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(54) **Compressor intake muffler and filter**

(57) A compressor assembly having a high velocity muffler system which produces a particle-free compressor pump feed while reducing noise output from the compressor assembly during compressing operations. The high velocity muffler system is maintenance-free and comprises an inertia filter. The compressor assembly uses a method for producing a compressor pump feed and reducing noise during compressing operations by processing a gas through the high velocity muffler system which has an inertia filter and a muffler chamber to produce a compressor pump feed which can be compressed by a pump assembly.

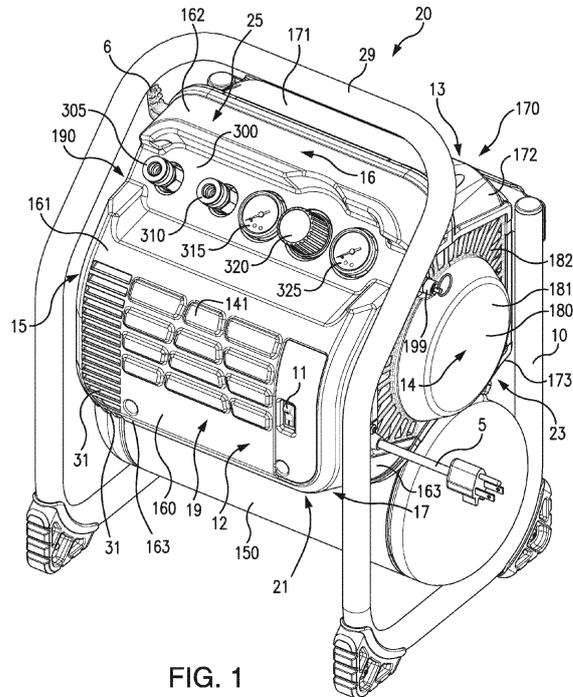


FIG. 1

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Description

[0001] The invention relates to a compressor for air, gas or gas mixtures.

[0002] Compressors are widely used in numerous applications. Existing compressors can generate a high noise output during operation. This noise can be annoying to users and can be distracting to those in the environment of compressor operation. Non-limiting examples of compressors which generate unacceptable levels of noise output include reciprocating, rotary screw and rotary centrifugal types. Compressors which are mobile or portable and not enclosed in a cabinet or compressor room can be unacceptably noisy. However, entirely encasing a compressor, for example in a cabinet or compressor room, is expensive, prevents mobility of the compressor and is often inconvenient or not feasible. Additionally, such encasement can create heat exchange and ventilation problems. There is a strong and urgent need for a quieter compressor technology.

[0003] When a power source for a compressor is electric, gas or diesel, unacceptably high levels of unwanted heat and exhaust gases can be produced. Additionally, existing compressors can be inefficient in cooling a compressor pump and motor. Existing compressors can use multiple fans, e.g. a compressor can have one fan associated with a motor and a different fan associated with a pump. The use of multiple fans adds cost manufacturing difficulty, noise and unacceptable complexity to existing compressors. Current compressors can also have improper cooling gas flow paths which can choke cooling gas flows to the compressor and its components. Thus, there is a strong and urgent need for a more efficient cooling design for compressors.

[0004] In an aspect of the present invention there is a muffler system for a compressor assembly, comprising: an inertia filter; and a muffler chamber; wherein the inertia filter filters a gas which is fed to the muffler chamber and which exits the muffler chamber for compression by a pump assembly.

[0005] Preferably the gas is air. Preferably the inertia filter is a T-inertia filter, a stepped inertia filter and / or a recessed inertia filter. Preferably the muffler chamber is free of a filter medium. Preferably the inertia filter has an inertia filter feed angle in a range of 15° to 90°. Preferably the inertia filter has a counterflow feed. Preferably the compressor assembly comprises an inertia filter baffle. Preferably at least one of a muffler feed line and a muffler outlet line which has an inner diameter which is in a range of 5% to 75% of a diameter of the muffler chamber.

[0006] In another aspect of the invention there is a method for producing a compressor pump feed, comprising the steps of: providing a compressor pump assembly having an inertia filter, a muffler and a compressor pump; filtering a gas by inertia filtering to produce a muffler feed; feeding the muffler feed to the muffler; and feeding a muffler effluent to the compressor pump as a compressor pump feed.

[0007] Preferably the method comprises the step of feeding the muffler feed to the muffler at a rate of 1.5 SCFM or greater. Preferably the filtering step further comprises the step of filtering a plurality of particles having a dimension equal to or greater than 1 μ . Preferably the filtering step further comprises the step of filtering a plurality of particles having a momentum of equal to or greater than 6.69×10^{-18} kg*m/sec. Preferably the filtering step further comprises the step of filtering a plurality of particles having an inertia of equal to or greater than 4.19×10^{-34} kg*m². Preferably the filtering step further comprises the step of filtering the gas through a T-inertia filter, a stepped inertia filter and / or a recessed inertia filter.

[0008] In an embodiment, a compressor assembly as disclosed herein can have a muffler for a feed air system of a compressor assembly. The muffler for a feed air system of a compressor assembly can have: an intake muffler feed line; a muffler outlet line and a muffler chamber wherein the intake muffler feed line is adapted to provide feed air to the muffler chamber and wherein the muffler outlet line is adapted to provide feed air from the muffler chamber for compression by a pump assembly.

[0009] A muffler for a feed air system of a compressor assembly can have a muffler chamber having a volume greater than 3 in³. A muffler for a feed air system of a compressor assembly can have a muffler chamber having a volume greater than 10 in³. A muffler for a feed air system of a compressor assembly can have a muffler chamber having a volume greater than 30 in³.

[0010] A muffler for a feed air system of a compressor assembly can have a muffler chamber which is the product of a blow molding process. A muffler for a feed air system of a compressor assembly can have a muffler chamber having a substantially curved surface area.

[0011] A muffler for a feed air system of a compressor assembly can have a muffler chamber having a first internal chord which is greater than 1.5 times the length of a second internal chord. A muffler for a feed air system of a compressor assembly can have a muffler having an angle in the intake muffler feed line which has a value in the range of from 33 degrees to 156 degrees. A muffler for a feed air system of a compressor assembly can have a muffler having an angle in the muffler outlet line which has a value in the range of from 33 degrees to 156 degrees.

[0012] A muffler for a feed air system of a compressor assembly can have a muffler having a muffler inlet centerline and a muffler outlet centerline which cross at an angle in a range of from 66 degrees to 156 degrees. A muffler for a feed air system of a compressor assembly can have a muffler having a muffler inlet centerline and a muffler outlet centerline which are perpendicular to each other. A muffler for a feed air system of a compressor assembly can have a muffler having a head feed centerline and a muffler intake centerline which are at an angle in a range of from 66 degrees to 156 degrees to each other. A muffler for a feed air system of a compres-

sor assembly can have a muffler having a head feed centerline and a muffler intake centerline which are at an angle of 146 degrees to each other.

[0013] In an aspect, a sound level of a compressor assembly can be controlled by a method of sound control for a compressor assembly, having the steps of: providing a feed air; providing an intake muffler having an outlet in communication with an inlet of a pump assembly adapted to compress the feed air; feeding the feed air through the muffler and into the pump assembly; and compressing the feed air at a compressor assembly sound level in a range of from 65 dBA to 75 dBA.

[0014] The method of sound control for a compressor assembly can have a step of compressing the feed air at a volumetric rate in a range of from 2.4 SCFM to 3.5 SCFM.

[0015] The method of sound control for a compressor assembly can have a step of compressing the feed air to a pressure in a range of from 150 to 250 psig.

[0016] The method of sound control for a compressor assembly can have a step of compressing the feed air at a volumetric rate in a range of from 2.4 SCFM to 3.5 SCFM and to a pressure in a range of from 150 to 250 psig. The method of sound control for a compressor assembly, can have a step of cooling the compressor assembly using a cooling air flow rate of from 3.5 SCFM to 100 SCFM.

[0017] The method of sound control for a compressor assembly can have a step of cooling the compressor assembly at a rate of from 60 BTU/min to 200 BTU/min.

[0018] In an embodiment, a compressor assembly can have a means for sound control of a feed air path which uses a means for dampening sound emitted from a pump system through the feed air path.

[0019] In an embodiment, the compressor assembly can have a muffler system having an inertia filter and a muffler chamber. The inertia filter can filter a gas which can be fed to the muffler chamber and which can exit the muffler chamber for compression by a pump assembly. In an embodiment, the gas can be air. The inertia filter can be selected from various embodiments, such as a T-inertia filter, a stepped inertia filter, a recessed inertia filter, or other design which filters particles based upon the particles' inertia. The inertia filter can have an inertia filter feed angle in a range of 15° to 90°. In an embodiment, the inertia filter can have a counterflow feed. Optionally, the compressor assembly can have an inertia filter baffle.

[0020] In an embodiment, the muffler chamber can be free of a filter medium. Further, the muffler system can have at least one of a muffler feed line and muffler outlet line which has an inner diameter which is in a range of 5% to 75% of a diameter and/or dimension of the muffler chamber.

[0021] The compressor assembly can use a method for producing a compressor pump feed having the steps of: providing a compressor pump assembly having an inertia filter, a muffler and a compressor pump; filtering

a gas by inertia filtering to produce a muffler feed; feeding the muffler feed to the muffler; and feeding a muffler effluent to the compressor pump. The method for producing a compressor pump feed can have the step of feeding the muffler feed to the muffler at a rate of 1.5 SCFM or greater. The method for producing a compressor pump feed can further have the step of filtering particles having a dimension greater than 1 μ . The method for producing a compressor pump feed can further have the step of filtering particles having a momentum of greater than 6.69x10⁻¹⁸ kg*m/sec. The method for producing a compressor pump feed can further have the step of filtering particles having an inertia of greater than 4.19x10⁻³⁴ kg*m².

[0022] The method for producing a compressor pump feed can use an inertia filter which is any of a variety of designs including, but not limited to, a T-inertia filter, a stepped inertia filter and a recessed inertia filter.

[0023] A method for producing a compressed gas can have the steps of: providing a compressor assembly having an inertia filter, a muffler and a compressor pump; filtering a gas feed stream through the inertia filter to produce a muffler feed; feeding the muffler feed to the muffler to produce a compressor pump feed; and compressing the compressor pump feed to a pressure greater than 25 PSIG by the compressor pump. In an embodiment, the method for producing a compressed gas, can further have the step of compressing the compressor pump feed at a rate of 1.5 SCFM or greater and can produce noise from the compressor assembly which is in a range of 60 dBA to 75 dBA when compressing the compressor pump feed.

[0024] The present invention in its several aspects and embodiments solves the problems discussed above and significantly advances the technology of compressors. The present invention can become more fully understood from the detailed description and the accompanying drawings, wherein:

FIG. 1 is a perspective view of a compressor assembly;

FIG. 2 is a front view of internal components of the compressor assembly;

FIG. 3 is a front sectional view of the motor and fan assembly;

FIG. 4 is a pump-side view of components of the pump assembly;

FIG. 5 is a fan-side perspective of the compressor assembly;

FIG. 6 is a rear perspective of the compressor assembly;

FIG. 7 is a rear view of internal components of the

- compressor assembly;
- FIG. 8 is a rear sectional view of the compressor assembly;
- FIG. 9 is a top view of components of the pump assembly;
- FIG. 10 is a top sectional view of the pump assembly;
- FIG. 11 is an exploded view of the air ducting shroud;
- FIG. 12 is a rear view of a valve plate assembly;
- FIG. 13 is a cross-sectional view of the valve plate assembly;
- FIG. 14 is a front view of the valve plate assembly;
- FIG. 15A is a perspective view of sound control chambers of the compressor assembly;
- FIG. 15B is a perspective view of sound control chambers having optional sound absorbers;
- FIG. 16A is a perspective view of sound control chambers with an air ducting shroud;
- FIG. 16B is a perspective view of sound control chambers having optional sound absorbers;
- FIG. 17 is a first table of embodiments of compressor assembly ranges of performance characteristics;
- FIG. 18 is a second table of embodiments of compressor assembly ranges of performance characteristics;
- FIG. 19 is a first table of example performance characteristics for an example compressor assembly;
- FIG. 20 is a second table of example performance characteristics for an example compressor assembly;
- FIG. 21 is a table containing a third example of performance characteristics of an example compressor assembly;
- FIG. 22 is a top view of a feed air system having a muffler;
- FIG. 23 is a sectional view of the inertia filter and the muffler;
- FIG. 23A is a sectional view of a high velocity muffler system;
- FIG. 24 is a sectional view of the muffler;
- FIG. 24A is a sectional view of example inertia filter feed configurations;
- FIG. 24B is a sectional view of an embodiment of a stepped inertia filter;
- FIG. 24C is a sectional view of example feed configurations of the stepped inertia filter;
- FIG. 24D is a sectional view of embodiments of a recessed inertia filter;
- FIG. 25 illustrates the use of optional sound absorption materials in the feed air path;
- FIG. 26 is a muffler system which is sinusoidal;
- FIG. 27 is a feed air path which is sinusoidal and has a plurality of cavity mufflers; and
- FIG. 28 is a feed air path which has a plurality of cavity mufflers.
- FIG. 29 is a table of filtered particle size distribution data;
- FIG. 30 is a table of filtered particle moment of inertia data.
- [0025]** Herein, like reference numbers in one figure refer to like reference numbers in another figure.
- [0026]** The invention relates to a compressor assembly which can compress air, or gas, or gas mixtures, and which has a low noise output, effective cooling means and high heat transfer. The inventive compressor assembly achieves efficient cooling of the compressor assembly **20** (FIG. 1) and/or pump assembly **25** (FIG. 2) and/or the components thereof (FIGS. 3 and 4). In an embodiment, the compressor can compress air. In another embodiment, the compressor can compress one or more gases, inert gases, or mixed gas compositions. The disclosure herein regarding compression of air is also applicable to the use of the disclosed apparatus in its many embodiments and aspects in a broad variety of services and can be used to compress a broad variety of gases and gas mixtures.
- [0027]** FIG. 1 is a perspective view of a compressor assembly **20** shown according to the invention. In an embodiment, the compressor assembly **20** can compress air, or can compress one or more gases, or gas mixtures. In an embodiment, the compressor assembly **20** is also referred to hearing herein as "a gas compressor assembly" or "an air compressor assembly".
- [0028]** The compressor assembly **20** can optionally be portable. The compressor assembly **20** can optionally have a handle **29**, which optionally can be a portion of

frame **10**.

[0029] In an embodiment, the compressor assembly **20** can have a value of weight between 15 lbs and 100 lbs. In an embodiment, the compressor assembly **20** can be portable and can have a value of weight between 15 lbs and 50 lbs. In an embodiment, the compressor assembly **20** can have a value of weight between 25 lbs and 40 lbs. In an embodiment, the compressor assembly **20** can have a value of weight of, e.g. 38 lbs, or 29 lbs, or 27 lbs, or 25 lbs, or 20 lbs, or less. In an embodiment, frame **10** can have a value of weight of 10 lbs or less. In an embodiment, frame **10** can weigh 5 lbs, or less, e.g. 4 lbs, or 3 lbs, of 2 lbs, or less.

[0030] In an embodiment, the compressor assembly **20** can have a front side **12** ("front"), a rear side **13** ("rear"), a fan side **14** ("fan-side"), a pump side **15** ("pump-side"), a top side **16** ("top") and a bottom side **17** ("bottom").

[0031] The compressor assembly **20** can have a housing **21** which can have ends and portions which are referenced herein by orientation consistently with the descriptions set forth above. In an embodiment, the housing **21** can have a front housing **160**, a rear housing **170**, a fan-side housing **180** and a pump-side housing **190**. The front housing **160** can have a front housing portion **161**, a top front housing portion **162** and a bottom front housing portion **163**. The rear housing **170** can have a rear housing portion **171**, a top rear housing portion **172** and a bottom rear housing portion **173**. The fan-side housing **180** can have a fan cover **181** and a plurality of intake ports **182**. The compressor assembly can be cooled by air flow provided by a fan **200** (FIG. 3), e.g. cooling air stream **2000** (FIG. 3).

[0032] In an embodiment, the housing **21** can be compact and can be molded. The housing **21** can have a construction at least in part of plastic, or polypropylene, acrylonitrile butadiene styrene (ABS), metal, steel, stamped steel, fiberglass, thermoset plastic, cured resin, carbon fiber, or other material. The frame **10** can be made of metal, steel, aluminum, carbon fiber, plastic or fiberglass.

[0033] Power can be supplied to the motor of the compressor assembly through a power cord **5** extending through the fan-side housing **180**. In an embodiment, the compressor assembly **20** can comprise one or more of a cord holder member, e.g. first cord wrap **6** and second cord wrap **7** (FIG. 2).

[0034] In an embodiment, power switch **11** can be used to change the operating state of the compressor assembly **20** at least from an "on" to an "off" state, and *vice versa*. In an "on" state, the compressor can be in a compressing state (also herein as a "pumping state") in which it is compressing air, or a gas, or a plurality of gases, or a gas mixture.

[0035] In an embodiment, other operating modes can be engaged by power switch **11** or a compressor control system, e.g. a standby mode, or a power save mode. In an embodiment, the front housing **160** can have a dashboard **300** which provides an operator-accessible loca-

tion for connections, gauges and valves which can be connected to a manifold **303** (FIG. 7). In an embodiment, the dashboard **300** can provide an operator access in non-limiting example to a first quick connection **305**, a second quick connection **310**, a regulated pressure gauge **315**, a pressure regulator **320** and a tank pressure gauge **325**. In an embodiment, a compressed gas outlet line, hose or other device to receive compressed gas can be connected the first quick connection **305** and/or second quick connection **310**. In an embodiment, as shown in FIG. 1, the frame can be configured to provide an amount of protection to the dashboard **300** from the impact of objects from at least the pump-side, fan-side and top directions.

[0036] In an embodiment, the pressure regulator **320** employs a pressure regulating valve. The pressure regulator **320** can be used to adjust the pressure regulating valve **26** (FIG. 7). The pressure regulating valve **26** can be set to establish a desired output pressure. In an embodiment, excess air pressure can be vented to atmosphere through the pressure regulating valve **26** and/or pressure relief valve **199** (FIG. 1). In an embodiment, pressure relief valve **199** can be a spring loaded safety valve. In an embodiment, the air compressor assembly **20** can be designed to provide an unregulated compressed air output.

[0037] In an embodiment, the pump assembly **25** and the compressed gas tank **150** can be connected to frame **10**. The pump assembly **25**, housing **21** and compressed gas tank **150** can be connected to the frame **10** by a plurality of screws and/or one or a plurality of welds and/or a plurality of connectors and/or fasteners.

[0038] The plurality of intake ports **182** can be formed in the housing **21** adjacent the housing inlet end **23** and a plurality of exhaust ports **31** can be formed in the housing **21**. In an embodiment, the plurality of the exhaust ports **31** can be placed in housing **21** in the front housing portion **161**. Optionally, the exhaust ports **31** can be located adjacent to the pump end of housing **21** and/or the pump assembly **25** and/or the pump cylinder **60** and/or cylinder head **61** (FIG. 2) of the pump assembly **25**. In an embodiment, the exhaust ports **31** can be provided in a portion of the front housing portion **161** and in a portion of the bottom front housing portion **163**.

[0039] The total cross-sectional open area of the intake ports **182** (the sum of the cross-sectional areas of the individual intake ports **182**) can be a value in a range of from 3.0 in² to 100 in². In an embodiment, the total cross-sectional open area of the intake ports **182** can be a value in a range of from 6.0 in² to 38.81 in². In an embodiment, the total cross-sectional open area of the intake ports **182** can be a value in a range of from 9.8 in² to 25.87 in². In an embodiment, the total cross-sectional open area of the intake ports **182** can be 12.936 in².

[0040] In an embodiment, the cooling gas employed to cool compressor assembly **20** and its components can be air (also known herein as "cooling air"). The cooling

air can be taken in from the environment in which the compressor assembly **20** is placed. The cooling air can be ambient from the natural environment, or air which has been conditioned or treated. The definition of "air" herein is intended to be very broad. The term "air" includes breathable air, ambient air, treated air, conditioned air, clean room air, cooled air, heated air, non-flammable oxygen containing gas, filtered air, purified air, contaminated air, air with particulates solids or water, air from bone dry (*i.e.* 0.00 humidity) air to air which is supersaturated with water, as well as any other type of air present in an environment in which a gas (*e.g.* air) compressor can be used. It is intended that cooling gases which are not air are encompassed by this disclosure. For non-limiting example, a cooling gas can be nitrogen, can comprise a gas mixture, can comprise nitrogen, can comprise oxygen (in a safe concentration), can comprise carbon dioxide, can comprise one inert gas or a plurality of inert gases, or comprise a mixture of gases.

[0041] In an embodiment, cooling air can be exhausted from compressor assembly **20** through a plurality of exhaust ports **31**. The total cross-sectional open area of the exhaust ports **31** (the sum of the cross-sectional areas of the individual exhaust ports **31**) can be a value in a range of from 3.0 in² to 100 in². In an embodiment, the total cross-sectional open area of the exhaust ports can be a value in a range of from 3.0 in² to 77.62 in². In an embodiment, the total cross-sectional open area of the exhaust ports can be a value in a range of from 4.0 in² to 38.81 in². In an embodiment, the total cross-sectional open area of the exhaust ports can be a value in a range of from 4.91 in² to 25.87 in². In an embodiment, the total cross-sectional open area of the exhaust ports can be 7.238 in².

[0042] Numeric values and ranges herein, unless otherwise stated, also are intended to have associated with them a tolerance and to account for variances of design and manufacturing, and/or operational and performance fluctuations. Thus, a number disclosed herein is intended to disclose values "about" that number. For example, a value X is also intended to be understood as "about X". Likewise, a range of Y-Z, is also intended to be understood as within a range of from "about Y-about Z". Unless otherwise stated, significant digits disclosed for a number are not intended to make the number an exact limiting value. Variance and tolerance, as well as operational or performance fluctuations, are an expected aspect of mechanical design and the numbers disclosed herein are intended to be construed to allow for such factors (in non-limiting *e.g.*, \pm 10 percent of a given value). This disclosure is to be broadly construed. Likewise, the claims are to be broadly construed in their recitations of numbers and ranges.

[0043] The compressed gas tank **150** can operate at a value of pressure in a range of at least from ambient pressure, *e.g.* 14.7 psig to 3000 psig ("psig" is the unit lbf/in² gauge), or greater. In an embodiment, compressed gas tank **150** can operate at 200 psig. In an

embodiment, compressed gas tank **150** can operate at 150 psig.

[0044] In an embodiment, the compressor has a pressure regulated on/off switch which can stop the pump when a set pressure is obtained. In an embodiment, the pump is activated when the pressure of the compressed gas tank **150** falls to 70 percent of the set operating pressure, *e.g.* to activate at 140 psig with an operating set pressure of 200 psig (140 psig = 0.70*200 psig). In an embodiment, the pump is activated when the pressure of the compressed gas tank **150** falls to 80 percent of the set operating pressure, *e.g.* to activate at 160 psig with an operating set pressure of 200 psig (160 psig = 0.80*200 psig). Activation of the pump can occur at a value of pressure in a wide range of set operating pressure, *e.g.* 25 percent to 99.5 percent of set operating pressure. Set operating pressure can also be a value in a wide range of pressure, *e.g.* a value in a range of from 25 psig to 3000 psig. An embodiment of set pressure can be 50 psig, 75 psig, 100 psig, 150 psig, 200 psig, 250 psig, 300 psig, 500 psig, 1000 psig, 2000 psig, 3000 psig, or greater than or less than, or a value in between these example numbers.

[0045] The compressor assembly **20** disclosed herein in its various embodiments achieves a reduction in the noise created by the vibration of the air tank while the air compressor is running, in its compressing state (pumping state) *e.g.* to a value in a range of from 60-75 dBA, or less, as measured by ISO3744-1995. Noise values discussed herein are compliant with ISO3744-1995. ISO3744-1995 is the standard for noise data and results for noise data, or sound data, provided in this application. Herein "noise" and "sound" are used synonymously.

[0046] The pump assembly **25** can be mounted to an air tank and can be covered with a housing **21**. A plurality of optional decorative shapes **141** can be formed on the front housing portion **161**. The plurality of optional decorative shapes **141** can also be sound absorbing and/or vibration dampening shapes. The plurality of optional decorative shapes **141** can optionally be used with, or contain at least in part, a sound absorbing material.

[0047] FIG. 2 is a front view of internal components of the compressor assembly.

[0048] The compressor assembly **20** can include a pump assembly **25**. In an embodiment, pump assembly **25** which can compress a gas, air or gas mixture. In an embodiment in which the pump assembly **25** compresses air, it is also referred to herein as air compressor **25**, or compressor **25**. In an embodiment, the pump assembly **25** can be powered by a motor **33** (*e.g.* FIG. 3).

