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(54) **FILTER ARRANGEMENTS; HOUSINGS; ASSEMBLIES; AND, METHODS**

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**Steven Campbell**, Bloomington, MN (US);  
**Johan Fobe**, Leuven (BE)

(21) Appl. No.: **15/068,969**

(22) Filed: **Mar. 14, 2016**

**Related U.S. Application Data**

(63) Continuation of application No. 14/170,818, filed on Feb. 3, 2014, now Pat. No. 9,283,507, which is a continuation of application No. 13/729,660, filed on Dec. 28, 2012, now Pat. No. 8,641,795, which is a continu-

ation of application No. 13/022,188, filed on Feb. 7, 2011, now Pat. No. 8,343,245, which is a continuation of application No. 11/587,882, filed on Aug. 21, 2007, now Pat. No. 7,905,936, filed as application No. PCT/US2005/014909 on Apr. 28, 2005.

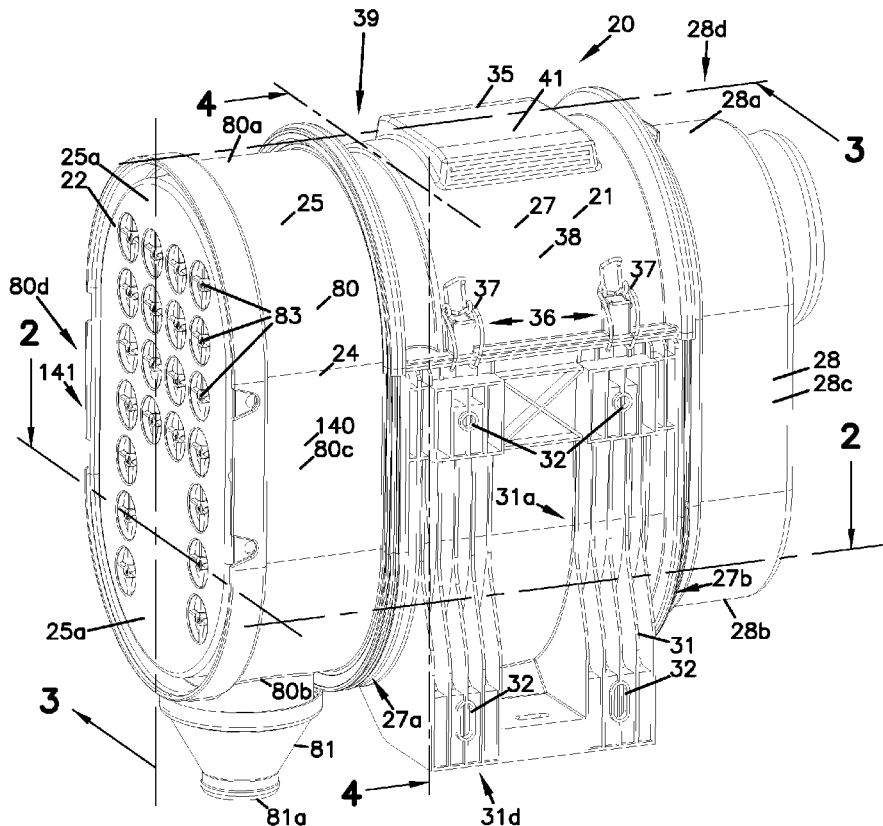
(60) Provisional application No. 60/567,121, filed on Apr. 30, 2004, provisional application No. 60/604,549, filed on Aug. 25, 2004, provisional application No. 60/649,301, filed on Feb. 1, 2005.

**Publication Classification**

(51) **Int. Cl.**  
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*B01D 46/00* (2006.01)  
*B01D 46/52* (2006.01)  
(52) **U.S. Cl.**  
CPC ..... *B01D 46/4227* (2013.01); *B01D 46/527* (2013.01); *B01D 46/0023* (2013.01)

(57) **ABSTRACT**

Air cleaner and preferred components for an air cleaner are provided. In certain arrangements, a band is mounted to the media pack, surrounding the media. Also, the cartridge is non-circular and includes a seal thereon.



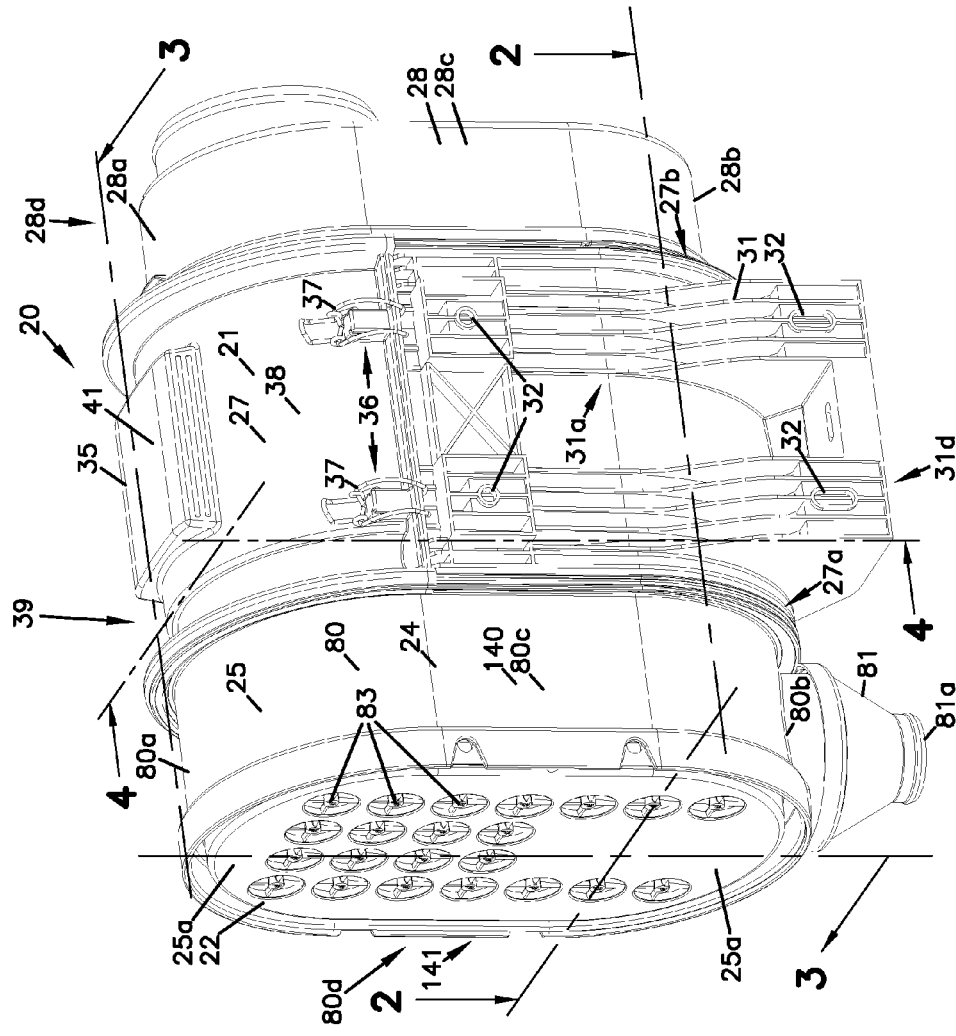


FIG. 1

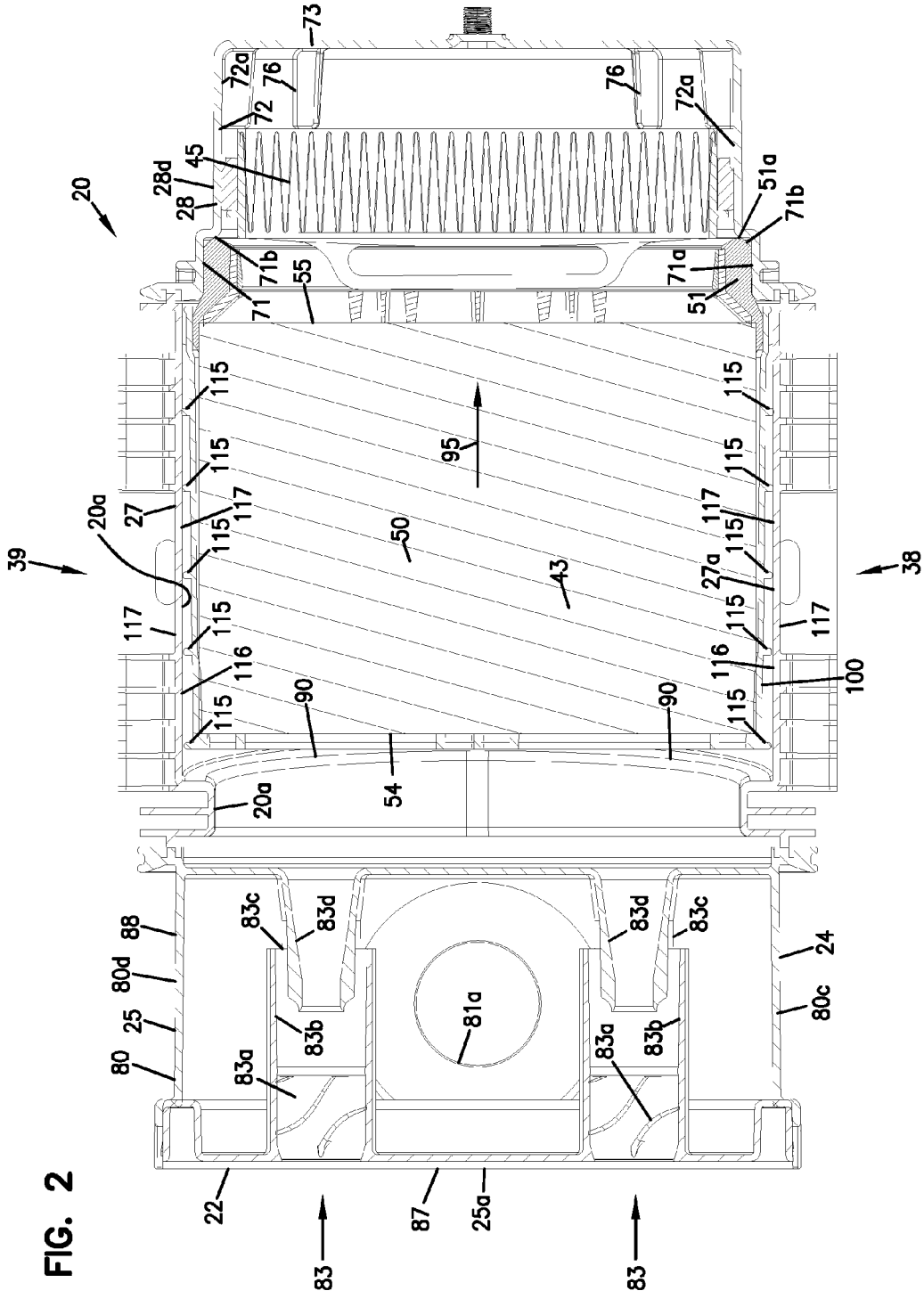


FIG. 2

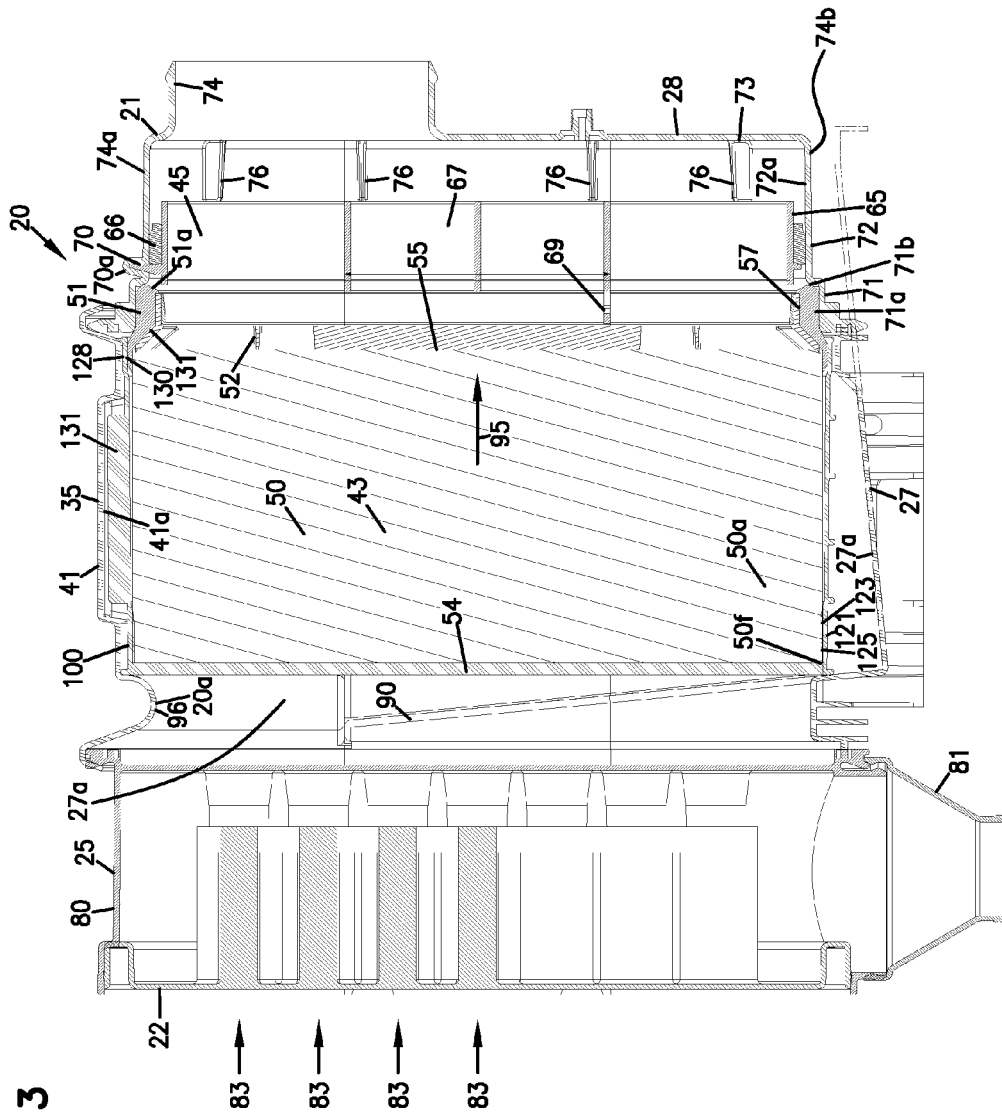


FIG. 3

FIG. 4

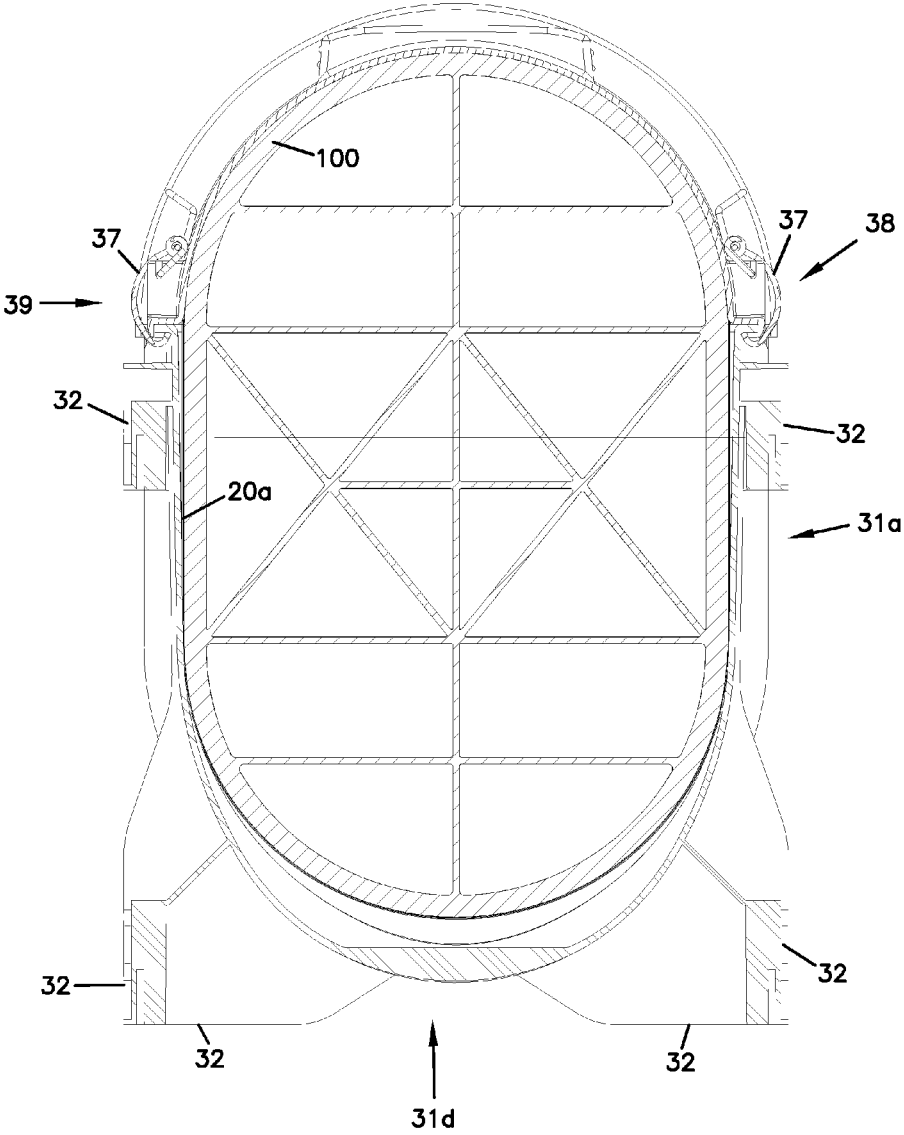


FIG. 5

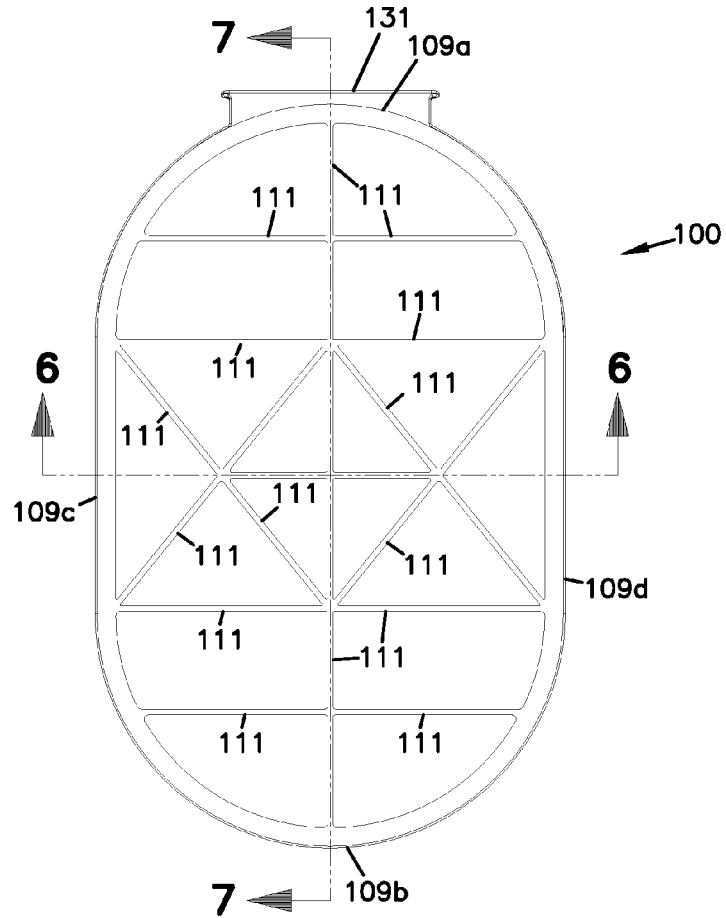


FIG. 6

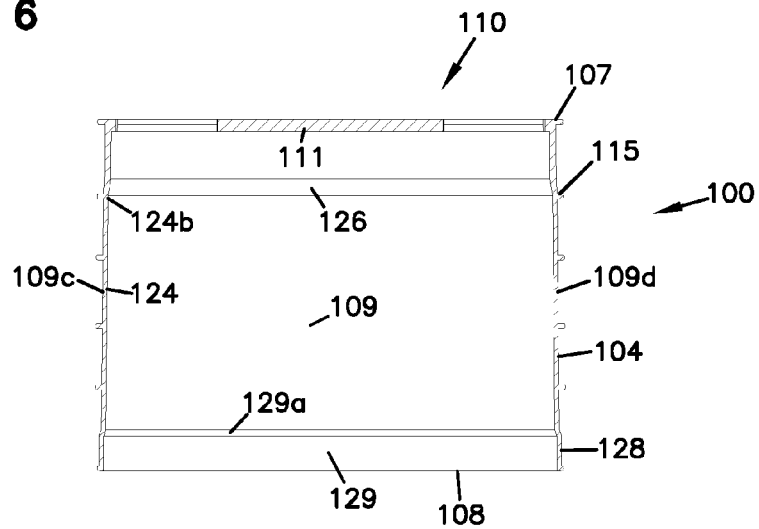


FIG. 7

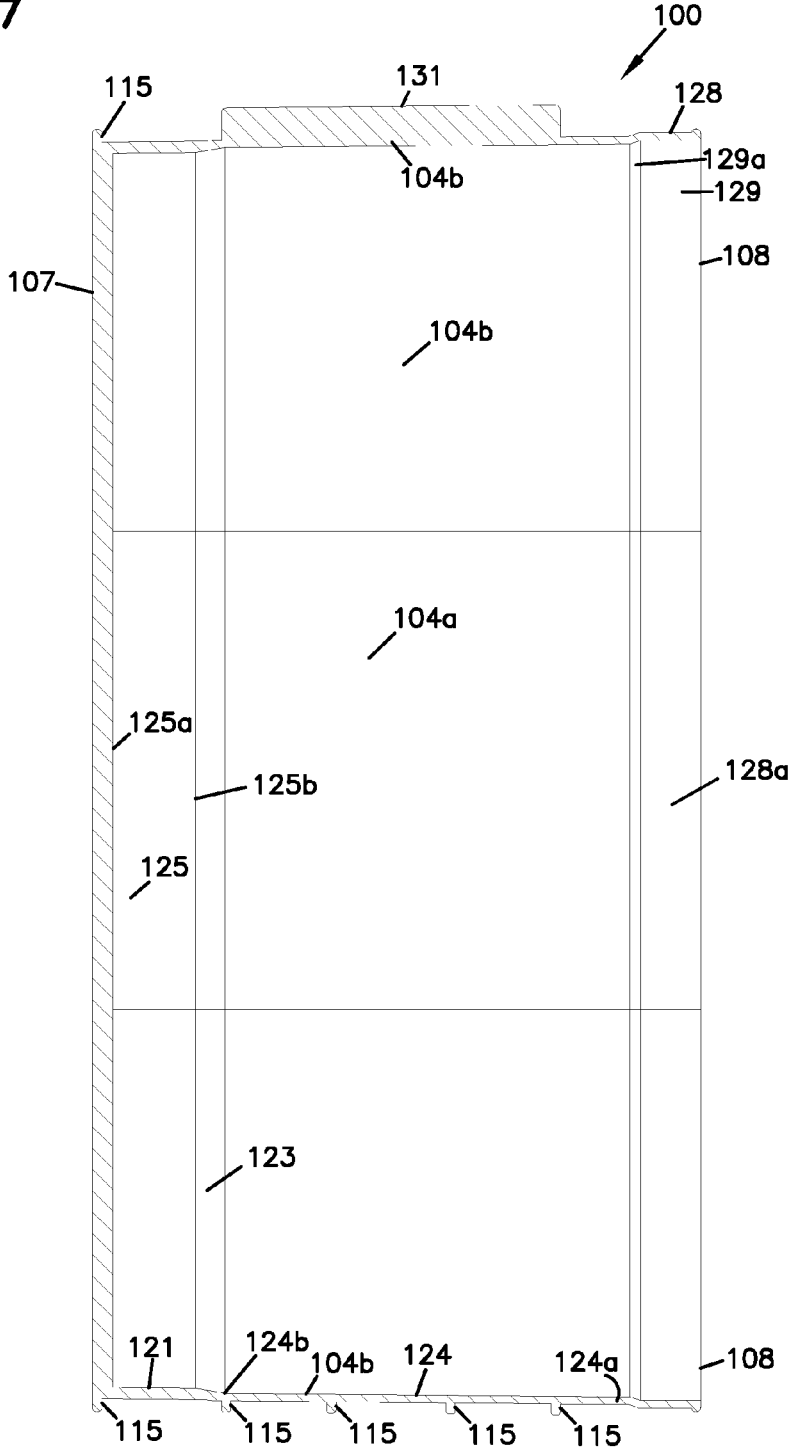
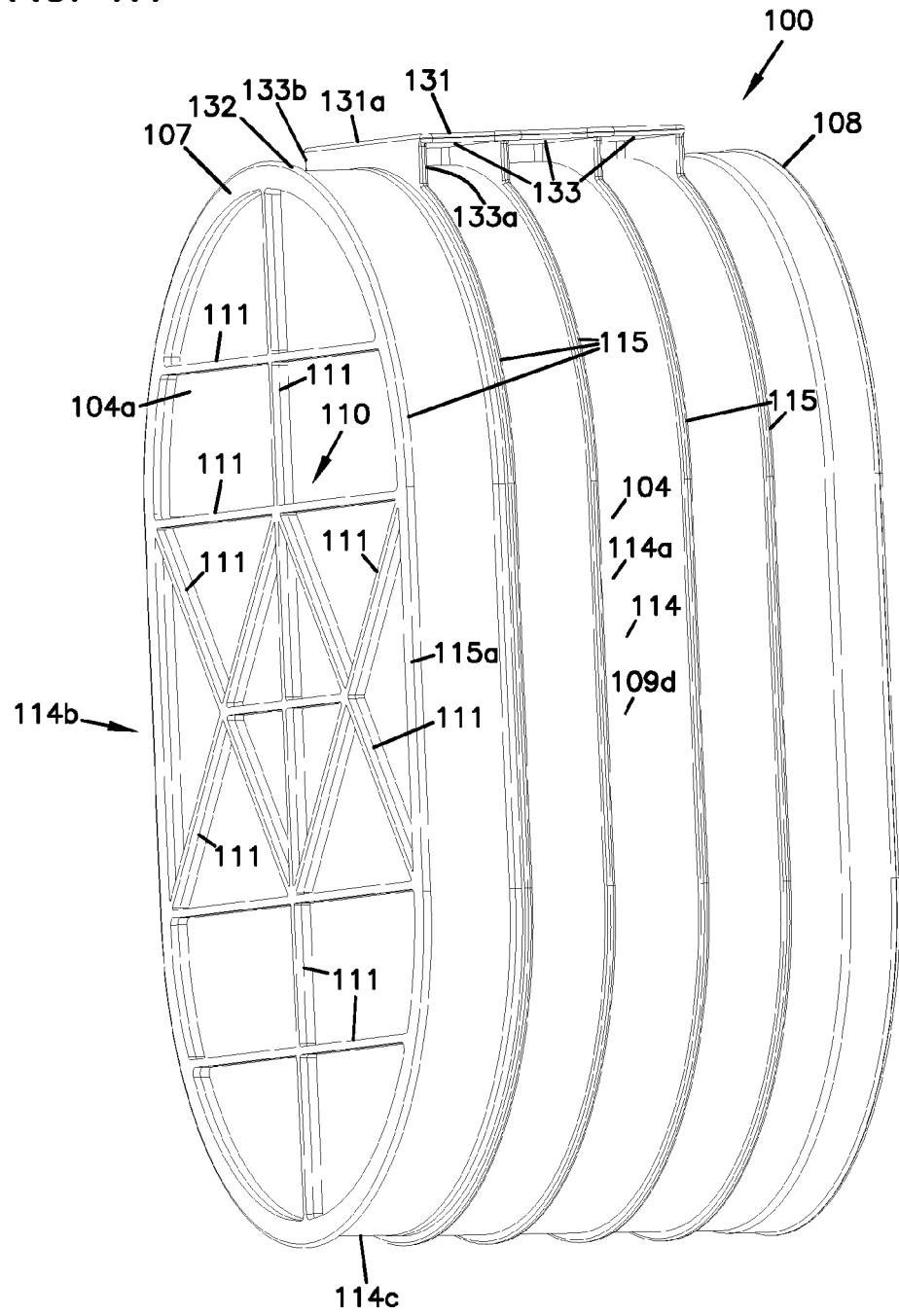


