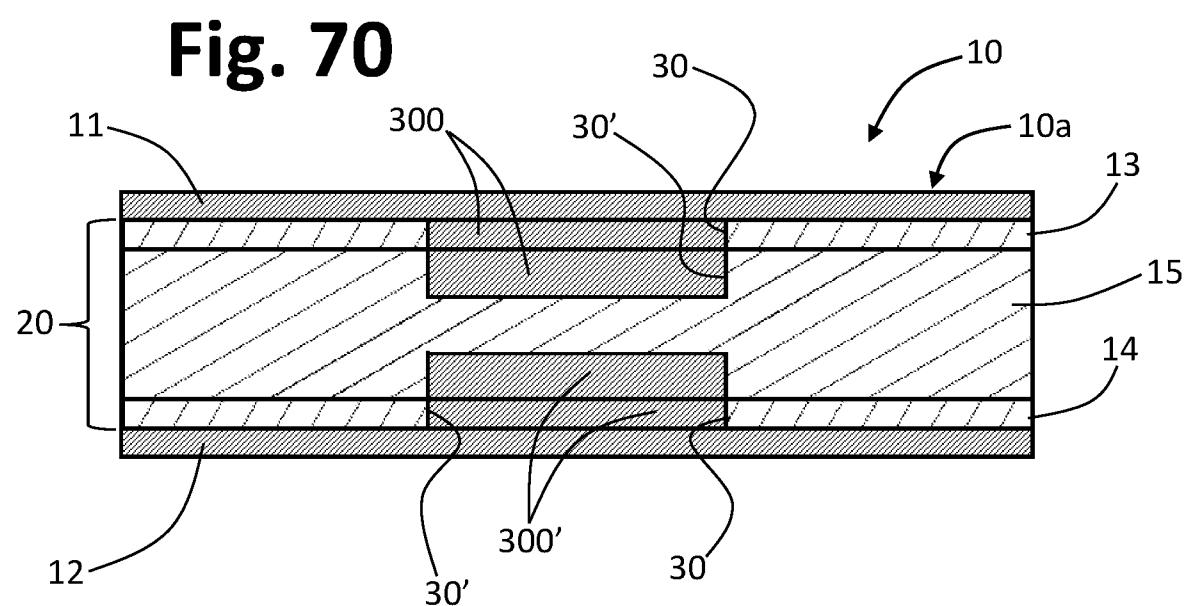
**Fig. 66****Fig. 67**

Fig. 68**Fig. 69****Fig. 70**

INTERNATIONAL SEARCH REPORT

International application No
PCT/IB2018/052973

A. CLASSIFICATION OF SUBJECT MATTER
INV. H05B3/26 H05B3/80
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
H05B

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

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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Y	column 2, line 33 - column 4, line 61; figures 1-4 ----- -/-	5,6,9, 10,18

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3 July 2018	12/07/2018

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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

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