[0049] FIG. 2 illustrates the compressor assembly **20** with a portion of the housing **21** removed and showing the pump assembly **25**. In an embodiment, the fan-side housing **180** can have a fan cover **181** and a plurality of intake ports **182**. The cooling gas, for example air, can be fed through an air inlet space **184** which feeds air into the fan **200** (*e.g.* FIG. 3). In an embodiment, the fan **200** can be housed proximate to an air intake port **186** of an

air ducting shroud **485**.

[0050] Air ducting shroud **485** can have a shroud inlet scoop **484**. As illustrated in FIG. 2, air ducting shroud **485** is shown encasing the fan **200** and the motor **33** (FIG. 3). In an embodiment, the shroud inlet scoop **484** can encase the fan **200**, or at least a portion of the fan and at least a portion of motor **33**. In this embodiment, an air inlet space **184** which feeds air into the fan **200** is shown. The air ducting shroud **485** can encase the fan **200** and the motor **33**, or at least a portion of these components.

[0051] FIG. 2 is an intake muffler **900** which can receive feed air for compression (also herein as "feed air **990**"; e.g. FIG. 8) via the intake muffler feed line **898**. The feed air **990** can pass through the intake muffler **900** and be fed to the cylinder head **61** via the muffler outlet line **902**. The feed air **990** can be compressed in pump cylinder **60** by piston **63**. The piston can be provided with a seal which can function, such as slide, in the cylinder without liquid lubrication. The cylinder head **61** can be shaped to define an inlet chamber **81** (e.g. FIG. 9) and an outlet chamber **82** (e.g. FIG. 8) for a compressed gas, such as air (also known herein as "compressed air **999**" or "compressed gas **999**"; e.g. FIG. 10). In an embodiment, the pump cylinder **60** can be used as at least a portion of an inlet chamber **81**. A gasket can form an air tight seal between the cylinder head **61** and the valve plate assembly **62** to prevent a leakage of a high pressure gas, such as compressed air **999**, from the outlet chamber **82**. Compressed air **999** can exit the cylinder head **61** via a compressed gas outlet port **782** and can pass through a compressed gas outlet line **145** to enter the compressed gas tank **150**.

[0052] As shown in FIG. 2, the pump assembly **25** can have a pump cylinder **60**, a cylinder head **61**, a valve plate assembly **62** mounted between the pump cylinder **60** and the cylinder head **61**, and a piston **63** which is reciprocated in the pump cylinder **60** by an eccentric drive **64** (e.g. FIG. 9). The eccentric drive **64** can include a sprocket **49** which can drive a drive belt **65** which can drive a pulley **66**. A bearing **67** can be eccentrically secured to the pulley **66** by a screw, or a rod bolt **57**, and a connecting rod **69**. Preferably, the sprocket **49** and the pulley **66** can be spaced around their perimeters and the drive belt **65** can be a timing belt. The pulley **66** can be mounted about pulley centerline **887** and linked to a sprocket **49** by the drive belt **65** (FIG. 3) which can be configured on an axis which is represent herein as a shaft centerline **886** supported by a bracket and by a bearing **47** (FIG. 3). A bearing can allow the pulley **66** to be rotated about an axis **887** (FIG. 10) when the motor rotates the sprocket **49**. As the pulley **66** rotates about the axis **887** (FIG. 10), the bearing **67** (FIG. 2) and an attached end of the connecting rod **69** are moved around a circular path.

[0053] The piston **63** can be formed as an integral part of the connecting rod **69**. A compression seal can be attached to the piston **63** by a retaining ring and a screw.

In an embodiment, the compression seal can be a sliding compression seal.

[0054] A cooling gas stream, such as cooling air stream **2000** (FIG. 3), can be drawn through intake ports **182** to feed fan **200**. The cooling air stream **2000** can be divided into a number of different cooling air stream flows which can pass through portions of the compressor assembly and exit separately, or collectively as an exhaust air stream through the plurality of exhaust ports **31**. Additionally, the cooling gas, e.g. cooling air stream **2000**, can be drawn through the plurality of intake ports **182** and directed to cool the internal components of the compressor assembly **20** in a predetermined sequence to optimize the efficiency and operating life of the compressor assembly **20**. The cooling air can be heated by heat transfer from compressor assembly **20** and/or the components thereof, e.g. pump assembly **25** (FIG. 3). The heated air can be exhausted through the plurality of exhaust ports **31**.

[0055] In an embodiment, one fan can be used to cool both the pump and motor. A design using a single fan to provide cooling to both the pump and motor can require less air flow than a design using two or more fans, e.g. using one or more fans to cool the pump, and also using one or more fans to cool the motor. Using a single fan to provide cooling to both the pump and motor can reduce power requirements and also reduces noise production as compared to designs using a plurality of fans to cool the pump and the motor, or which use a plurality of fans to cool the pump assembly **25**, or the compressor assembly **20**.

[0056] In an embodiment, the fan blade **205** (e.g. FIG. 3) establishes a forced flow of cooling air through the internal housing, such as the air ducting shroud **485**. The cooling air flow through the air ducting shroud can be a volumetric flow rate having a value of between 25 CFM to 400 CFM. The cooling air flow through the air ducting shroud can be a volumetric flow rate having a value of between 45 CFM to 125 CFM.

[0057] In an embodiment, the outlet pressure of cooling air from the fan can be in a range of from 1 psig to 50 psig. In an embodiment, the fan **200** can be a low flow fan with which generates an outlet pressure having a value in a range of from 1 inch of water to 10 psi. In an embodiment, the fan **200** can be a low flow fan with which generates an outlet pressure having a value in a range of from 2 in of water to 5 psi.

[0058] In an embodiment, the air ducting shroud **485** can flow 100 CFM of cooling air with a pressure drop of from 0.0002 psi to 50 psi along the length of the air ducting shroud. In an embodiment, the air ducting shroud **485** can flow 75 CFM of cooling air with a pressure drop of 0.028 psi along its length as measured from the entrance to fan **200** through the exit from conduit **253** (FIG. 7).

[0059] In an embodiment, the air ducting shroud **485** can flow 75 CFM of cooling air with a pressure drop of 0.1 psi along its length as measured from the outlet of fan **200** through the exit from conduit **253**. In an embod-

iment, the air ducting shroud **485** can flow 100 CFM of cooling air with a pressure drop of 1.5 psi along its length as measured from the outlet of fan **200** through the exit from conduit **253**. In an embodiment, the air ducting shroud **485** can flow 150 CFM of cooling air with a pressure drop of 5.0 psi along its length as measured from the outlet of fan **200** through the exit from conduit **253**.

[0060] In an embodiment, the air ducting shroud **485** can flow 75 CFM of cooling air with a pressure drop in a range of from 1.0 psi to 30 psi across as measured from the outlet of fan **200** across the motor **33**.

[0061] Depending upon the compressed gas output, the design rating of the motor **33** and the operating voltage, in an embodiment, the motor **33** can operate at a value of rotation (motor speed) between 5,000 rpm and 20,000 rpm. In an embodiment, the motor **33** can operate at a value in a range of between 7,500 rpm and 12,000 rpm. In further embodiments, the motor **33** can operate at e.g. 11,252 rpm, or 11,000 rpm; or 10,000 rpm; or 9,000 rpm; or 7,500 rpm; or 6,000 rpm; or 5,000 rpm. The pulley **66** and the sprocket **49** can be sized to achieve reduced pump speeds (also herein as "reciprocation rates", or "piston speed") at which the piston **63** is reciprocated. For example, if the sprocket **49** can have a diameter of 1 in and the pulley **66** can have a diameter of 4 in, then a motor **33** speed of 14,000 rpm can achieve a reciprocation rate, or a piston speed, of 3,500 strokes per minute. In an embodiment, if the sprocket **49** can have a diameter of 1.053 in and the pulley **66** can have a diameter of 5.151 in, then a motor **33** speed of 11,252 rpm can achieve a reciprocation rate, or a piston speed (pump speed), of 2,300 strokes per minute.

[0062] FIG. 3 is a front sectional view of the motor and fan assembly.

[0063] FIG. 3 illustrates the fan **200** and motor **33** covered by air ducting shroud **485**. The fan **200** is shown proximate to a shroud inlet scoop **484**.

[0064] The motor can have a stator **37** with an upper pole **38** around which upper stator coil **40** is wound and/or configured. The motor can have a stator **37** with a lower pole **39** around which lower stator coil **41** is wound and/or configured. A shaft **43** can be supported adjacent a first shaft end **44** by a bearing **45** and is supported adjacent to a second shaft end **46** by a bearing **47**. A plurality of fan blades **205** can be secured to the fan **200** which can be secured to the first shaft end **44**. When power is applied to the motor **33**, the shaft **43** rotates at a high speed to in turn drive the sprocket **49** (FIG. 2), the drive belt **65** (FIG. 4), the pulley **66** (FIG. 4) and the fan blade **200**. In an embodiment, the motor can be a non-synchronous universal motor. In an embodiment, the motor can be a synchronous motor used.

[0065] The compressor assembly **20** can be designed to accommodate a variety of types of motor **33**. The motors **33** can come from different manufacturers and can have horsepower ratings of a value in a wide range from small to very high. In an embodiment, a motor **33** can be purchased from the existing market of commercial mo-

tors. For example, although the housing **21** is compact, In an embodiment, it can accommodate a universal motor, or other motor type, rated, for example, at 1/2 horsepower, at 3/4 horsepower or 1 horsepower by scaling and/or designing the air ducting shroud **485** to accommodate motors in a range from small to very large.

[0066] FIG. 3 and FIG. 4 illustrate the compression system for the compressor which is also referred to herein as the pump assembly **25**. The pump assembly **25** can have a pump **59**, a pulley **66**, drive belt **65** and driving mechanism driven by motor **33**. The connecting rod **69** can connect to a piston **63** (e.g. FIG. 10) which can move inside of the pump cylinder **60**.

[0067] In one embodiment, the pump **59** such as "gas pump" or "air pump" can have a piston **63**, a pump cylinder **60**, in which a piston **63** reciprocates and a cylinder rod **69** (FIG. 2) which can optionally be oil-less and which can be driven to compress a gas, e.g. air. The pump **59** can be driven by a high speed universal motor, e.g. motor **33** (FIG. 3), or other type of motor.

[0068] FIG. 4 is a pump-side view of components of the pump assembly **25**. The "pump assembly **25**" can have the components which are attached to the motor and/or which serve to compress a gas; which in non-limiting example can comprise the fan, the motor **33**, the pump cylinder **60** and piston **63** (and its driving parts), the valve plate assembly **62**, the cylinder head **61** and the outlet of the cylinder head **782**. Herein, the feed air system **905** system (FIG. 7) is referred to separately from the pump assembly **25**.

[0069] FIG. 4 illustrates that pulley **66** is driven by the motor **33** using drive belt **65**.

[0070] FIG. 4 (also see FIG. 10) illustrates an offset **880** which has a value of distance which represents one half ($\frac{1}{2}$) of the stroke distance. The offset **880** can have a value between 0.25 in and 6 in, or larger. In an embodiment, the offset **880** can have a value between 0.75 in and 3 in. In an embodiment, the offset **880** can have a value between 1.0 in and 2 in, e.g. 1.25 in. In an embodiment, the offset **880** can have a value of about 0.796 in. In an embodiment, the offset **880** can have a value of about 0.5 in. In an embodiment, the offset **880** can have a value of about 1.5 in.

[0071] A stroke having a value in a range of from 0.50 in and 12 in, or larger can be used. A stroke having a value in a range of from 1.5 in and 6 in can be used. A stroke having a value in a range of from 2 in and 4 in can be used. A stroke of 2.5 in can be used. In an embodiment, the stroke can be calculated to equal two (2) times the offset, for example, an offset **880** of 0.796 produces a stroke of $2(0.796) = 1.592$ in. In another example, an offset **880** of 2.25 produces a stroke of $2(2.25) = 4.5$ in. In yet another example, an offset **880** of 0.5 produces a stroke of $2(0.5) = 1.0$ in.

[0072] The compressed air passes through valve plate assembly **62** and into the cylinder head **61** having a plurality of cooling fins **89**. The compressed gas is discharged from the cylinder head **61** through the outlet line

145 which feeds compressed gas to the compressed gas tank **150**.

[0073] FIG. 4 also identifies the pump-side of upper motor path **268** which can provide cooling air to upper stator coil **40** and lower motor path **278** which can provide cooling to lower stator coil **41**.

[0074] FIG. 5 illustrates tank seal **600** providing a seal between the housing **21** and compressed gas tank **150** viewed from fan-side **14**. FIG. 5 is a fan-side perspective of the compressor assembly **20**. FIG. 5 illustrates a fan-side housing **180** having a fan cover **181** with intake ports **182**. FIG. 5 also shows a fan-side view of the compressed gas tank **150**. Tank seal **600** is illustrated sealing the housing **21** to the compressed gas tank **150**. Tank seal **600** can be a one piece member or can have a plurality of segments which form tank seal **600**.

[0075] FIG. 6 is a rear-side perspective of the compressor assembly **20**. FIG. 6 illustrates a tank seal **600** sealing the housing **21** to the compressed gas tank **150**.

[0076] FIG. 7 is a rear view of internal components of the compressor assembly. In this sectional view, in which the rear housing **170** is not shown, the fan-side housing **180** has a fan cover **181** and intake ports **182**. The fan-side housing **180** is configured to feed air to air ducting shroud **485**. Air ducting shroud **485** has shroud inlet scoop **484** and conduit **253** which can feed a cooling gas, such as air, to the cylinder head **61** and pump cylinder **60**.

[0077] FIG. 7 also provides a view of the feed air system **905**. The feed air system **905** can feed a feed air **990** through a feed air port **952** for compression in the pump cylinder **60** of pump assembly **25**. The feed air port **952** can optionally receive a clean air feed from an inertia filter **949** (FIG. 8). The clean air feed can pass through the feed air port **952** to flow through an air intake hose **953** and an intake muffler feed line **898** to the intake muffler **900**. The clean air can flow from the intake muffler **900** through muffler outlet line **902** and cylinder head hose **903** to feed pump cylinder head **61**. Noise can be generated by the compressor pump **299**, such as when the piston forces air in and out of the valves of valve plate assembly **62**. The intake side of the pump can provide a path for the noise to escape from the compressor which intake muffler **900** can serve to muffle.

[0078] The filter distance **1952** between an inlet centerline **1950** of the feed air port **952** and a scoop inlet **1954** of shroud inlet scoop **484** can vary widely and have a value in a range of from 0.5 in to 24 in, or even greater for larger compressor assemblies. The filter distance **1952** between inlet centerline **1950** and inlet cross-section of shroud inlet scoop **484** identified as scoop inlet **1954** can be e.g. 0.5 in, or 1.0 in, or 1.5 in, or 2.0 in, or 2.5 in, or 3.0 in, or 4.0 in, or 5.0 in or 6.0 in, or greater. In an embodiment, the filter distance **1952** between inlet centerline **1950** and inlet cross-section of shroud inlet scoop **484** identified as scoop inlet **1954** can be 1.859 in. In an embodiment, the inertia filter can have multiple inlet ports which can be located at different locations of the air ducting shroud **485**. In an embodiment, the inertial

filter is separate from the air ducting shroud and its feed is derived from one or more inlet ports.

[0079] FIG. 7 illustrates that compressed air can exit the cylinder head **61** via the compressed gas outlet port **782** and pass through the compressed gas outlet line **145** to enter the compressed gas tank **150**. FIG. 7 also shows a rear-side view of manifold **303**.

[0080] FIG. 8 is a rear sectional view of the compressor assembly **20**. FIG. 8 illustrates the fan cover **181** having a plurality of intake ports **182**. A portion of the fan cover **181** can be extended toward the shroud inlet scoop **484**, e.g. the rim **187**. In this embodiment, the fan cover **181** has a rim **187** which can eliminate a visible line of sight to the air inlet space **184** from outside of the housing **21**. In an embodiment, the rim **187** can cover or overlap an air space **188**. FIG. 8 illustrates an inertia filter **949** having an inertia filter chamber **950** and air intake path **922**.

[0081] In an embodiment, the rim **187** can extend past the air inlet space **184** and overlaps at least a portion of the shroud inlet scoop **484**. In an embodiment, the rim **187** does not extend past and does not overlap a portion of the shroud inlet scoop **484** and the air inlet space **184** can have a width between the rim **187** and a portion of the shroud inlet scoop **484** having a value of distance in a range of from 0.1 in to 2 in, e.g. 0.25 in, or 0.5 in. In an embodiment, the air ducting shroud **485** and/or the shroud inlet scoop **484** can be used to block line of sight to the fan **200** and the pump assembly **25** in conjunction with or instead of the rim **187**.

[0082] The inertia filter **949** can provide advantages over the use of a filter media which can become plugged with dirt and/or particles and which can require replacement to prevent degrading of compressor performance. Additionally, filter media, even when it is new, creates a pressure drop and can reduce compressor performance.

[0083] Air must make a substantial change in direction from the flow of cooling air to become compressed gas feed air to enter and pass through the feed air port **952** to enter the air intake path **922** from the inertia filter chamber **950** of the inertia filter **949**. Any dust and other particles dispersed in the flow of cooling air have sufficient inertia that they tend to continue moving with the cooling air rather than change direction and enter the air intake path **922**.

[0084] FIG. 8 also shows a section of a dampening ring **700**. The dampening ring **700** can optionally have a cushion member **750**, as well as optionally a first hook **710** and a second hook **720**.

[0085] FIG. 9 is a top view of the components of the pump assembly **25**.

[0086] Pump assembly **25** can have a motor **33** which can drive the shaft **43** which causes a sprocket **49** to drive a drive belt **65** to rotate a pulley **66**. The pulley **66** can be connected to and can drive the connecting rod **69** which has a piston **63** (FIG. 2) at an end. The piston **63** can compress a gas in the pump cylinder **60** pumping the compressed gas through the valve plate assembly **62** into the cylinder head **61** and then out through a com-

pressed gas outlet port **782** through an outlet line **145** and into the compressed gas tank **150**.

[0087] FIG. 9 also shows a pump **91**. Herein, pump **91** collectively refers to a combination of parts including the cylinder head **61**, the pump cylinder **60**, the piston **63** and the connecting rod having the piston **63**, as well as the components of these parts.

[0088] FIG. 10 is a top sectional view of the pump assembly **25**. FIG. 10 also shows a shaft centerline **886**, as well as pulley centerline **887** and a rod bolt centerline **889** of a rod bolt **57**. FIG. 10 illustrates an offset **880** which can be a dimension having a value in the range of 0.5 in to 12 in, or greater. In an embodiment, the stroke can be 1.592 in, from an offset **880** of 0.796 in. FIG. 10 also shows air inlet chamber **81**.

[0089] FIG. 11 illustrates an exploded view of the air ducting shroud **485**. In an embodiment, the air ducting shroud **485** can have an upper ducting shroud **481** and a lower ducting shroud **482**. In the example of FIG. 11, the upper ducting shroud **481** and the lower ducting shroud **482** can be fit together to shroud the fan **200** and the motor **33** and can create air ducts for cooling pump assembly **25** and/or the compressor assembly **20**. In an embodiment, the air ducting shroud **485** can also be a motor cover for motor **33**. The upper air ducting shroud **481** and the lower air ducting shroud **482** can be connected by a broad variety of means which can include snaps and/or screws.

[0090] FIG. 12 is a rear-side view of a valve plate assembly. A valve plate assembly **62** is shown in detail in FIGS. 12, 13 and 14.

[0091] The valve plate assembly **62** of the pump assembly **25** can include air intake and air exhaust valves. The valves can be of a reed, flapper, one-way or other type. A restrictor can be attached to the valve plate adjacent the intake valve. Deflection of the exhaust valve can be restricted by the shape of the cylinder head which can minimize valve impact vibrations and corresponding valve stress.

[0092] The valve plate assembly **62** has a plurality of intake ports **103** (five shown) which can be closed by the intake valves **96** (FIG. 14) which can extend from fingers **105** (FIG. 13). In an embodiment, the intake valves **96** can be of the reed or "flapper" type and are formed, for example, from a thin sheet of resilient stainless steel. Radial fingers 113 (FIG. 12) can radiate from a valve finger hub 114 to connect the plurality of valve members **104** of intake valves **96** and to function as return springs. A rivet **107** secures the hub **106** (e.g. FIG. 13) to the center of the valve plate **95**. An intake valve restrictor **108** can be clamped between the rivet **107** and the hub **106**. The surface **109** terminates at an edge **110** (FIGS. 13 and 14). When air is drawn into the pump cylinder **60** during an intake stroke of the piston **63**, the radial fingers 113 can bend and the plurality of valve members **104** separate from the valve plate assembly **62** to allow air to flow through the intake ports **103**.

[0093] FIG. 13 is a cross-sectional view of the valve

plate assembly and FIG. 14 is a front-side view of the valve plate assembly. The valve plate assembly **62** includes a valve plate **95** which can be generally flat and which can mount a plurality of intake valves **96** (FIG. 14) and a plurality of outlet valves **97** (FIG. 12). In an embodiment, the valve plate assembly **62** (FIGS. 10 and 12) can be clamped to a bracket by screws which can pass through the cylinder head **61** (e.g. FIG. 2), the gasket and a plurality of through holes **99** in the valve plate assembly **62** and engage a bracket. A valve member **112** of the outlet valve **97** can cover an exhaust port **111**. A cylinder flange and a gas tight seal can be used in closing the cylinder head assembly. In an embodiment, a flange and seal can be on a cylinder side (herein front-side) of a valve plate assembly **62** and a gasket can be between the valve plate assembly **62** and the cylinder head **61**.

[0094] FIG. 14 illustrates the front side of the valve plate assembly **62** which can have a plurality of exhaust ports **111** (three shown) which are normally closed by the outlet valves **97**. A plurality of a separate circular valve member **112** can be connected through radial fingers 113 (FIG. 12) which can be made of a resilient material to a valve finger hub **114**. The valve finger hub **114** can be secured to the rear side of the valve plate assembly **62** by the rivet **107**. Optionally, the cylinder head **61** can have a head rib **118** (FIG. 13) which can project over and can be spaced a distance from the valve members **112** to restrict movement of the exhaust valve members **112** and to lessen and control valve impact vibrations and corresponding valve stress.

[0095] FIG. 15A is a perspective view of a plurality of sound control chambers of an embodiment of the compressor assembly **20**. FIG. 15A illustrates an embodiment having four (4) sound control chambers. The number of sound control chambers can vary widely in a range of from one to a large number, e.g. 25, or greater. In a non-limiting example, in an embodiment, a compressor assembly **20** can have a fan sound control chamber **550** (also herein as "fan chamber **550**"), a pump sound control chamber **491** (also herein as "pump chamber **491**"), an exhaust sound control chamber **555** (also herein as "exhaust chamber **555**"), and an upper sound control chamber **480** (also herein as "upper chamber **480**").

[0096] FIG. 15B is a perspective view of sound control chambers having optional sound absorbers. The optional sound absorbers can be used to line the inner surface of housing **21**, as well as both sides of partitions which are within the housing **21** of the compressor assembly **20**.

[0097] FIG. 16A is a perspective view of sound control chambers with an air ducting shroud **485**. FIG. 16A illustrates the placement of air ducting shroud **485** in coordination with, for example, the fan chamber **550**, the pump sound control chamber **491**, the exhaust sound control chamber **555**, and the upper sound control chamber **480**.

[0098] FIG. 16B is a perspective view of sound control chambers having optional sound absorbers. The optional sound absorbers can be used to line the inner surface of housing **21**, as well as both sides of partitions which are

within the housing **21** of compressor assembly **20**.

[0099] FIG. 17 is a first table of embodiments of compressor assembly range of performance characteristics. The compressor assembly **20** can have values of performance characteristics as recited in FIG. 17 which are within the ranges set forth in FIG. 17.

[0100] FIG. 18 is a second table of embodiments of ranges of performance characteristics for the compressor assembly **20**. The compressor assembly **20** can have values of performance characteristics as recited in FIG. 18 which are within the ranges set forth in FIG. 18.

[0101] The compressor assembly **20** achieves efficient heat transfer. The heat transfer rate can have a value in a range of from 25 BTU/min to 1000 BTU/min. The heat transfer rate can have a value in a range of from 90 BTU/min to 500 BTU/min. In an embodiment, the compressor assembly **20** can exhibit a heat transfer rate of 200 BTU/min. The heat transfer rate can have a value in a range of from 50 BTU/min to 150 BTU/min. In an embodiment, the compressor assembly **20** can exhibit a heat transfer rate of 135 BTU/min. In an embodiment, the compressor assembly **20** exhibited a heat transfer rate of 84.1 BTU/min.

[0102] The heat transfer rate of a compressor assembly **20** can have a value in a range of 60 BTU/min to 110 BTU/min. In an embodiment of the compressor assembly **20**, the heat transfer rate can have a value in a range of 66.2 BTU/min to 110 BTU/min; or 60 BTU/min to 200 BTU/min.