FIG. 7A





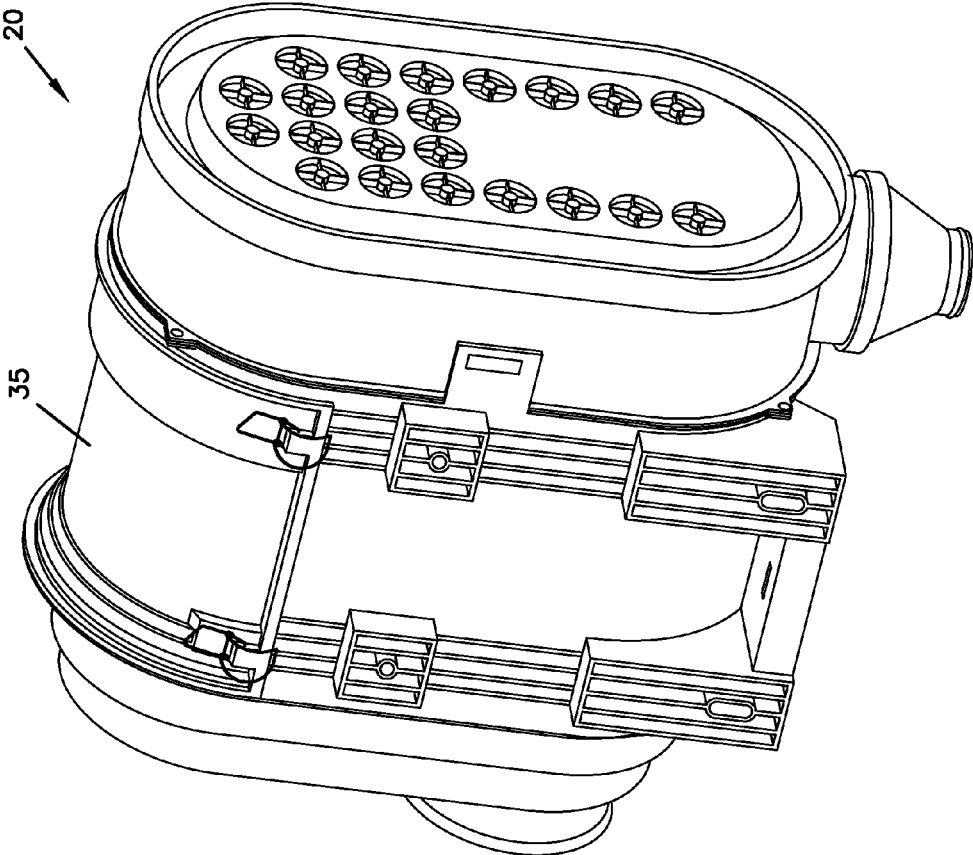


FIG.8

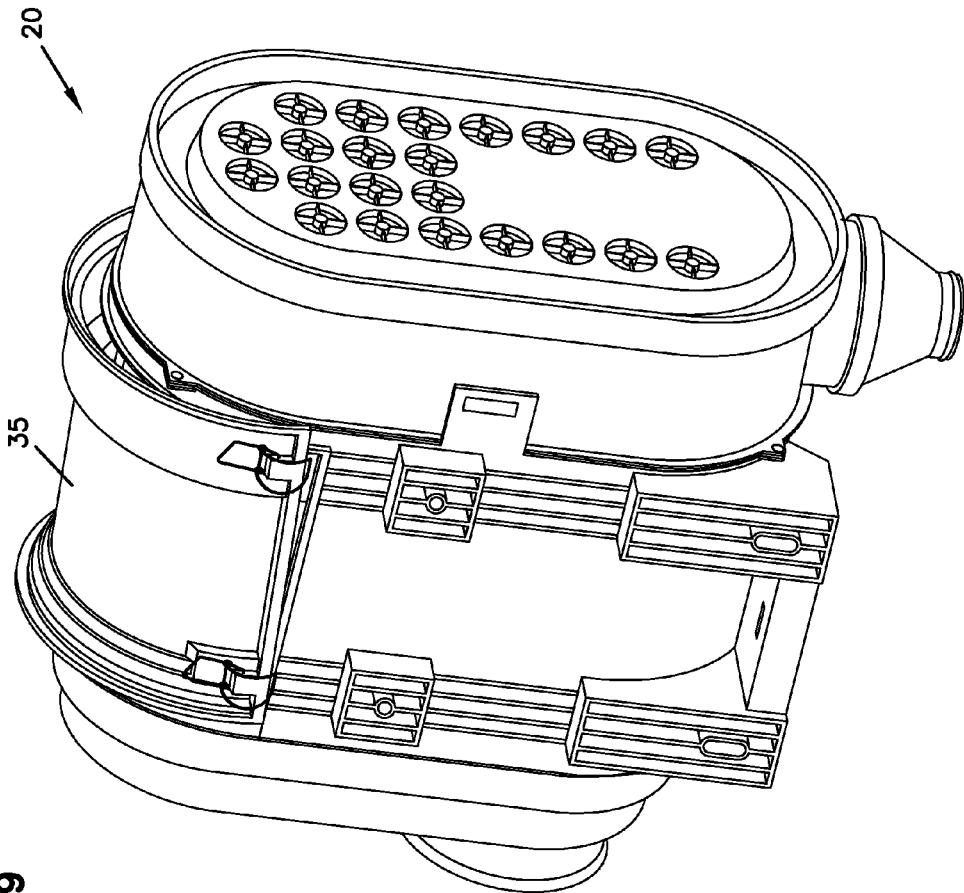


FIG.9

FIG.10

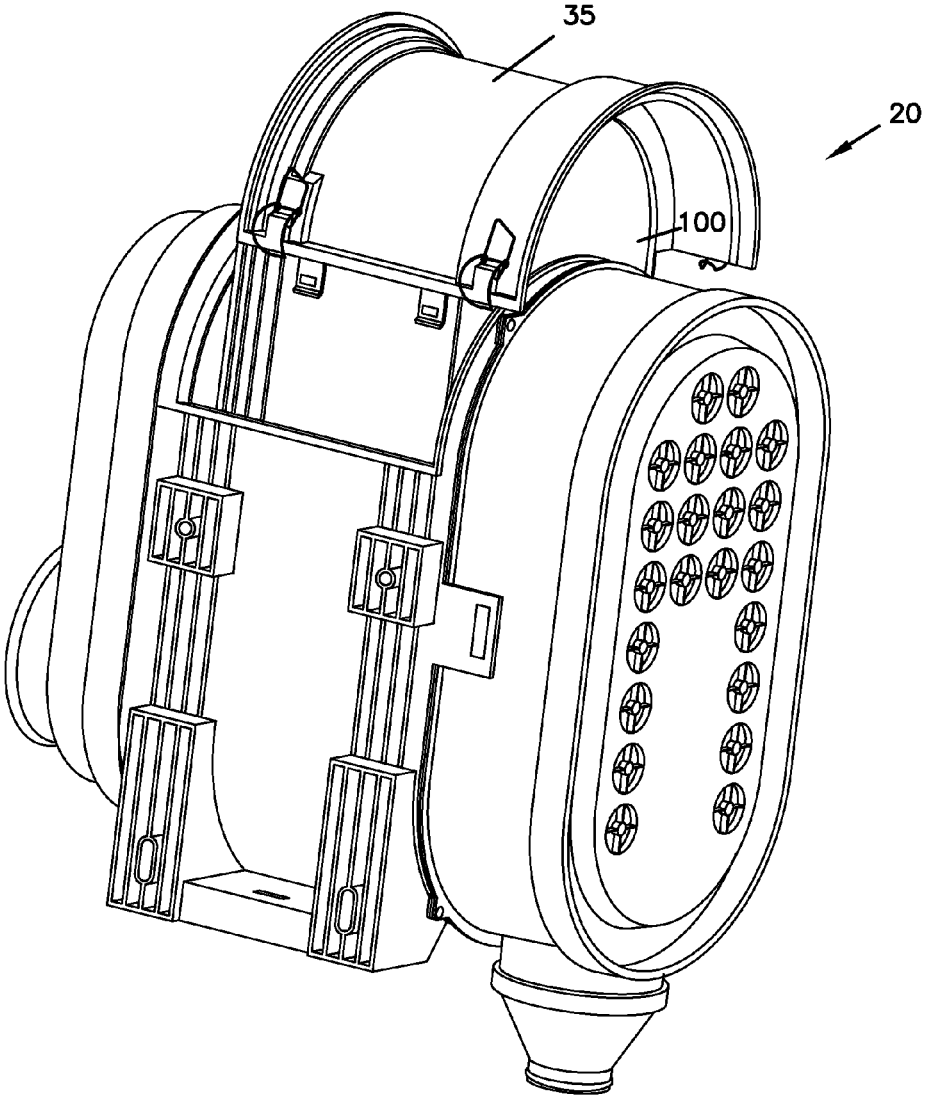


FIG. 11

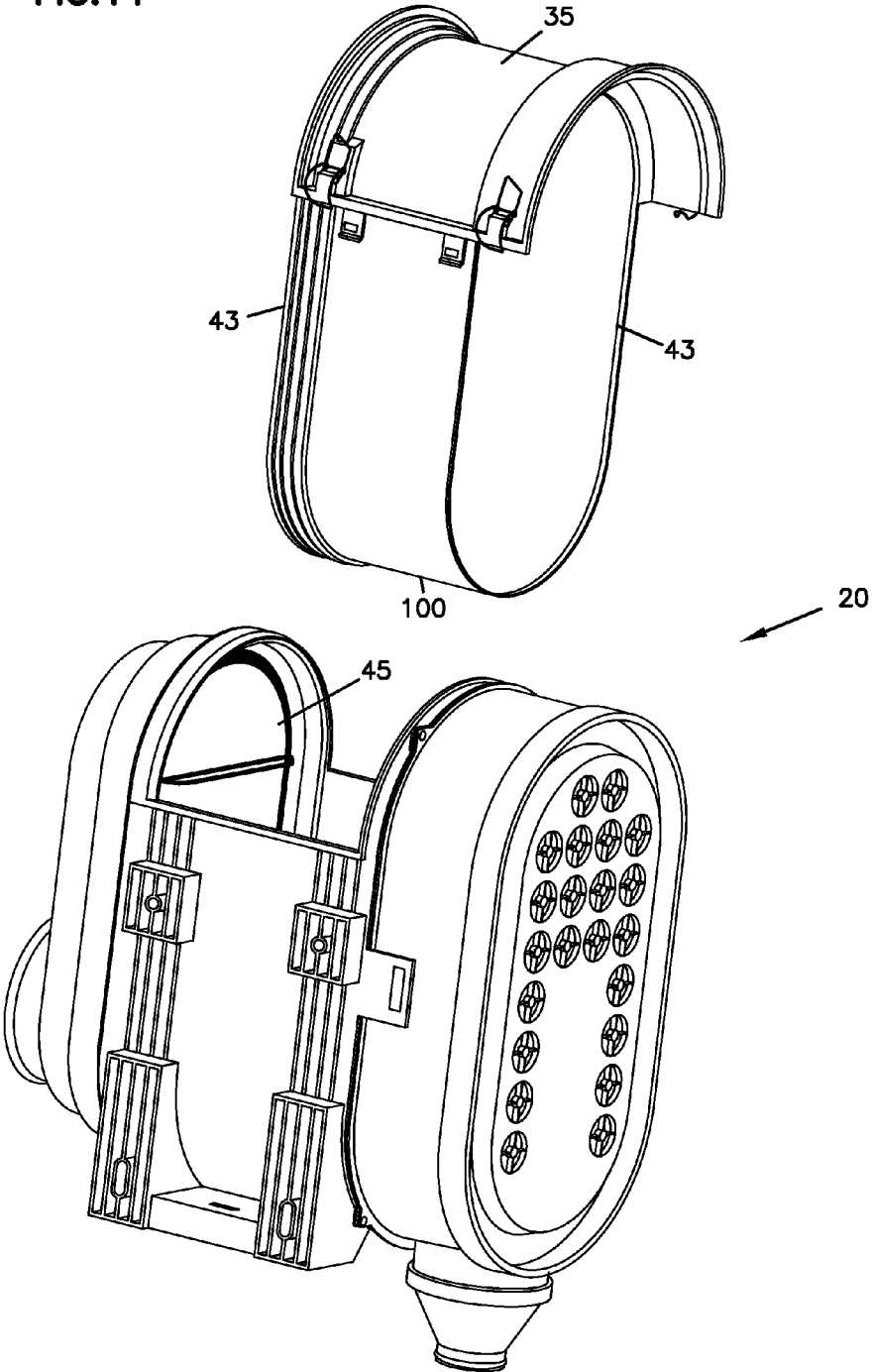


FIG.12

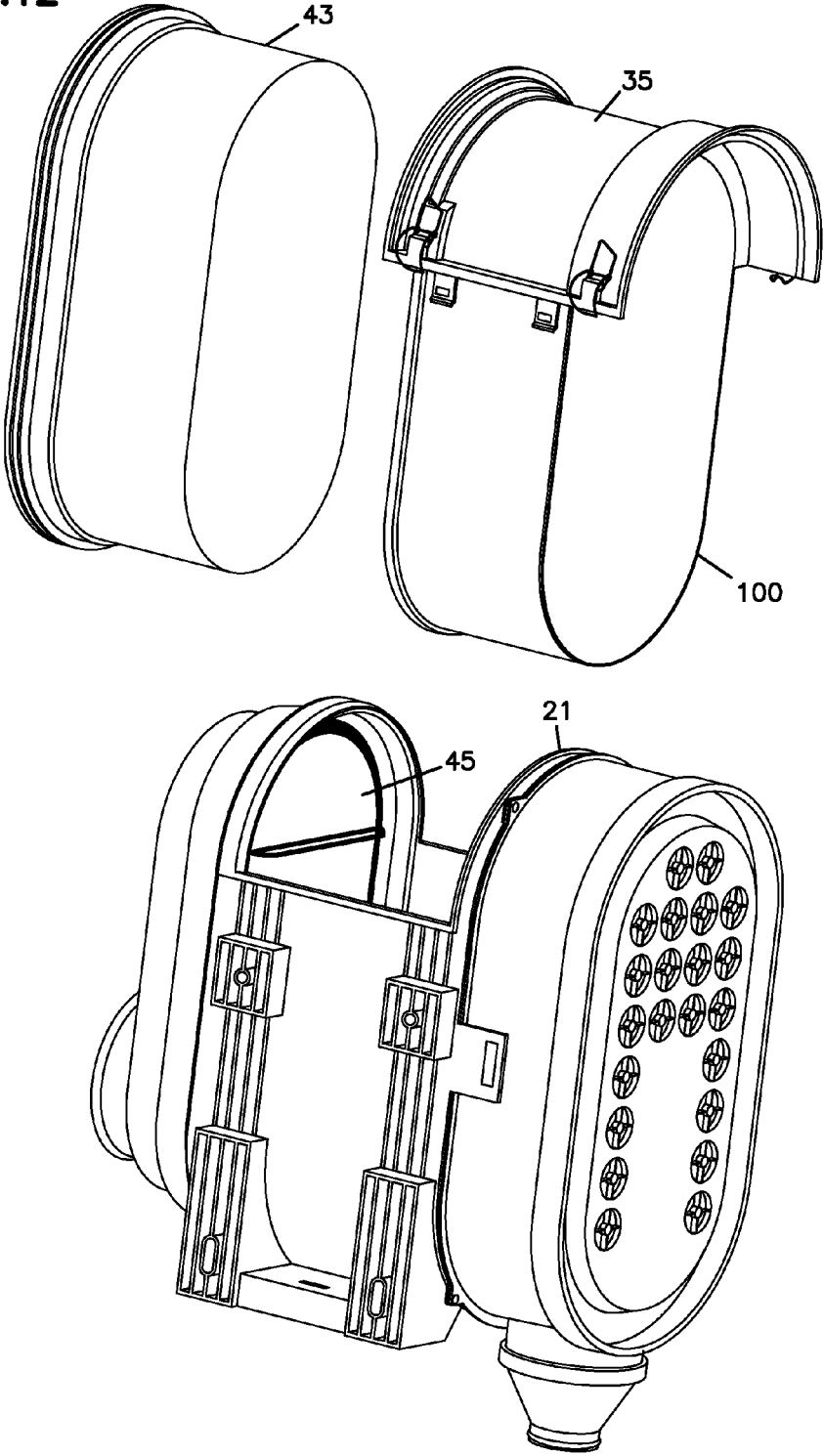


FIG. 13

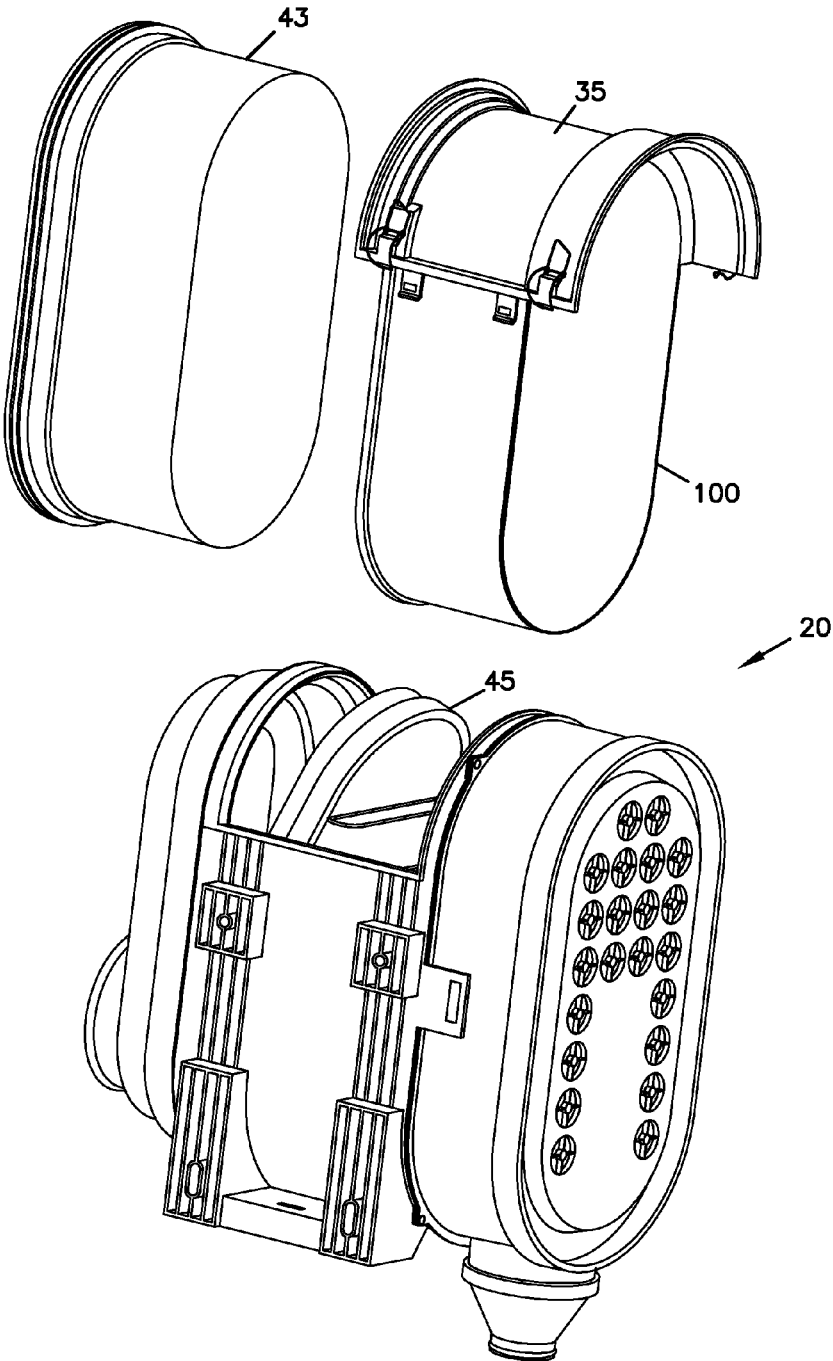
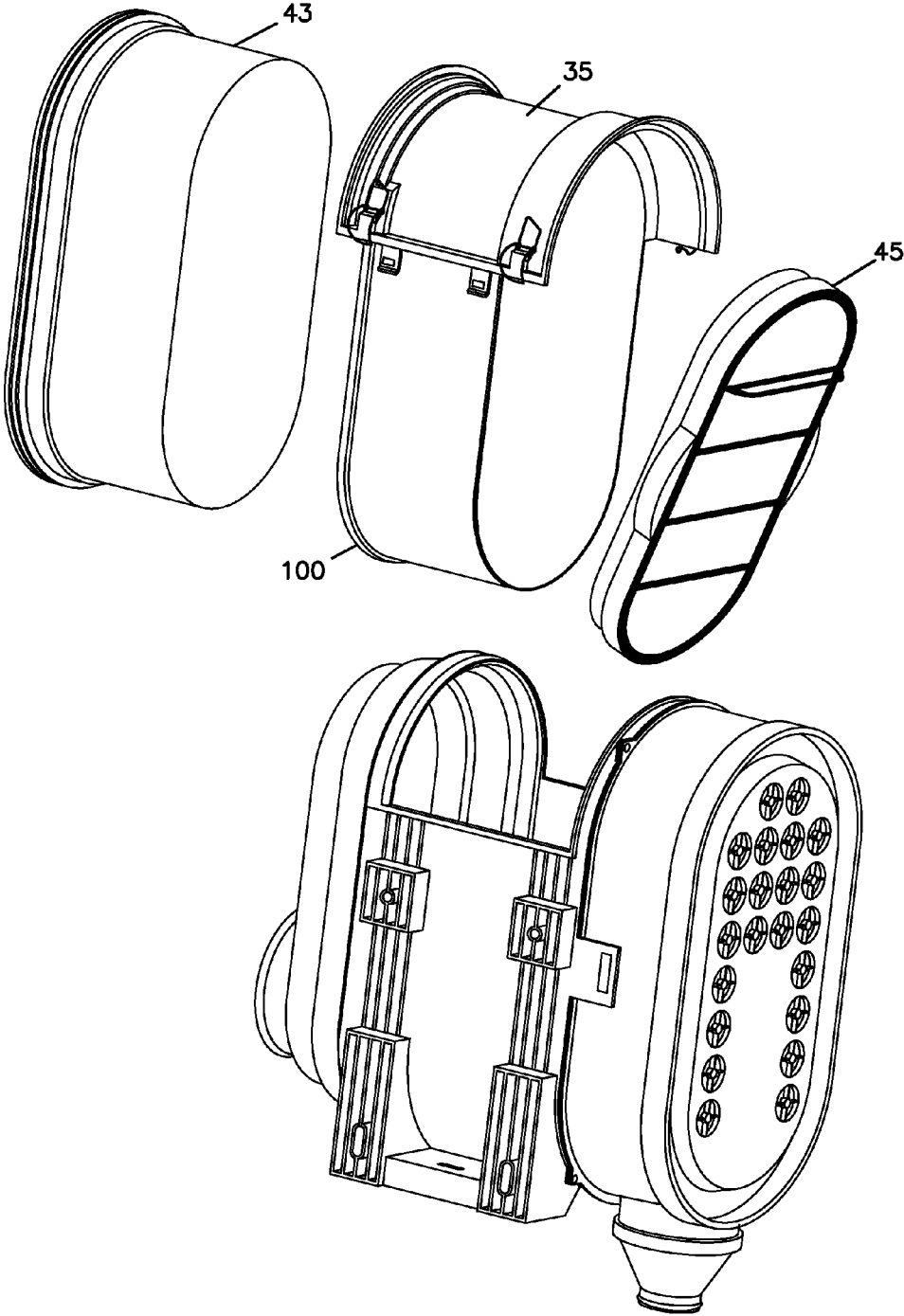


FIG.14



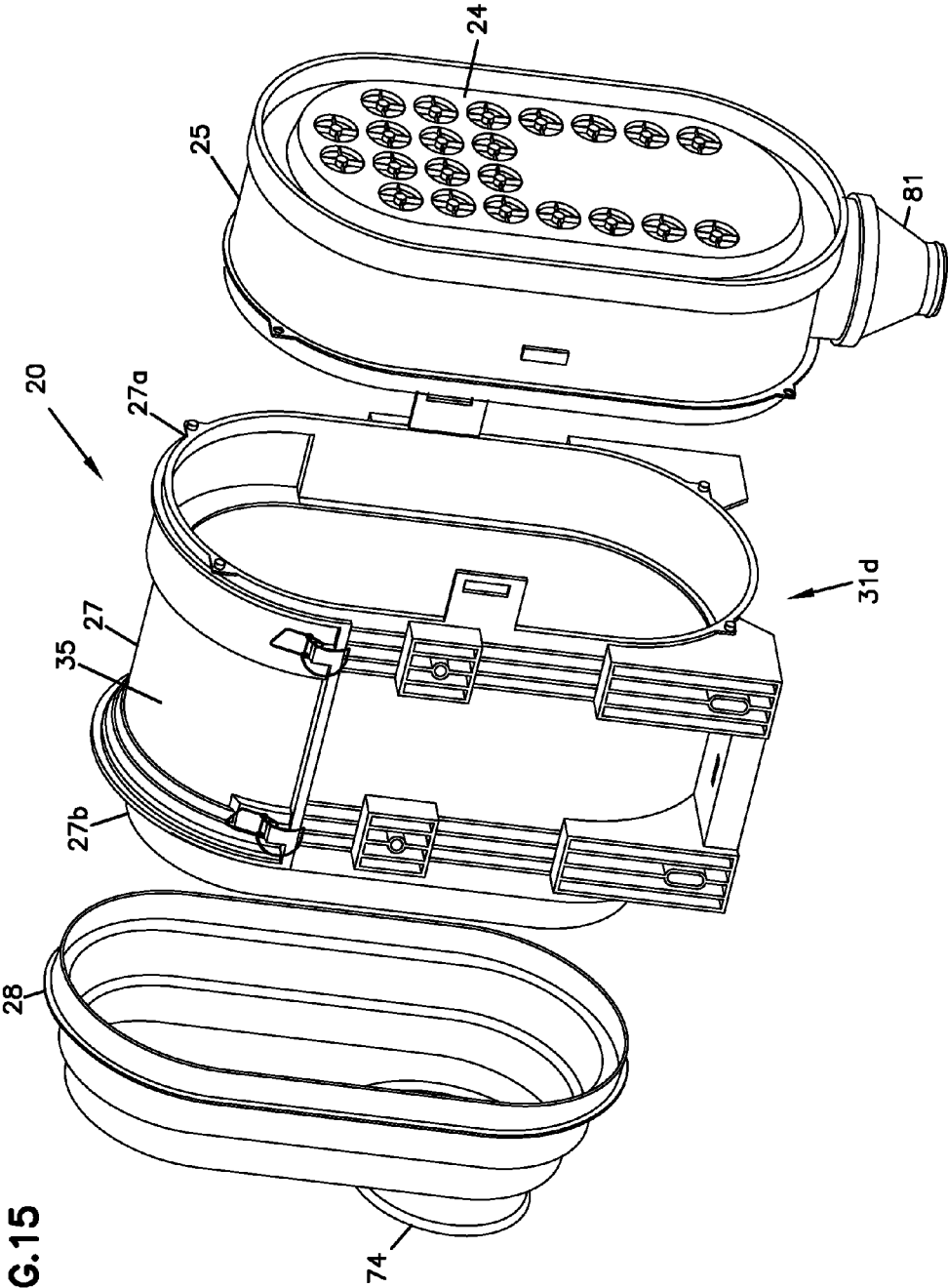


FIG. 15



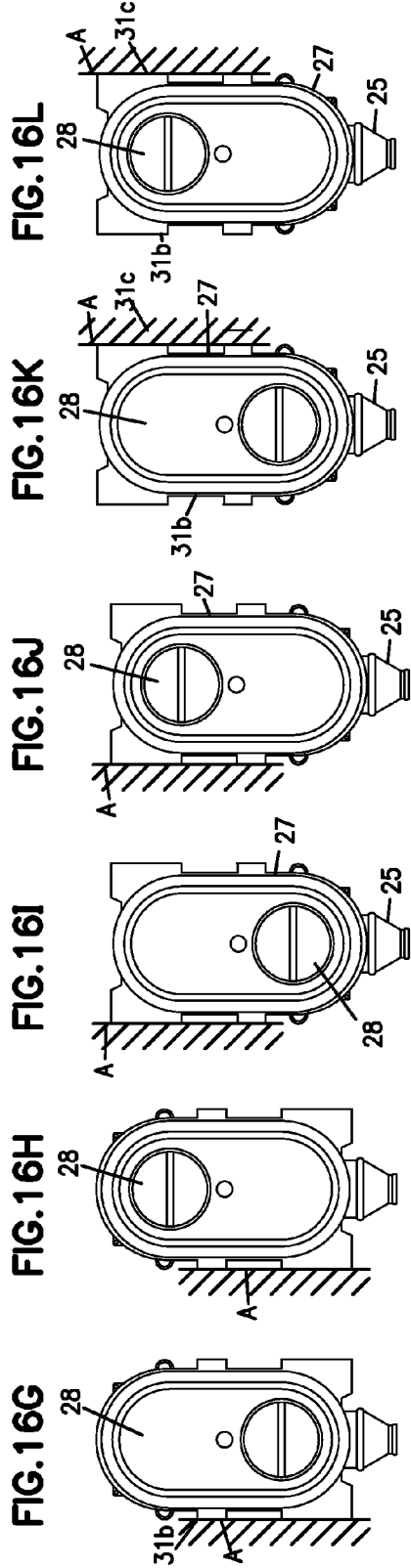
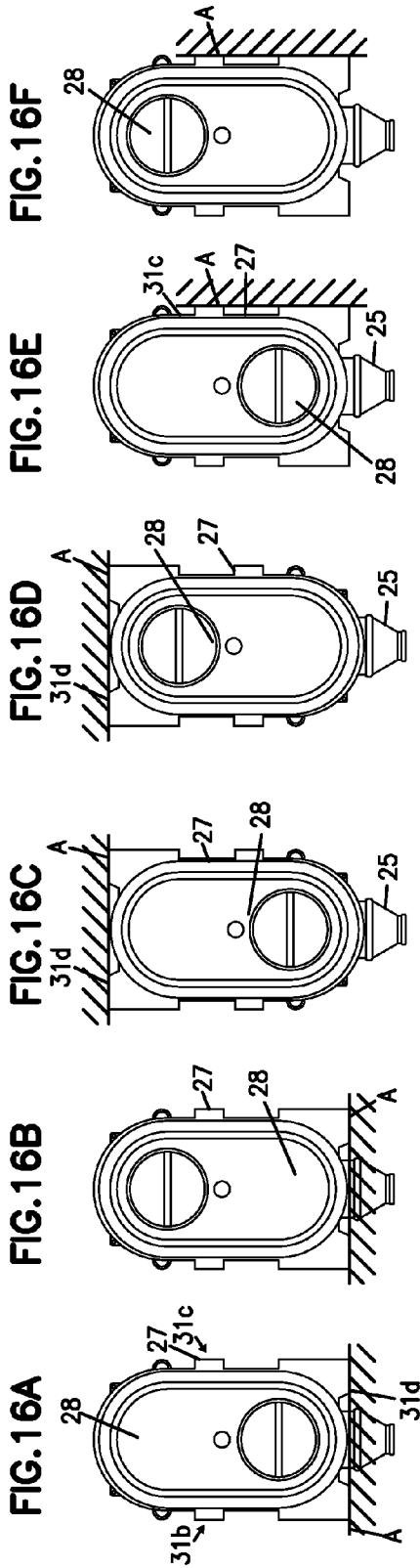


FIG.16O

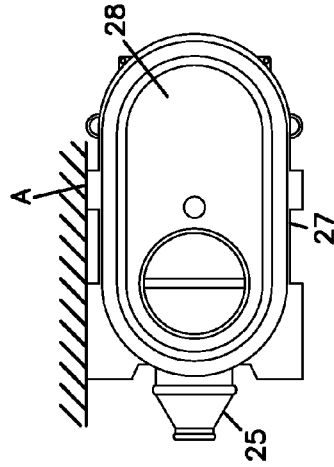


FIG.16R

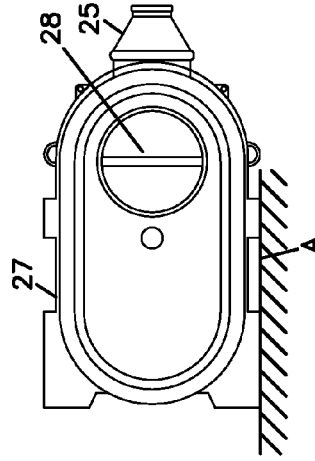


FIG.16N

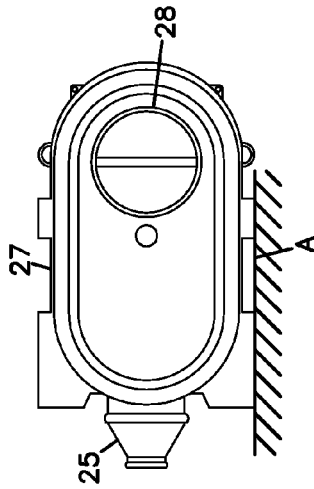


FIG.16Q

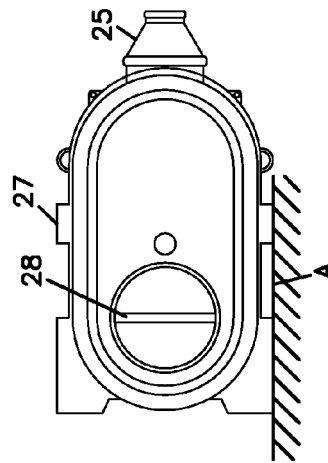


FIG.16M

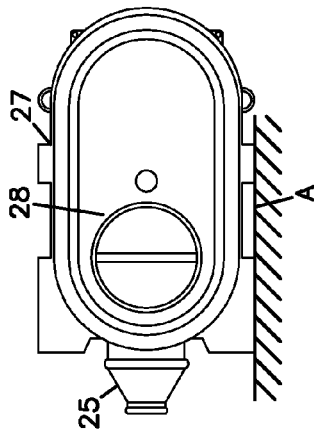


FIG.16P

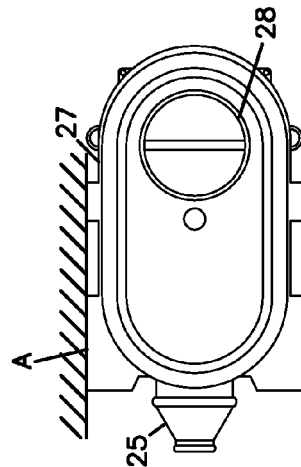


FIG. 16U

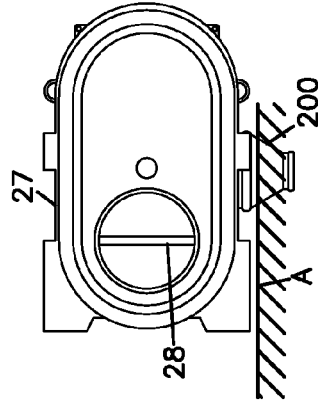


FIG. 16X

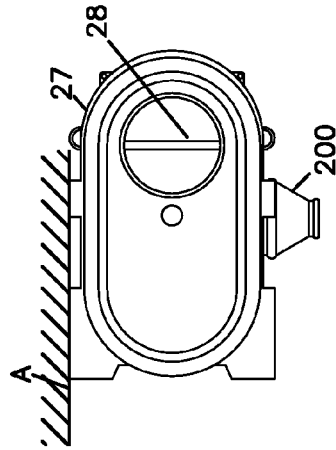


FIG. 16T

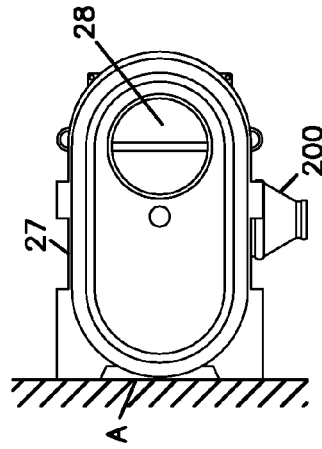


FIG. 16W

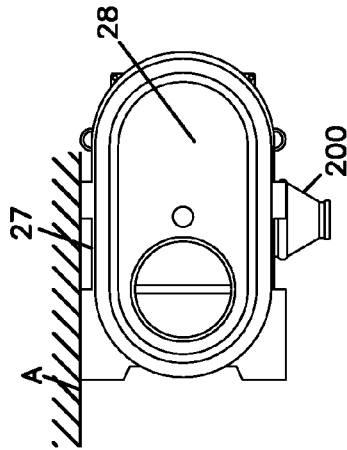


FIG. 16S

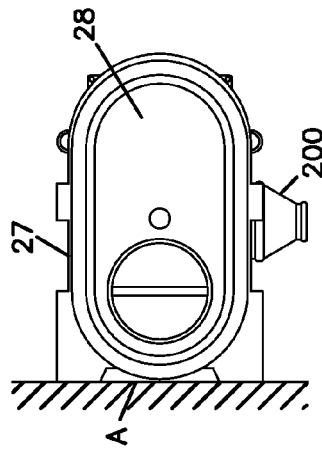
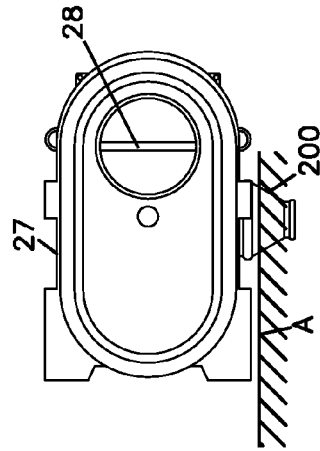


FIG. 16V



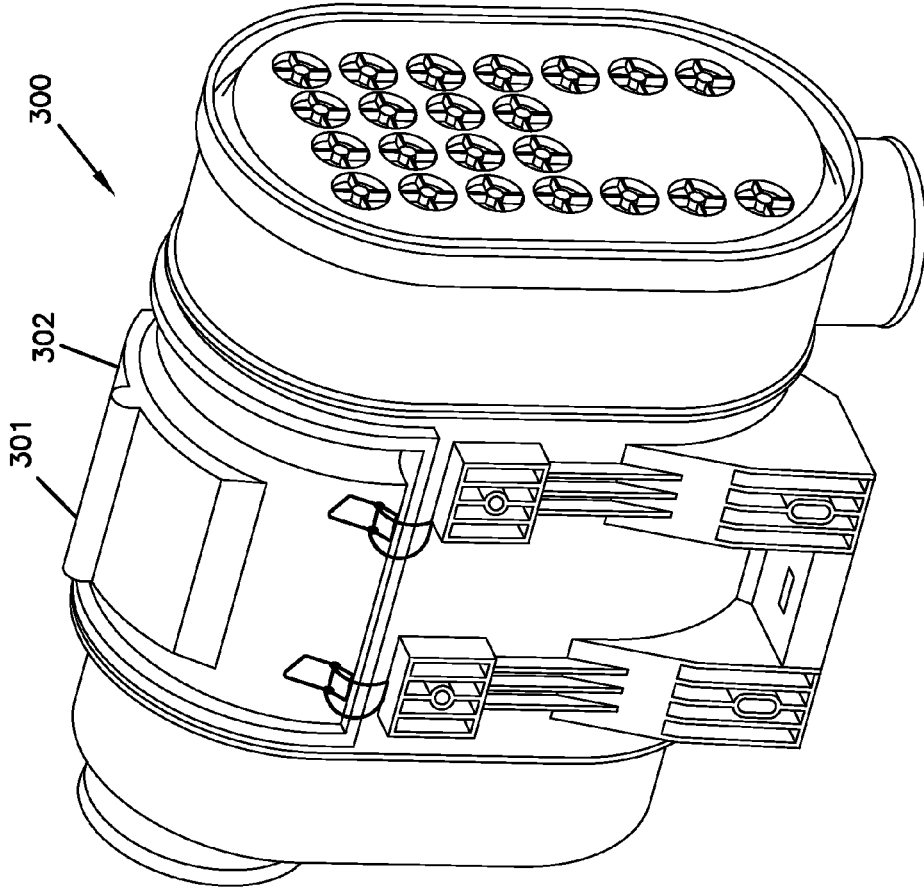


FIG. 17

FIG. 18

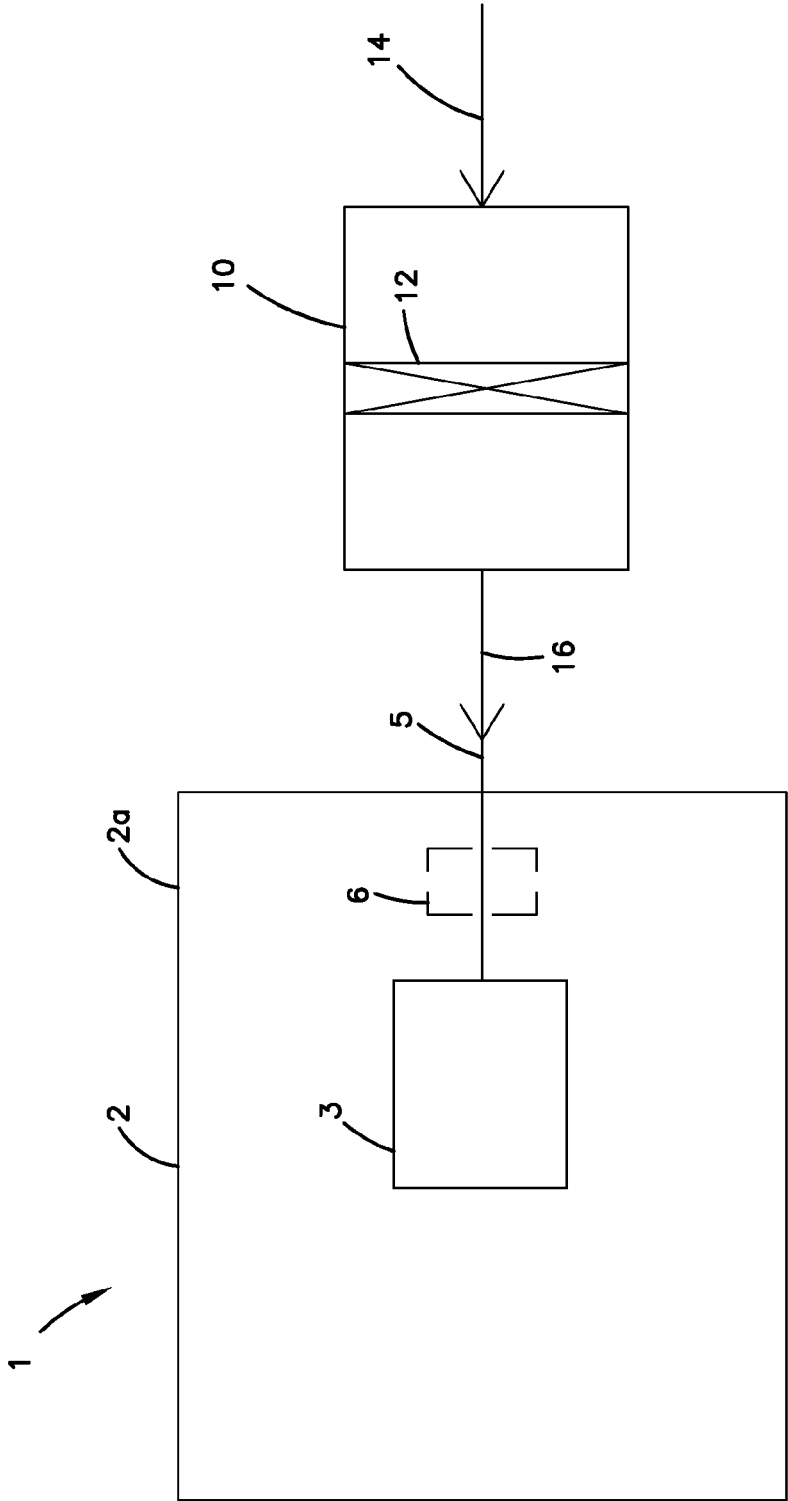


FIG. 19

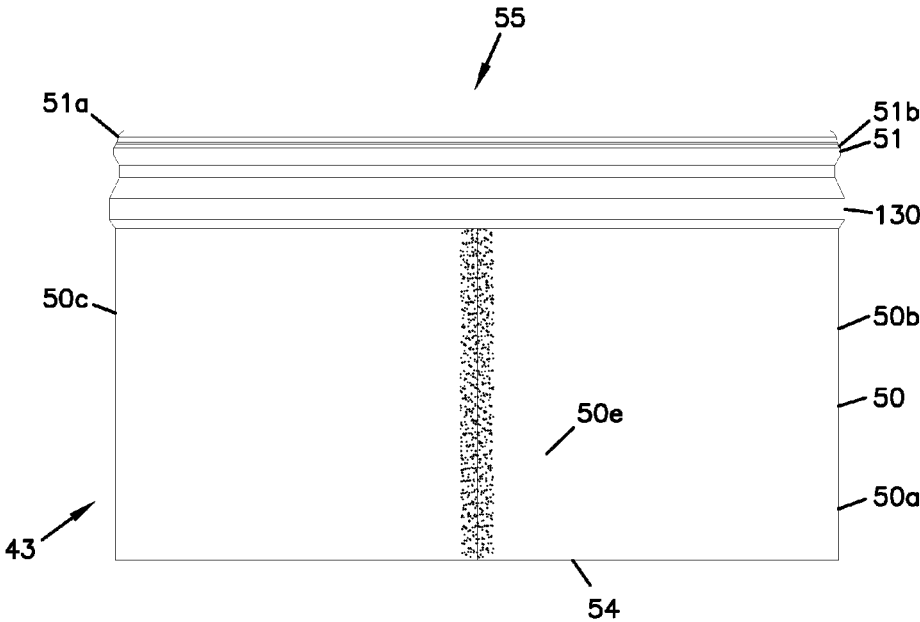


FIG. 20

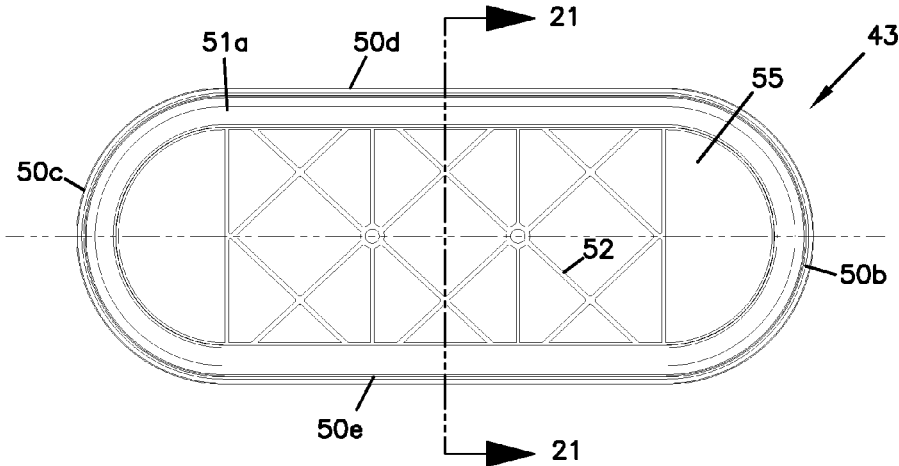
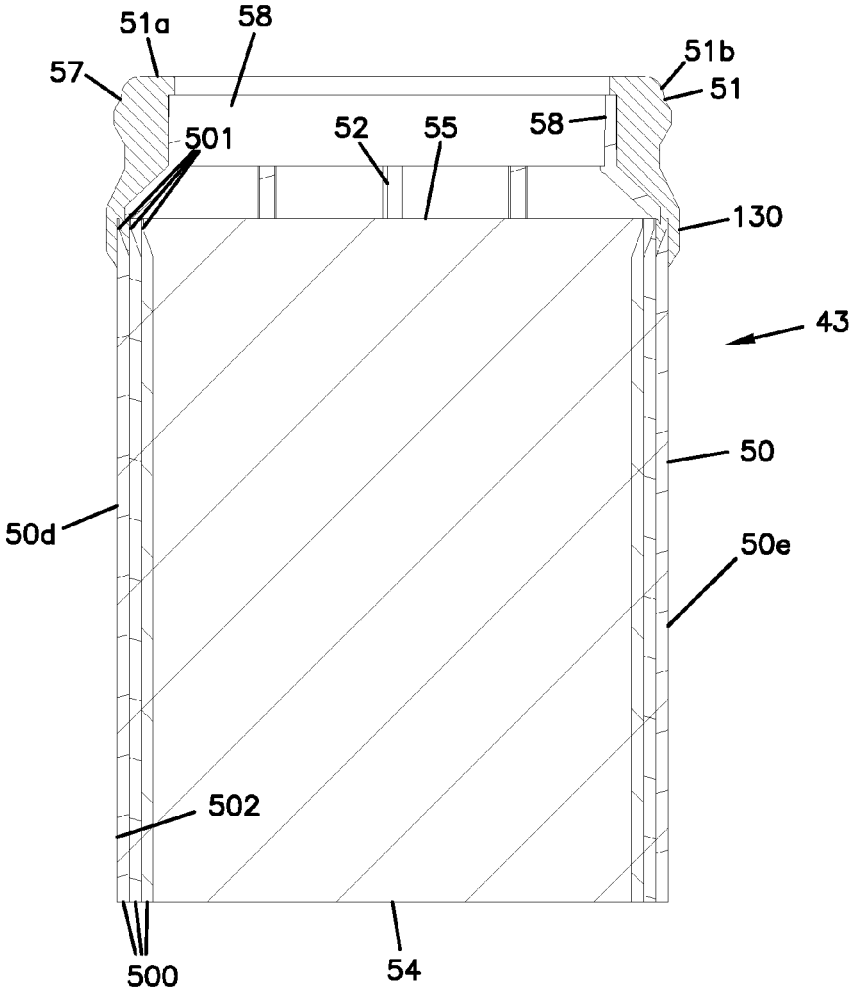