[0103] The compressor assembly **20** can have noise emissions reduced by, for example, slower fan and/or slower motor speeds, use of a check valve muffler, use of tank vibration dampeners, use of tank sound dampeners, use of a tank dampening ring, use of tank vibration absorbers to dampen noise to and/or from the tank walls which can reduce noise. In an embodiment, a two stage intake muffler can be used on the pump. A housing having reduced or minimized openings can reduce noise from the compressor assembly. As disclosed herein, the elimination of line of sight to the fan and other components as attempted to be viewed from outside of the compressor assembly **20** can reduce noise generated by the compressor assembly. Additionally, routing cooling air through ducts, using foam lined paths and/or routing cooling air through tortuous paths can reduce noise generation by the compressor assembly **20**.

[0104] Additionally, noise can be reduced from the compressor assembly **20** and its sound level lowered by one or more of the following, employing slower motor speeds, using a check valve muffler and/or using a material to provide noise dampening of the housing **21** and its partitions and/or the compressed air tank **150** heads and shell. Other noise dampening features can include one or more of the following and be used with or apart from those listed above, using a two-stage intake muffler in the feed to a feed air port **952**, elimination of line of sight to the fan and/or other noise generating parts of the compressor assembly **20**, a quiet fan design and/or rout-

ing cooling air routed through a tortuous path which can optionally be lined with a sound absorbing material, such as a foam. Optionally, fan **200** can be a fan which is separate from the shaft **43** and can be driven by a power source which is not shaft **43**.

[0105] In an example, an embodiment of compressor assembly **20** achieved a decibel reduction of 7.5 dBA. In this example, noise output when compared to a pancake compressor assembly was reduced from about 78.5 dBA to about 71 dBA.

Example 1.

[0106] FIG. 19 is a first table of example performance characteristics for an example embodiment. FIG. 19 contains combinations of performance characteristics exhibited by an embodiment of compressor assembly **20**.

Example 2.

[0107] FIG. 20 is a second table of example performance characteristics for an example embodiment. FIG. 20 contains combinations of further performance characteristics exhibited by an embodiment of compressor assembly **20**.

Example 3.

[0108] FIG. 21 is a table containing a third example of performance characteristics of an example compressor assembly **20**. In the Example of FIG. 21, a compressor assembly **20** having an air ducting shroud **485**, a dampening ring **700**, an intake muffler **900**, four sound control chambers, a fan cover, four foam sound absorbers and a tank seal **600** exhibited the performance values set forth in FIG. 21.

[0109] FIGS. 22 and 23 illustrate a top view of a feed air system **905** having an intake muffler **900** (also herein as "compressor intake muffler **900**" or "muffler **900**").

[0110] The feed air system **905** can feed air to be compressed along the feed air path **922** (FIG. 23) from a feed air port **952** to the cylinder head **61**. In an embodiment, air can be fed from an optional inertia filter **949** which can be present in the air ducting shroud **485** (FIG. 22). In an embodiment, the intake muffler **900** can be in the feed path to the cylinder head **61**. In an embodiment, the air ducting shroud **485** is optional. In an embodiment, a muffler **900** can be used without an air ducting shroud **485**. In an embodiment, a muffler **900** can be used without an inertia filter. In an embodiment, a muffler **900** can be used with an inertia filter and without an air ducting shroud **485**. In an embodiment, an intake muffler **900** can be used in conjunction with a mechanical air filter, and/or air filter material.

[0111] FIG. 23 further is a sectional view of the inertia filter **949** and the intake muffler **900**. The feed air port **952** can provide feed to an air intake hose **953**. The air intake hose **953** can connect with an intake muffler feed

line **898** which can have a muffler feed line inlet portion **897** and a muffler feed portion **899**. The muffler feed portion **899** can feed the intake muffler **900**. The intake muffler **900** can have a muffler outlet line **902**. The muffler outlet line **902** can have a muffler outlet portion **901** and a hose feed portion **903**.

[0112] In the example embodiment illustrated in FIG. 22, the muffler outlet line **902** can have a head feed centerline **1902** which can be at an angle **1991** of 146 degrees as measured from the intake muffler intake centerline **1898** of the intake muffler feed line **898** in a top view as depicted in FIG. 22.

[0113] FIG. 23 further illustrates the inertia filter **949** which can have an inertia filter chamber **950** and the feed air port **952**. The inertia filter **949** can be a maintenance-free intake filter. The combination of the intake muffler **900** and the inertia filter **949** can reduce the sound level of an air compressor and provide a maintenance-free intake filter. The inertia filter feed air port **952** can optionally have a small diameter; in non-limiting example having a value in the range of 0.05 to 2.0 in. In an embodiment, the internal diameter (also herein as "ID") of the feed air port **952** exiting the inertia **949** filter can have a value in a range of from 0.1 in to 6 in. In an embodiment, the ID of the feed air port **952** exiting inertia filter can be 0.400 in or smaller. In an embodiment, the ID of the feed air port **952** exiting inertia filter can be, e.g. 0.75 in, or 0.50 in, or 0.4 in, or 0.3 in, or 0.20 in, or smaller.

[0114] The feed air port **952** can provide feed to the intake muffler **900**. The inertia filter **949** can prevent particulates, e.g. dirt particles, from entering the cylinder head **61** and/or compressor and/or compressor system. In an embodiment, the inertia filter **949** can be used in conjunction with a filter and/or filter media. In an embodiment, the inertia filter **949** can prevent degrading of the compressor performance because it can prevent the accumulation of particulates and dirt and can protect the compressor and its components, e.g. the pump cylinder **60** and the piston **63** from being exposed to damaging particles. Additionally, the inertia filter **949** can have a very low pressure drop, which can be less than 1 psi, e.g. 0.05 psi, or less.

[0115] In an embodiment, the inertia filter **949** can block and/or attenuate a portion of the noise produced by the pump assembly **25**, e.g. from the cylinder head **61**. In an embodiment, the compressor assembly **20** can have both an inertia filter **949** and an intake muffler **900** to achieve reduction of the noise level of the compressor assembly **20**.

[0116] FIG. 23 illustrates the feed air system **905** having a feed air path **922** which is fed from inertia filter **949**. Compressed air feed enters the feed air path **922** through the feed air port **952**, then can pass through the intake muffler feed line **898**, then through the intake muffler **900** then can pass through the muffler outlet line **902**, then can pass through the cylinder head feed hose **904** and then through a cylinder head intake port **920**.

[0117] In an embodiment, the ID of the cylinder head

intake port **920** can have a value in a range of from 0.15 in to 3.0 in. In an embodiment, the ID of the cylinder head intake port **920** can have a value in a range of from 0.25 in to 1.75 in. In an embodiment, the ID of the cylinder head intake port **920** can have a value in a range of from 0.25 in to 0.50 in. In an embodiment, the ID of the cylinder head intake port **920** can be 0.380, or smaller.

[0118] In an embodiment, the intake muffler **900** can include a large chamber which can be a muffler chamber **910** with two tubes extending therefrom, e.g. the intake muffler feed line **898** and the muffler outlet line **902**. The muffler chamber **910** can optionally be large, or larger, in diameter as compared to the diameter of the intake muffler feed line **898** or the diameter of the muffler outlet line **902**. Optionally, the two tubes can be smaller in diameter as compared to the muffler chamber **910**. In an embodiment, the volume of muffler chamber **910** can have a volume with a value in a range of from 3.14 in³ to 150 in³, or greater. In an embodiment, the volume of muffler chamber **910** can be 10.85 in³. In an embodiment, the volume of muffler chamber **910** can be 30 in³. In a non-limiting example, these two small tubes can be an intake muffler feed line **898** and a muffler outlet line **902**. In an embodiment, the volume of muffler chamber **910**, the volume of the intake muffler feed line **898**, and the volume of the muffler outlet line **902** can have a total volume of 11.75 in³.

[0119] The feed air port **952** can be plumbed so that it is located in and/or fed from the path of the high velocity cooling air for the compressor. It can be assembled perpendicular to this high velocity flow to provide the inertia filter **949**. The muffler outlet line **902** can be a tube which connects to the small intake opening in the head.

[0120] In an embodiment, the feed air port **952** can be plumbed so that it is located in and/or fed from the path of the high velocity cooling air for the compressor. It can be assembled perpendicular to this high velocity flow to provide the inertia filter **949**.

[0121] The cylinder head **61** can include a head cavity **461** which encloses the intake valve area **463**. The cylinder head **61** can have a cylinder head intake port **920**. In an embodiment, the cylinder head intake port can be larger than the diameter of at least one element of the feed air path **922** to the cylinder head intake port **920**. In an embodiment, elements of the feed air path **922** can include the feed air port **952**, the intake muffler feed line **898**, the intake muffler **900**, the muffler outlet line **902** and cylinder head feed hose **904**. For example, the feed air port **952** can have an inner diameter which is smaller than an inner diameter of the cylinder head intake port **920**. In an embodiment, by having a diameter along the feed air path **922**, which can be smaller than the diameter of the cylinder head intake port **920**, the smaller diameter opening can dampen or attenuate noise generated inside of the pump and which can escape through the cylinder head intake port **920**.

[0122] In a non-limiting example, unwanted noise can escape through a plurality of an intake port **103** of the

valve plate assembly **62** of the cylinder head **61**. The intake muffler **900** can dampen or muffle noise which can escape from, for example, the cylinder head **61**.

[0123] In an embodiment, the sound waves escaping through the small opening in the cylinder head **61** can travel through a first tube, such as the muffler outlet line **902**, and into the large chamber, such as the muffler chamber **910**. The waves can expand and move around in the muffler chamber **910** and can be attenuated before some of them travel out from a second tube, e.g. the intake muffler feed line **898**, and then out of compressor assembly **20**, and optionally to the atmosphere. The muffler can reduce the noise emitted from the intake muffler feed line **898** and/or the cylinder head **61**. In an embodiment, intake muffler **900** can have a muffler chamber **910** can have a rounded and/or curved shape such as oval or spherical and be such that the shape eliminates flat walls which could be excited and generate additional sound waves and/or noise. In an embodiment, the intake muffler **900** and/or the muffler chamber **910** can be produced by a blow molding process. In an embodiment, the intake muffler **900** and/or the muffler chamber **910**, as well as the first tube, such as the muffler outlet line **902**, and the second tube, such as the intake muffler feed line **898**, to the atmosphere can be produced as one part by a blow molding process.

[0124] In an embodiment, the intake muffler **900** and/or the muffler chamber **910**, as well as the first tube, such as the muffler outlet line **902**, and the second tube, such as the intake muffler feed line **898**, can be produced by the blow molding process such that all or part of the blow-molded piece can have an average wall thickness of 0.05 in. The intake muffler **900** and/or the muffler chamber **910** can be blow-molded as separate parts which can be joined together. A multi-piece production process can simplify fabrication and achieve consistent wall thicknesses, which can range in thickness from 0.02 in to 0.25 in, such as 0.025 in, or 0.03 in, or 0.05 in, or 0.075 in, or 0.125 in.

[0125] In embodiments, the intake muffler **900** and/or the muffler chamber **910** can be manufactured as one, two, three, four, or more pieces. The piece and/or pieces can be manufactured by one or more processes, such as, but not limited to, blow molding, injection molding, thermoset molding, milling or other process. The materials of production can be any of, but not limited to, plastic, polymer, fiberglass, composites, ceramics, metal, glass, woven materials, woven mesh, woven wires or other material. In an embodiment, the intake muffler **900** can have the first tube, such as the muffler outlet line **902**, and the second tube, such as the intake muffler feed line **898**, which have inner diameters which are the same or different.

[0126] In an embodiment, the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** can be the same as the inner diameter of the intake port **920**, or less than the inner diameter of the intake port **920**. In an embodiment the inner diameter of the

intake muffler feed line **898** and/or the muffler outlet line **902** can be in a range of 50% to 100%, such as 50%, or 75%, or 80%, or 90%, or 95%, or 97% of the inner diameter of the intake port **920**.

[0127] In an embodiment, the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** to the inner diameter of the intake muffler **900** can be in a range of 5% to 75% of an inner dimension of the intake muffler **900**, such as 10%, or 25%, or 33%, or 40%, or 45%, or 50%, or 55%, or 60%, or 75%. In an embodiment in which the intake muffler **900** has an inner diameter, the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** to the inner diameter of the intake muffler **900** can be in a range of 40% to 50%, of the inner diameter of the intake muffler **900**, such as 42%, or 42.5%, or 45%, or 47.5%, or 48%. In an embodiment, the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** can be equal to or greater than 0.25 in. In an embodiment the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** can be less than 0.5 in. In an embodiment, the inner diameter of the intake muffler feed line **898** and/or the muffler outlet line **902** can be in a range of from 0.2 in to 3 in, such as 0.25 in, or 0.5 in, or 0.75 in, or 1.0 in, or 1.25 in, 1.3 in, or 1.4 in, or 1.5 in, or 1.6 in, or 1.7 in, or 1.75 in, or 2.0 in.

[0128] In other embodiments, the inner cross sectional area of the intake muffler feed line **898** and/or the muffler outlet line **902** can be in a range of from 5% to 80% of an inner cross sectional area of the muffler, such as 15%, or 20% , or 25%, or 30%, or 35%, or 40%, or 50%.

[0129] The intake muffler **900** can lower the noise level (sound level) emitted from the pump assembly **25**, cylinder head **61** and/or compressor assembly **20**.

[0130] In an embodiment, the feed air **990** fed to the feed air system **905** undergoes an abrupt change in flow direction from the direction taken by the air which becomes cooling air as the feed air **990** exits the air ducting shroud **485** and enters feed air port **952**. Particles contained in the portion of cooling air stream **2000** which becomes feed air **990** by entering feed air port **952** pass by the feed air port **952** as a consequence of the inertia of the particles.

[0131] FIG. 24 is a sectional view of the muffler. FIG. 24 illustrates a muffler **900** which can have a major internal chord **880** which can have a distance which can optionally be measured along a muffler major axis **2899**. The major internal chord **880** optionally can be coaxial with the muffler feed centerline **1899**. In an embodiment, the major internal chord **880** can have an ID in a range of from 1.0 in to 16.0 in. In an embodiment, the major internal chord **880** can be an ID with a distance of 3.40 in. In an embodiment, the OD along the major axis length collinear with muffler feed centerline **1899** of muffler can be 3.500 in.

[0132] The muffler **900** can also have a minor internal chord **882** which can optionally be measured along a muffler minor axis **884** can be an ID with a distance of

1.800 in. In an embodiment, the minor internal chord **882** can have an ID in a range of from 1.0 in to 16.0 in. In an embodiment, the OD of minor axis width of muffler can be 1.900 in.

[0133] In an embodiment, the ratio of the internal chord **880** to the minor internal chord **882** can have a value in a range of from 1.0 to 12.0, or greater. In an embodiment, the ratio of the major internal chord **880** to the minor internal chord **882** can be greater than 1.2. In an embodiment, the ratio of the major internal chord **880** to the minor internal chord **882** can be greater than 1.5. In an embodiment, the ratio of the major internal chord **880** to the minor internal chord **882** can be greater than 4.0. In an embodiment, the ratio of the major internal chord **880** to the minor internal chord **882** can be 1.88.

[0134] FIG. 23A is a sectional view of a high velocity muffler system **5000** which can contribute to achieving very low compressor assembly noise values, such as 60 dBA to 70 dBA, or 65 dBA to 70 dBA, or 65 dBA to 75 dBA, or 60 dBA to 75 dBA, when the compressor assembly **20** is compressing the gas. The compressor assembly **20** noise values of 60 dBA to 75 dBA can be achieved by the designs disclosed herein at high capacities of use, for example: cooling fan flowrates of 50 SCFM to 100 SCFM; and/or heat transfer rates of 60 BTU/min to 200 BTU/min; and/or compressing 2.0 SCFM to 3.5 SCFM to outlet pressures equal to or greater than 25 PSIG, such as 50 PSIG, or 75 PSIG, or 135 PSIG, or 150 PSIG, or 175 PSIG, or 200 PSIG, or higher.

[0135] As shown in FIG. 23A, the high velocity muffler system **5000** can have an inertia filter **949** which can have any of a variety of designs, such as a T-inertia filter (FIG. 23A), or a stepped inertia filter **2999** (FIG. 24B and FIG. 24C), or a recessed inertia filter **2988** (FIG. 24D). The inertia filter **949** can operate under positive or negative pressure and can draw feed air in through the feed air port **952**. Particles bypass the inertia filter inlet because the particles' inertia and direction of movement, such as in-line with the direction of air feed flow **948**. The movement of particles past the feed air port **952** of inertia filter **949** can be such that the particles are not drawn into the feed air port **82** and which as a result can produce a particle-free flow of air into the air port **952**. The particles passing and not entering the feed air port **952** can result in a particle-free flow of a compressor pump feed **985** which can feed the cylinder head **61**. The compressor pump feed **985** can be fed to the cylinder head **61** of the pump assembly **25**. The particle-free flow of the compressor pump feed **985** eliminates the need for filter media in the compressor pump feed system, such as in the high velocity muffler system **5000**, and keeps the compressor feed path and high velocity muffler system **5000** clean of accumulated particulates and maintenance-free.

[0136] The inertia filter can filter a broad variety of materials from the cooling air which is drawn into the feed air port **952** to become the compressor pump feed **985**. FIG. 29 is a table of filtered particle size distribution data for particles which can be filtered by the inertia filter **949**

to produce the compressor pump feed **985**. The type of particles which can be inertia filtered is without limitation. In an embodiment, particles having sizes greater than 0.001 μ can be filtered by inertia filtering. FIG. 29 provides non-limiting examples of particles and particle sizes which can be present in cooling air and removed from the compressor pump feed **985** by inertia filtering by the inertia filter **949**. Such particles include but are not limited to drywall dust; sand; saw dust; cement dust; airborne liquid droplets; dry clay; atmospheric dust; diatomaceous earth; airborne paint; graphite brush dust; joint compound; and airborne liquid water droplets. In the examples herein, "drywall dust" means dust having a dimension equal to 1 μ or greater which can result from the sanding of applied and dried drywall joint compound. In the examples herein, "joint compound" means dry powdered drywall joint compound having a dimension of equal to 1 μ or greater.

[0137] As shown in FIG. 29, particles which can be filtered by the inertia filter **949** can range from 0.00075 p, such as for tiny particle size atmospheric dust, to 10000 μ or larger, such as for sand particles. The inertia filter **949** can remove any type of particles which can shorten the life of the compressor assembly **20** and/or cylinder head **61**. The inertia filter **949** can remove particles equal to or greater than 0.05 μ which have sufficient inertia to pass across the feed air port **952** without being drawn onto the compressor pump feed **985**. The following are non-limiting examples of a selection of particles selected from a broad variety of particle types which can be filtered by the inertia filter **949**. For example, the inertia filter **949** can remove particles of drywall dust having a particle size equal to or greater than 0.75 μ , such as 1 p, or 1.5 p, or 2 p, or 3 p, or 5 p, or greater. The inertia filter **949** can remove particles of sand having a particle size equal to or greater than 60 μ , such as 100 μ , or 5050 p, or 10000 p, or greater. The inertia filter **949** can remove particles of saw dust having a particle size equal to or greater than 20 p, such as 30 p, or 315 p, or 600 p, or greater. The inertia filter **949** can remove particles of cement dust having a particle size equal to or greater than 0.5 p, such as 1 p, or 3 p, or 52 p, or 100 p, or greater. The inertia filter **949** can remove particles of dry clay having a particle size equal to or greater than 0.05 p, such as 0.1 p, or 25 p, or 50 p, or greater. The inertia filter **949** can remove particles of graphite brush dust having a particle size equal to or greater than 1 p, such as 5 p, or 20 p, or 90 p, or greater. The inertia filter **949** can remove particles of airborne paint having a particle size equal to or greater than 4 p, such as 7 p, or 20 p, or 10 p, or greater. The inertia filter **949** can remove particles of airborne liquid droplets and/or airborne liquid water droplets having a particle size equal to or greater than 0.2 p, such as 0.5 p, or 3 p, or 5 p, or greater.

[0138] In another respect, FIG. 30 provides a table of average momentum for particles and particle sizes which can be inertia filtered by embodiments of the inertia filter **949**. Momentum values disclosed herein assume a

spherical particle shape and an air velocity at the entrance to the inertia filter of 15.98 m/sec of cooling air passing across the feed air port **952** of the inertia filter **949**. For example, the inertia filter **949** can remove particles of sand having a mass of 8.33×10^{-7} g or greater and a momentum of 1.33×10^{-8} kg m/sec or greater. Saw dust having a mass of 4.10×10^{-9} g or greater and a momentum of 6.55×10^{-11} kg m/sec or greater can be removed by the inertia filter **949**. Graphite brush dust having a mass of 5.04×10^{-11} g or greater and a momentum of 8.05×10^{-13} kg m/sec or greater can be removed by the inertia filter **949**. Cement dust having a mass of 1.13×10^{-11} g or greater and a momentum of 1.81×10^{-13} kg m/sec or greater can be removed by the inertia filter **949**. Joint compound having a mass of 3.36×10^{-13} g or greater and a momentum of 1.41×10^{-15} kg m/sec or greater can be removed by the inertia filter **949**. Airborne liquid water droplets having a mass of 6.53×10^{-14} g or greater and a momentum of 1.04×10^{-15} kg m/sec or greater can be removed by the inertia filter **949**. Dry clay having a mass of 4.19×10^{-16} g or greater and a momentum of 6.69×10^{-18} kg m/sec or greater can be removed by the inertia filter **949**. Drywall dust having a mass of 3.36×10^{-16} g or greater and a momentum of 5.36×10^{-18} kg m/sec or greater can be removed by the inertia filter **949**.

[0139] FIG. 30 provides a table of moment of inertia and particle sizes which can be inertia filtered by embodiments of the inertia filter **949**. Moment of inertia values disclosed herein assume a spherical particle shape and a cooling air velocity passing across the inertia filter **949** at the feed air port **952** of 15.98 m/sec. For example, the inertia filter **949** can remove particles of sand having a mass of 8.33×10^{-7} g or greater and a moment of inertia of 8.33×10^{-19} kg*m² or greater. Saw dust having a mass of 4.10×10^{-9} g or greater and a moment of inertia of 3.69×10^{-22} kg*m² or greater can be removed by the inertia filter **949**. Graphite brush dust having a mass of 5.04×10^{-11} g or greater and a moment of inertia of 1.26×10^{-25} kg*m² or greater can be removed by the inertia filter **949**. Cement dust having a mass of 1.13×10^{-11} g or greater and a moment of inertia of 1.02×10^{-26} kg*m² or greater can be removed by the inertia filter **949**. Joint compound having a mass of 3.36×10^{-13} g or greater and a moment of inertia of 3.36×10^{-29} kg*m² or greater can be removed by the inertia filter **949**. Airborne liquid water droplets having a mass of 6.53×10^{-14} g or greater and a moment of inertia of 1.63×10^{-30} kg*m² or greater can be removed by the inertia filter **949**. Dry clay having a mass of 4.19×10^{-16} g or greater and a moment of inertia of 4.19×10^{-34} kg*m² or greater can be removed by the inertia filter **949**. Drywall dust having a mass of 3.36×10^{-16} g or greater and a moment of inertia of 3.36×10^{-34} kg*m² or greater can be removed by the inertia filter **949**.

[0140] The momentum and moment of inertia values herein are not limiting and a wide range of particle shapes, and cooling air velocities across the entrance of

the feed air port **952** of the inertia filter **949**, are encompassed by this disclosure. For example, the air velocities across the entrance of the inertia filter can range from 7 m/sec to 50 m/sec, such as 10 m/sec, or 14 m/sec, or 15 m/sec, or 18 m/sec, or 20 m/sec, or 25 m/sec, or 30 m/sec.

[0141] In an embodiment, the high velocity muffler system **5000** can provide the compressor pump feed **985** at a rate of 1.5 SCFM to 4.0 SCFM. The velocity of inertia filter flow rates feeding the intake muffler **900** and/or cylinder head **61** can be in a range of 2686 ft/min to 7164 ft/min.

[0142] The high velocity muffler system **5000** having an inertia filter **949** can be a particle-free muffler system providing a particle-free feed stream to the cylinder head **61**. Herein, "particle-free" means any compressor pump feed **985** which has been filtered by the inertia filter. The filtering action of the inertia filter can produce the compressor pump feed **985** which is free of particulate matter and can be considered a particle-free feed stream to the compressor pump **299** having cylinder head **61**.

[0143] In an embodiment, the inertia filter and muffler do not have any filter medium. Herein, "maintenance-free muffler" means any muffler not having filter medium, or which has a filter medium which receives, as feed, a gas which has been filtered by the inertia filter **949**. In an embodiment, the feed pathway from the inertia filter chamber **950** through the cylinder head **61** is free of any filter medium. The use of the inertia filter and the elimination of a need to use filter media eliminates any need for maintenance, or filter media replacement, to keep the feed pathway clear of buildup and the high velocity muffler system **5000** achieves a very low pressure drop.