FIG. 21



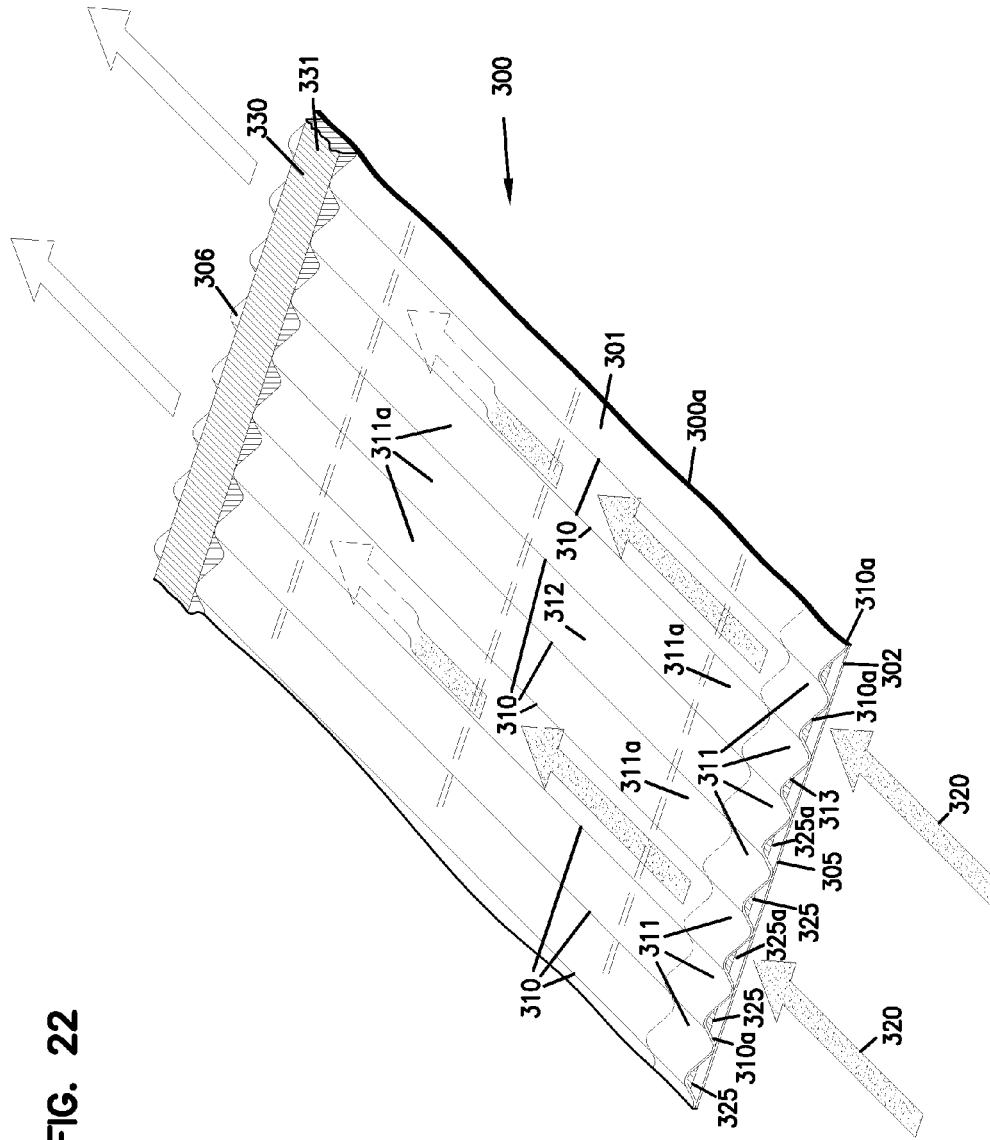


FIG. 22



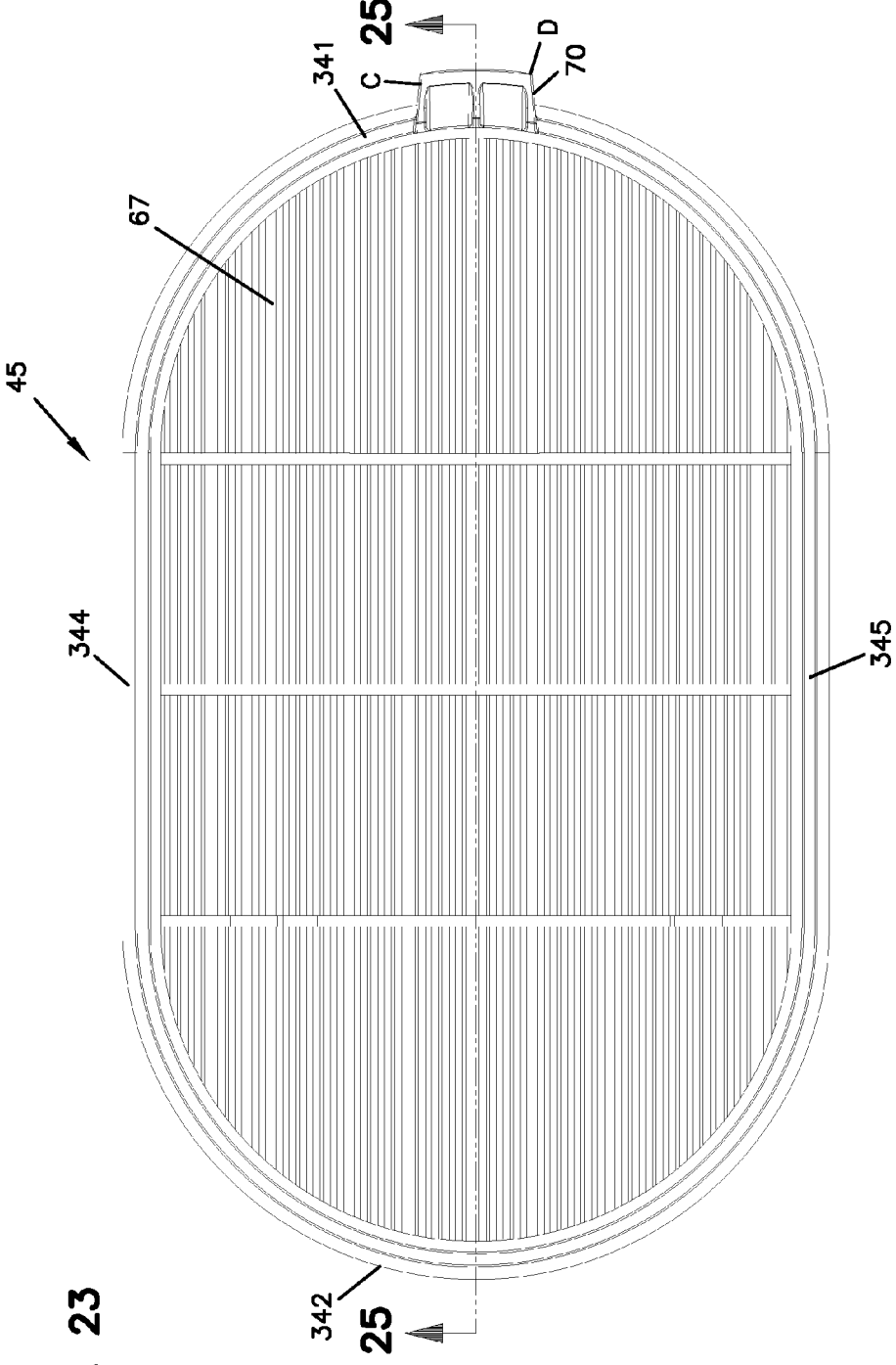


FIG. 23

FIG. 24

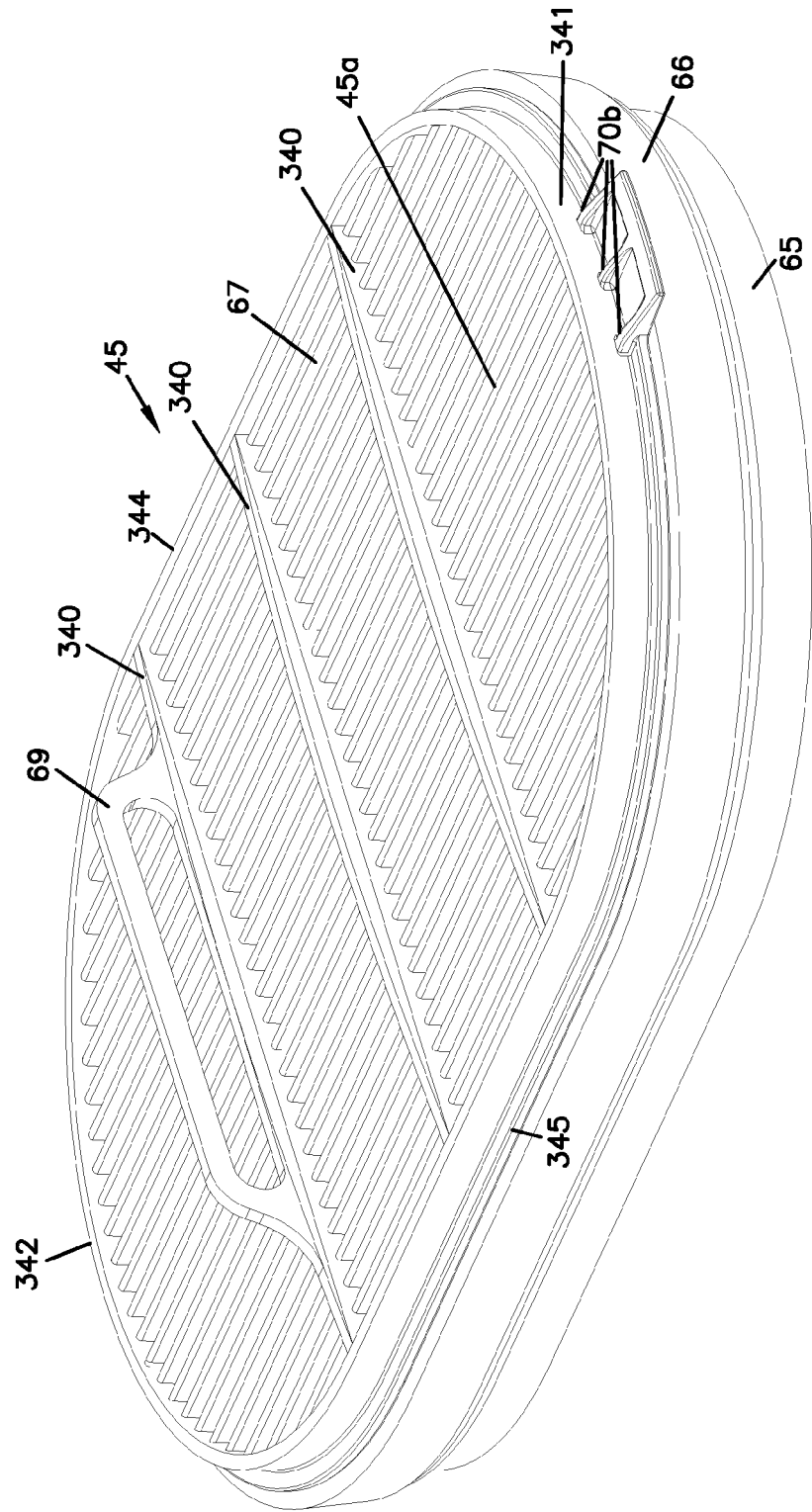
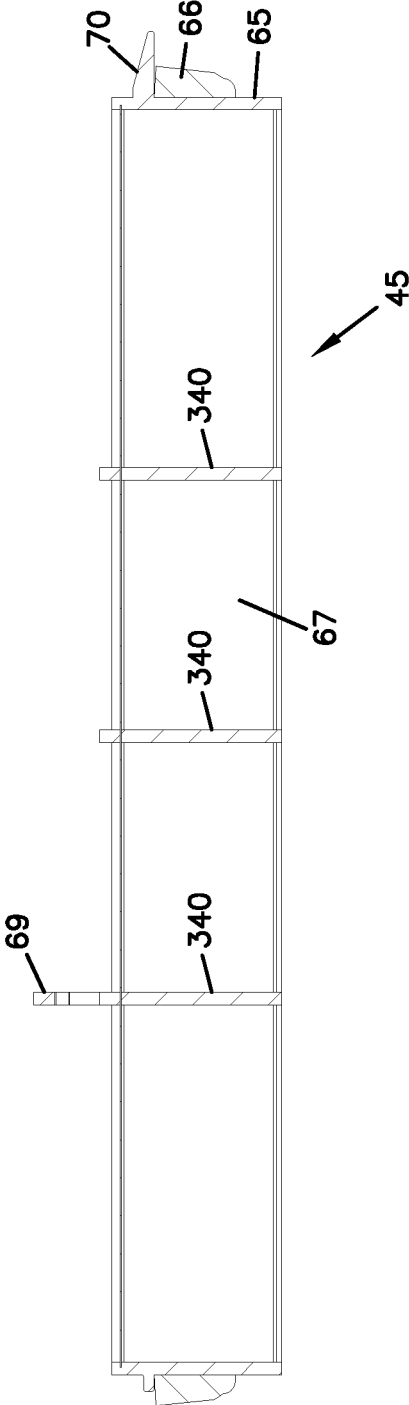


FIG.25



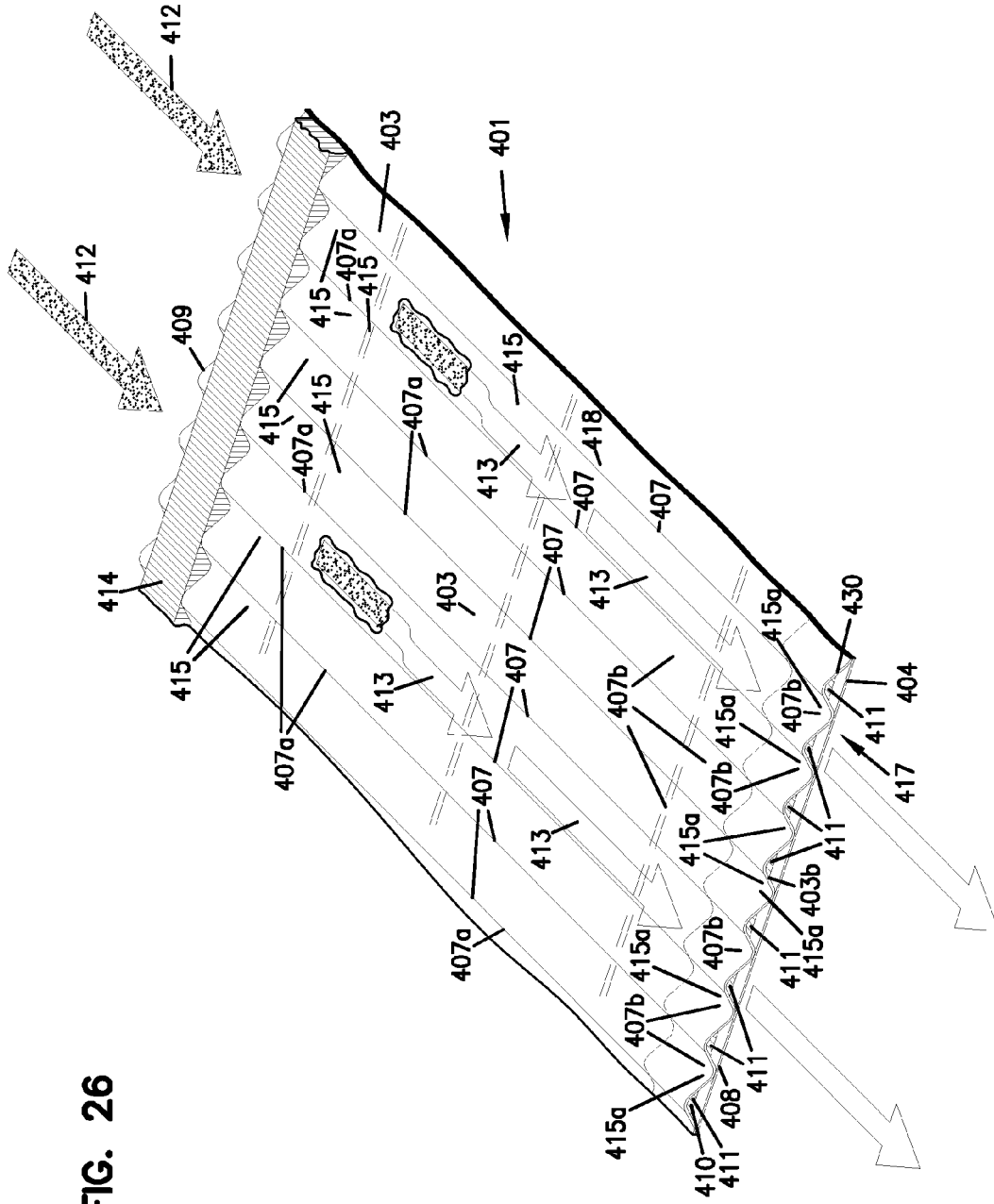
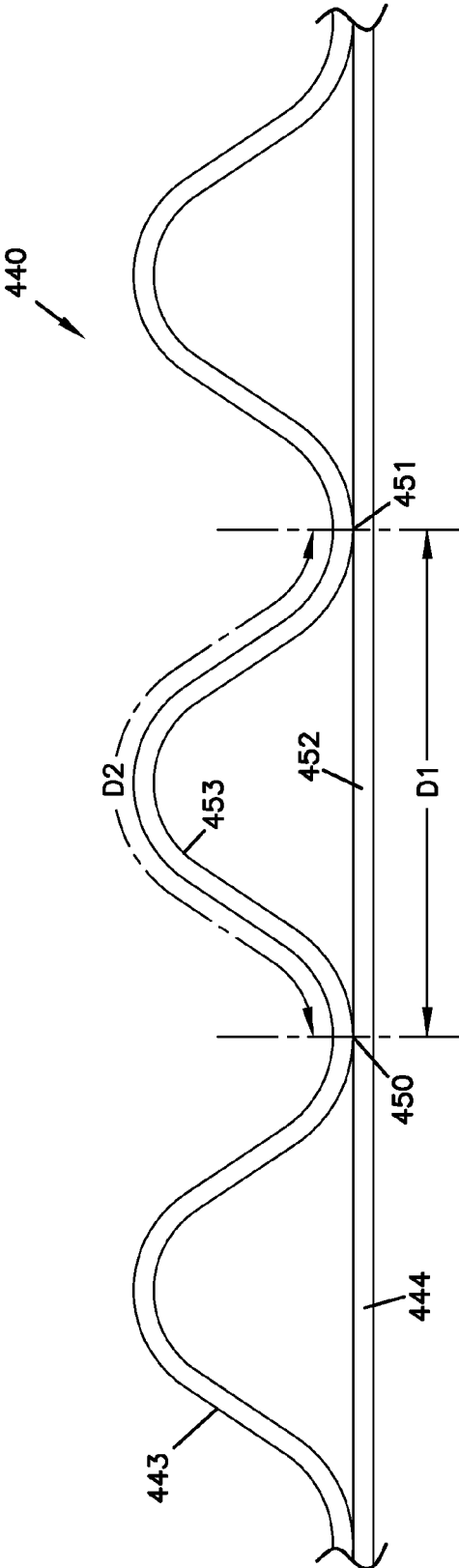
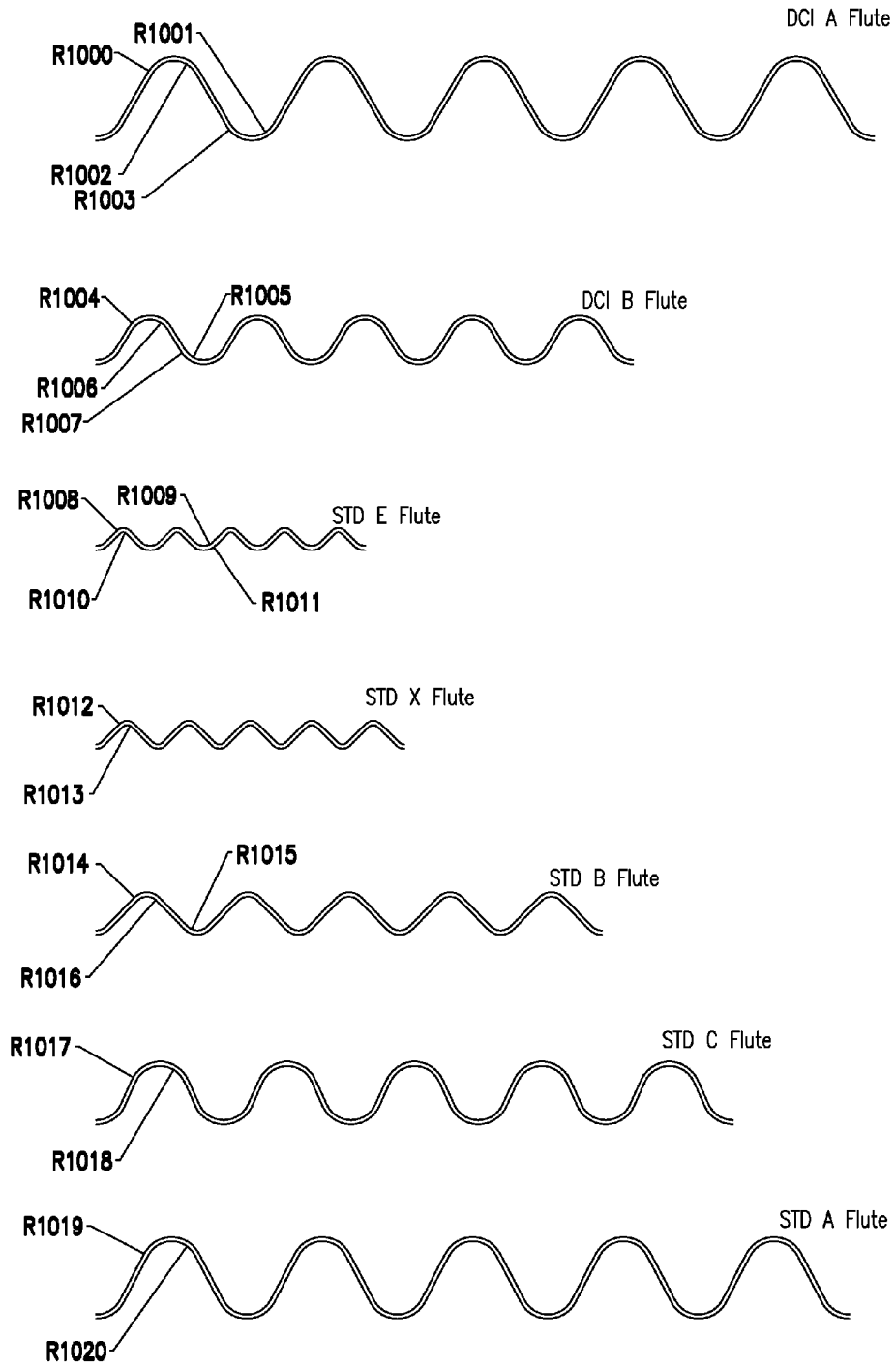


FIG. 26

FIG. 27



**FIG. 28**



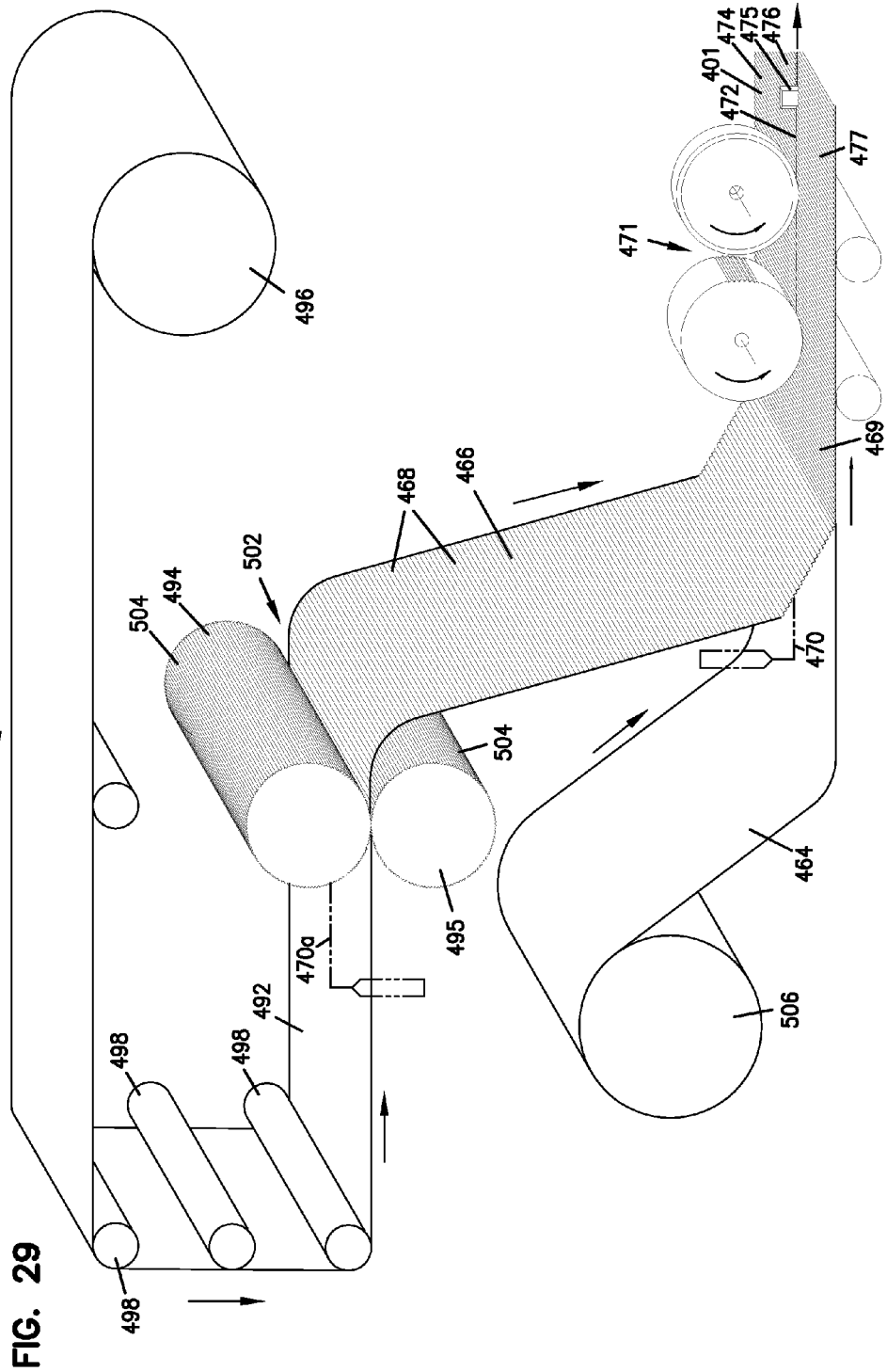


FIG. 30

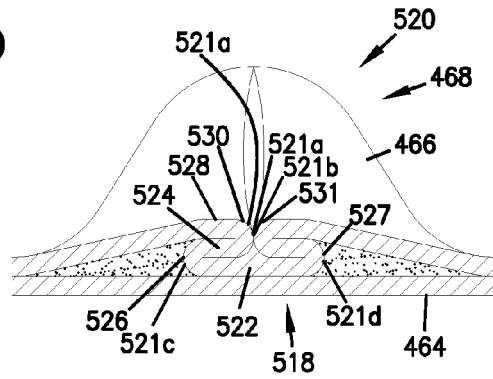


FIG. 31

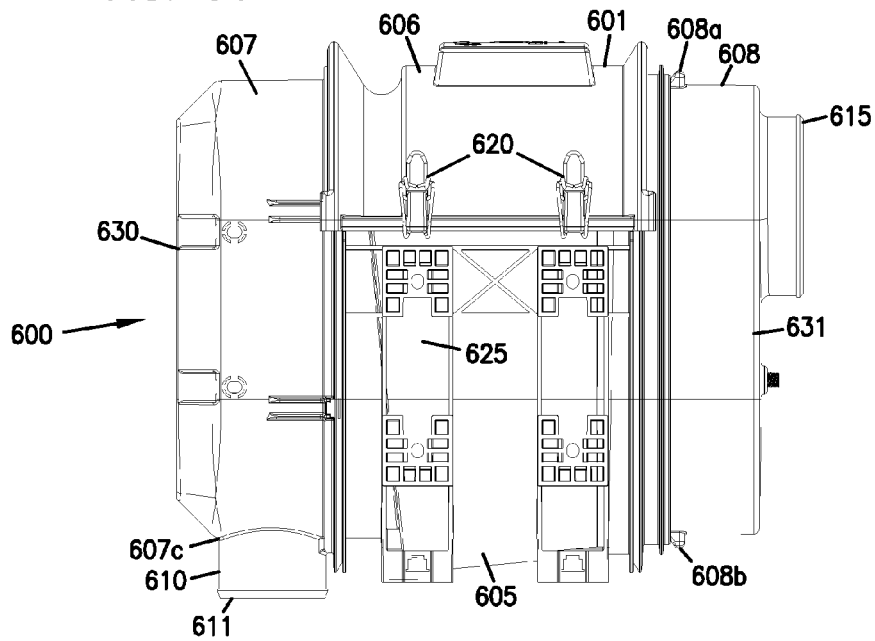
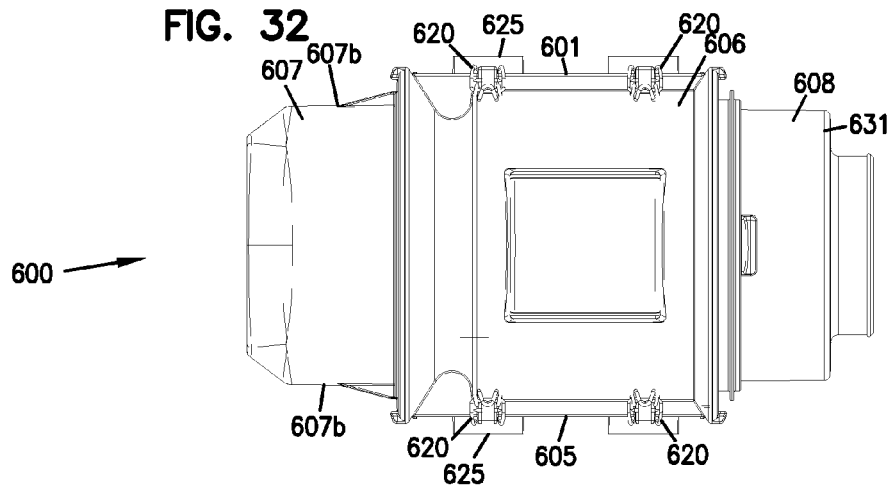