[0144] In an embodiment, the inertia filter can remove 95% or greater of particles present in the cooling air passing the feed air port **952** at a velocity of 15.98 m/sec when the particles' diameter is equal to or greater than 1μ . Herein, the percentage of particles removed is also referred to as the "efficiency" of the filter. In an embodiment, the inertia filter removed 99% or greater of the particles present in the cooling air passing the feed air port **952** at a velocity of 15.98 m/sec when the particles' diameter is equal to or greater than 1μ . In other embodiments, the inertia filter removed 99% or greater of the particles having particle sizes greater than 3μ present in the cooling air passing the feed air port **952** at a velocity of 15.98 m/sec when the particles' diameter is equal to or greater than 3μ . In another embodiment, under drywall dust particle conditions, the inertia filter removed particles in a range of from 95% to greater than 99% efficiency for particles having particle diameters equal to and greater than 1μ . In another embodiment, the inertia filter can remove from 95% to greater than 99% of drywall dust particles having a mass equal to or greater than 8.84×10^{-14} g and a momentum of 1.41×10^{-15} kg m/sec or greater.

[0145] The efficiency of the inertia filter **949** of the high velocity muffler system **5000** and the low contamination of particles in the compressor pump feed **985** can dramatically lengthen the lifespan of the compressor assem-

bly **20**. An inertia filter **949** can have a high efficiency even under harsh conditions of use, such as the intake of cooling air feed having very high particle counts. For non-limiting example, a cooling air feed having a high particle count can exist when a thick cloud of drywall dust is present in the source of the cooling air feed. In an embodiment, drywall dust having a concentration in a range of 100-5000 mg/m³ can be removed with an efficiency in a range of from 90% to 99% or greater, or 95% to 99% or greater. The high velocity muffler system **5000** having an inertia filter **949** can be used in various embodiments to achieve an operating life of the compressor assembly **20** of 25 years or greater.

[0146] By another measure, the high velocity muffler system **5000** having an inertia filter **949** can be used to achieve an operating life of the compressor assembly **20** of, for example 500 hrs or greater of maintenance-free use. In an embodiment, the high velocity muffler system **5000** having an inertia filter **949** can be used to achieve an operating life of the pump assembly **25** and/or the pump cylinder **60** and/or cylinder head **61** of the pump assembly **25** of, for example 500 hrs or greater of maintenance-free use.

[0147] In an embodiment, the high velocity muffler system **5000** having an inertia filter **949** can be a low pressure drop muffler system. In an embodiment, the pressure drop across the inertia filter **949** can be 0.08 psi to 0.37 psi and the pressure drop across the intake muffler **900** can be 0.13 psi to 0.56 psi. The pressure drop across the high velocity muffler system **5000** from the feed air port **952** of the inertia filter to the exit of the or the muffler chamber **910** and/or cylinder head **61** intake can be less than 1 psi, such as in a range of 0.21 psi to 0.93 psi.

[0148] FIG. 24 is an embodiment of a rear view of the geometry of an example feed air path **922**. In an embodiment, muffler feed angle **2899** can have an angle in a range of from 66 degrees to 145 degrees. In an embodiment, muffler feed angle **2899** can be 90 degrees and muffler outlet angle **2901** can be 90 degrees.

[0149] The muffler outlet portion **901** can have a muffler outlet centerline **1901**. The hose feed portion **903** can connect to the cylinder head feed hose **904** which can provide compressed air feed to cylinder head intake port **920**.

[0150] In an embodiment, the muffler feed centerline **1899** and the muffler outlet centerline **1901** cross at an angle in a range of from 66 degrees to 156 degrees. In an embodiment, the muffler feed centerline **1899** and the muffler outlet centerline **1901** are perpendicular to each other.

[0151] In an embodiment, muffler inlet angle **2954** can have a value of from 33 degrees to 156 degrees. In an embodiment, muffler inlet angle **2954** can be 51.9 degrees. In an embodiment, head feed angle **2061** can be 38.1 degrees. In an embodiment, feed tilt angle **2955** can be 38.1 degrees. In an embodiment, muffled feed tilt angle **2956** can be 51.9 degrees.

[0152] In an embodiment, the inner diameter (also

herein as "ID") of an air intake hose **953**, can be 0.500 in. In an embodiment, the ID of the intake muffler feed line **898** can be 0.400 in. In an embodiment, the ID of muffler feed orifice **954** can be 0.370 in. In an embodiment, the ID of the muffler exit orifice **957** can be 0.370 in. In an embodiment, the ID of the muffler outlet line **902** can be 0.400 in. In an embodiment, the ID of the cylinder head feed hose **904** can be 0.500 in.

[0153] FIG. 24A is a sectional view of example inertia filter feed configurations. In an embodiment, the inertia filter **949** can be configured such that the inertia filter axis **947** can have an inertia filter feed angle **2952** which can be perpendicular to the direction of air feed flow **948**. In other embodiments, the inertia filter feed angle **2952** can be greater than 90° or less than 90°. In an embodiment, the inertia filter feed angle **2952** can have a value in a range of from 90° to 115°, or from 90° to 135°.

[0154] FIG. 24A shows by phantom lines an inertia filter **949** which has a counterflow feed angle **2997** of 45°. Herein, the inertia filter feed angle **2952** which is less than 90° is considered to constitute, and is synonymous with, a counterflow feed angle **2997**. The counterflow feed angle **2997** can have any value greater than zero and less than 90°, such as 33°, or 45°, or 66°, or 75°, or 80°, or 89°.

[0155] FIG. 24A shows by phantom lines a low pressure drop feed line **2951** configured to reduce pressure drop between the inertia filter chamber **950** and the intake muffler **900**. In an embodiment, the low pressure drop feed line **2951** can comprise at least one angle which is not 90°. FIG. 24A illustrates an embodiment in which each of a line angle **2995**, **2985**, **2975** and **2965** are 135°. In the embodiment of FIG. 24A no angle of the low pressure drop feed line **2951** is 90°. One or more of the line angles can be less than or greater than 90°. In an embodiment, the low pressure drop feed line **2951** can be in part or wholly, curved, U-shaped, semicircular, sinusoidal, spiral or bent.

[0156] FIG. 24B is a sectional view of a stepped inertia filter **2999**. A stepped inertia filter **2999** can have one or more steps between a source location of feed air and the feed air port **952**. In an embodiment, the stepped inertia filter can have one or more steps, such as 1 ... n steps, in which for example n=1 to 100, located upstream of the feed air port **952**. FIG. 24B shows a stepped inertia filter **2999** having one of a filter feed step **1953**. There is no limit to the number n of filter feed steps which can be used. In an embodiment, one or more filter feed ramps can be used instead of a feed step or a number of feed steps. A combination of one or more filter feed steps and one or more filter feed ramps can also be used. The embodiment of FIG. 24B uses the filter feed step **1953** having a filter ledge **951** and a step shelf **1956** which are separated by a step distance **1951**. In an embodiment, the step distance **1951** can be equal to or greater than 0.25 cm, or in a range of from 0.25 cm to 10 cm, such as 0.5 cm, or 1 cm, or 1.5 cm, or 2 cm, or 2.5 cm, or 3 cm, or greater.

[0157] There is no limitation as to the length of the step distance 1953, or of multiple filter step distances which may be used. The use of one or more of the filter feed step 1953 can increase the efficiency of the inertia filter 949, reduce the particles potentially drawn into the inertia filter 949 and improve the particle-free quality of the compressor pump feed 985 which flows from the high velocity muffler system 5000 and into the cylinder head 61.

[0158] FIG. 24C is a sectional view of example feed configurations of the stepped inertia filter. FIG. 24C shows by phantom lines the stepped inertia filter 2999 having a counterflow feed angle 2997 of 45°. The counterflow feed angle 2997 of the stepped inertia filter 2999 can have any value greater than zero and less than 90°, such as 33°, or 45°, or 66°, or 75°, or 80°, or 89°. The embodiment of FIG. 24C uses the filter feed step 1953 having a filter ledge 951 and the step shelf 1956 which are separated by the step distance 1951.

[0159] FIG. 24D is a sectional view of a recessed inertia filter 2988. FIG. 24D shows an embodiment of a recessed inertia filter 2988 having an inertia filter baffle 2993 which can be in part or wholly configured to have at least a portion which has a baffle angle 2996 which can have a value in a range of from 0° to 90° against the direction of air feed flow 948. The inertia filter baffle 1993 can be an angled member, a curved member, or other shape. FIG. 24D illustrates an embodiment of the recessed inertia filter 2988 having a smoothing baffle 2991 which is shown in phantom lines.

[0160] This disclosure is not limited regarding the location and/or configuration of the recessed inertia filter 2988, with or without, a baffle. The recessed inertia filter 2988, in its various embodiments, encompasses any inertia filter 949 which draws feed from a location which is offset from, or off flow path from, or separated from, or protected from, or partitioned from at least a portion of a source gas and/or a source air flow stream, such as the air feed flow 948, or its equivalent. In an embodiment, a conduit, chamber, feed line, pathway, or other configuration, can be used to locate the recessed inertia filter 2988 in a recessed location from the air feed flow 948.

[0161] FIG. 25 illustrates the use of optional sound absorption materials in the feed air path 922.

[0162] FIG. 25 illustrates the use of optional sound absorption materials in the feed air path 922. Optionally, one or a plurality of sound absorbers can be used at positions along the feed air path 922. Optionally, one or a plurality of an intake hose absorber 870 can be used in an air intake hose 953. Optionally, one or a plurality of an intake muffler feed line absorber 872 can be used in an intake muffler feed line 898. Optionally, one or a plurality of an intake muffler internal absorber 874 can be used in an intake muffler 900. Optionally, one or a plurality of a muffler outlet line absorber 876 can be used in a muffler outlet line 902. Optionally, one or a plurality of a cylinder head feed hose absorber 878 can be used in a cylinder head feed hose 904.

[0163] FIG. 26 is a muffler system which is sinusoidal.

In an embodiment, a feed air path 922 can have a sinusoidal conduit 890. The sinusoidal conduit 890 can optionally be corrugated or have a sound absorbing internal structure.

5 [0164] FIG. 27 is a feed air path which is sinusoidal and has a plurality of cavity mufflers 890.

[0165] FIG. 27 is a feed air path 922 which has a sinusoidal portion 891 which has a plurality of cavity mufflers 893.

10 [0166] FIG. 28 is a feed air path which has a conduit 894 which has a plurality of cavity mufflers 895.

[0167] The scope of this disclosure is to be broadly construed. It is intended that this disclosure disclose equivalents, means, systems and methods to achieve the devices, designs, operations, control systems, controls, activities, mechanical actions, fluid dynamics and results disclosed herein. For each mechanical element or mechanism disclosed, it is intended that this disclosure also encompasses within the scope of its disclosure and teaches equivalents, means, systems and methods for practicing the many aspects, mechanisms and devices disclosed herein. Additionally, this disclosure regards a compressor and its many aspects, features and elements. Such an apparatus can be dynamic in its use and operation. This disclosure is intended to encompass the equivalents, means, systems and methods of the use of the compressor assembly and its many aspects consistent with the description and spirit of the apparatus, means, methods, functions and operations disclosed herein. The claims of this application are likewise to be broadly construed.

[0168] The description of the inventions herein in their many embodiments is merely exemplary in nature and, thus, variations that do not depart from the gist of the invention are intended to be within the scope of the invention and the disclosure herein. Such variations are not to be regarded as a departure from the spirit and scope of the invention.

[0169] It will be appreciated that various modifications and changes can be made to the above described embodiments of a compressor assembly as disclosed herein without departing from the scope of the following claims.

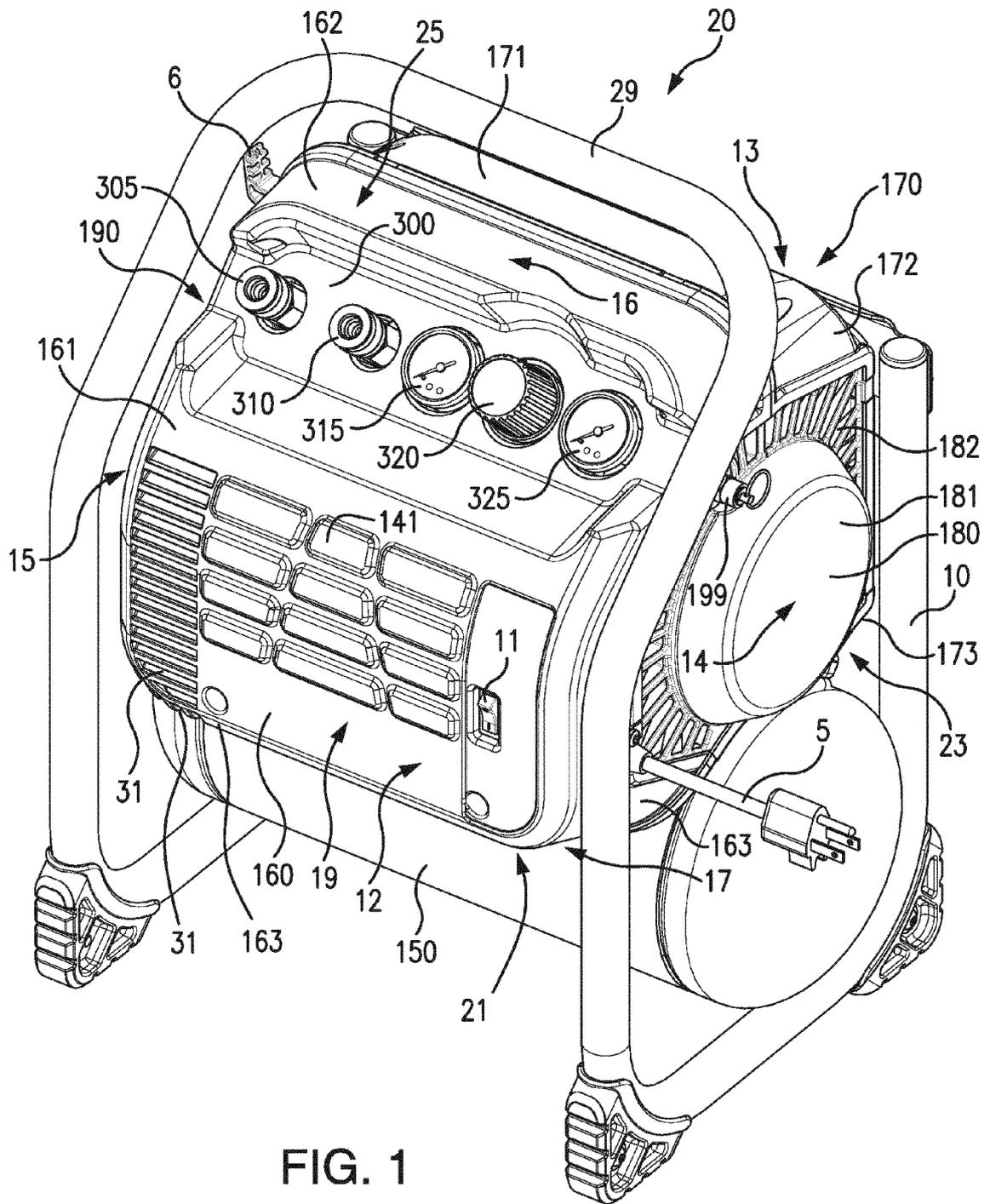
45 Claims

1. A muffler system for a compressor assembly, comprising:

50 an inertia filter; and
a muffler chamber;
wherein the inertia filter filters a gas which is fed to the muffler chamber and which exits the muffler chamber for compression by a pump assembly.

55 2. The muffler system according to claim 1, wherein the gas is air.

3. The muffler system according to claims 1 or 2, wherein the inertia filter is a T-inertia filter, a stepped inertia filter and / or a recessed inertia filter.
4. The muffler system according to claims 1 to 3, wherein the muffler chamber is free of a filter medium. 5
5. The muffler system according to claims 1 to 4, wherein the inertia filter has an inertia filter feed angle in a range of 15° to 90°. 10
6. The muffler system according to claims 1 to 5, wherein the inertia filter has a counterflow feed.
7. The muffler system according to claims 1 to 6, wherein the compressor assembly comprises an inertia filter baffle. 15
8. The muffler system according to claims 1 to 7, further comprising at least one of a muffler feed line and a muffler outlet line which has an inner diameter which is in a range of 5% to 75% of a diameter of the muffler chamber. 20
9. A method for producing a compressor pump feed, comprising the steps of: 25
- providing a compressor pump assembly having an inertia filter, a muffler and a compressor pump; 30
- filtering a gas by inertia filtering to produce a muffler feed;
- feeding the muffler feed to the muffler; and
- feeding a muffler effluent to the compressor pump as a compressor pump feed. 35
10. A method for producing a compressor pump feed according to claim 9, further comprising the step of feeding the muffler feed to the muffler at a rate of 1.5 SCFM or greater. 40
11. A method for producing a compressor pump feed according to claims 9 or 10, wherein the filtering step further comprises the step of filtering a plurality of particles having a dimension equal to or greater than 1 μ. 45
12. A method for producing a compressor pump feed according to claims 9 to 11, wherein the filtering step further comprises the step of filtering a plurality of particles having a momentum of equal to or greater than 6.69x10⁻¹⁸ kg*m/sec. 50
13. A method for producing a compressor pump feed according to claims 9 to 12, wherein the filtering step further comprises the step of filtering a plurality of particles having an inertia of equal to or greater than 4.19x10⁻³⁴ kg*m². 55
14. A method for producing a compressor pump feed according to claims 9 to 13, wherein the filtering step further comprises the step of filtering the gas through a T-inertia filter, a stepped inertia filter and / or a recessed inertia filter.



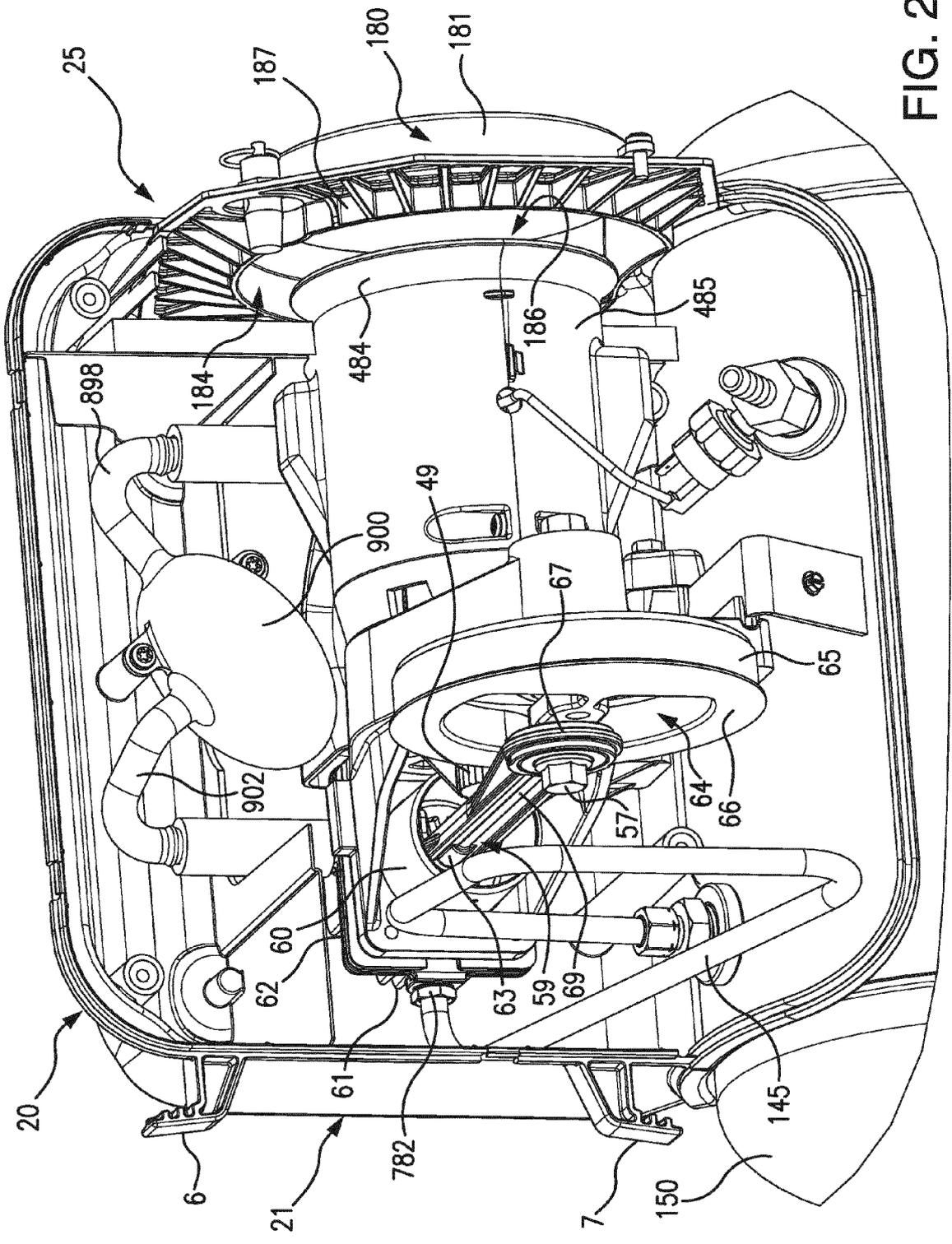
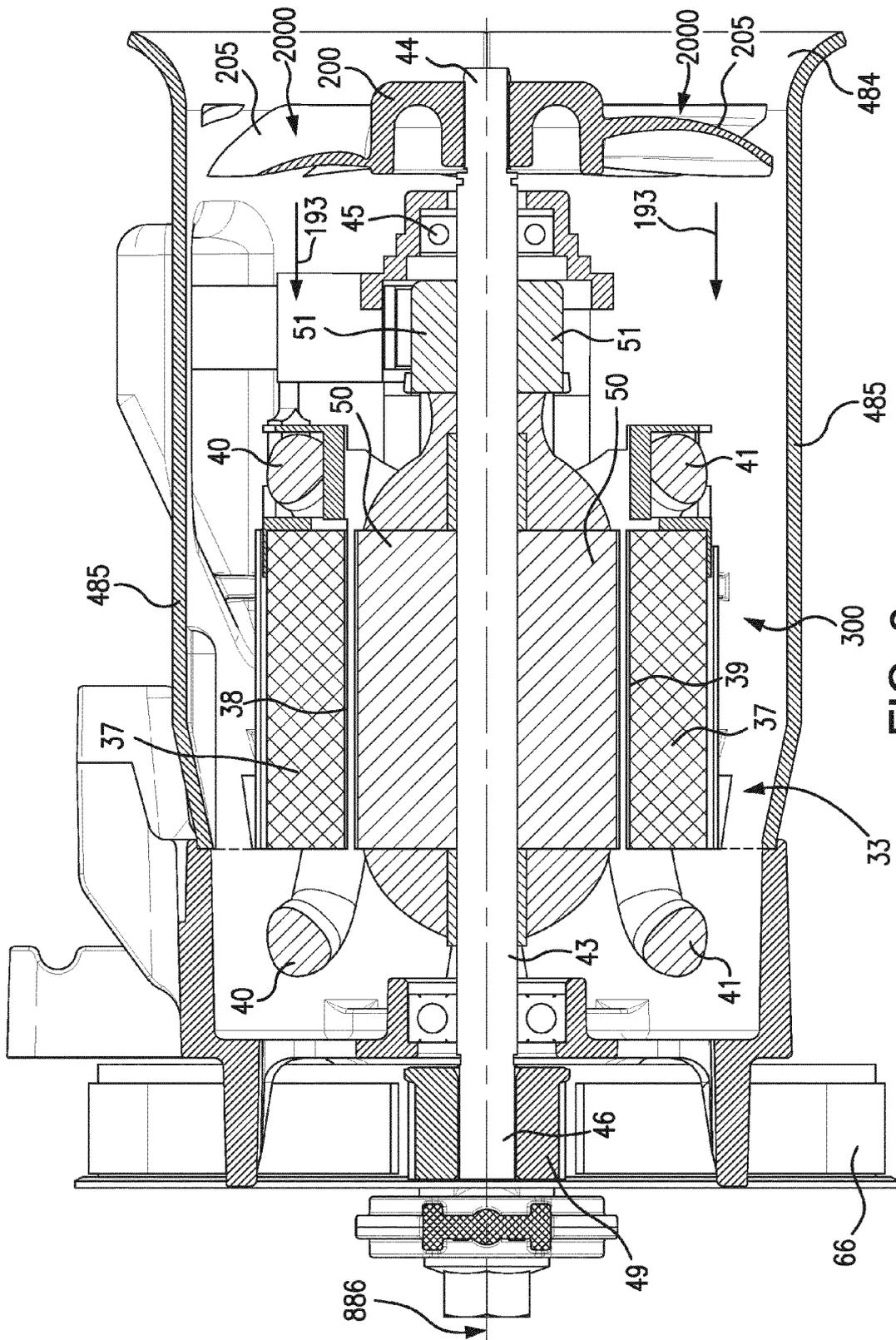


FIG. 2



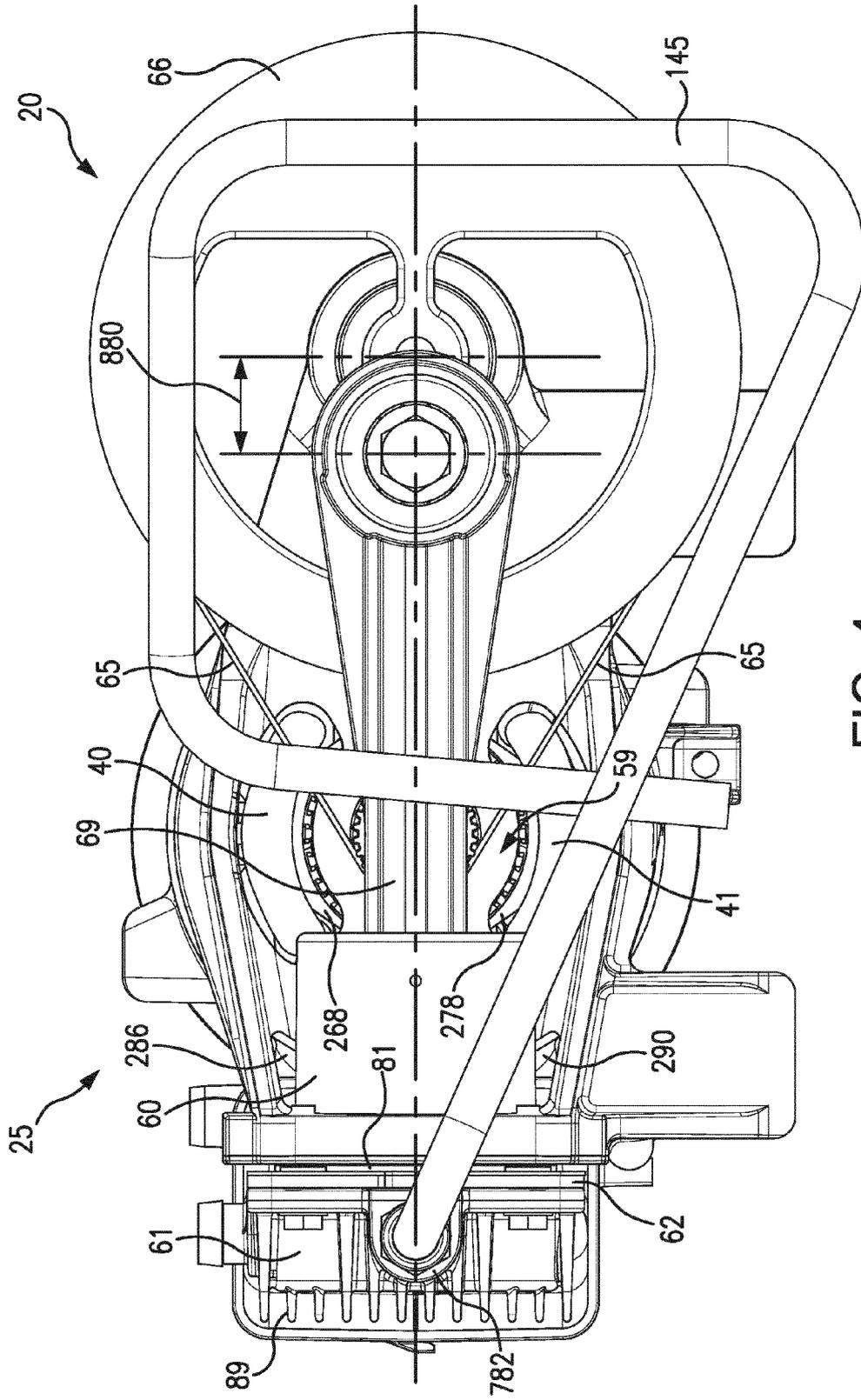


FIG. 4

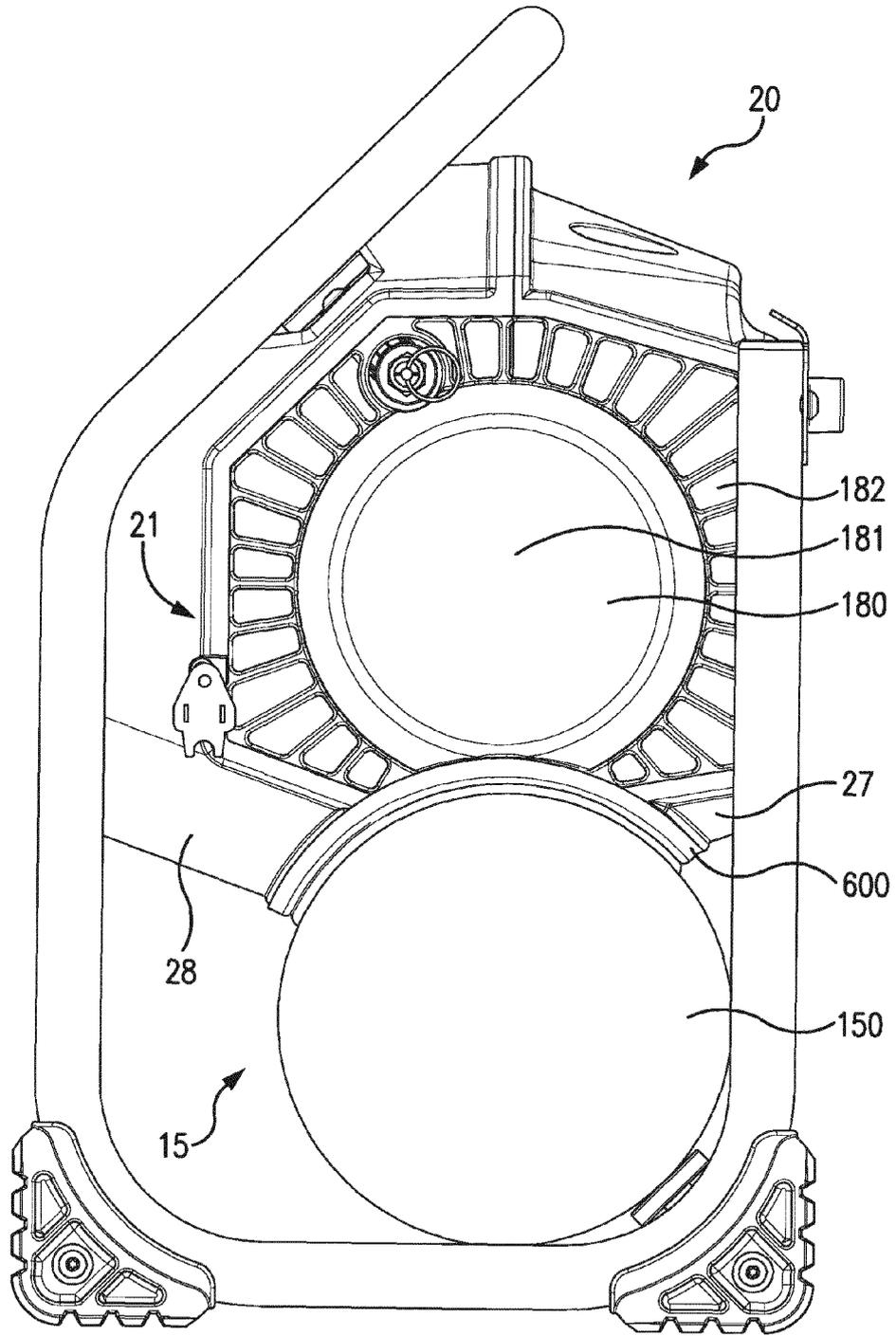
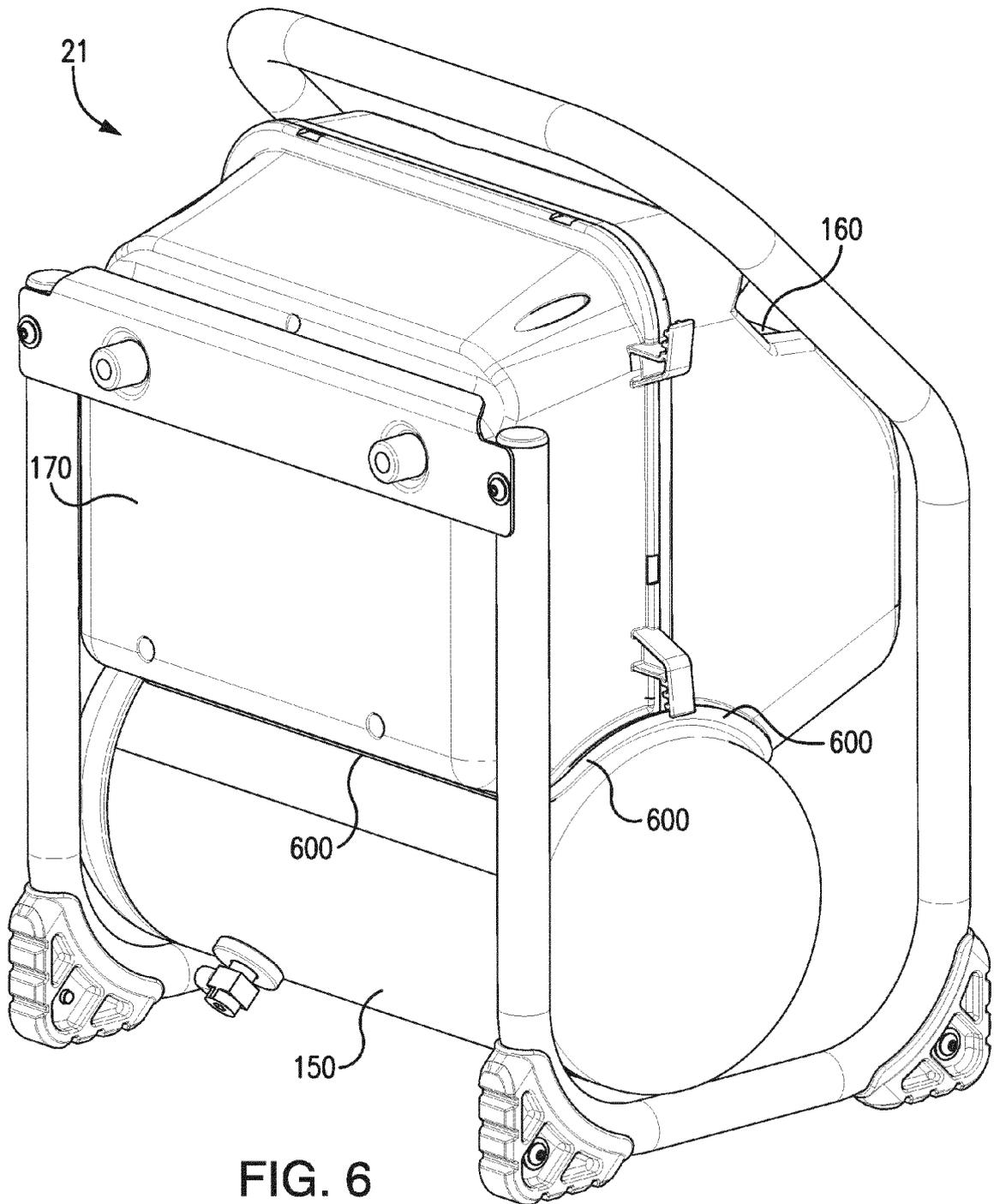


FIG. 5



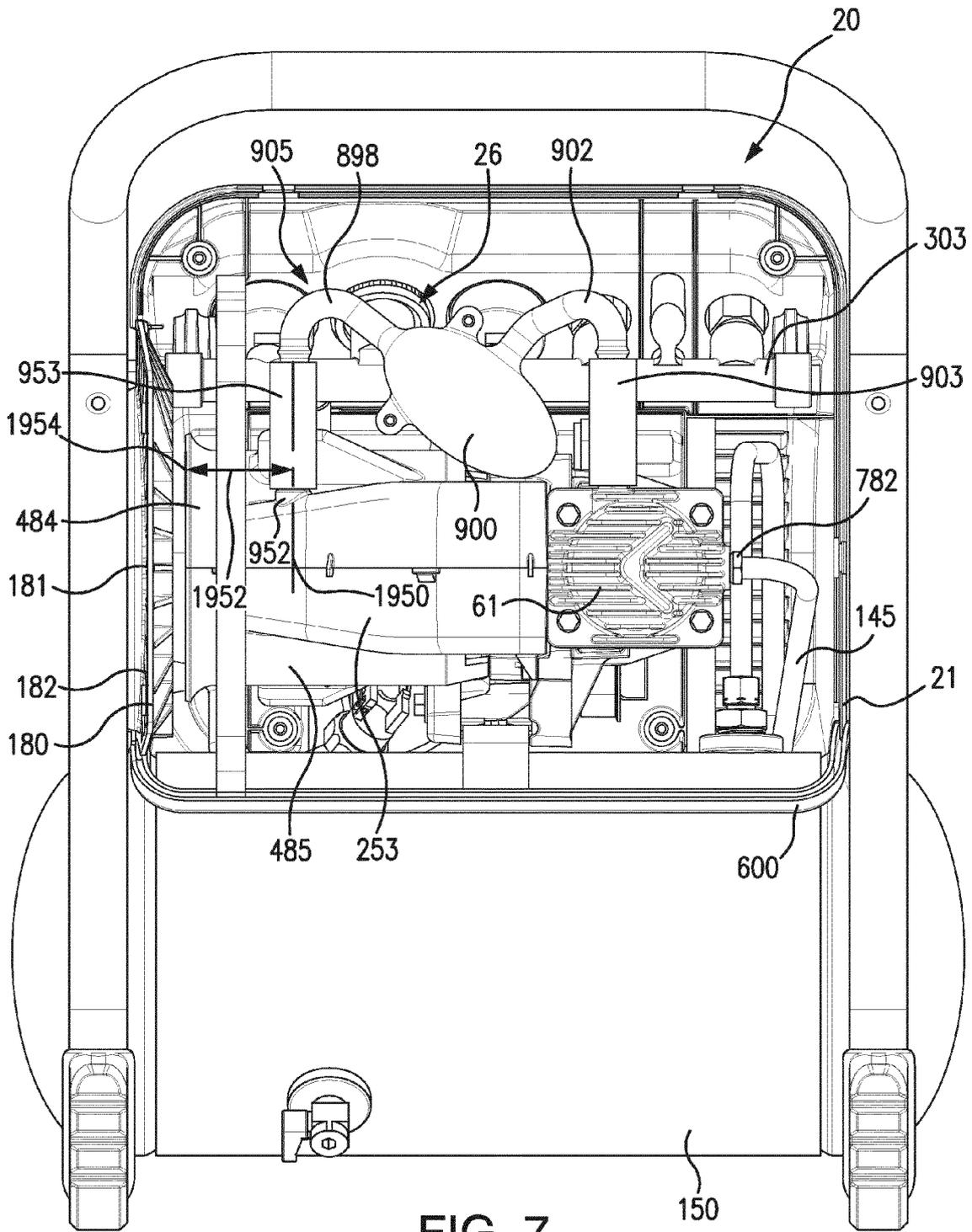


FIG. 7

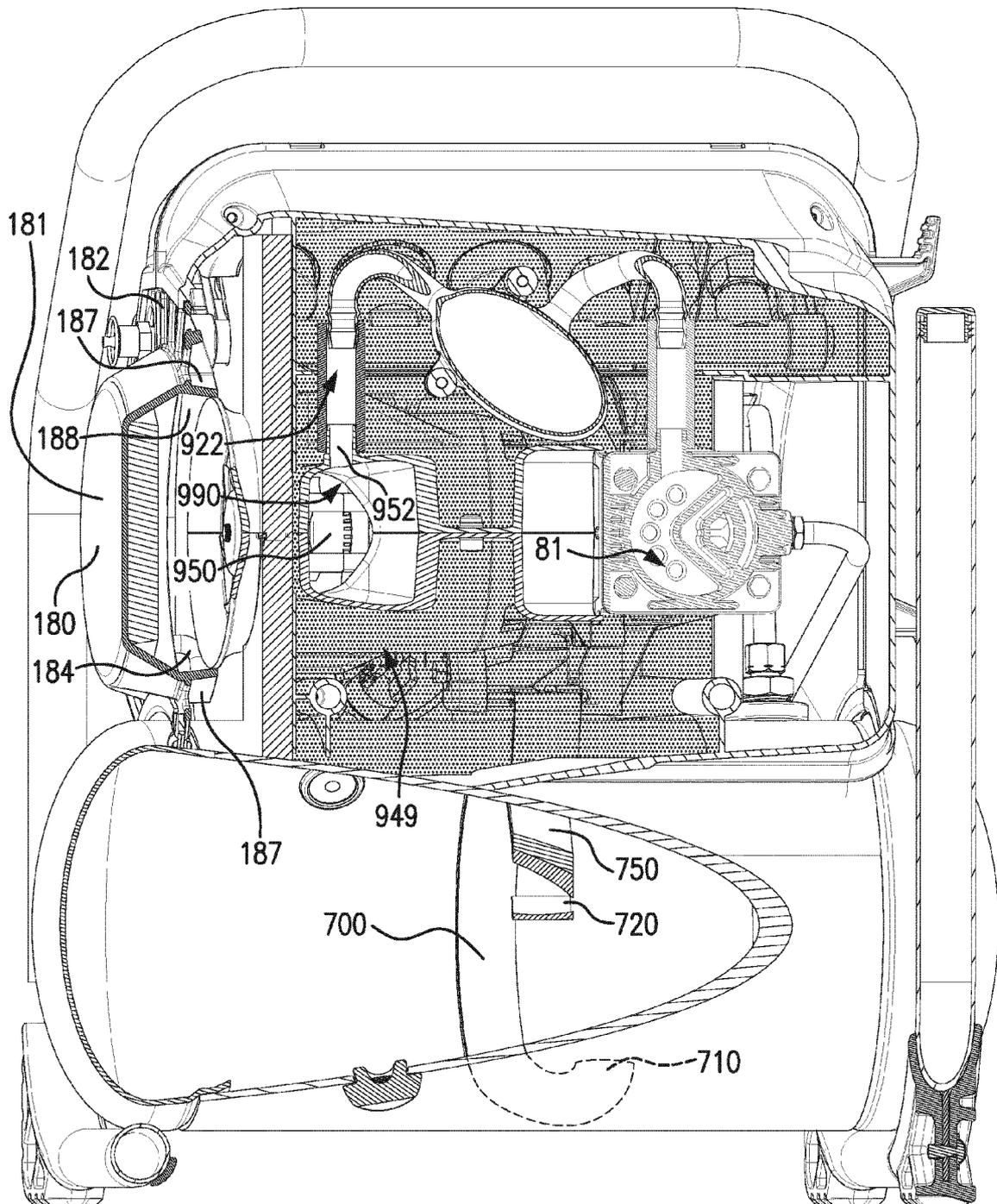
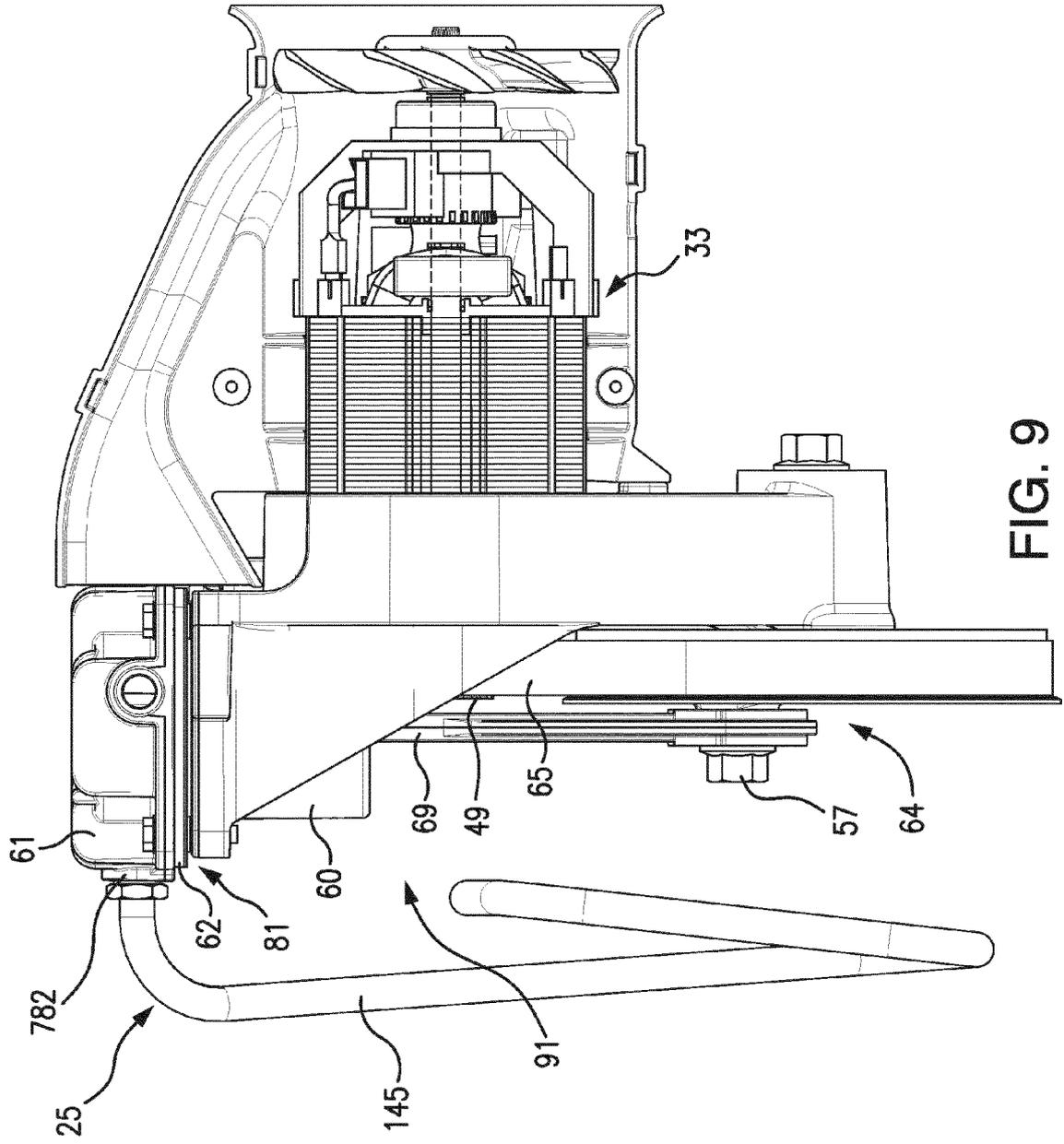
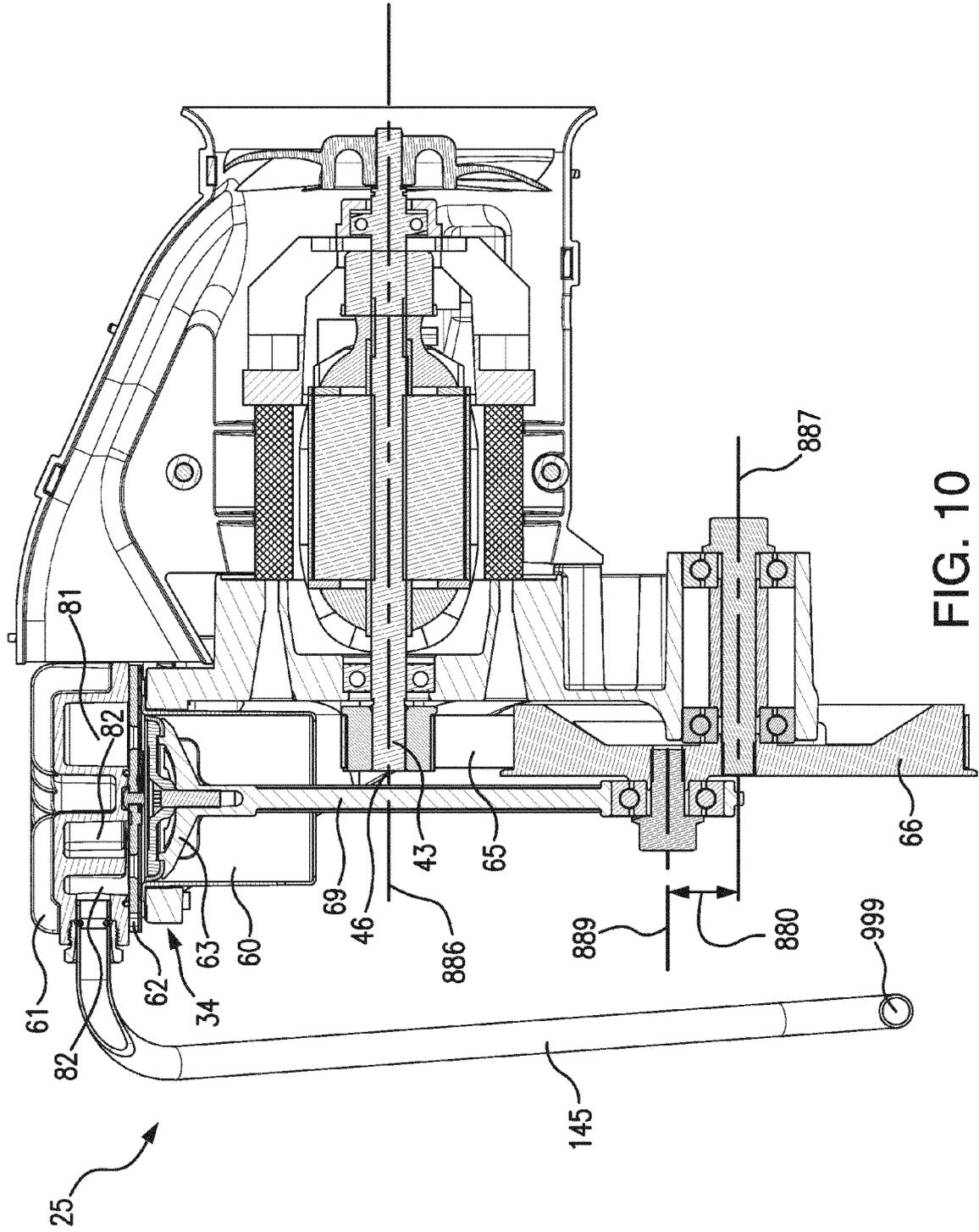