FIG. 32





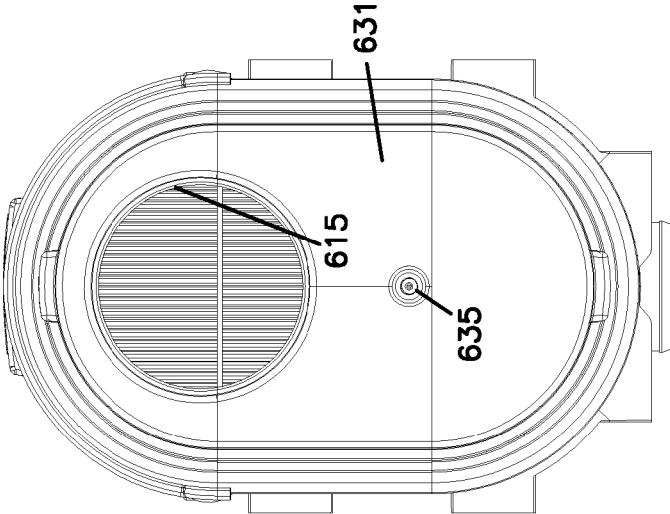


FIG. 34

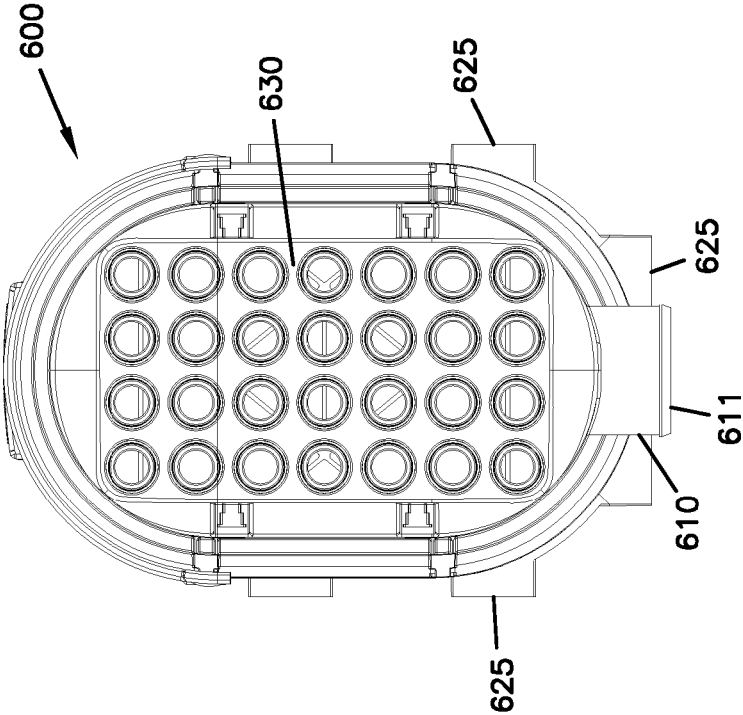


FIG. 33

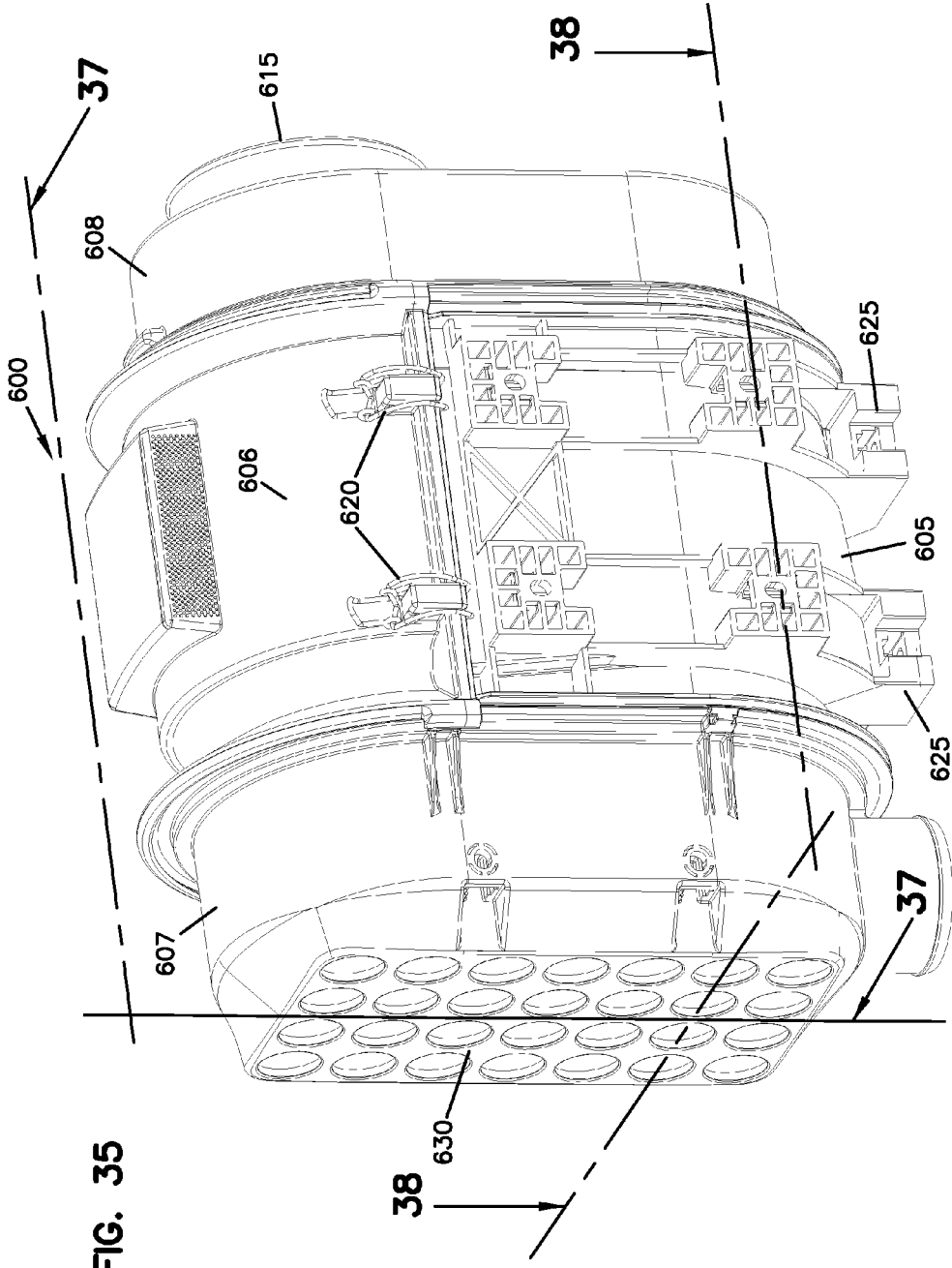
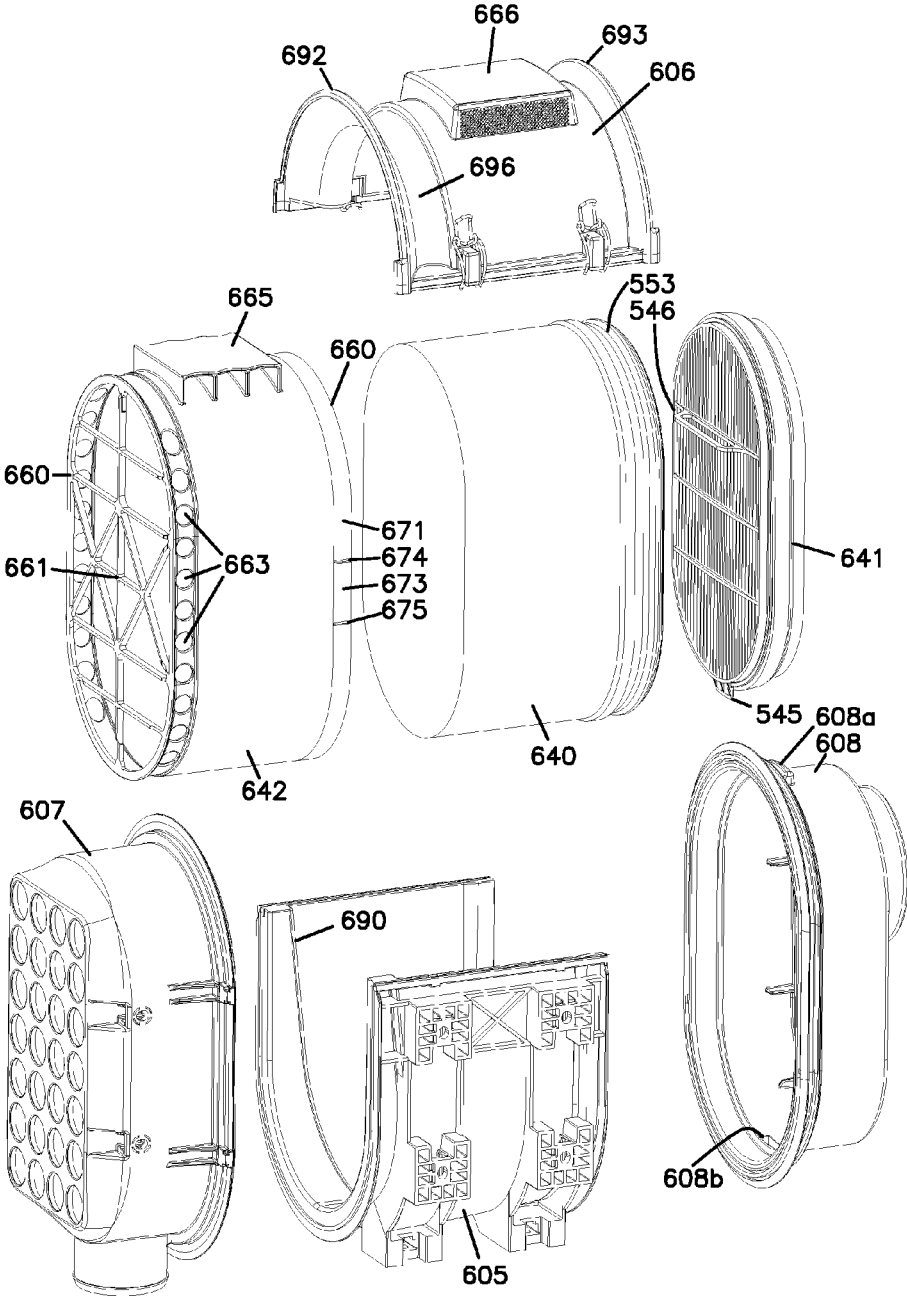


FIG. 35

FIG. 36



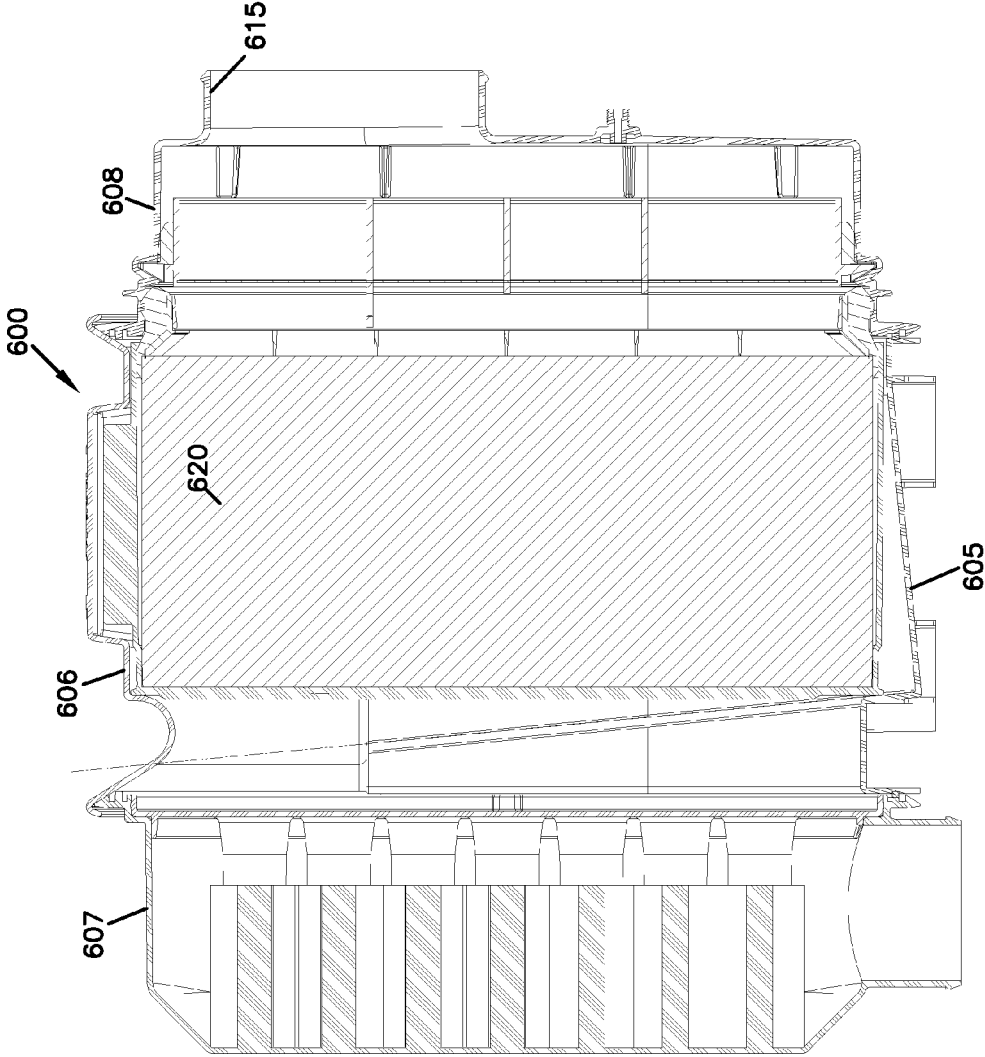


FIG. 37

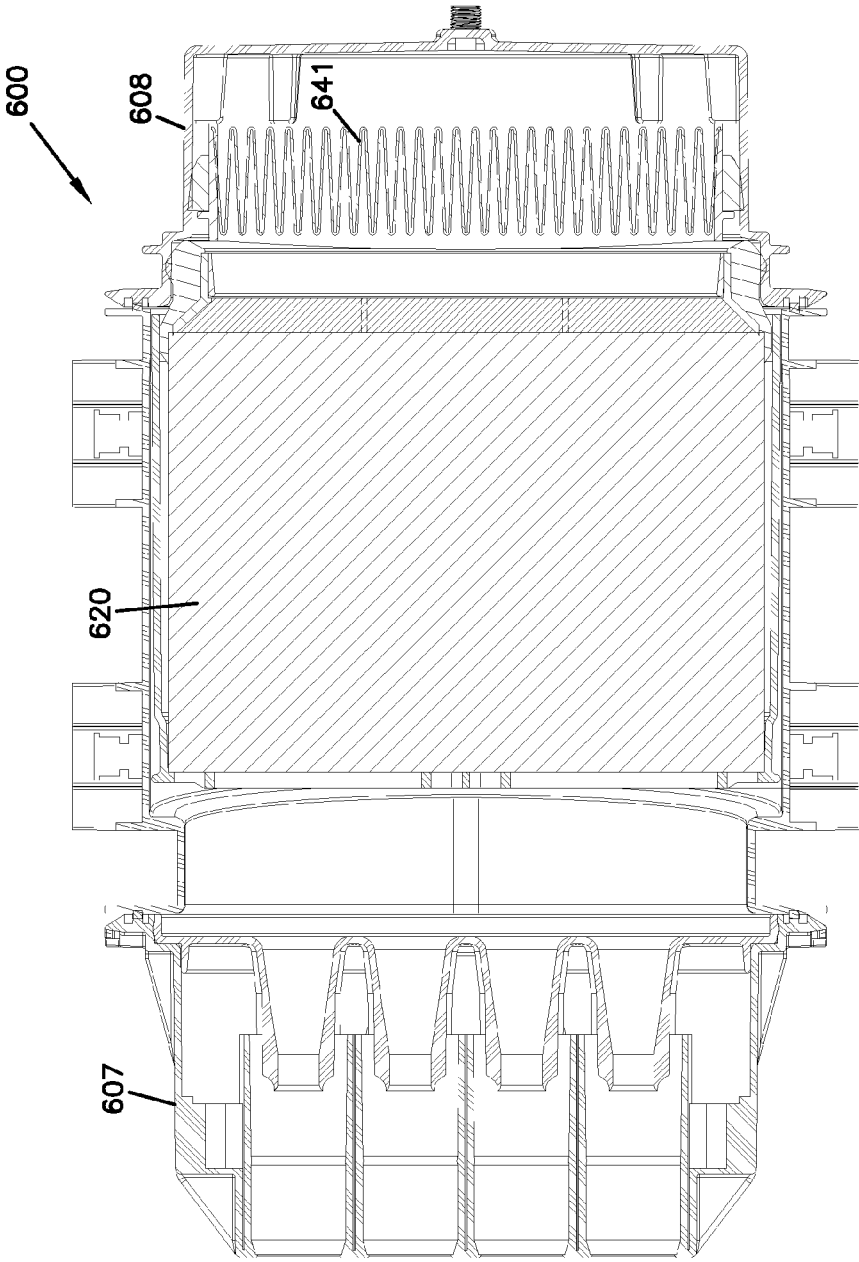
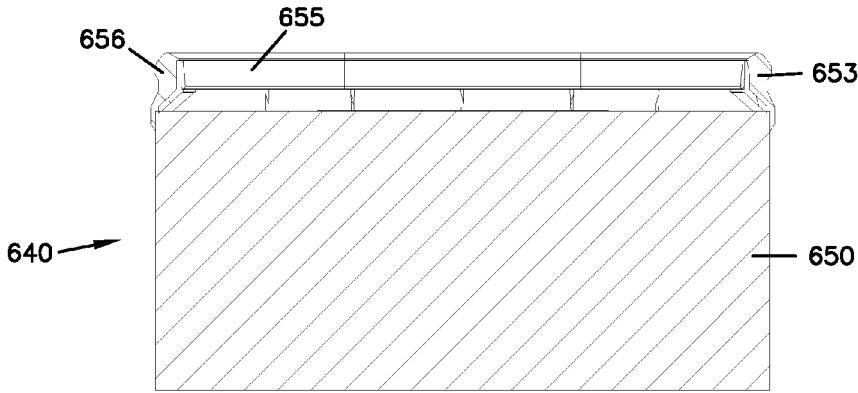


FIG. 38

FIG. 39



FIG. 40



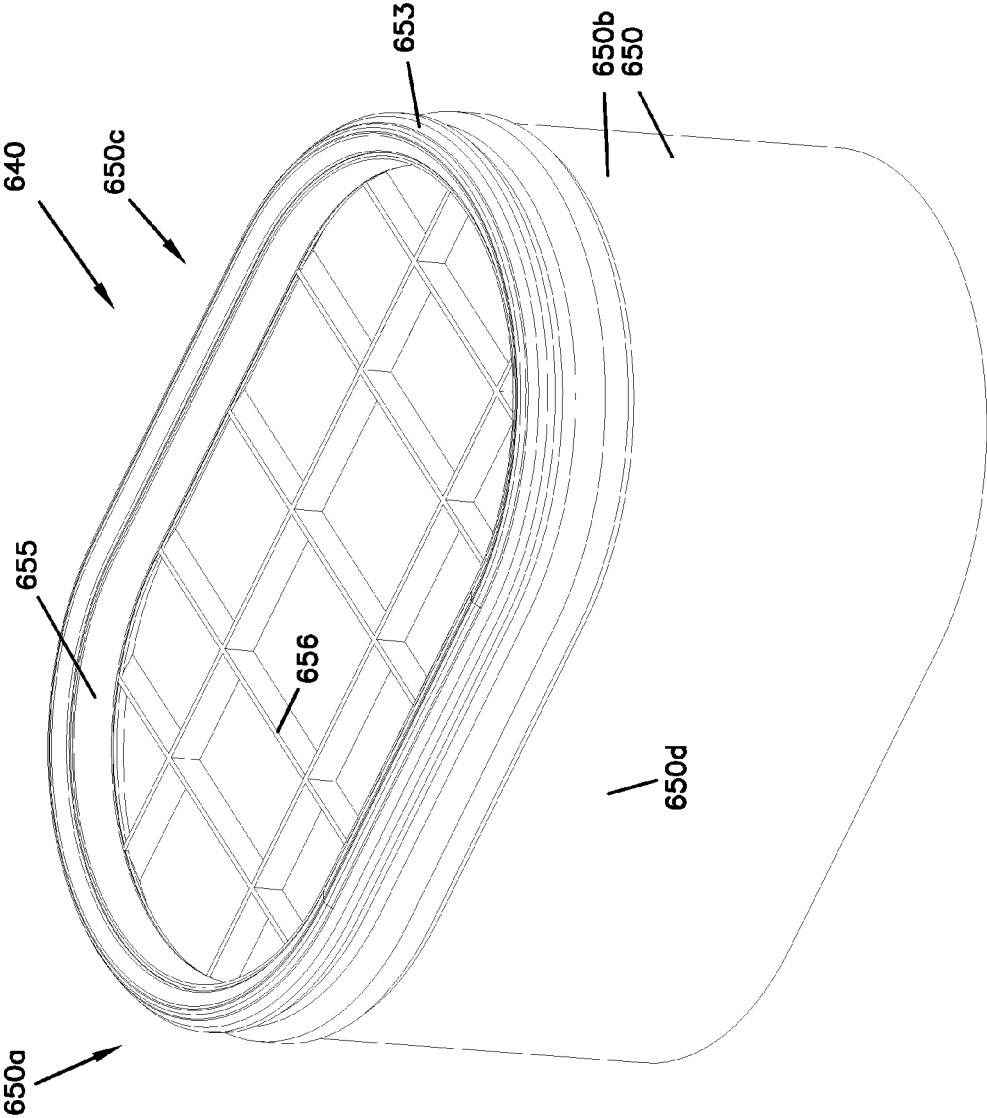


FIG. 41

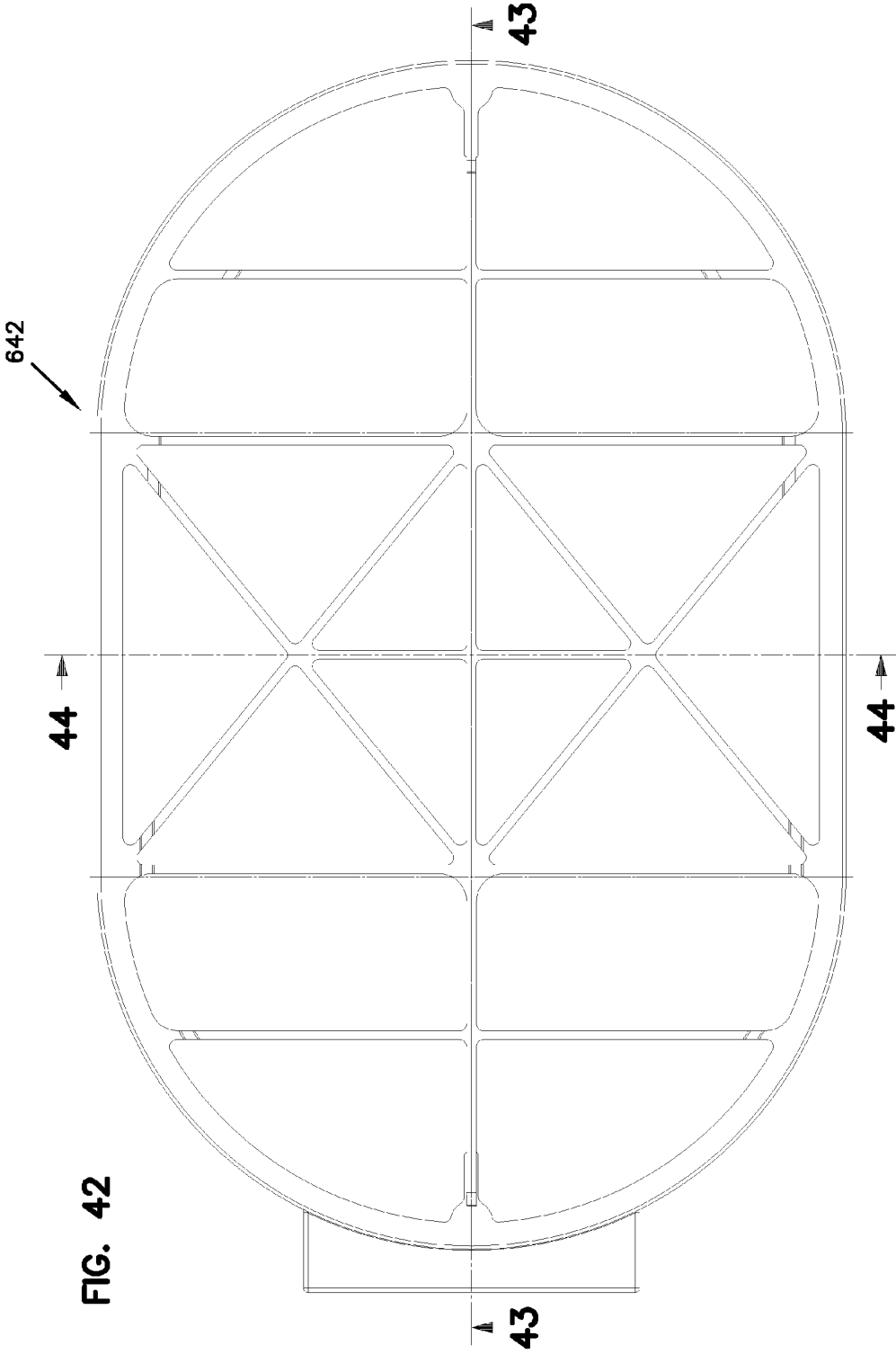


FIG. 42



FIG. 43

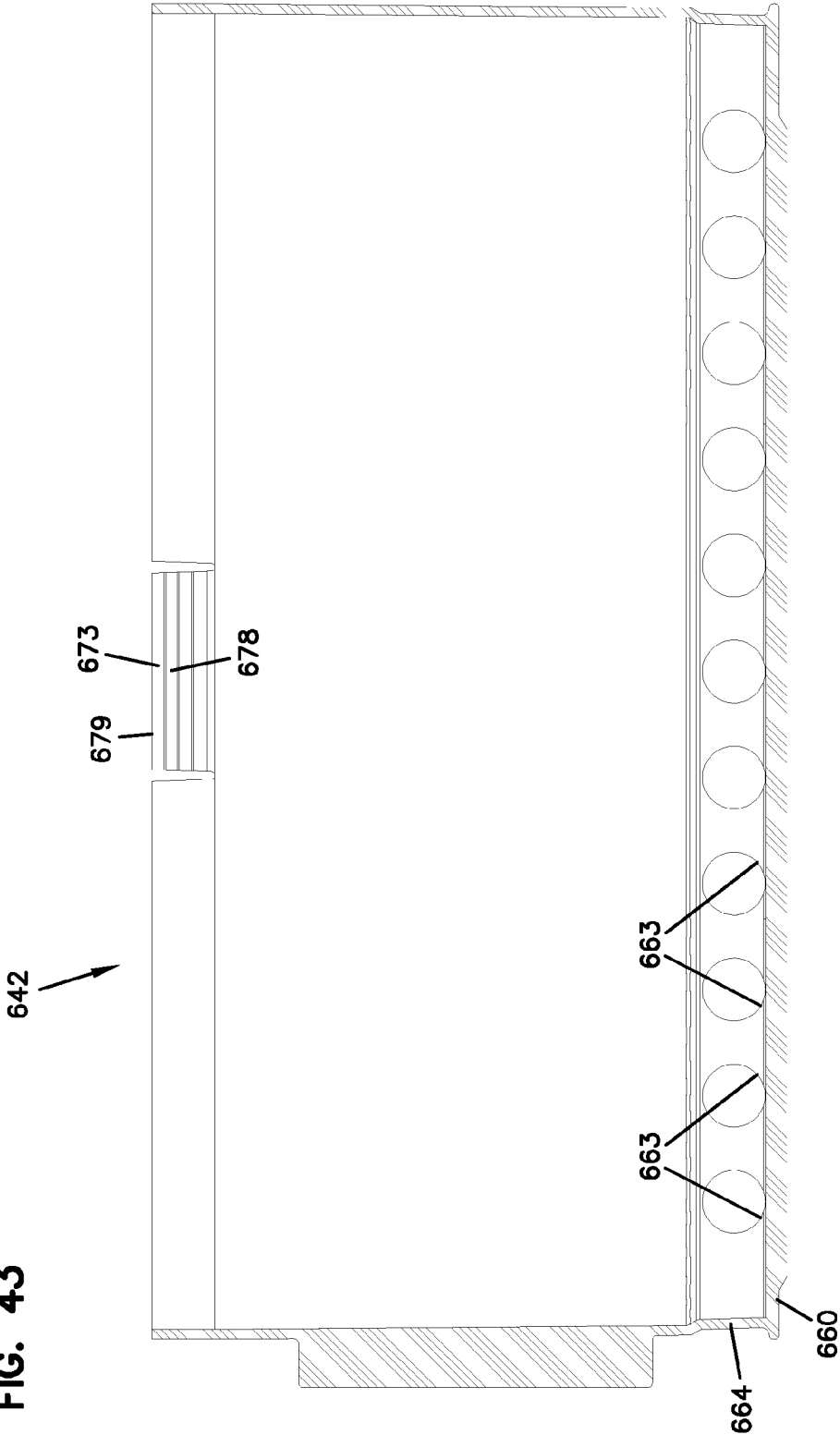


FIG. 44

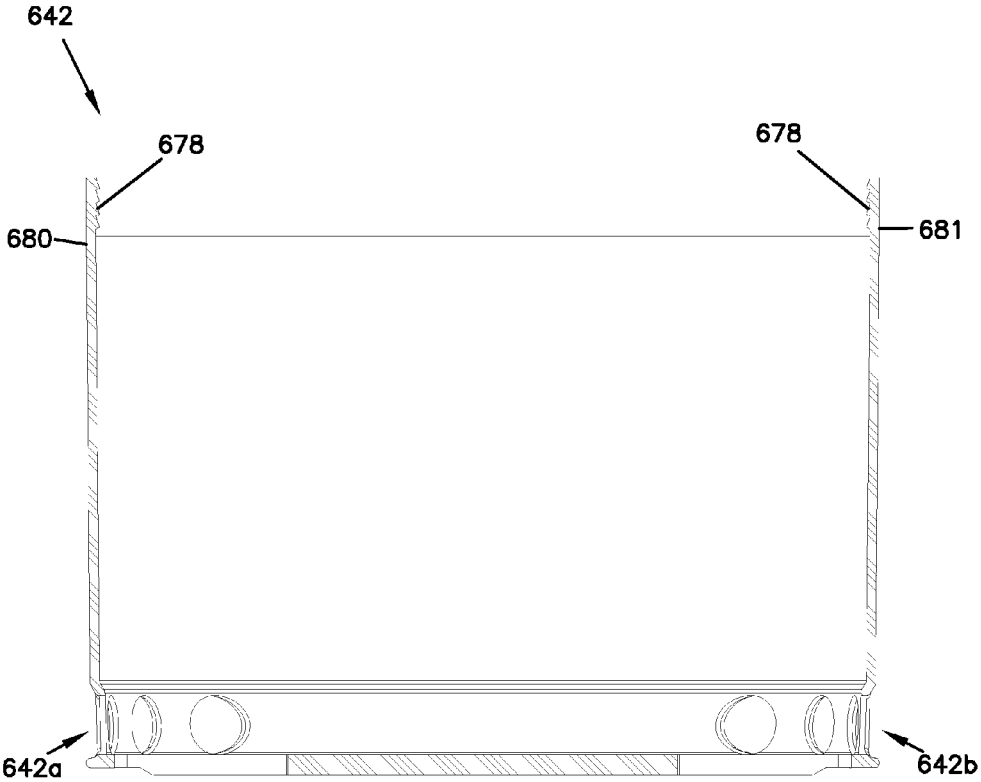


FIG. 45

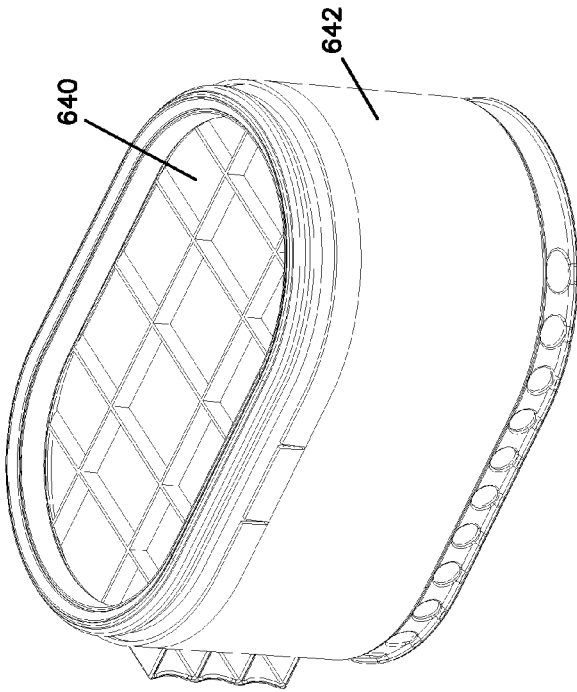
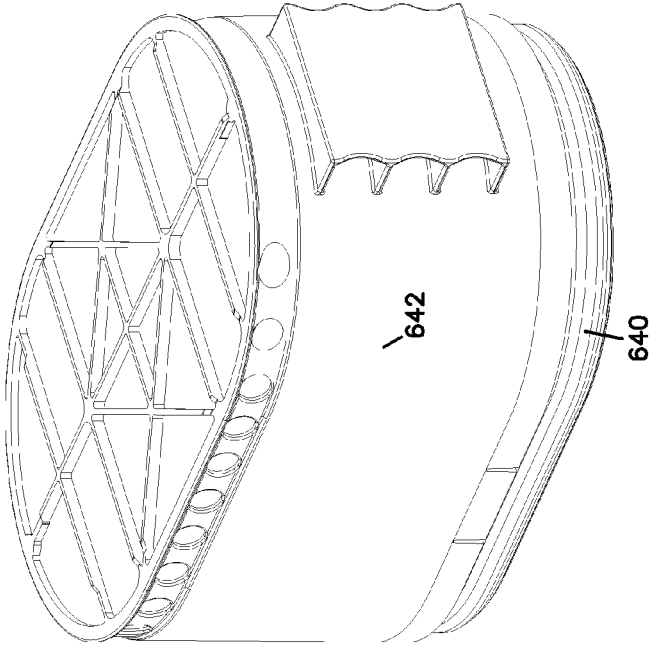


FIG. 46



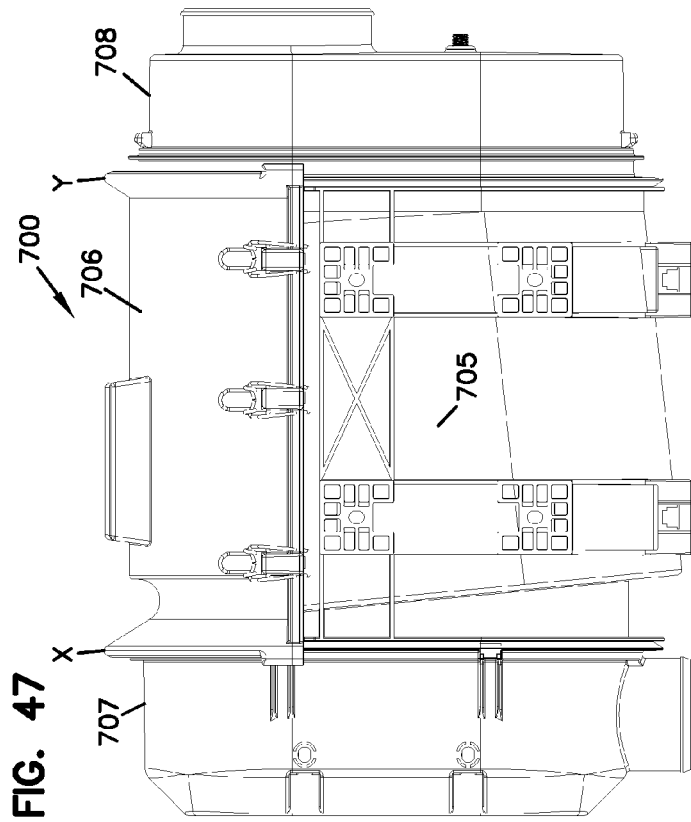


FIG. 48

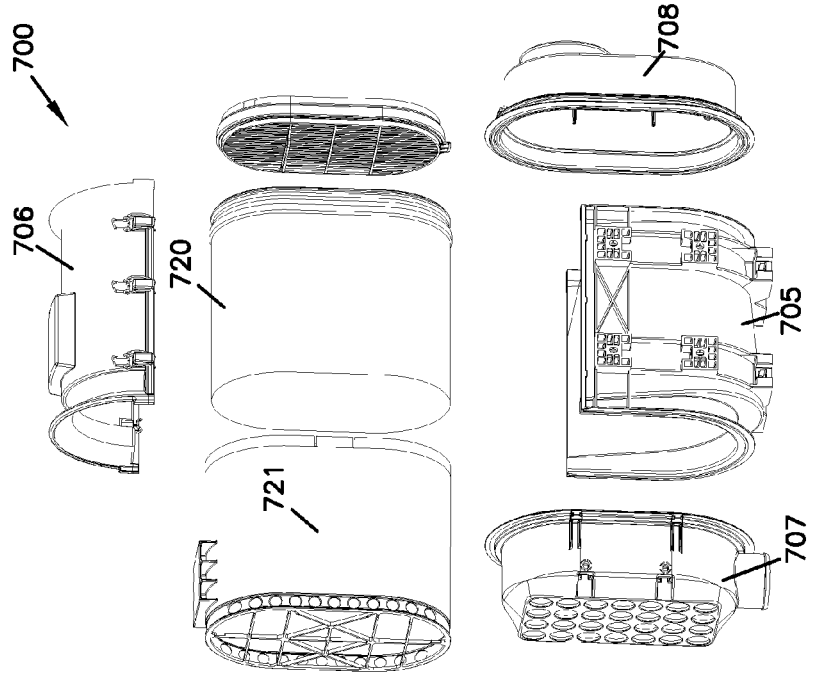
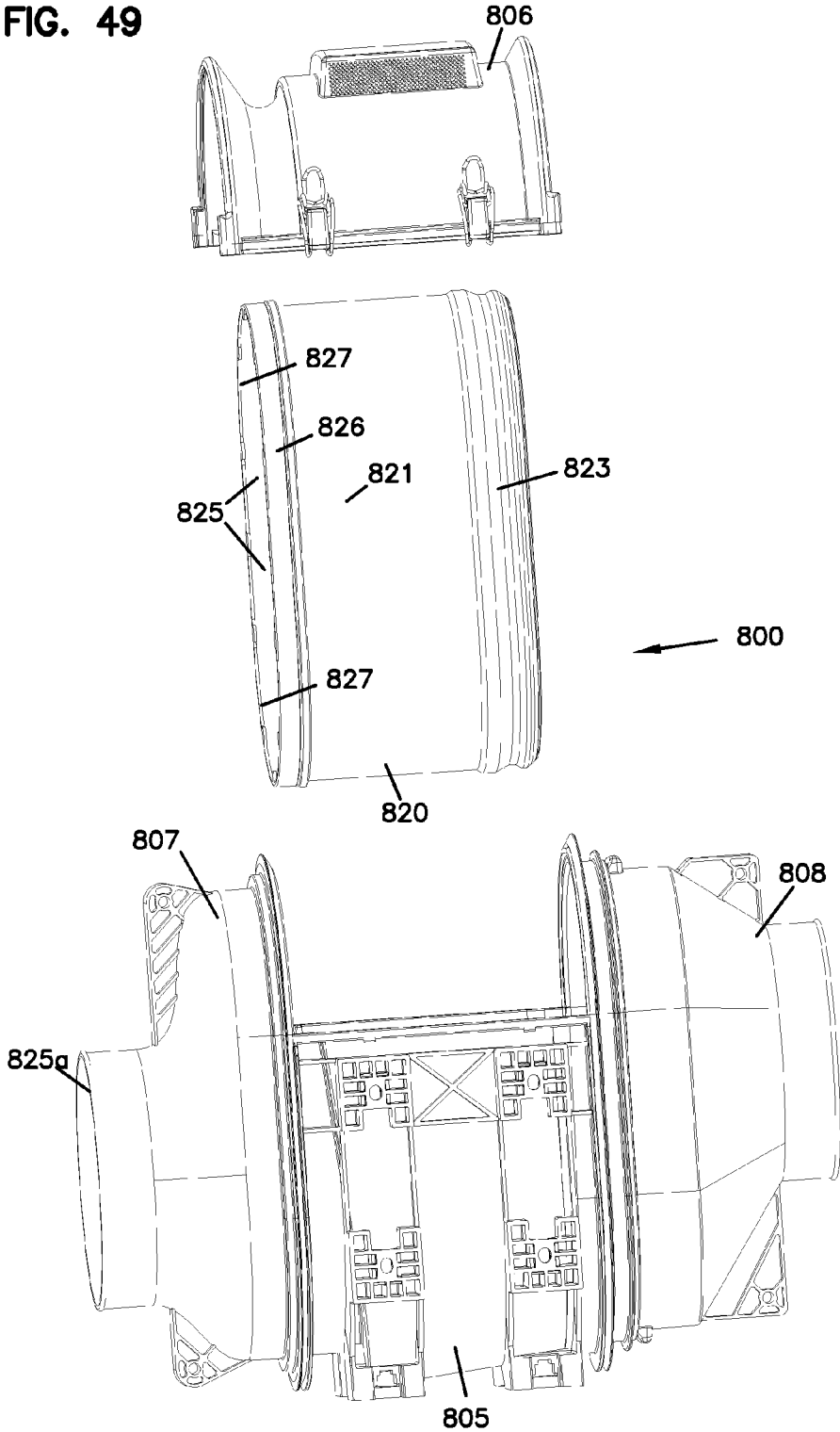


FIG. 49



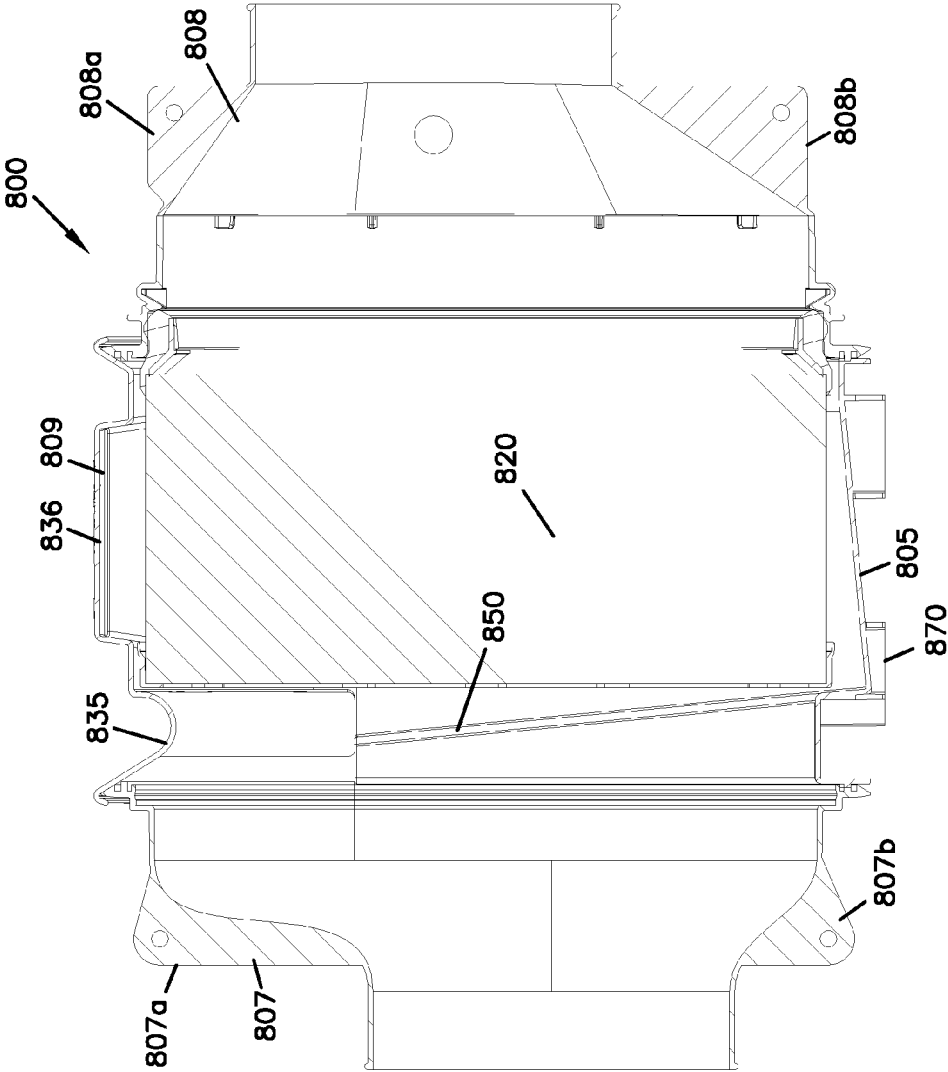


FIG. 50

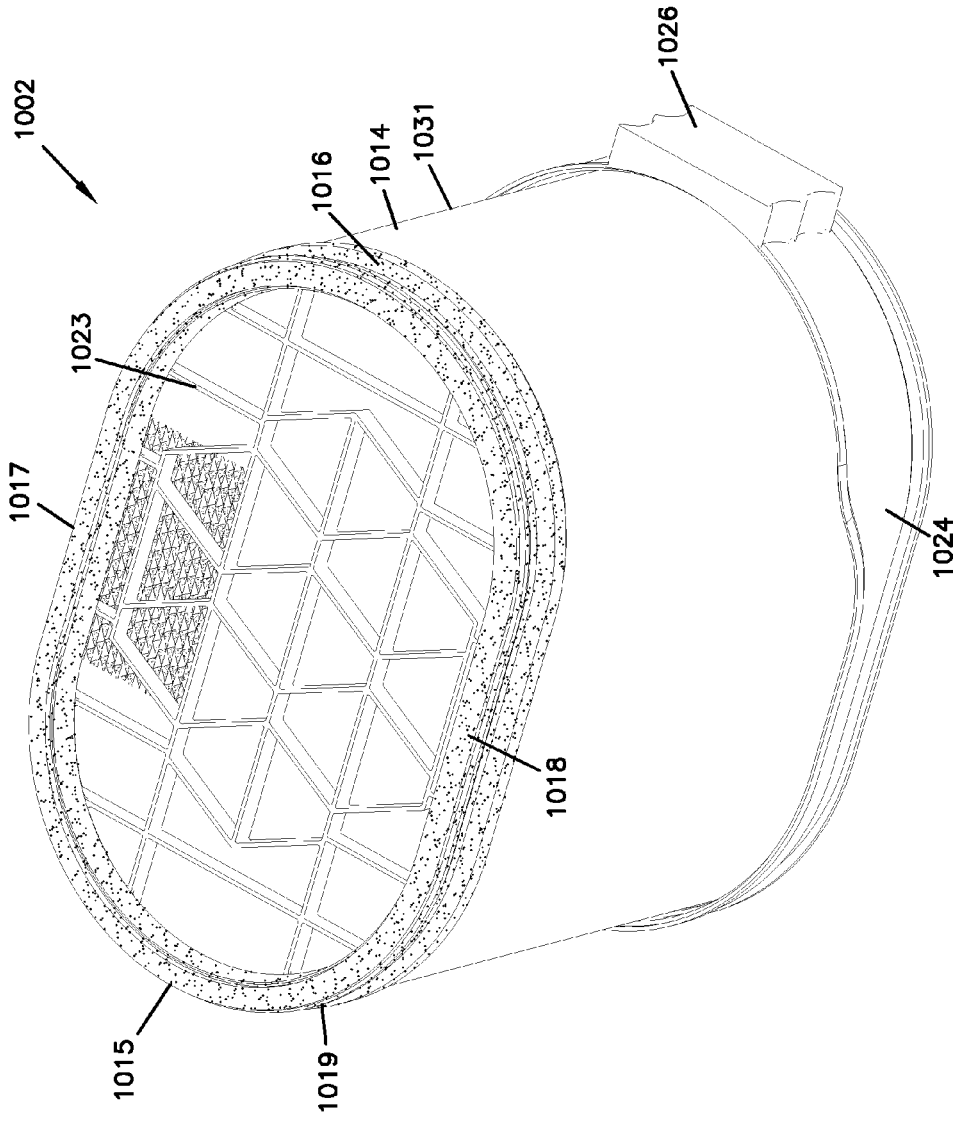
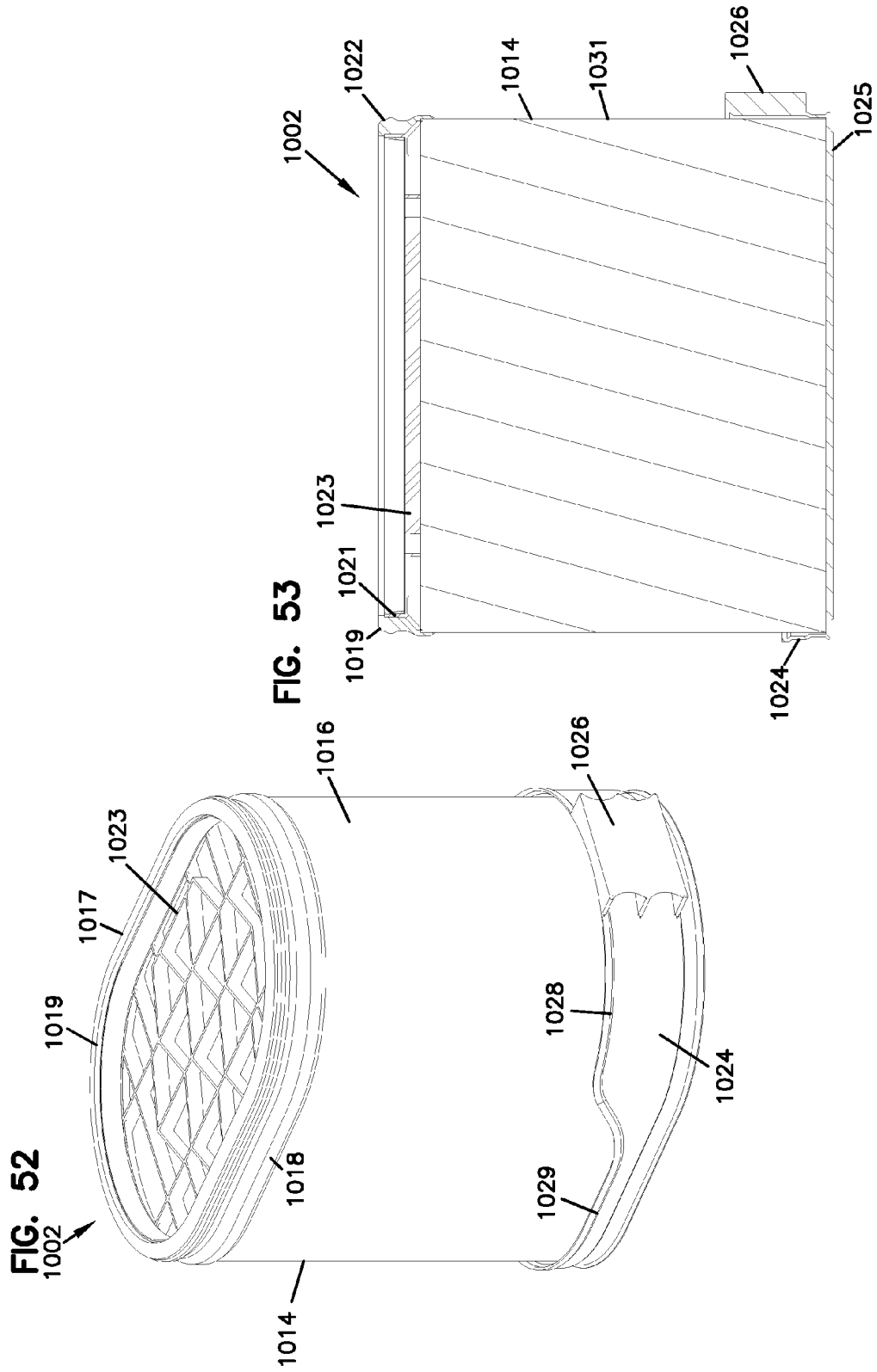