FIG. 8





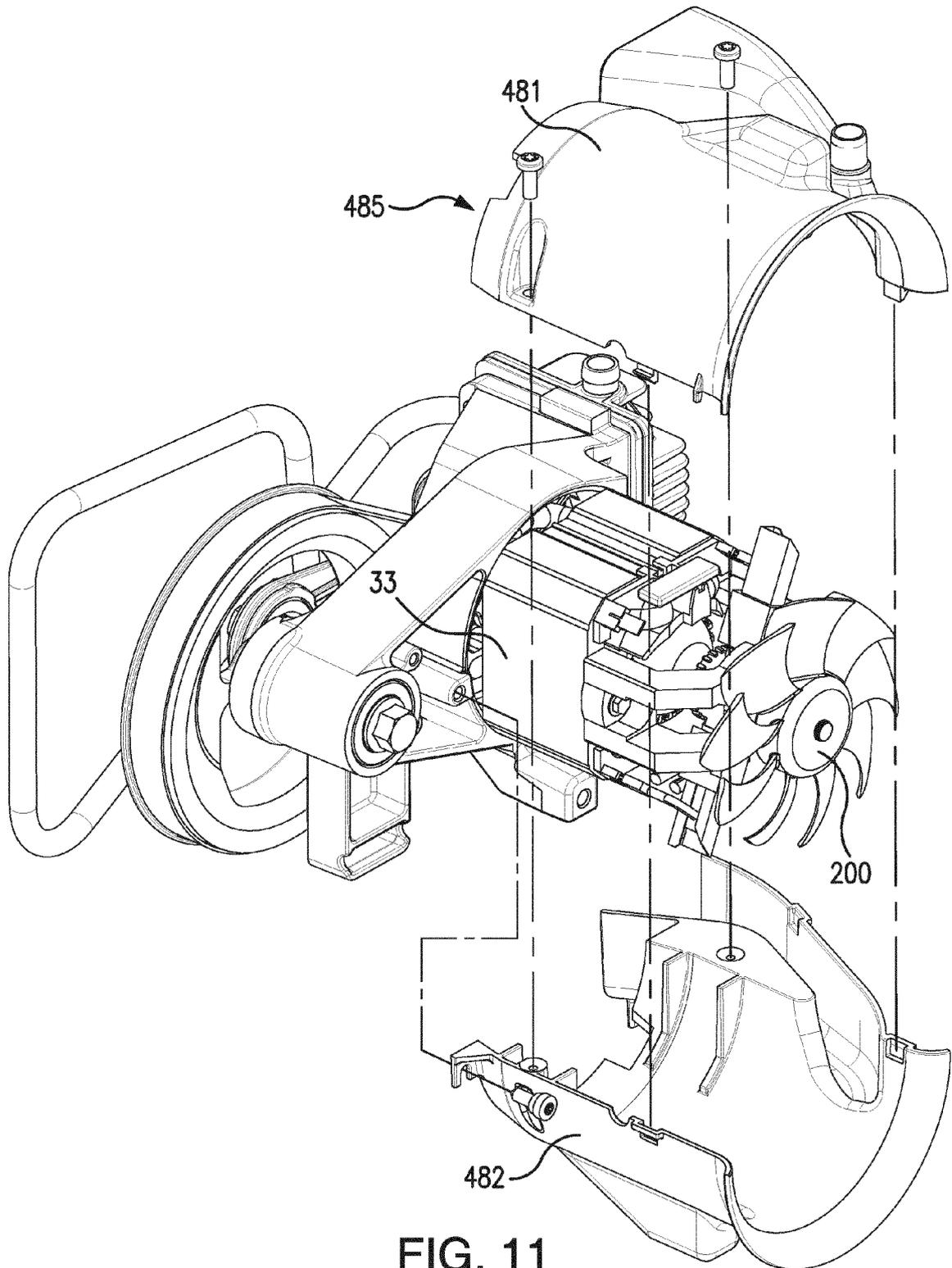


FIG. 11

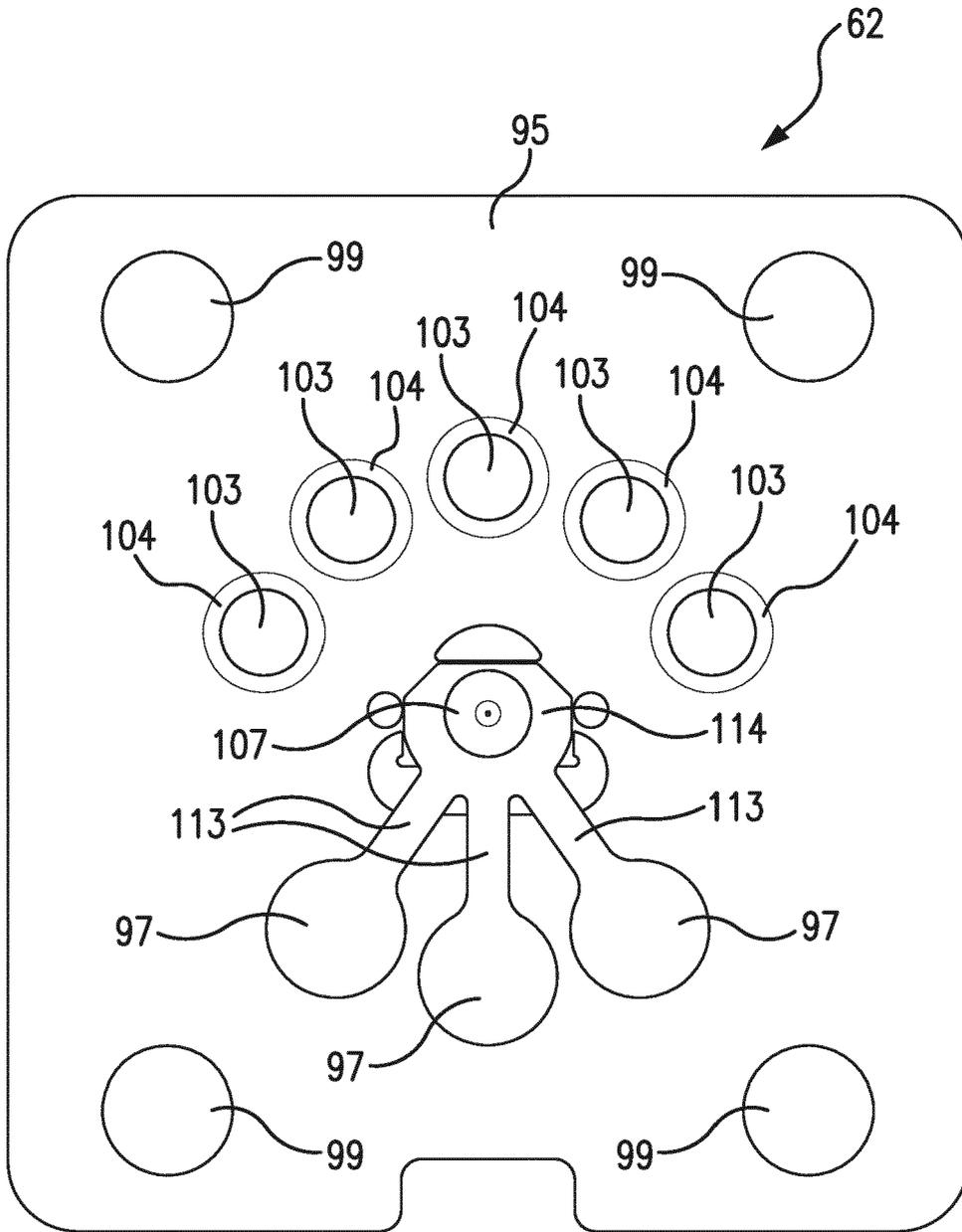


FIG. 12

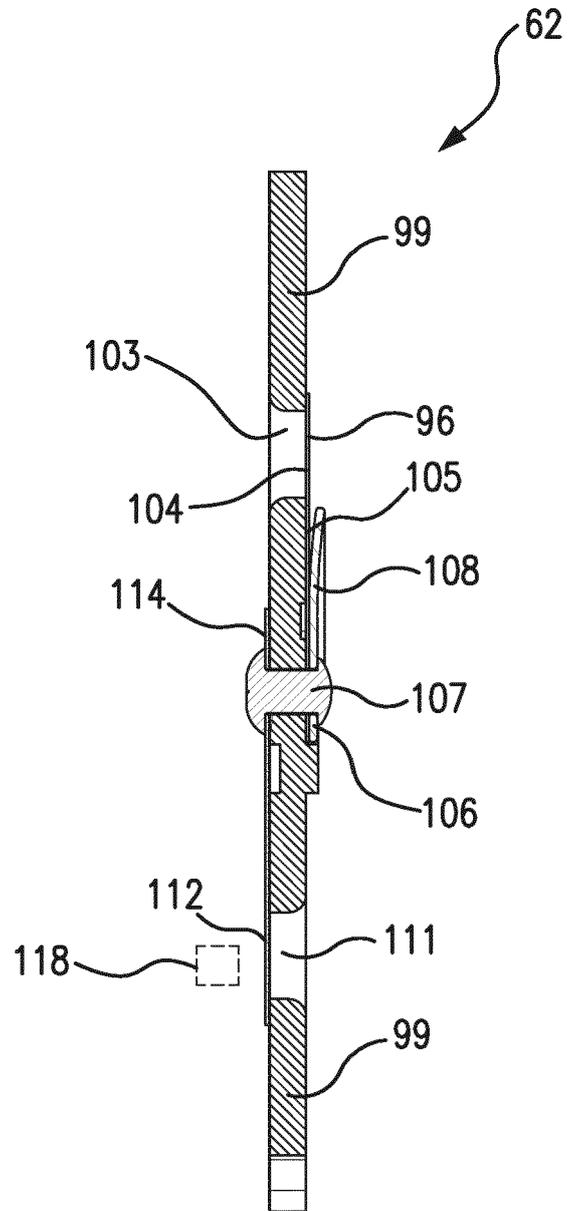


FIG. 13

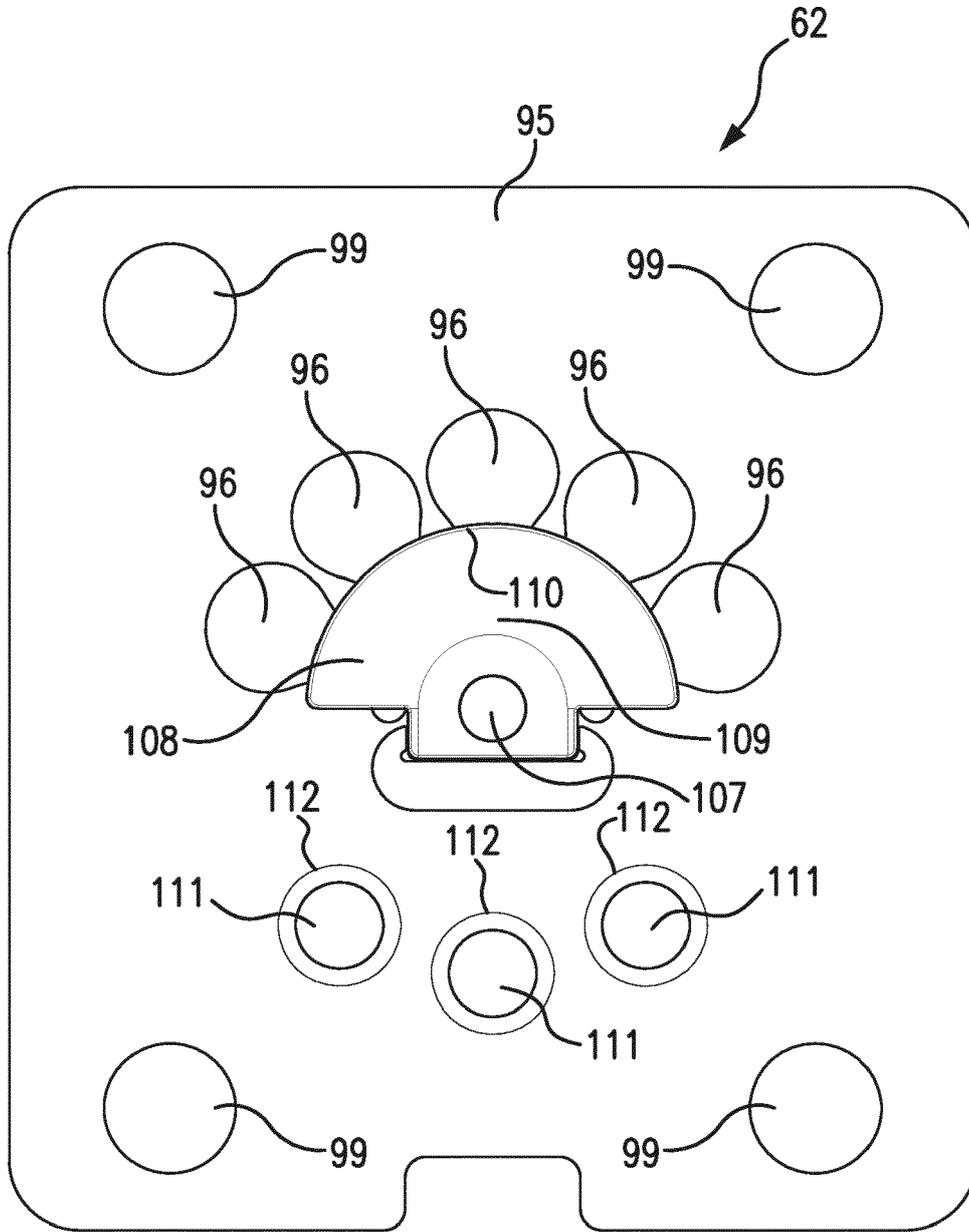


FIG. 14

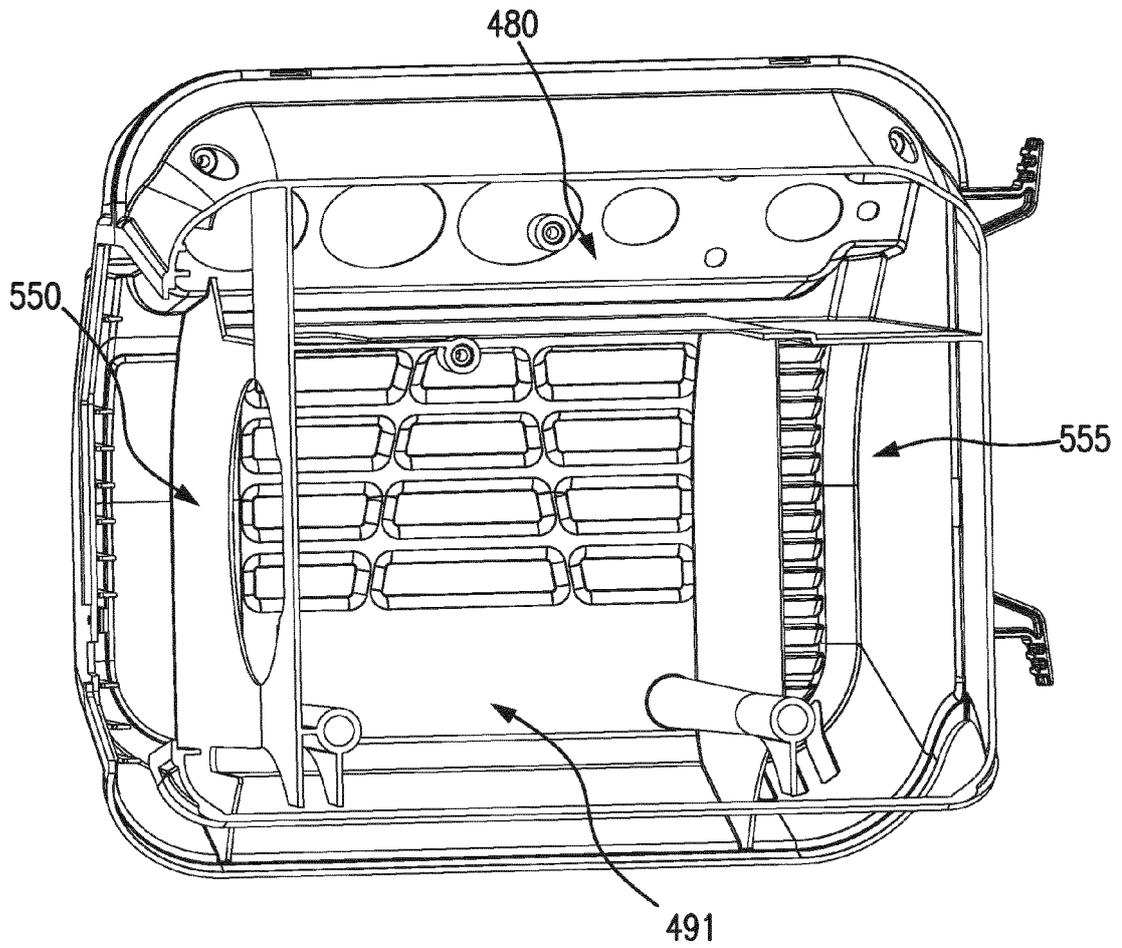


FIG. 15A

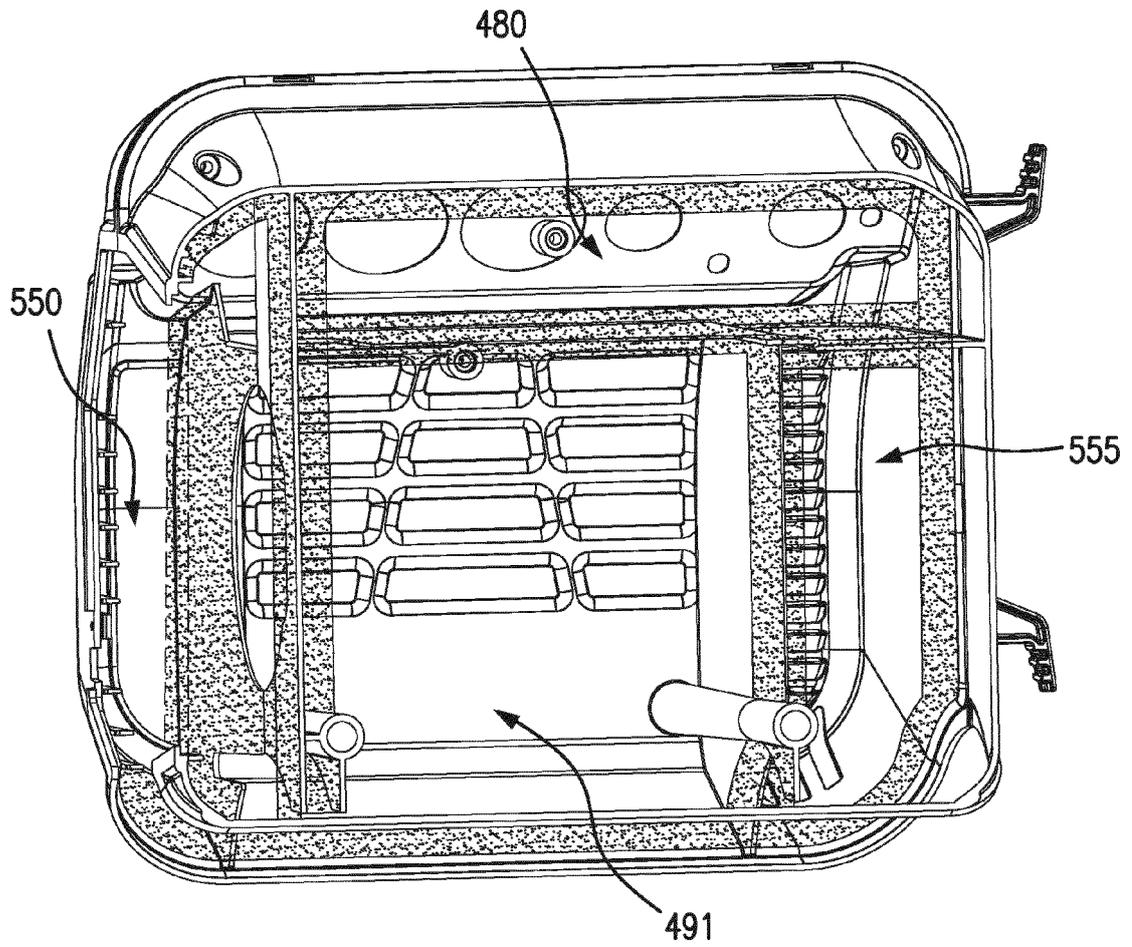


FIG. 15B

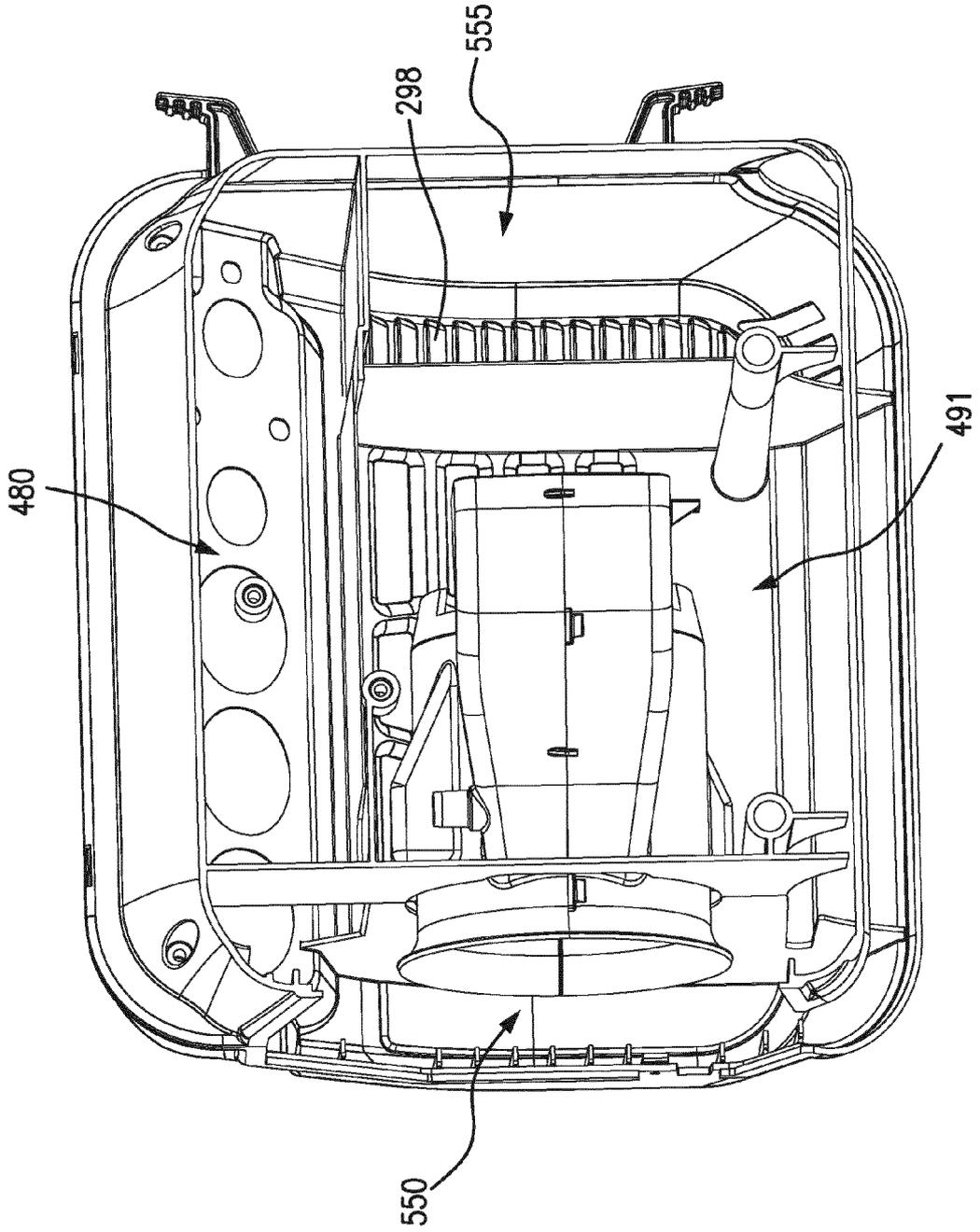


FIG. 16A

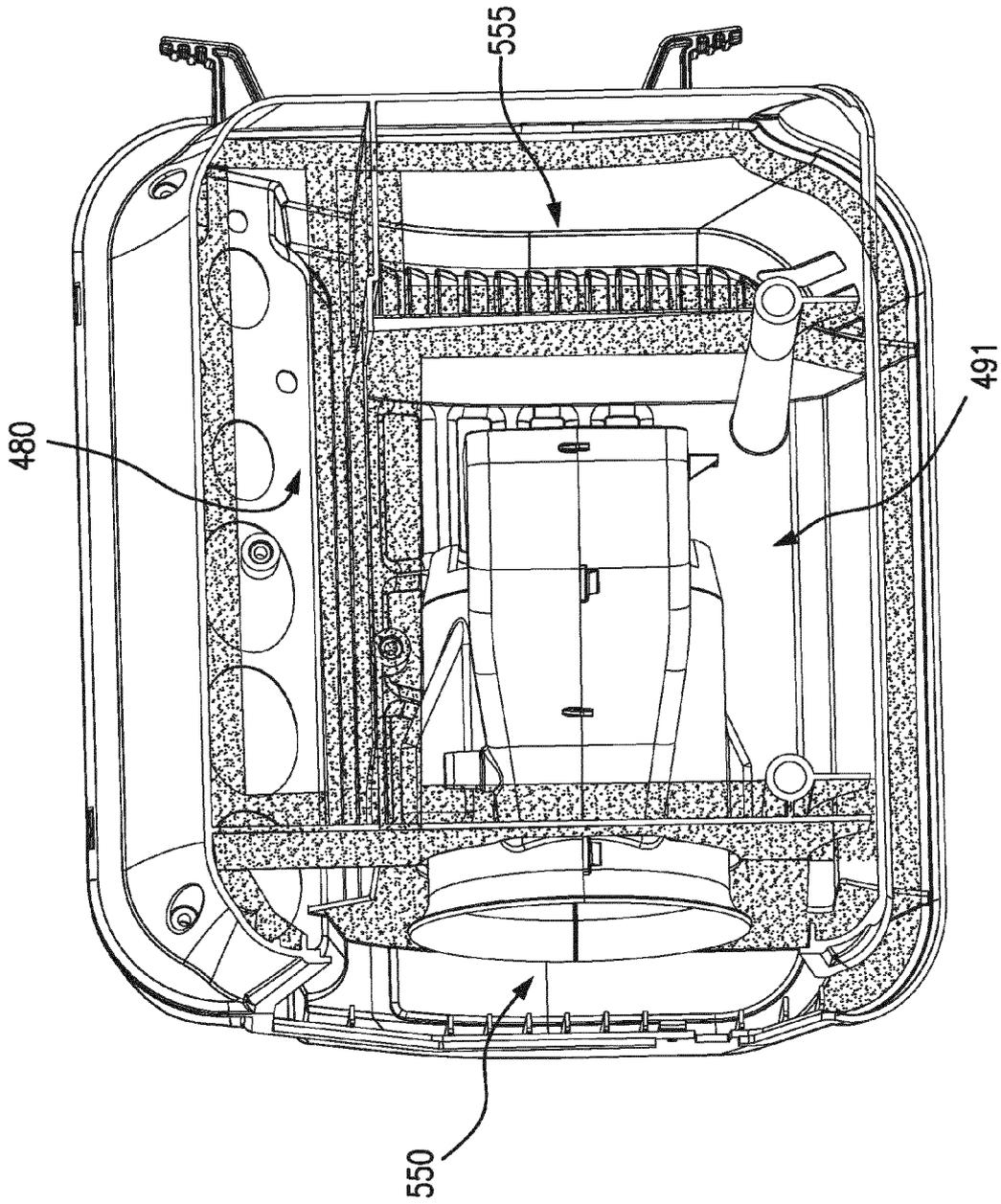


FIG. 16B

Sound Level	Pump Air Delivery	Maximum Pressure	Heat Transfer Rate	Cooling Fan Flowrate	Pump Speed	Cylinder Bore	Stroke	Swept Volume	Volumetric Efficiency	Input Power	Motor Efficiency
(dBA)	(SCFM@90 psig)	(psig)	BTU/min	(CFM)	(rpm)	(inches)	(inches)	inches ³	(% at 150 psig)	(Watts)	(%)
65 - 75	2.4 - 3.5										
65 - 75		150 - 250									
65 - 75			60 - 200								
65 - 75				50 - 100							
65 - 75	2.4 - 3.5	150 - 250	60 - 200								
65 - 75	2.4 - 3.5	150 - 250		50 - 100							
65 - 75	2.4 - 3.5	150 - 250			1500 - 3000	1.5 - 2.25	1.3 - 2				
65 - 75	2.4 - 3.5	150 - 250						2.3 - 8	33 - 50		
65 - 75	2.4 - 3.5	150 - 250								1000-1800	45 - 65

FIG. 17

Sound Level	Pump Air Delivery	Maximum Pressure	Heat Transfer Rate	Cooling Fan Flowrate	Pump Speed	Cylinder Bore	Stroke	Swept Volume	Volumetric Efficiency	Input Power	Motor Efficiency
(dBA)	(SCFM@90 psig)	(psig)	BTU/min	(CFM)	(rpm)	(inches)	(inches)	inches ³	(% at 150 psig)	(Watts)	(%)
65 - 75					1500 - 3000						
65 - 75						1.5 - 2.25					
65 - 75							1.3 - 2				
65 - 75								2.3 - 8			
65 - 75									33 - 50	1000-1800	
65 - 75	2.4 - 3.5	150 - 250	60 - 200	50 - 100							45 - 65
65 - 75					1500 - 3000	1.5 - 2.25					
65 - 75	2.4 - 3.5	150 - 250	60 - 200	50 - 100	1500 - 3000	1.5 - 2.25	1.3 - 2				
65 - 75	2.4 - 3.5	150 - 250	60 - 200	50 - 100	1500 - 3000	1.5 - 2.25	1.3 - 2	2.3 - 8	33 - 50	1000-1800	45 - 65

FIG. 18

Sound Level	Pump Air Delivery	Maximum Pressure	Heat Transfer Rate	Cooling Fan Flowrate	Pump Speed	Cylinder Bore	Stroke	Swept Volume	Volumetric Efficiency	Input Power	Motor Efficiency
(dBA)	(SCFM@90 psig)	(psig)	BTU/min	(CFM)	(rpm)	(inches)	(inches)	inches ³	(% at 150 psig)	(Watts)	(%)
70.5	2.9			71.5							
70.5	2.9				2300	1.875	1.592				
70.5	2.9							4.4	41		
70.5	2.9									1446	56.5
70.5	2.9	200	84.1								
70.5	2.9	200		71.5							
70.5	2.9	200			2300	1.875	1.592				
70.5	2.9	200						4.4	41		
70.5	2.9	200								1446	56.5
70.5	2.9		84.1								
70.5	2.9			71.5							
70.5	2.9				2300						
70.5	2.9	200	84.1							1446	
70.5	2.9	200		71.5							
70.5	2.9	200			2300						
70.5	2.9	200								1446	
70.5	2.9	200	84.1	71.5							
70.5	2.9		84.1		2300						
70.5	2.9									1446	

FIG. 19

Sound Level	Pump Air Delivery	Maximum Pressure	Heat Transfer Rate	Cooling Fan Flowrate	Pump Speed	Cylinder Bore	Stroke	Swept Volume	Volumetric Efficiency	Input Power	Motor Efficiency
(dBA)	(SCFM@90 psig)	(psig)	BTU/min	(CFM)	(rpm)	(inches)	(inches)	inches ³	(% at 150 psig)	(Watts)	(%)
70.5	2.9	200	84.1	71.5							
70.5	2.9	200	84.1		2300						
70.5	2.9	200	84.1	71.5	2300						
70.5	2.9	200	84.1			1.875					
70.5	2.9	200	84.1				1.592				
70.5	2.9	200	84.1	71.5	2300						
70.5	2.9	200	84.1	71.5	2300	1.875					
70.5	2.9	200	84.1	71.5	2300		1.592				
70.5	2.9	200	84.1	71.5	2300	1.875	1.592				
70.5	2.9	200	84.1					4.4			
70.5	2.9	200	84.1						41		
70.5	2.9	200	84.1	71.5	2300	1.875	1.592	4.4			
70.5	2.9	200	84.1	71.5	2300	1.875	1.592	4.4	41		
70.5	2.9	200	84.1							1446	
70.5	2.9	200	84.1								56.5
70.5	2.9	200	84.1	71.5	2300	1.875	1.592	4.4	41	1446	
70.5	2.9	200	84.1	71.5	2300	1.875	1.592	4.4	41	1446	56.5

FIG. 20

	Compressor Assembly Performance Data
Motor Speed (RPM)	11200
Pump Speed (RPM)	2300
Voltage	120
Air Flow (SCFM) @ 90 psi	2.9
Current Draw @ 90 psi (amps)	11.8
Volumetric Efficiency @ 90 psi	49.6%
Motor Torque (lb-in) @ 90 psi	6.01
Motor Efficiency @ 90 psi	56.3%
Air Flow (SCFM) @ 150 psi	2.4
Current Draw @ 150 psi (amps)	12.05
Volumetric Efficiency @ 150 psi	41.0%
Motor Torque (lb-in) @ 150 psi	6.16
Motor Efficiency @ 150 psi	56.5%
Air Flow (SCFM) @ 200 psi	2.15
Current Draw @ 200 psi (amps)	11.88
Volumetric Efficiency @ 200 psi	36.7%
Motor Torque (lb-in) @ 200 psi	6.06
Motor Efficiency @ 200 psi	56.4%
Cylinder Bore (inches)	1.875
Cylinder Stroke (inches)	1.592
Cylinder Swept Volume (cubic inches)	4.40
Sound Level (dBA)	70.5
Heat Transfer Rate (BTU/min)	84.1

FIG. 21

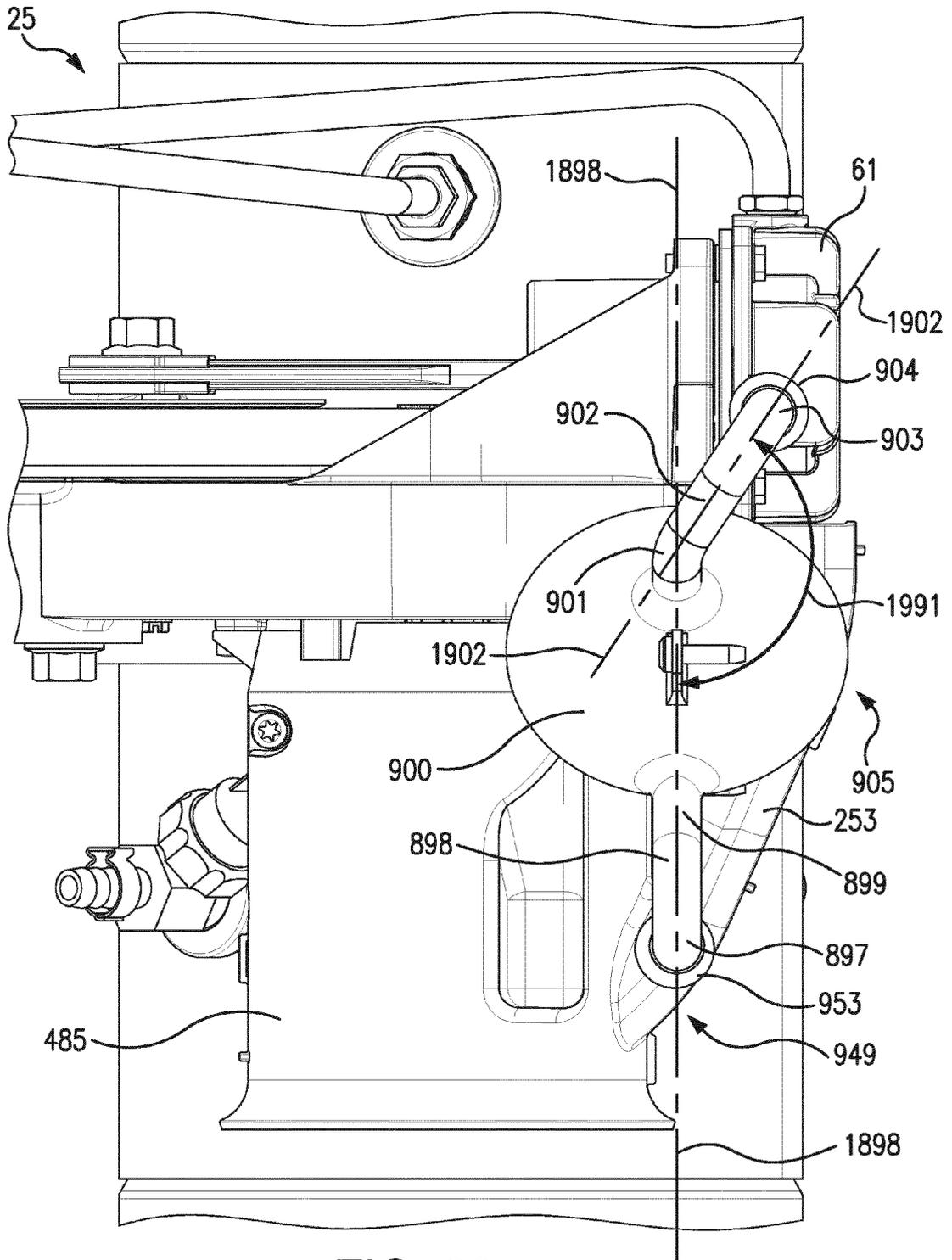


FIG. 22

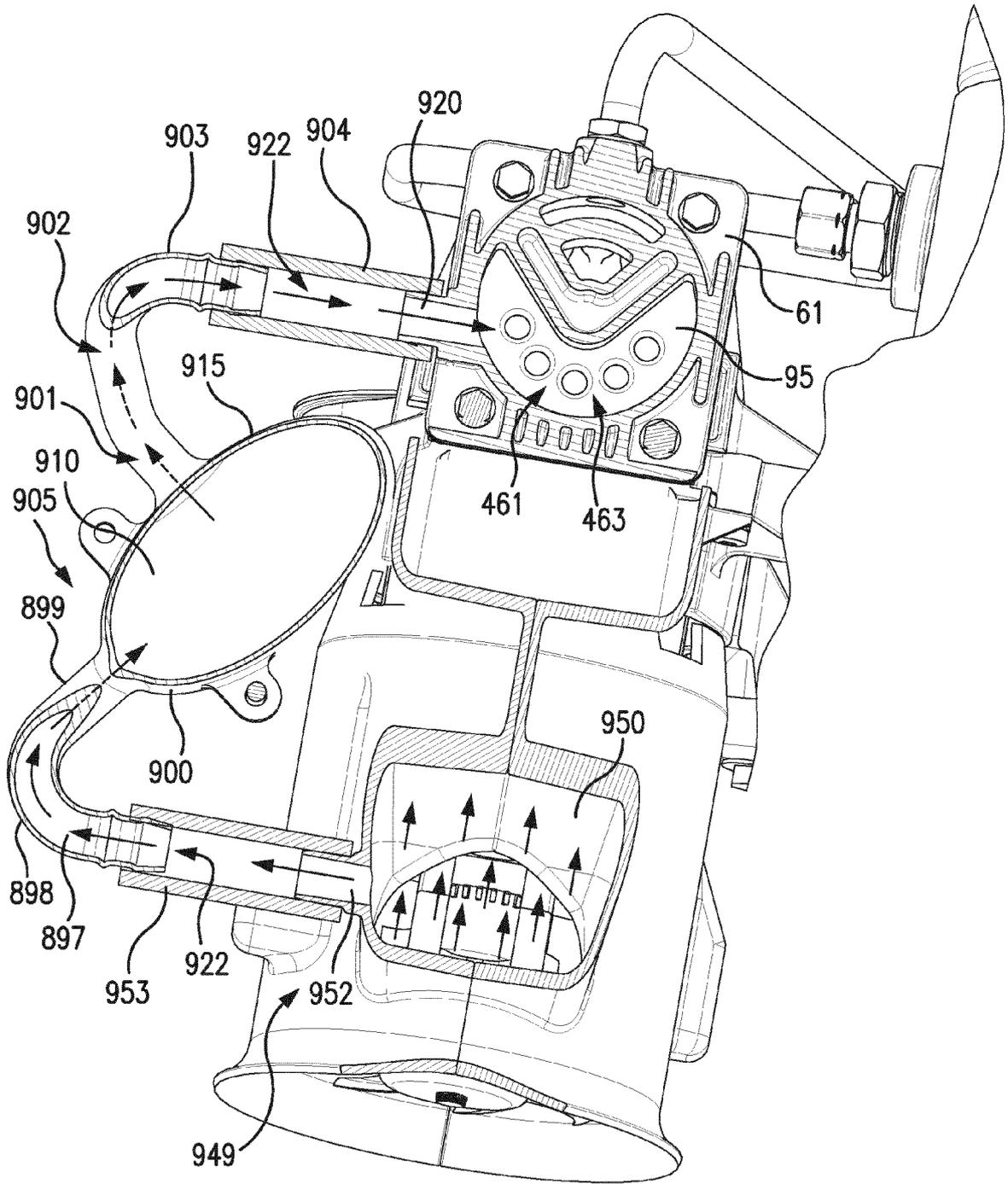


FIG. 23

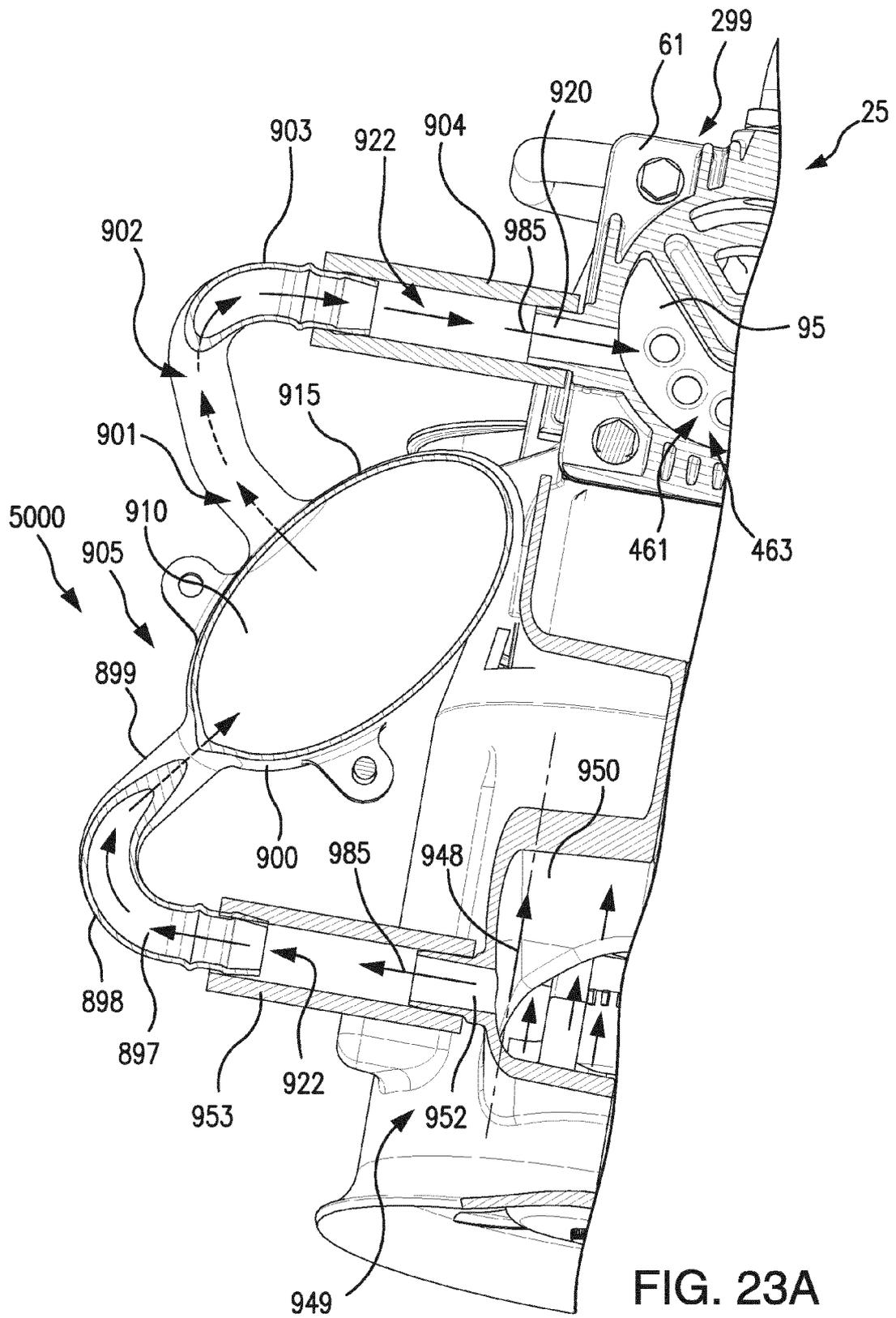
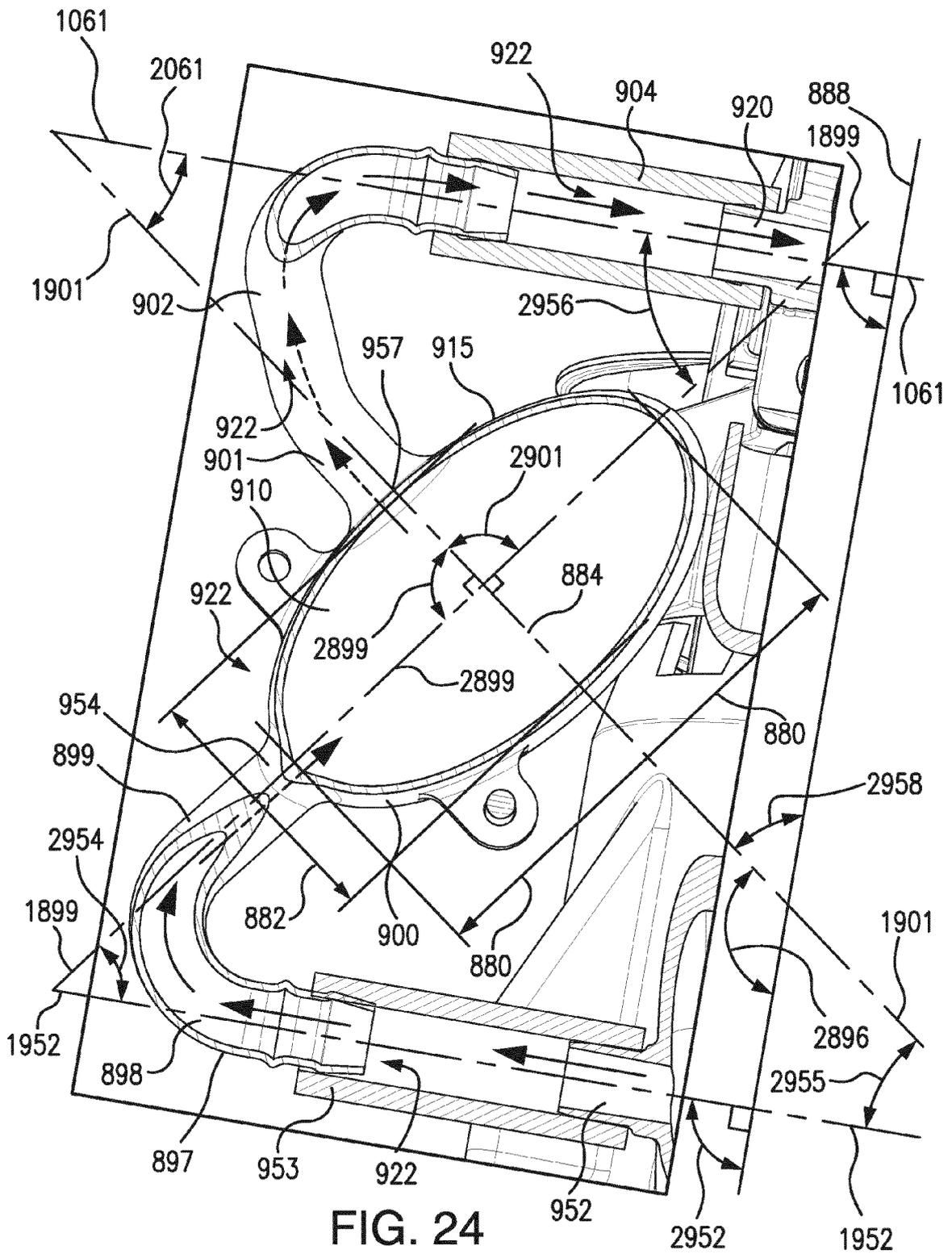