FIG. 51





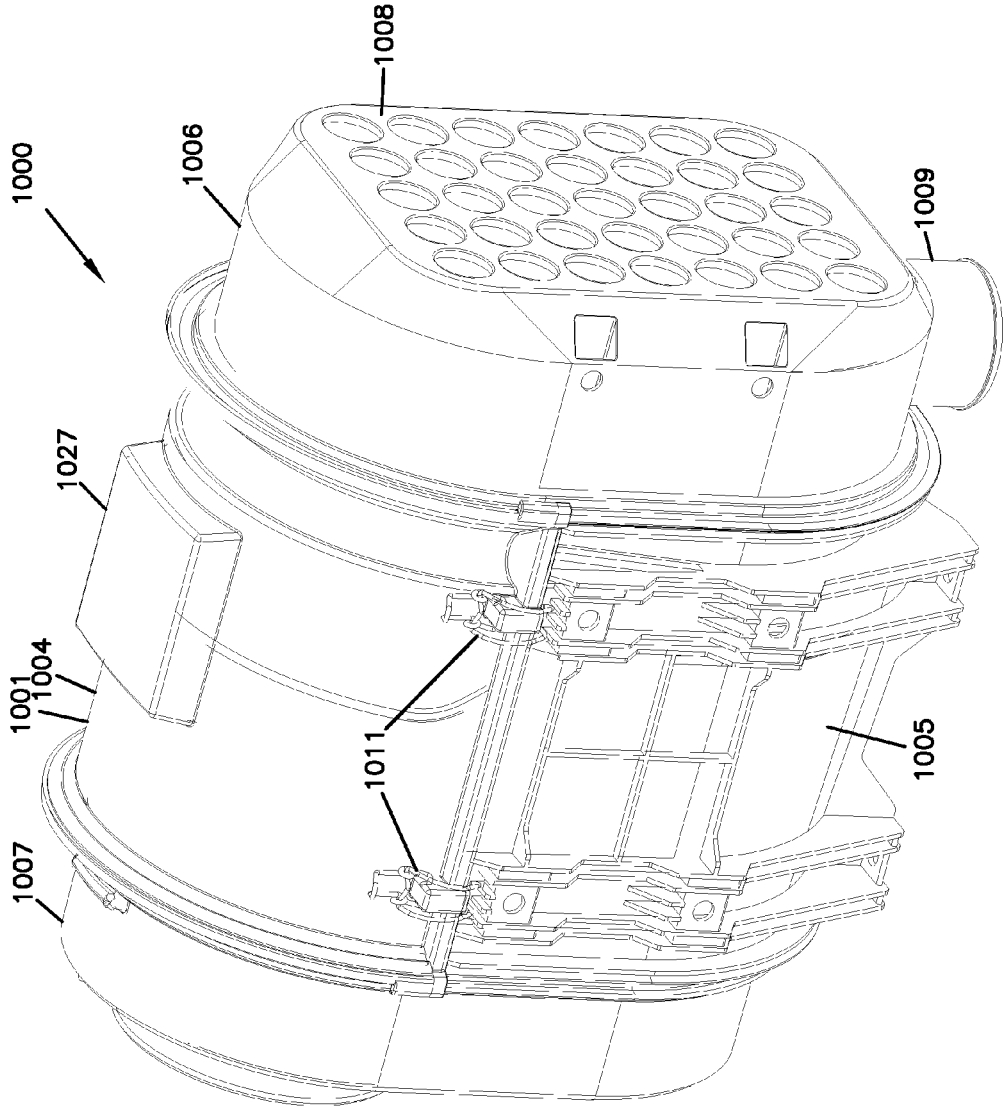


FIG. 54

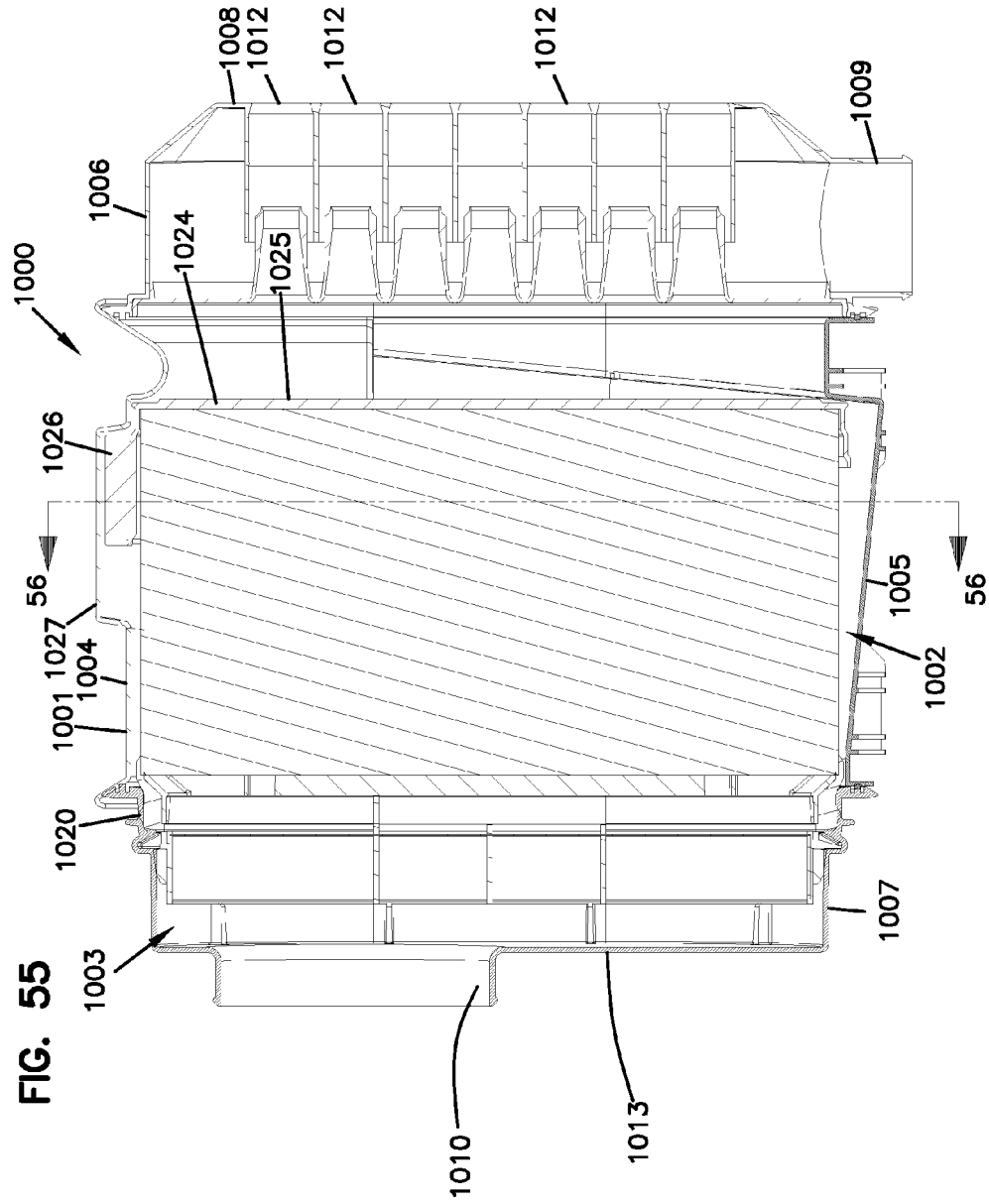


FIG. 56

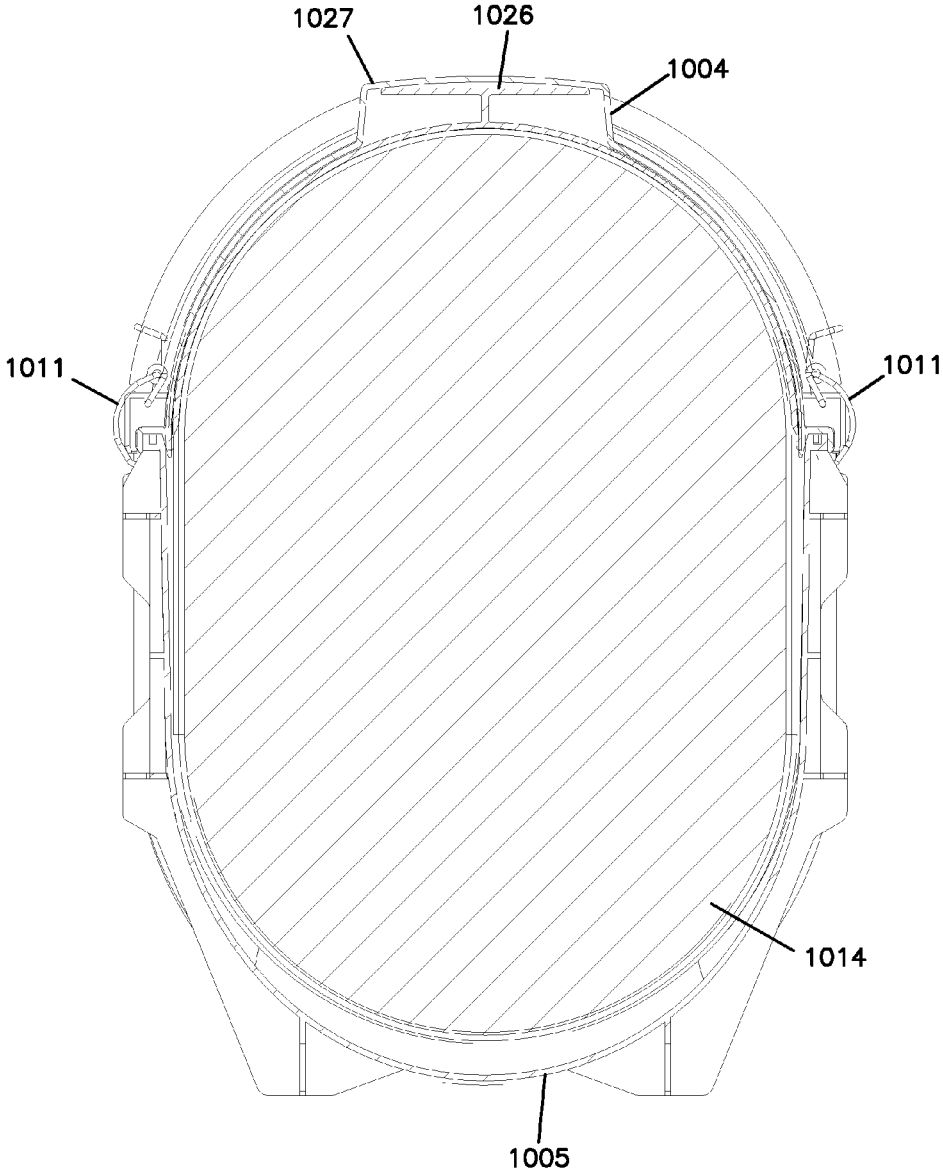


FIG. 57

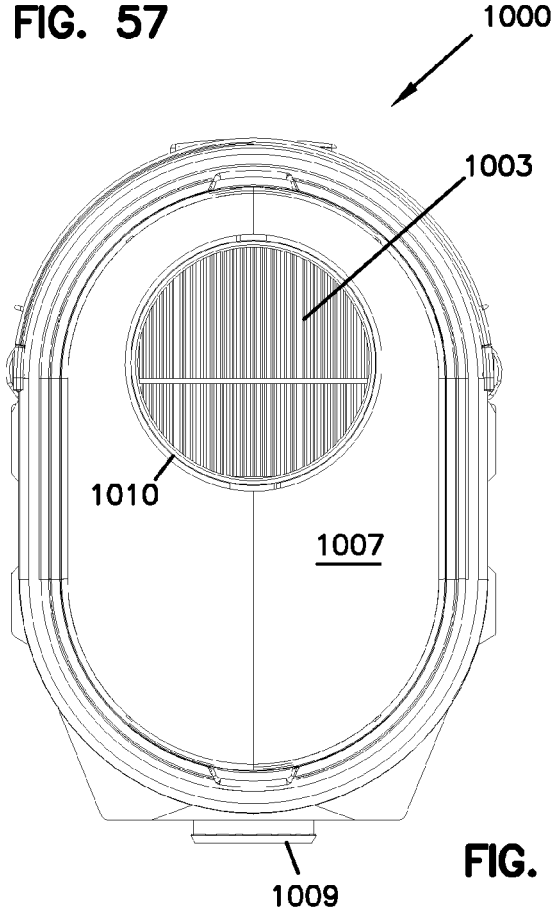
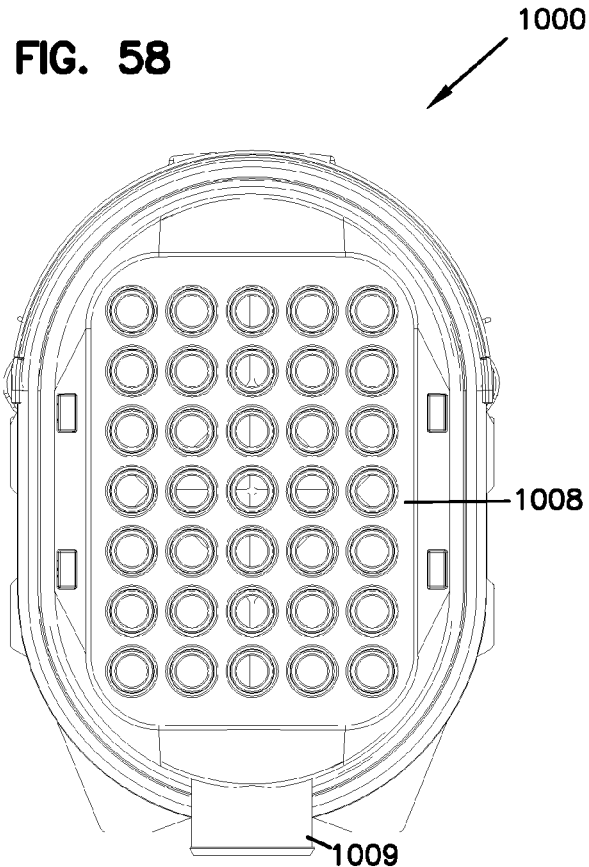
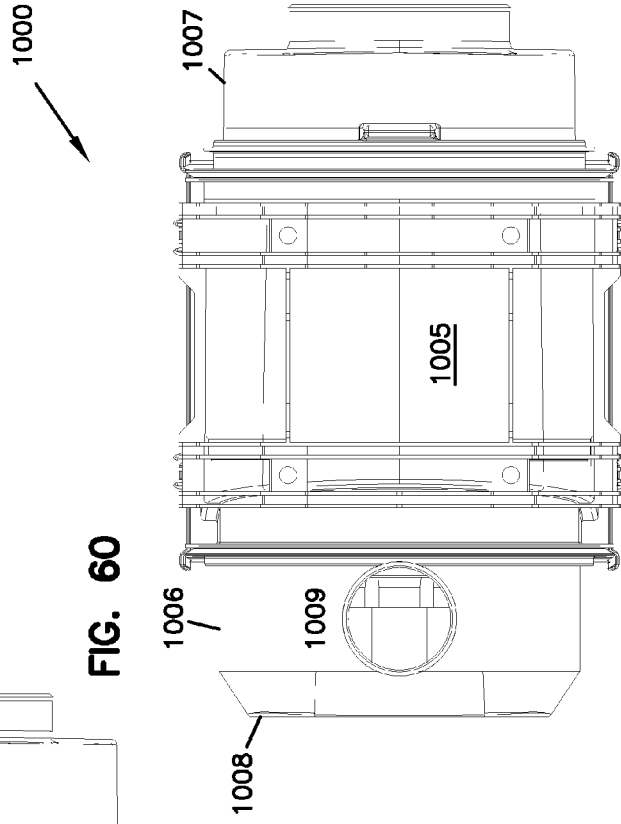
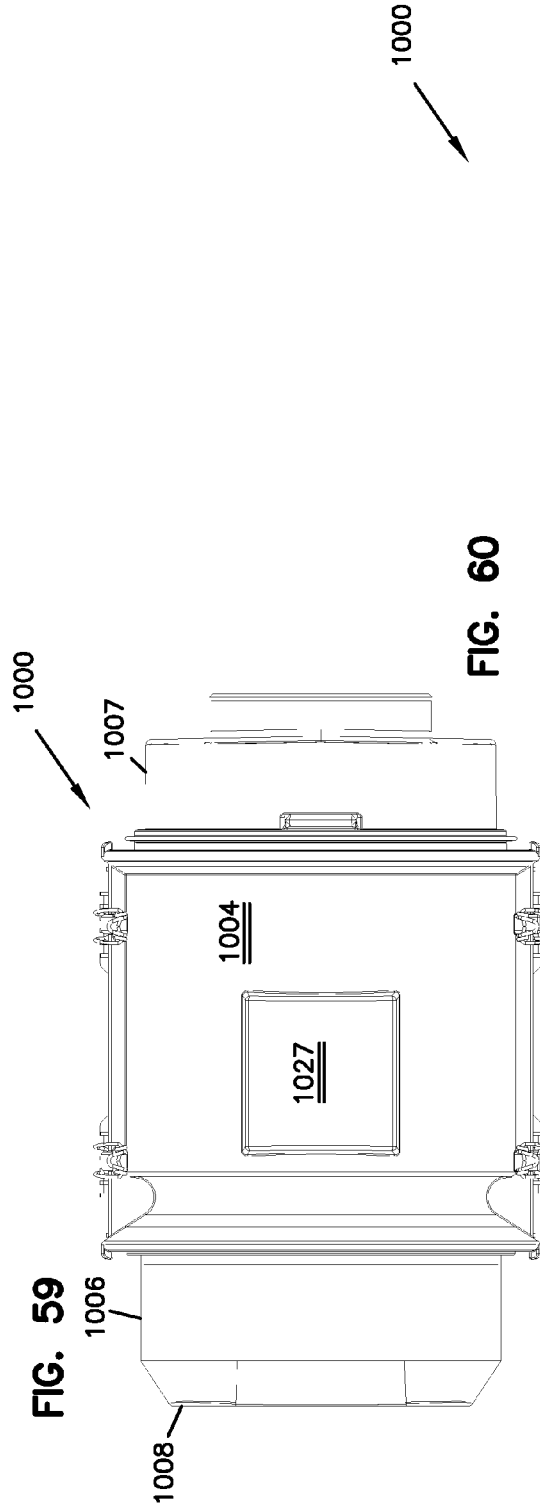


FIG. 58





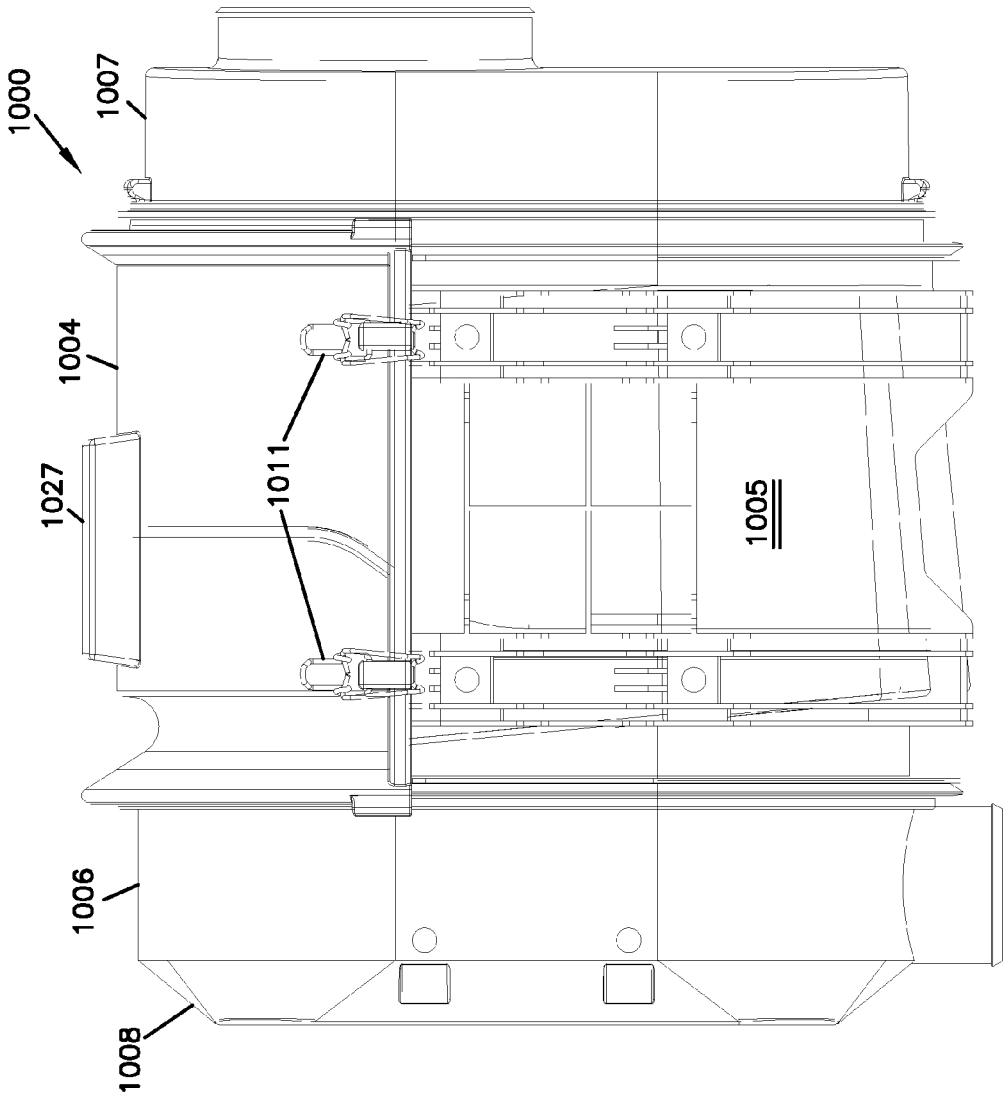


FIG. 61

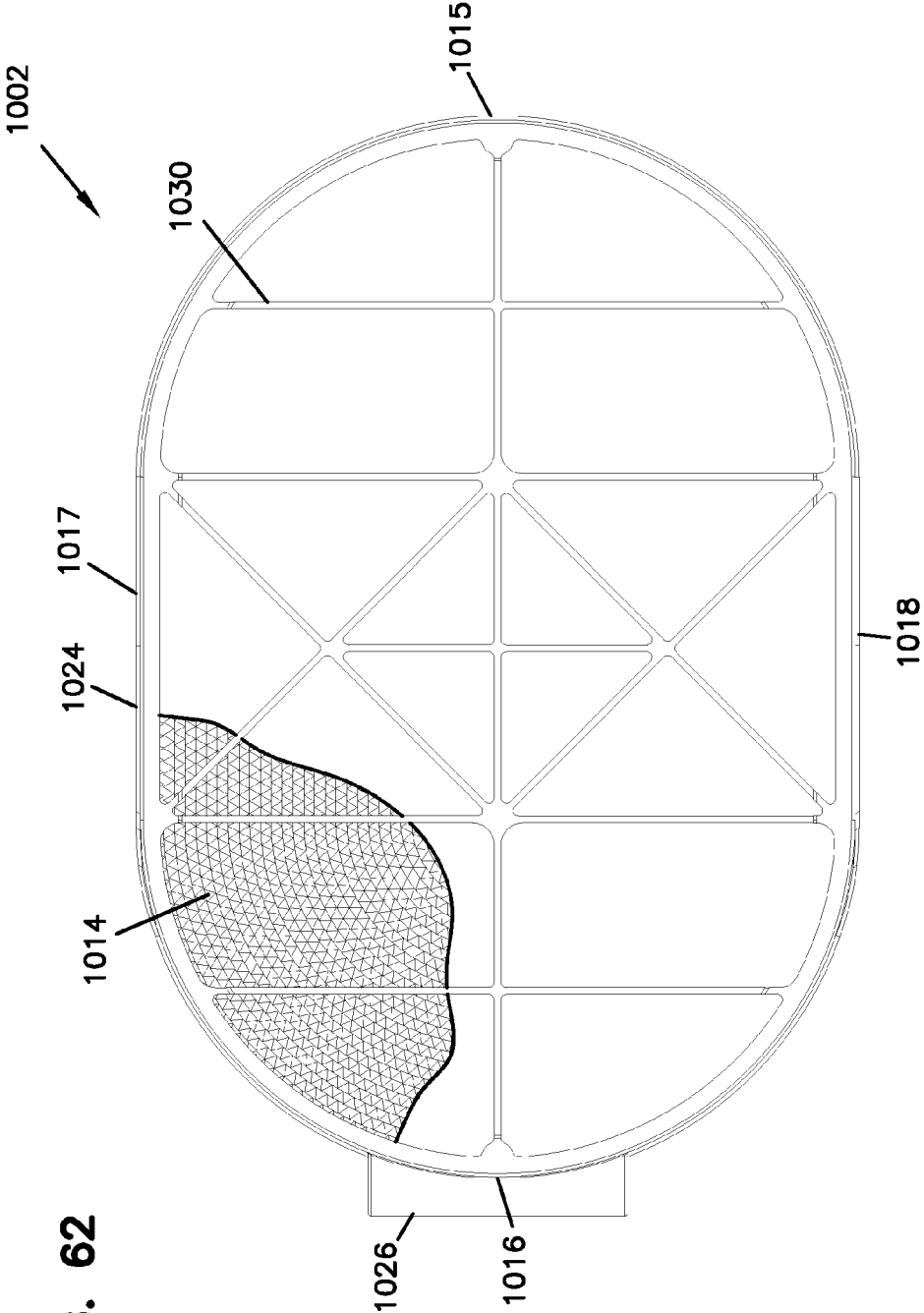


FIG. 62

**FILTER ARRANGEMENTS; HOUSINGS;  
ASSEMBLIES; AND, METHODS**

**[0001]** The present application is a continuation of U.S. Ser. No. 14/170,818, filed Feb. 3, 2014. U.S. Ser. No. 14/170,818 is a continuation of U.S. Ser. No. 13/729,660, filed Dec. 28, 2012, which issued as U.S. Pat. No. 8,641,795. U.S. Ser. No. 13/729,660 is a continuation of U.S. Ser. No. 13/022,188 filed Feb. 7, 2011, which issued as U.S. Pat. No. 8,343,245. U.S. Ser. No. 13/022,188 is a continuation of U.S. Ser. No. 11/587,882, filed Aug. 21, 2007, which issued as U.S. Pat. No. 7,905,936, as a U.S. National Stage filing of PCT/US2005/014909, filed Apr. 28, 2005. The PCT application claims priority to U.S. Provisional Patent Application 60/649,301 filed Feb. 1, 2005, U.S. Provisional Patent Application 60/604,549, filed Aug. 25, 2004, and U.S. Provisional Patent Application 60/567,121, filed Apr. 30, 2004. The complete disclosures of each of U.S. Ser. No. 14/170,818; U.S. Ser. No. 13/729,660; U.S. Ser. No. 13/022,188; U.S. Ser. No. 11/587,882; PCT US2005/014909; and, provisionals 60/649,301; 60/604,549; and, 60/567,121 is incorporated herein by reference in its entirety. A claim of priority is made to each of U.S. Ser. No. 14/170,818; U.S. Ser. No. 13/729,660; U.S. Ser. No. 13/022,188; U.S. Ser. No. 11/587,882; PCT US2005/014909; and, provisionals 60/649,301; 60/604,549; and, 60/567,121 to the extent appropriate.

**TECHNICAL FIELD**

**[0002]** The present disclosure concerns air cleaners, for use, for example, for cleaning engine combustion air for vehicles and other equipment. The disclosure provides preferred components, assemblies and methods.

**BACKGROUND**

**[0003]** Gas streams often carry particulate material therein. In many instances it is desirable to remove some or all of the particulate material from the gas flow stream. For example, air intake streams to engines for motorized vehicles or power generation equipment often include particulate material therein. The particulate material, should it reach the internal workings of the mechanisms involved, can cause substantial damage. It is therefore preferred, for such systems, to remove the particulate material from the gas flow upstream of the engine or other equipment involved. A variety of air cleaner arrangements have been developed for particulate removal.

**[0004]** There has been a general trend for the utilization of air cleaner arrangements that utilize, as a media pack, z-filter media constructions. In general z-filter media constructions can be characterized as comprising a fluted sheet secured to a facing sheet, formed into a media pack configuration. Examples of z-filter arrangements are described in PCT Publication WO 97/40918, published Nov. 6, 1997; U.S. Pat. Nos. 6,190,432 and 6,350,291; PCT application US 04/07927, filed Mar. 17, 2004; U.S. Provisional application 60/532,783, filed Dec. 22, 2003; PCT Publication 03/095068, published Nov. 20, 2003; PCT publication WO 04/007054, published Jan. 22, 2004; PCT publication WO 03/084641, published Oct. 16, 2003; and, U.S. Provisional Application 60/543,804, filed Feb. 11, 2004; the complete disclosures of each of these cited references being incorporated herein by reference.

**[0005]** With some arrangements, it has been desired to develop configurations in which the z-filter media is loaded into an air cleaner housing through a side (as opposed to an

end) of the housing. Such arrangements are described for example in WO 03/095068, incorporated herein by reference.

**[0006]** In general, improvements have been sought.

**SUMMARY OF THE DISCLOSURE**

**[0007]** According to the present disclosure, various features and techniques are provided, for advantageous use in air cleaner arrangements or as components for air cleaner arrangements. Some preferred components are provided, as well as assemblies which use those components. Also, methods of assembly, service and use are provided.

**[0008]** Specific componentry, techniques and configurations disclosed herein can be used together, as illustrated in the embodiments, to advantage. However they may be separately selected and used to create alternate advantageous arrangements. Thus, there is no specific requirement for arrangements according to the present disclosure, that all of the various advantageous features disclosed be present.

**[0009]** Among the advantageous features disclosed, is a band or cassette component useable within an air cleaner assembly. The cassette component is configured for advantageous receipt of a z-filter media pack therein, during use. The cassette component and media pack can be manually separable or permanently mounted. By the term “manually separable” and variants thereof, as used in the context, it is meant that the components can be separated under ordinary hand pressure, without damage to the cassette component, allowing the cassette component to be reused. When assembled together, the cassette component and the filter cartridge, will sometimes be referenced as a filter cartridge/cassette combination or by variants thereof.

**[0010]** Other advantageous features provided include an overall housing configuration with a mounting arrangement for advantage. One particular mounting arrangement disclosed is a boxed u-shaped arrangement, having three sides configured for mounting corresponding to two opposite sides and a base, of a boxed U. In this context, the term “boxed” is meant to refer to a u-shape formed with three straight mounting sides; i.e., two opposite parallel sides and a central base extending therebetween. Although alternatives are possible, in typical preferred arrangements shown, a side service access is provided in the air cleaner housing, at a location opposite the central base of the boxed u-shaped mounting arrangement.

**[0011]** Also provided is a modular configuration for an air cleaner including separately premade and then assemblable components corresponding to: an inlet section; a central or main air filter cartridge receiving section; an access cover; and, an outlet section. These components can be premade and then be assembled into an air cleaner. A typical preferred air cleaner would involve these components being molded from plastic, and then being welded or otherwise secured together to form the air cleaner housing.

**[0012]** A preferred safety element arrangement for use with a preferred air cleaner configuration according to the present disclosure is also provided. The safety element includes a handle arrangement for easy manual manipulation, and, also, a pivot projection for assistance in mounting.

**[0013]** Other preferred features, components and techniques will be apparent from the following drawings and detailed descriptions.



## BRIEF DESCRIPTION OF THE DRAWINGS

[0014] FIG. 1 is an inlet end perspective view of an air cleaner assembly according to the present disclosure.

[0015] FIG. 2 is a horizontal cross-sectional view taken along line 2-2, FIG. 1.

[0016] FIG. 3 is a vertical cross-sectional view taken along line 3-3, FIG. 1.

[0017] FIG. 4 is a vertical cross-sectional view taken along line 4-4, FIG. 1.

[0018] FIG. 5 is an end view of a cassette component useable in the assembly of FIG. 1.

[0019] FIG. 6 is a cross-sectional view taken along line 6-6, FIG. 5.

[0020] FIG. 7 is a cross-sectional view taken along line 7-7, FIG. 5.

[0021] FIG. 7A is an inlet end perspective view of the cassette component depicted in FIG. 5.

[0022] FIG. 8 is a schematic, perspective view of an assembly having features analogous to those of the assembly shown in FIG. 1.

[0023] FIG. 9 is a schematic depiction of the assembly of FIG. 8 shown during an initial part of a step of cover removal.

[0024] FIG. 10 is the arrangement of FIGS. 8 and 9, shown during a later part of cover removal, relative to FIG. 9.

[0025] FIG. 11 is a view of arrangement shown in FIGS. 8-10, shown with a cover removed, and a filter cartridge component removed.

[0026] FIG. 12 is a view of the arrangement of FIG. 11, with a filter cartridge component separated from a cassette and cover component, both of which are shown removed from the air cleaner housing.

[0027] FIG. 13 depicts FIG. 12 with partial removal of a safety or secondary filter.

[0028] FIG. 14 depicts FIG. 13 with a safety filter fully removed.

[0029] FIG. 15 depicts the assembly of FIG. 8 with an outlet component and an inlet component shown separated, for an understanding of how they can be positioned alternately.

[0030] FIG. 16A-X are schematic depictions showing how an assembly having certain features as shown in FIG. 8 can be mounted in a variety of orientations; FIGS. 16A-X only showing some of the possible orientations.

[0031] FIG. 17 is a perspective view of an alternate embodiment to the air cleaner depicted in FIG. 1.

[0032] FIG. 18 is a schematic depiction of a system including an air cleaner.

[0033] FIG. 19 is a side view of the main or primary filter cartridge of FIG. 3.

[0034] FIG. 20 is a top (outlet end) view of the main or primary filter cartridge of FIG. 19.

[0035] FIG. 21 is a cross-sectional view of the filter cartridge of FIG. 19 depicted along line 21-21, FIG. 20.

[0036] FIG. 22 is a fragmentary view of z-filter media useable in the filter cartridge of FIGS. 3 and 19-21.

[0037] FIG. 23 is a top plan view of a safety element useable in the assembly of FIG. 1-3.

[0038] FIG. 24 is an inlet end perspective view of the safety element depicted in FIG. 23.

[0039] FIG. 25 is a cross-sectional view taken along line 25-25, FIG. 23.

[0040] FIG. 26 is a second fragmentary, schematic, perspective view of z-filter media useable in arrangements according to the present disclosure.

[0041] FIG. 27 is a schematic, cross-sectional view of a portion of the media depicted in FIG. 26.

[0042] FIG. 28 is a schematic view of examples of various corrugated media definitions.

[0043] FIG. 29 is a schematic view of a process for manufacturing media according to the present disclosure.

[0044] FIG. 30 is a cross-sectional view of an optional end dart for media flutes useable in arrangements according to the present disclosure.

[0045] FIG. 31 is a side elevational view of a second air cleaner assembly embodying principles according to the present disclosure.

[0046] FIG. 32 is a top plan view of the air cleaner of FIG. 31.

[0047] FIG. 33 is an inlet end view of the air cleaner of FIG. 31.

[0048] FIG. 34 is an outlet end view of the air cleaner of FIG. 31.

[0049] FIG. 35 is a side perspective view of the air cleaner of FIG. 31.

[0050] FIG. 36 is an exploded perspective view of the air cleaner of FIG. 31.

[0051] FIG. 37 is a cross-sectional view of the air cleaner of FIG. 31, taken along lines 37-37, FIG. 35.

[0052] FIG. 38 is a cross-sectional view of the air cleaner of FIG. 31, taken along lines 38-38, FIG. 35.

[0053] FIG. 39 is a side elevational view of a filter cartridge useable in the air cleaner assembly of FIG. 31.

[0054] FIG. 40 is a cross-sectional view of the filter cartridge of FIG. 39.

[0055] FIG. 41 is a perspective view of the filter cartridge of FIG. 39.

[0056] FIG. 42 is an inlet end view cassette useable to receive the filter cartridge of FIG. 39 within the air cleaner of FIG. 31.

[0057] FIG. 43 is a cross-sectional view of the filter cartridge of FIG. 42, taken along line 43-43 thereof.

[0058] FIG. 44 is a cross-sectional view of the filter cartridge of FIG. 42, and taken along line 44-44 thereof.

[0059] FIG. 45 is an outlet end perspective view of a sub-assembly comprising a filter element according to FIG. 39 received within a cassette according to FIG. 42.

[0060] FIG. 46 is an inlet end perspective view of an inlet end of the assembly of FIG. 45.

[0061] FIG. 47 is a side elevational view of a third air cleaner assembly.

[0062] FIG. 48 is an exploded view of the air cleaner assembly of FIG. 47.

[0063] FIG. 49 is an exploded view of a fourth air cleaner assembly.

[0064] FIG. 50 is a cross-sectional view of the air cleaner assembly of FIG. 49.

[0065] FIG. 51 is a perspective view of another embodiment of a filter cartridge.

[0066] FIG. 52 is an alternate perspective view of the filter cartridge depicted in FIG. 51.

[0067] FIG. 53 is a cross-sectional view of the filter cartridge depicted in FIGS. 51 and 52.

[0068] FIG. 54 is a perspective view of another embodiment of an air cleaner assembly in accordance with principles of this disclosure.

[0069] FIG. 55 is a cross-sectional view of the air cleaner assembly of FIG. 54 and showing the filter cartridge of FIGS. 51 and 52 operably installed therein.

[0070] FIG. 56 is a cross-sectional view of the air cleaner assembly of FIG. 54, the cross-section being taken along the line 56-56 of FIG. 55.

[0071] FIG. 57 is an end elevational view of the air cleaner assembly of FIG. 54, depicting the outlet end.

[0072] FIG. 58 is an end elevational view of the air cleaner assembly of FIG. 54, depicting the inlet end.

[0073] FIG. 59 is a top plan view of the air cleaner assembly of FIG. 54.

[0074] FIG. 60 is a bottom plan view of the air cleaner assembly of FIG. 54.

[0075] FIG. 61 is a side elevational view of the air cleaner assembly of FIG. 54.

[0076] FIG. 62 is a bottom plan view of the filter cartridge depicted in FIGS. 51 and 52.

## DETAILED DESCRIPTION

### I. Z-Filter Media Configurations, Generally

[0077] Fluted filter media can be used to provide fluid filter constructions in a variety of manners. One well known manner is as a z-filter construction. The term “z-filter construction” as used herein, is meant to refer to a filter construction in which individual ones of corrugated, folded or otherwise formed filter flutes are used to define sets of longitudinal, typically parallel, inlet and outlet filter flutes for fluid flow through the media; the fluid flowing along the length of the flutes between opposite inlet and outlet flow ends (or flow faces) of the media. Some examples of z-filter media are provided in U.S. Pat. Nos. 5,820,646; 5,772,883; 5,902,364; 5,792,247; 5,895,574; 6,210,469; 6,190,432; 6,350,296; 6,179,890; 6,235,195; Des. 399,944; Des. 428,128; Des. 396,098; Des. 398,046; and, Des. 437,401; each of these fifteen cited references being incorporated herein by reference.

[0078] One type of z-filter media, utilizes two specific media components joined together, to form the media construction. The two components are: (1) a fluted (typically corrugated) media sheet; and, (2) a facing media sheet. The facing media sheet is typically non-corrugated, however it can be corrugated, for example perpendicularly to the flute direction as described in U.S. provisional 60/543,804, filed Feb. 11, 2004, incorporated herein by reference.