FIG. 23A



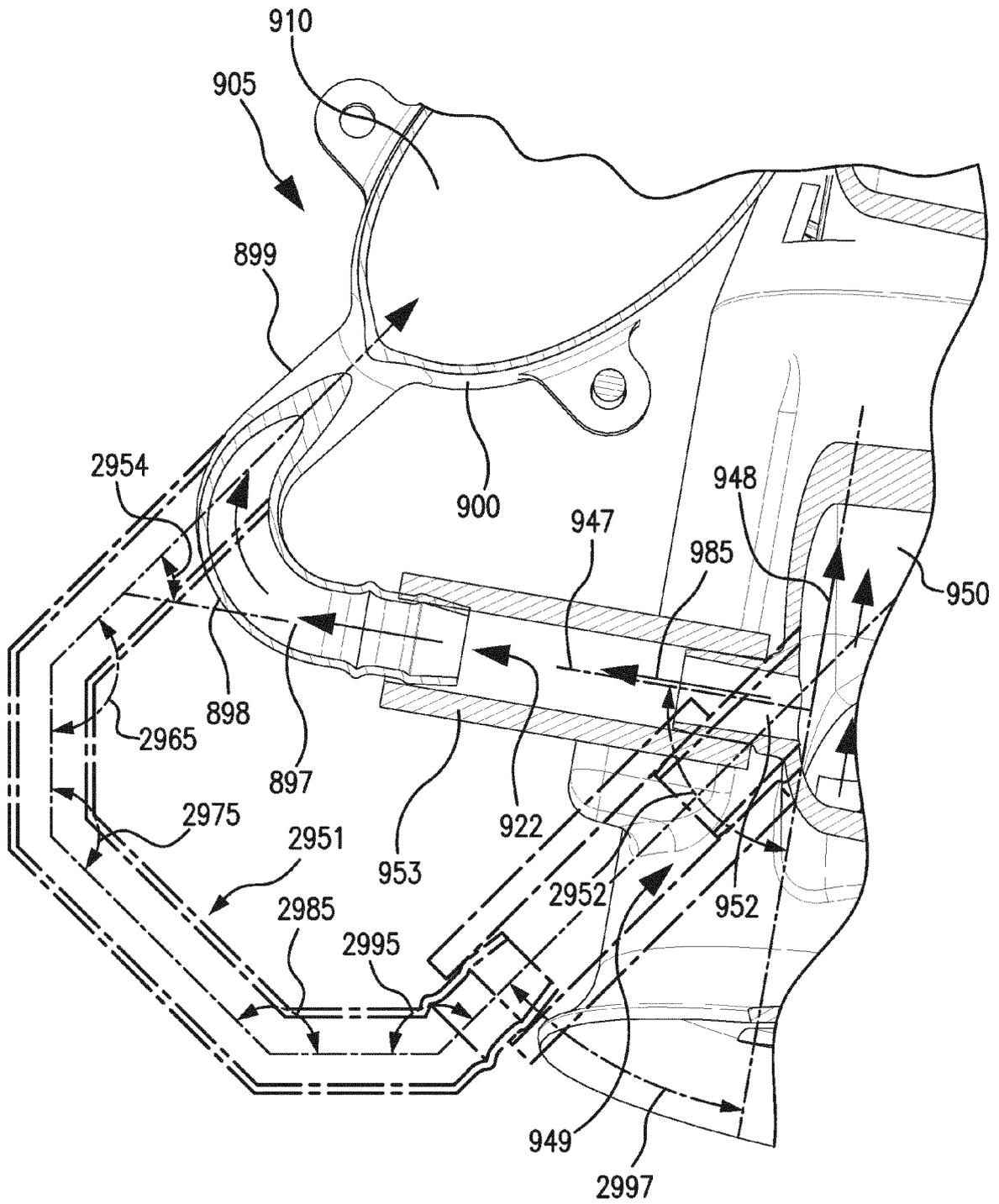


FIG. 24A

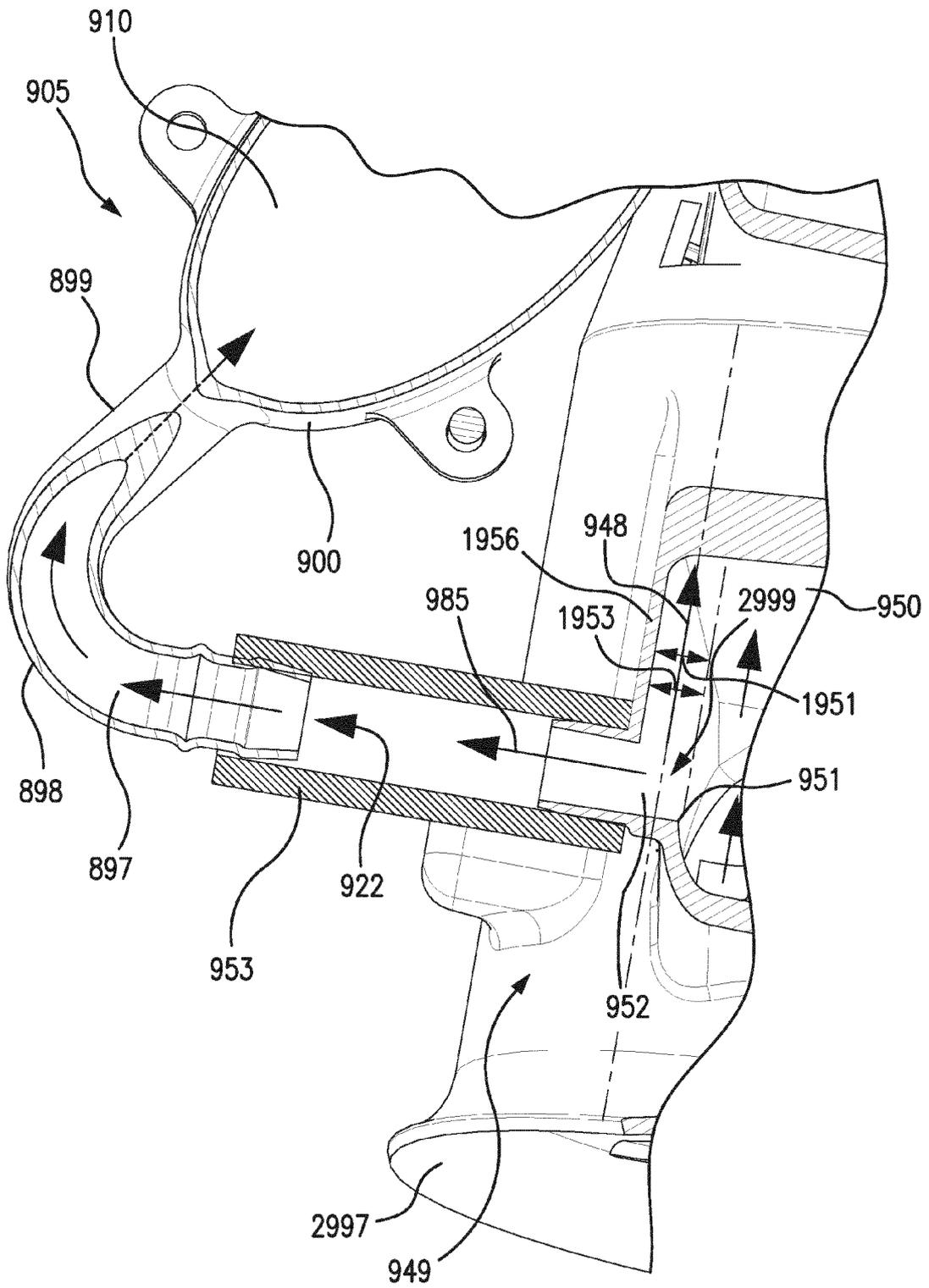


FIG. 24B

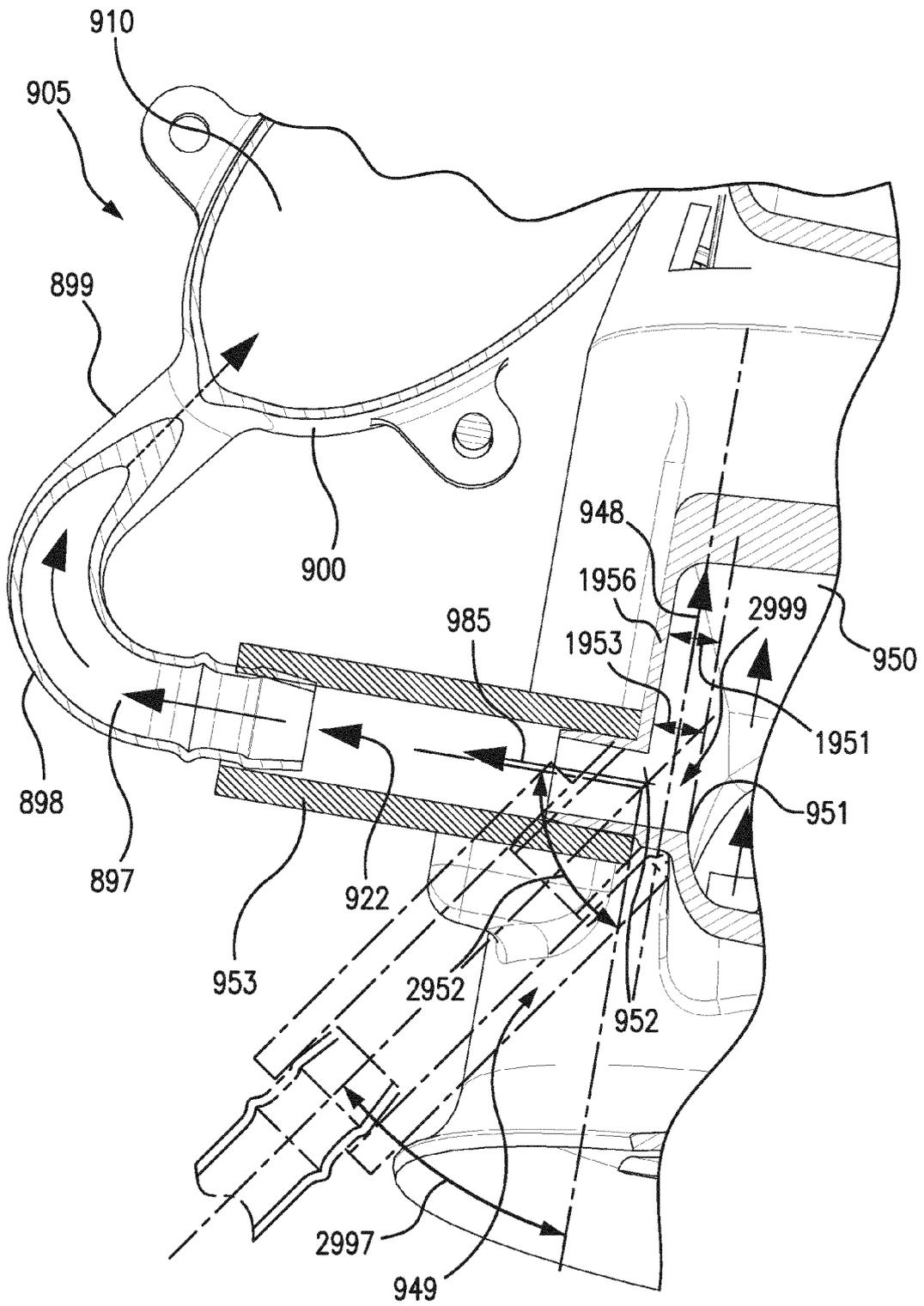


FIG. 24C

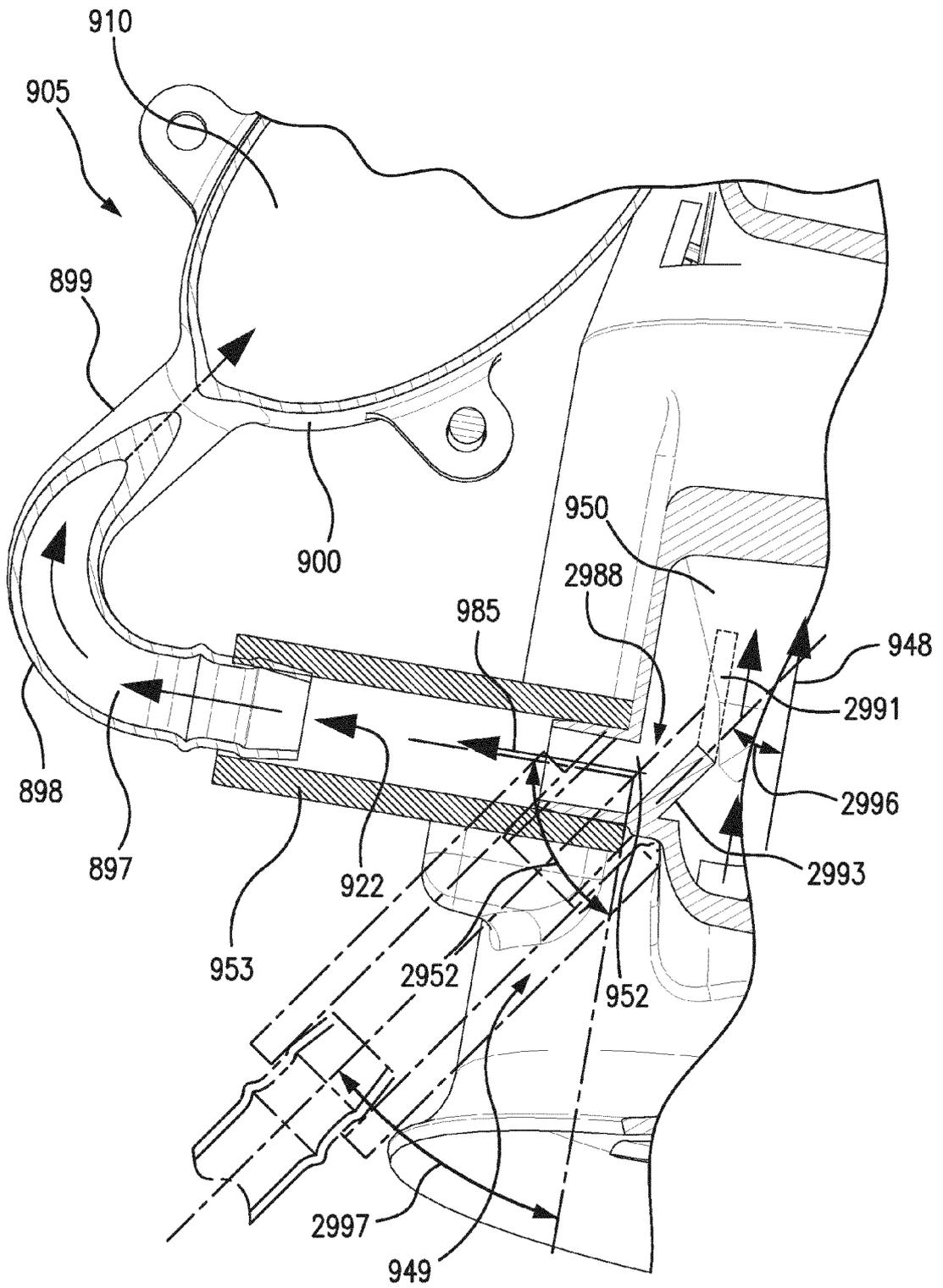


FIG. 24D

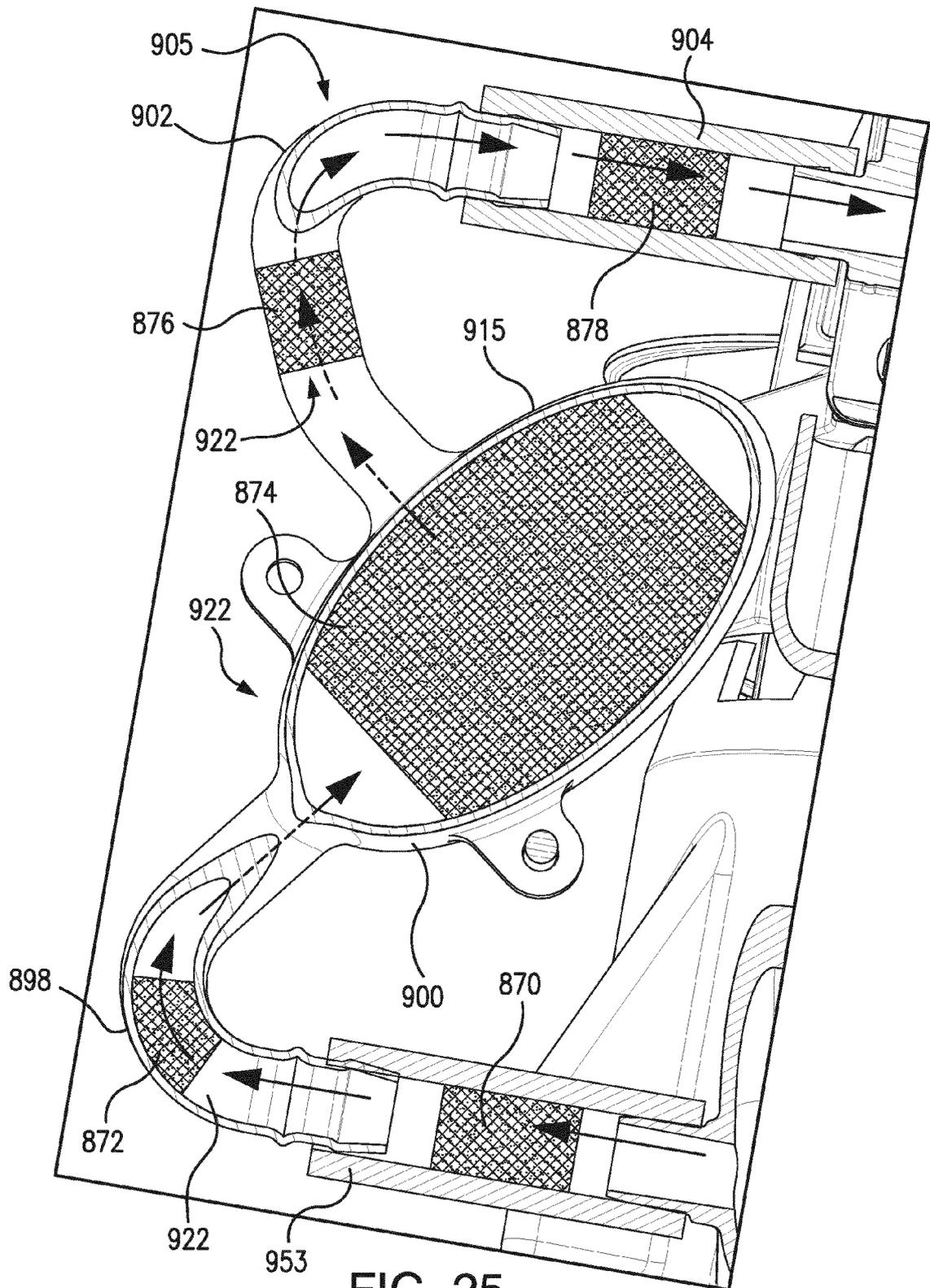


FIG. 25

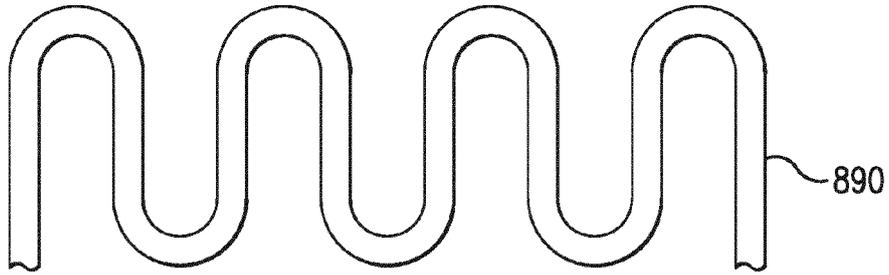


FIG. 26

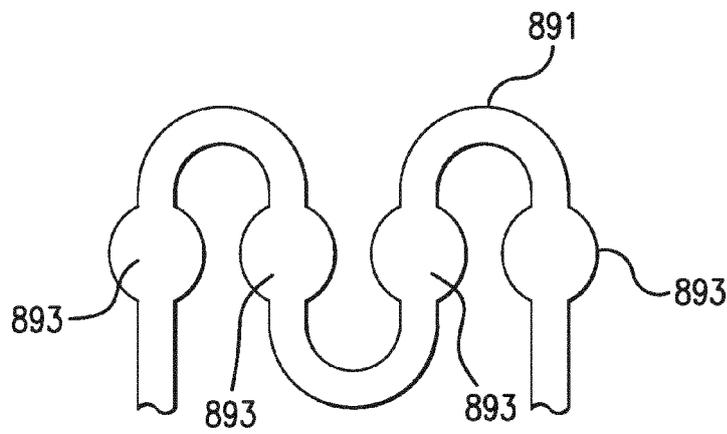


FIG. 27

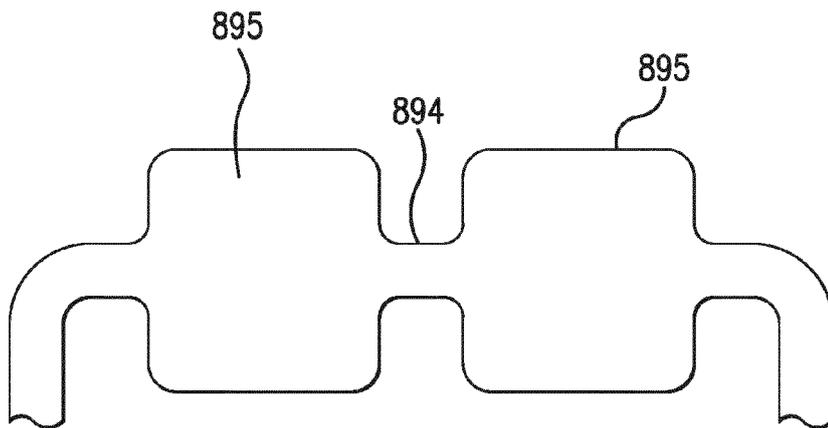


FIG. 28

	Tiny Particle Size (μ)	Small Particle Size (μ)	Average Particle Size (μ)	Larger Particle Size (μ)
Drywall Dust	0.75	1	3	5
Sand	60	100	5050	10000
Saw Dust	20	30	315	600
Cement Dust	1	3	52	100
Airborne Liquid Droplets	0.2	0.5	3	5
Dry Clay	0.05	0.1	25	50
Atmospheric Dust	0.00075	0.001	20	40
Diatomaceous Earth	5	7.5	20	200
Airborne Paint	4	7	20	10
Graphite Brush Dust	1	5	20	90
Joint Compound	0.5	1	20	5
Airborne Liquid Water Droplets	0.2	0.5	20	5

FIG. 29

Material	Particle Size (microns, μ)	Density (g/cubic cm)	Mass (g)	Average Momentum (kg m/sec)	Moment of Inertia (kg m ²)
Sand	100 to 10000	1.5900	8.33E-07	1.33E-08	8.33E-19
Saw Dust	30 to 600	0.2900	4.10E-09	6.55E-11	3.69E-22
Graphite Brush Dust	5 to 90	0.7700	5.04E-11	8.05E-13	1.26E-25
Cement Dust	3 to 100	0.8000	1.13E-11	1.81E-13	1.02E-26
Joint Compound	1 to 5	0.6410	3.36E-13	1.41E-15	3.36E-29
Airborne Liquid Water Droplets	.5 to 5	0.998	6.53E-14	1.04E-15	1.63E-30
Dry Clay	.1 to 50	0.8	4.19E-16	6.69E-18	4.19E-34
Drywall Dust	.1 to 100	0.6410	3.36E-16	5.36E-18	3.36E-34

FIG. 30



EUROPEAN SEARCH REPORT

Application Number
EP 13 18 4002

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (IPC)
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Y	* column 2, line 24 - column 4, line 30; figures 1,3,6 *	2-8, 10-14	
X	----- US 2002/134617 A1 (NISSEN JENS ERIK [US] ET AL NISSEN JENS ERIK [DE] ET AL) 26 September 2002 (2002-09-26)	1,9	
Y	* paragraph [0022] - paragraph [0026] *	2-8, 10-14	
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A	----- WO 2009/152594 A1 (WHIRLPOOL SA [BR]; FAGOTTI FABIAN [BR]) 23 December 2009 (2009-12-23) * abstract *	1,9	
The present search report has been drawn up for all claims			TECHNICAL FIELDS SEARCHED (IPC)
			F04B
Place of search		Date of completion of the search	Examiner
Munich		20 November 2013	Fistas, Nikolaos
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone		T : theory or principle underlying the invention	
Y : particularly relevant if combined with another document of the same category		E : earlier patent document, but published on, or after the filing date	
A : technological background		D : document cited in the application	
O : non-written disclosure		L : document cited for other reasons	
P : intermediate document	 & : member of the same patent family, corresponding document	

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**ANNEX TO THE EUROPEAN SEARCH REPORT
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EP 13 18 4002

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report. The members are as contained in the European Patent Office EDP file on The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

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