[0079] The fluted (typically corrugated) media sheet and the facing media sheet together, are used to define media having parallel inlet and outlet flutes. In some instances, the fluted sheet and facing sheet are secured together and are then coiled to form a z-filter media construction. Such arrangements are described, for example, in U.S. Pat. Nos. 6,235,195 and 6,179,890, each of which is incorporated herein by reference. In certain other arrangements, some non-coiled sections of fluted media secured to facing media, are stacked on one another, to create a filter construction. An example of this is described in FIG. 11 of U.S. Pat. No. 5,820,646, incorporated herein by reference.

[0080] For specific applications as described herein, coiled arrangements are preferred. Typically, coiling of the fluted sheet/facing sheet combination around itself, to create a coiled media pack, is conducted with the facing sheet directed outwardly. Some techniques for coiling are described in U.S. provisional application 60/467,521, filed May 2, 2003 and PCT Application US 04/07927, filed Mar. 17, 2004, each of which is incorporated herein by reference. The resulting coiled arrangement generally has, as the outer surface of the media pack, a portion of the facing sheet.

[0081] The term “corrugated” used herein to refer to structure in media, is meant to refer to a flute structure resulting from passing the media between two corrugation rollers, i.e., into a nip or bite between two rollers, each of which has surface features appropriate to cause a corrugation affect in the resulting media. The term “corrugation” is not meant to refer to flutes that are formed by techniques not involving passage of media into a bite between corrugation rollers. However, the term “corrugated” is meant to apply even if the media is further modified or deformed after corrugation, for example by the folding techniques described in PCT WO 04/007054, published Jan. 22, 2004, incorporated herein by reference.

[0082] Corrugated media is a specific form of fluted media. Fluted media is media which has individual flutes (for example formed by such techniques as corrugating or folding) extending thereacross.

[0083] Serviceable filter element or filter cartridge configurations utilizing z-filter media are sometimes referred to as “straight through flow configurations” or by variants thereof. In general, in this context what is meant is that the serviceable filter elements generally have an inlet flow end (or face) and an opposite exit flow end (or face), with flow entering and exiting the filter cartridge in generally the same straight through direction. The term “serviceable” in this context is meant to refer to a media containing filter cartridge that is periodically removed and replaced from a corresponding fluid cleaner. In some instances, each of the inlet flow end and outlet flow end will be generally flat or planar, with the two parallel to one another. However, variations from this, for example non-planar faces are possible.

[0084] A straight through flow configuration (especially for a coiled media pack) is, for example, in contrast to serviceable filter cartridges such as cylindrical pleated filter cartridges of the type shown in U.S. Pat. No. 6,039,778, incorporated herein by reference, in which the flow generally makes a turn as it passes through the serviceable cartridge. That is, in a U.S. Pat. No. 6,039,778 filter, the flow enters the cylindrical filter cartridge through a cylindrical side, and then turns to exit through an end face (in forward-flow systems). In a typical reverse-flow system, the flow enters the serviceable cylindrical cartridge through an end face and then turns to exit through a side of the cylindrical filter cartridge. An example of such a reverse-flow system is shown in U.S. Pat. No. 5,613,992, incorporated by reference herein.

[0085] The term “z-filter media construction” and variants thereof as used herein, without more, is meant to refer to any or all of: a web of corrugated or otherwise fluted media secured to facing media with appropriate sealing to allow for definition of inlet and outlet flutes; or, such a media coiled or otherwise constructed or formed into a three dimensional network of inlet and outlet flutes; and/or, a filter construction including such media.

[0086] In FIG. 26, an example of media 401 useable in z-filter media is shown. The media 401 is formed from a corrugated sheet 403 and a facing sheet 404.

[0087] In general, the corrugated sheet 403, FIG. 26, is of a type generally characterized herein as having a regular, curved, wave pattern of flutes or corrugations 407. The term “wave pattern” in this context, is meant to refer to a flute or corrugated pattern of alternating troughs 407b and ridges 407a. The term “regular” in this context is meant to refer to the fact that the pairs of troughs and ridges (407b, 407a) alternate with generally the same repeating corrugation (or

flute) shape and size. (Also, typically in a regular configuration each trough **407b** is substantially an inverse of each ridge **407a**.) The term “regular” is thus meant to indicate that the corrugation (or flute) pattern comprises troughs and ridges with each pair (comprising an adjacent trough and ridge) repeating, without substantial modification in size and shape of the corrugations along at least 70% of the length of the flutes. The term “substantial” in this context, refers to a modification resulting from a change in the process or form used to create the corrugated or fluted sheet, as opposed to minor variations from the fact that the media sheet **403** is flexible. With respect to the characterization of a repeating pattern, it is not meant that in any given filter construction, an equal number of ridges and troughs is necessarily present. The media **401** could be terminated, for example, between a pair comprising a ridge and a trough, or partially along a pair comprising a ridge and a trough. (For example, in FIG. **26** the media **401** depicted in fragmentary has eight complete ridges **407a** and seven complete troughs **407b**.) Also, the opposite flute ends (ends of the troughs and ridges) may vary from one another. Such variations in ends are disregarded in these definitions, unless specifically stated. That is, variations in the ends of flutes are intended to be covered by the above definitions.

[**0088**] In the context of the characterization of a “curved” wave pattern of corrugations, the term “curved” is meant to refer to a corrugation pattern that is not the result of a folded or creased shape provided to the media, but rather the apex **407a** of each ridge and the bottom **407b** of each trough is formed along a radiused curve. Although alternatives are possible, a typical radius for such z-filter media would be at least 0.25 mm and typically would be not more than 3 mm. (Media that is not curved, by the above definition, can also be useable.)

[**0089**] An additional characteristic of the particular regular, curved, wave pattern depicted in FIG. **26**, for the corrugated sheet **403**, is that at approximately a midpoint **430** between each trough and each adjacent ridge, along most of the length of the flutes **407**, is located a transition region where the curvature inverts. For example, viewing back side or face **403a**, FIG. **26**, trough **407b** is a concave region, and ridge **407a** is a convex region. Of course when viewed toward front side or face **403b**, trough **407b** of side **403a** forms a ridge; and, ridge **407a** of face **403a**, forms a trough. (In some instances, region **430** can be a straight segment, instead of a point, with curvature inverting at ends of the straight segment **430**.)

[**0090**] A characteristic of the particular regular, curved, wave pattern corrugated sheet **403** shown in FIG. **26**, is that the individual corrugations are generally straight. By “straight” in this context, it is meant that through at least 70% (typically at least 80%) of the length between edges **408** and **409**, the ridges **407a** and troughs **407b** do not change substantially in cross-section. The term “straight” in reference to corrugation pattern shown in FIG. **26**, in part distinguishes the pattern from the tapered flutes of corrugated media described in FIG. 1 of WO 97/40918 and PCT Publication WO 03/47722, published Jun. 12, 2003, incorporated herein by reference. The tapered flutes of FIG. 1 of WO 97/40918, for example, would be a curved wave pattern, but not a “regular” pattern, or a pattern of straight flutes, as the terms are used herein.

[**0091**] Referring to the present FIG. **26** and as referenced above, the media **401** has first and second opposite edges **408**

and **409**. When the media **401** is coiled and formed into a media pack, in general edge **409** will form an inlet end for the media pack and edge **408** an outlet end, although an opposite orientation is possible.

[**0092**] Adjacent edge **408** is provided sealant, in this instance in the form of a sealant bead **410**, sealing the corrugated (fluted) sheet **403** and the facing sheet **404** together. Bead **410** will sometimes be referred to as a “single facer” bead, when it is applied as a bead between the corrugated sheet **403** and facing sheet **404**, to form the single facer or media strip **401**. Sealant bead **410** seals closed individual flutes **411** adjacent edge **408**, to passage of air therefrom.

[**0093**] Adjacent edge **409**, is provided sealant, in this instance in the form of a seal bead **414**. Seal bead **414** generally closes flutes **415** to passage of unfiltered fluid therein, adjacent edge **409**. Bead **414** would typically be applied as the media **401** is coiled about itself, with the corrugated sheet **403** directed to the inside. Thus, bead **414** will form a seal between a back side **417** of facing sheet **404**, and side **418** of the corrugated sheet **403**. The bead **414** will sometimes be referred to as a “winding bead” when it is applied as the strip **401** is coiled into a coiled media pack. If the media **401** were cut in strips and stacked, instead of coiled, bead **414** would be a “stacking bead.”

[**0094**] Referring to FIG. **26**, once the media **401** is incorporated into a media pack, for example by coiling or stacking, it can be operated as follows. First, air in the direction of arrows **412**, would enter open flutes **411** adjacent end **409**. Due to the closure at end **408**, by bead **410**, the air would pass through the media shown by arrows **413**. It could then exit the media pack, by passage through open ends **415a** of the flutes **415**, adjacent end **408** of the media pack. Of course operation could be conducted with air flow in the opposite direction. The media pack is closed to unfiltered air flow therethrough.

[**0095**] For the particular arrangement shown herein in FIG. **26**, the parallel corrugations **407a**, **407b** are generally straight completely across the media, from edge **408** to edge **409**. Straight flutes or corrugations can be deformed or folded at selected locations, especially at ends. Modifications at flute ends for closure are generally disregarded in the above definitions of “regular,” “curved” and “wave pattern.”

[**0096**] Z-filter constructions which do not utilize straight, regular curved wave pattern corrugation (flute) shapes are known. For example in Yamada et al. U.S. Pat. No. 5,562,825 corrugation patterns which utilize somewhat semicircular (in cross section) inlet flutes adjacent narrow V-shaped (with curved sides) exit flutes are shown (see FIGS. 1 and 3, of U.S. Pat. No. 5,562,825). In Matsumoto, et al. U.S. Pat. No. 5,049,326 circular (in cross-section) or tubular flutes defined by one sheet having half tubes attached to another sheet having half tubes, with flat regions between the resulting parallel, straight, flutes are shown, see FIG. 2 of Matsumoto '326. In Ishii, et al. U.S. Pat. No. 4,925,561 (FIG. 1) flutes folded to have a rectangular cross section are shown, in which the flutes taper along their lengths. In WO 97/40918 (FIG. 1), flutes or parallel corrugations which have a curved, wave patterns (from adjacent curved convex and concave troughs) but which taper along their lengths (and thus are not straight) are shown. Also, in WO 97/40918 flutes which have curved wave patterns, but with different sized ridges and troughs, are shown.

[**0097**] In general, the filter media is a relatively flexible material, typically a non-woven fibrous material (of cellulose fibers, synthetic fibers or both) often including a resin therein,

sometimes treated with additional materials. Thus, it can be conformed or configured into the various corrugated patterns, without unacceptable media damage. Also, it can be readily coiled or otherwise configured for use, again without unacceptable media damage. Of course, it must be of a nature such that it will maintain the required corrugated configuration, during use.

**[0098]** In the corrugation process, an inelastic deformation is caused to the media. This prevents the media from returning to its original shape. However, once the tension is released the flute or corrugations will tend to spring back, recovering only a portion of the stretch and bending that has occurred. The facing sheet is sometimes tacked to the fluted sheet, to inhibit this spring back in the corrugated sheet.

**[0099]** Also, typically, the media contains a resin. During the corrugation process, the media can be heated to above the glass transition point of the resin. When the resin then cools, it will help to maintain the fluted shapes.

**[0100]** The media of the corrugated sheet **403**, facing sheet **404** or both, can be provided with a fine fiber material on one or both sides thereof, for example in accord with U.S. Pat. No. 6,673,136, incorporated herein by reference.

**[0101]** An issue with respect to z-filter constructions relates to closing of the individual flute ends. Typically a sealant or adhesive is provided, to accomplish the closure. As is apparent from the discussion above, in typical z-filter media, especially that which uses straight flutes as opposed to tapered flutes, large sealant surface areas (and volume) at both the upstream end and the downstream end are needed. High quality seals at these locations are critical to proper operation of the media structure that results. The high sealant volume and area, creates issues with respect to this.

**[0102]** Attention is now directed to FIG. 27, in which a z-filter media construction **440** utilizing a regular, curved, wave pattern corrugated sheet **443**, and a non-corrugated facing sheet **444**, is depicted. The distance **D1**, between points **450** and **451**, defines the extension of facing media **444** in region **452** underneath a given corrugated flute **453**. The length **D2** of the arcuate media for the corrugated flute **453**, over the same distance **D1** is of course larger than **D1**, due to the shape of the corrugated flute **453**. For a typical regular shaped media used in fluted filter applications, the linear length **D2** of the media **453** between points **450** and **451** will generally be at least 1.2 times **D1**. Typically, **D2** would be within a range of 1.2-2.0 time **D1**, inclusive. One particularly convenient arrangement for air filters has a configuration in which **D2** is about 1.25-1.35×**D1**. Such media has, for example, been used commercially in Donaldson Powercore™ Z-filter arrangements. Herein the ratio **D2/D1** will sometimes be characterized as the flute/flat ratio or media draw for the corrugated (fluted) media.

**[0103]** In the corrugated cardboard industry, various standard flutes have been defined. For example the standard E flute, standard X flute, standard B flute, standard C flute and standard A flute. FIG. 28, attached, in combination with Table A below provides definitions of these flutes.

**[0104]** Donaldson Company, Inc., (DCI) the assignee of the present disclosure, has used variations of the standard A and standard B flutes, in a variety of z-filter arrangements. These flutes are also defined in Table A and FIG. 28.

TABLE A

(Flute definitions for FIG. 28)	
DCI A Flute:	Flute/flat = 1.52:1; The Radii (R) are as follows: R1000 = .0675 inch (1.715 mm); R1001 = .0581 inch (1.476 mm); R1002 = .0575 inch (1.461 mm); R1003 = .0681 inch (1.730 mm);
DCI B Flute:	Flute/flat = 1.32:1; The Radii (R) are as follows: R1004 = .0600 inch (1.524 mm); R1005 = .0520 inch (1.321 mm); R1006 = .0500 inch (1.270 mm); R1007 = .0620 inch (1.575 mm);
Std. E Flute:	Flute/flat = 1.24:1; The Radii (R) are as follows: R1008 = .0200 inch (.508 mm); R1009 = .0300 inch (.762 mm); R1010 = .0100 inch (.254 mm); R1011 = .0400 inch (1.016 mm);
Std. X Flute:	Flute/flat = 1.29:1; The Radii (R) are as follows: R1012 = .0250 inch (.635 mm); R1013 = .0150 inch (.381 mm);
Std. B Flute:	Flute/flat = 1.29:1; The Radii (R) are as follows: R1014 = .0410 inch (1.041 mm); R1015 = .0310 inch (.7874 mm); R1016 = .0310 inch (.7874 mm);
Std. C Flute:	Flute/flat = 1.46:1; The Radii (R) are as follows: R1017 = .0720 inch (1.829 mm); R1018 = .0620 inch (1.575 mm);
Std. A Flute:	Flute/flat = 1.53:1; The Radii (R) are as follows: R1019 = .0720 inch (1.829 mm); R1020 = .0620 inch (1.575 mm).

**[0105]** Of course other, standard, flutes definitions from the corrugated box industry are known.

**[0106]** In general, standard flute configurations from the corrugated box industry can be used to define corrugation shapes or approximate corrugation shapes for corrugated media. Comparisons above between the DCI A flute and DCI B flute, and the corrugation industry standard A and standard B flutes, indicate some convenient variations.

## II. Manufacture of Coiled Media Configurations Using Fluted Media, Generally

**[0107]** In FIG. 29, one example of a manufacturing process for making a media strip corresponding to strip **401**, FIG. 26 is shown. In general, facing sheet **464** and the fluted (corrugated) sheet **466** having flutes **468** are brought together to form a media web **469**, with an adhesive bead located therebetween at **470**. The adhesive bead **470** will form a single facer bead **410**, FIG. 26. An optional darting process occurs at station **471** to form center darted section **472** located mid-web. The z-filter media or Z-media strip **474** can be cut or slit at **475** along the bead **470** to create two pieces **476**, **477** of z-filter media **474**, each of which has an edge with a strip of sealant (single facer bead) extending between the corrugating and facing sheet. Of course, if the optional darting process is used, the edge with a strip of sealant (single facer bead) would also have a set of flutes darted at this location.

**[0108]** Techniques for conducting a process as characterized with respect to FIG. 29 are described in PCT WO 04/007054, published Jan. 22, 2004 incorporated herein by reference.

**[0109]** Still in reference to FIG. 29, before the z-filter media **474** is put through the darting station **471** and eventually slit at **475**, it must be formed. In the schematic shown in FIG. 29, this is done by passing a sheet of media **492** through a pair of corrugation rollers **494**, **495**. In the schematic shown in FIG. 29, the sheet of media **492** is unrolled from a roll **496**, wound

around tension rollers **498**, and then passed through a nip or bite **502** between the corrugation rollers **494**, **495**. The corrugation rollers **494**, **495** have teeth **504** that will give the general desired shape of the corrugations after the flat sheet **492** passes through the nip **502**. After passing through the nip **502**, the sheet **492** becomes corrugated across the machine direction and is referenced at **466** as the corrugated sheet. The corrugated sheet **466** is then secured to facing sheet **464**. (The corrugation process may involve heating the media, in some instances.)

[0110] Still in reference to FIG. **29**, the process also shows the facing sheet **464** being routed to the darting process station **471**. The facing sheet **464** is depicted as being stored on a roll **506** and then directed to the corrugated sheet **466** to form the Z-media **474**. The corrugated sheet **466** and the facing sheet **464** are secured together by adhesive or by other means (for example by sonic welding).

[0111] Referring to FIG. **29**, an adhesive line **470** is shown used to secure corrugated sheet **466** and facing sheet **464** together, as the sealant bead. Alternatively, the sealant bead for forming the facing bead could be applied as shown as **470a**. If the sealant is applied at **470a**, it may be desirable to put a gap in the corrugation roller **495**, and possibly in both corrugation rollers **494**, **495**, to accommodate the bead **470a**.

[0112] The type of corrugation provided to the corrugated media is a matter of choice, and will be dictated by the corrugation or corrugation teeth of the corrugation rollers **494**, **495**. One preferred corrugation pattern will be a regular curved wave pattern corrugation of straight flutes, as defined herein above. A typical regular curved wave pattern used, would be one in which the distance **D2**, as defined above, in a corrugated pattern is at least 1.2 times the distance **D1** as defined above. In one preferred application, typically  $D2=1.25-1.35 \times D1$ . In some instances the techniques may be applied with curved wave patterns that are not "regular," including, for example, ones that do not use straight flutes.

[0113] As described, the process shown in FIG. **29** can be used to create the center darted section **472**. FIG. **30** shows, in cross-section, one of the flutes **468** after darting and slitting.

[0114] A fold arrangement **518** can be seen to form a darted flute **520** with four creases **521a**, **521b**, **521c**, **521d**. The fold arrangement **518** includes a flat first layer or portion **522** that is secured to the facing sheet **464**. A second layer or portion **524** is shown pressed against the first layer or portion **522**. The second layer or portion **524** is preferably formed from folding opposite outer ends **526**, **527** of the first layer or portion **522**.

[0115] Still referring to FIG. **30**, two of the folds or creases **521a**, **521b** will generally be referred to herein as "upper, inwardly directed" folds or creases. The term "upper" in this context is meant to indicate that the creases lie on an upper portion of the entire fold **520**, when the fold **520** is viewed in the orientation of FIG. **30**. The term "inwardly directed" is meant to refer to the fact that the fold line or crease line of each crease **521a**, **521b**, is directed toward the other.

[0116] In FIG. **30**, creases **521c**, **521d**, will generally be referred to herein as "lower, outwardly directed" creases. The term "lower" in this context refers to the fact that the creases **521c**, **521d** are not located on the top as are creases **521a**, **521b**, in the orientation of FIG. **30**. The term "outwardly directed" is meant to indicate that the fold lines of the creases **521c**, **521d** are directed away from one another.

[0117] The terms "upper" and "lower" as used in this context are meant specifically to refer to the fold **520**, when

viewed from the orientation of FIG. **30**. That is, they are not meant to be otherwise indicative of direction when the fold **520** is oriented in an actual product for use.

[0118] Based upon these characterizations and review of FIG. **30**, it can be seen that a preferred regular fold arrangement **518** according to FIG. **30** in this disclosure is one which includes at least two "upper, inwardly directed, creases." These inwardly directed creases are unique and help provide an overall arrangement in which the folding does not cause a significant encroachment on adjacent flutes.

[0119] A third layer or portion **528** can also be seen pressed against the second layer or portion **524**. The third layer or portion **528** is formed by folding from opposite inner ends **530**, **531** of the third layer **528**.

[0120] Another way of viewing the fold arrangement **518** is in reference to the geometry of alternating ridges and troughs of the corrugated sheet **466**. The first layer or portion **522** is formed from an inverted ridge. The second layer or portion **524** corresponds to a double peak (after inverting the ridge) that is folded toward, and in preferred arrangements folded against, the inverted ridge.

[0121] Techniques for providing the optional dart described in connection with FIG. **30**, in a preferred manner, are described in PCT WO 04/007054, incorporated herein by reference. Techniques for coiling the media, with application of the winding bead, are described in PCT application US 04/07927, filed Mar. 17, 2004 and incorporated herein by reference.

[0122] Techniques described herein are particularly well adapted for use with media packs that result from coiling a single sheet comprising a corrugated sheet/facing sheet combination, i.e., a "single facer" strip. Certain of the techniques can be applied with arrangements that, instead of being formed by coiling, are formed from a plurality of strips of single facer.

[0123] Coiled media pack arrangements can be provided with a variety of peripheral perimeter definitions. In this context the term "peripheral, perimeter definition" and variants thereof, is meant to refer to the outside perimeter shape defined, looking at either the inlet end or the outlet end of the media pack. Typical shapes are circular as described in PCT WO 04/007054 and PCT application US 04/07927. Other useable shapes are obround, some examples of obround being oval shape. In general oval shapes have opposite curved ends attached by a pair of opposite sides. In some oval shapes, the opposite sides are also curved. In other oval shapes, sometimes called racetrack shapes, the opposite sides are generally straight. Racetrack shapes are described for example in PCT WO 04/007054 and PCT application US 04/07927.

[0124] Another way of describing the peripheral or perimeter shape is by defining the perimeter resulting from taking a cross-section through the media pack in a direction orthogonal to the winding axis of the coil.

[0125] Opposite flow ends or flow faces of the media pack can be provided with a variety of different definitions. In many arrangements, the ends are generally flat and perpendicular to one another. In other arrangements, the end faces include tapered, coiled, stepped portions which can either be defined to project axially outwardly from an axial end of the side wall of the media pack; or, to project axially inwardly from an end of the side wall of the media pack. Examples of such media pack arrangements are shown in U.S. Provisional Application 60/578,482, filed Jun. 8, 2004, incorporated herein by reference.

[0126] The flute seals (for example from the single facer bead, winding bead or stacking bead) can be formed from a variety of materials. In various ones of the cited and incorporated references, hot melt or polyurethane seals are described as possible for various applications. Such materials are also useable for arrangements as characterized herein.

### III. Example System and Overview of Air Cleaner

[0127] The principles and arrangements described herein are useable in a variety of systems. One particular system is depicted schematically in FIG. 18, generally at 1. In FIG. 18, equipment 2, such as a vehicle 2a having an engine 3 with some defined rated air flow demand, for example in the range of 50 cfm to 2000 cfm, is shown schematically. The equipment 2 may, for example, comprise a bus, an over-the-highway truck, an off-road vehicle, a tractor, a light-duty or medium-duty truck, or a marine vehicle such as a power boat. The engine 3 powers the equipment 2 upon fuel combustion. In FIG. 18, air flow is shown drawn into the engine 3 at an air intake at region 5. An optional turbo 6 is shown in phantom, as optionally boosting the air intake to the engine 3. The turbo 6 is shown downstream from an air cleaner 10. The air cleaner 10 has a filter cartridge 12 and is shown in the air inlet stream to the engine 3. In general, in operation, air is drawn in at arrow 14 into the air cleaner 10 and through the filter cartridge 12. Upon passage through the air cleaner 10, selected particles and contaminants are removed from the air. The cleaned air then flows downstream at arrow 16 into the intake 5. From there, the air flow is directed into the engine 3.

[0128] In a typical air cleaner 10, the filter cartridge 12 is a serviceable component. That is, the cartridge 12 is removable and replaceable within the air cleaner 10. This allows the cartridge 12 to be serviced, by removal and replacement, with respect to remainder of air cleaner 10, when the cartridge 12 becomes sufficiently loaded with dust or other contaminant, to require servicing.

[0129] Attention is now directed to FIG. 1, which depicts, in perspective view, air cleaner or air cleaner assembly 20, useable as air cleaner 10, FIG. 18. Referring to FIG. 1, air cleaner 20 includes a housing 21 defining: inlet end 22; inlet section 24 comprising, in this instance, a precleaner section 25; a central (in this instance main filter cartridge receiving) section 27; and outlet section 28. As will be apparent from further descriptions below, for the particular air cleaner 20 depicted, inlet section 24 is configured to be secured, during assembly, to central section 27, in a selected one of two different orientations; and, outlet section 28 is also configured to be secured to central section 27, in a selected one of two different orientations. Further, by using such a modular type of construction, alternate inlet sections can be mounted on the same style of central section 27. These features allow for a variety of alternate configurations possible for the air cleaner assembly 20, to advantage, as discussed in connection with FIGS. 16A-X.

[0130] The air cleaner housing 21 further includes, on an outer portion thereof, mounting arrangement 31. The mounting arrangement 31 includes a plurality of mounting pads 32, (see also FIG. 4) engage able with an equipment framework structure. The mounting pads 32 shown, are selectively positioned to allow for a variety of alternate mounting configurations, as described below. The particular mounting arrangement 31 depicted, will sometimes be referred to as a “boxed U-shaped” mounting arrangement 31a, or as a 3-sided mounting arrangement 31a, as discussed below.

[0131] Although alternatives are possible, for the particular air cleaner 20 depicted, the mounting arrangement 31 is positioned on, and as an integral part of, the central (in this instance main filter cartridge receiving) section 27. By “integral” in this context, it is meant that the parts are not, generally, separable from one another. A typical arrangement would involve molding the mounting arrangement 31 as part of a remainder of the main filter cartridge receiving section 27, from plastic. That is, while the features characterized herein can be implemented in metal air cleaners, in typical arrangements the housing 21 comprises plastic, with the various components molded. Of course in alternate arrangements, mounting portions can be provided on the inlet section 24 and/or the outlet section 28, but the arrangement 20 depicted is advantageous for certain applications, as described below in connection with FIGS. 16A-X.

[0132] Still referring to FIG. 1, air cleaner 20 includes removable service or access cover or panel 35. The removable access cover 35 allows for selective opening of a service access to an interior 20a (FIGS. 2 and 3) of air cleaner 20, for access to components positioned therein. The access cover 35 is secured in place by latch arrangement 36, FIG. 1, in this instance comprising four over-center wire latches 37, two mounted on each of the opposite sides 38, 39, of housing 21. The access cover 35 is positioned in a side (as opposed to an end 27a, 27b) of main filter cartridge receiving section 27, for operation as described below.

[0133] Typically the access cover 35 is positioned to provide a service access or opening at a location opposite a central base section of the boxed u-shaped mounting arrangement 31a. The central base section is indicated generally at 31d, FIG. 4.

[0134] The particular access cover 35 depicted, includes central projection 41 therein, useable for purposes discussed herein below.

[0135] Referring to FIG. 3, air cleaner 20 includes, positioned therein, main or primary filter cartridge 43 and optional secondary or safety element 45. In typical embodiments, each one of primary filter cartridge 43 and secondary or safety filter element 45 is sized and configured to be removed from housing 21, when access cover 35 is removed, through a resulting side access or service opening. For the particular arrangement shown, secondary or safety element 45 cannot be removed unless primary filter cartridge 43 has previously been removed.

[0136] Still referring to FIG. 3, primary filter cartridge 43 preferably comprises a z-filter media pack 50 having housing seal arrangement 51 and grid 52 secured thereto. The primary filter cartridge 43 may be in accord with, and be assembled in accord with the principles of, U.S. provisional application 60/532,783, filed Dec. 22, 2003, the complete disclosure of which is incorporated herein by reference. An example filter cartridge 43 is shown in FIGS. 19, 20 and 21, discussed below.

[0137] In general what is meant by the term “z-filter media pack,” in this context, is that the media pack 50, FIG. 3: (a) comprises an arrangement having an inlet face 54 and an opposite outlet face 55; and, (b) the media pack 50 comprises a plurality of inlet flutes and outlet flutes, formed by z-filter media comprising fluted media secured to a facing sheet. In general, the inlet flutes are open at or near (adjacent) inlet face 54 and are closed to outlet flow of air at or near (adjacent) the outlet flow face 55. In addition, the outlet flow flutes are sealed closed at or near (adjacent) the inlet flow face 54, and

are open at or near (adjacent) the outlet flow face **55** for flow of air therefrom. Thus air, after entering the inlet flutes at the inlet flow face **54**, must pass through the media of the media pack **50** before it can exit the media pack **50** via the outlet flow flutes at the outlet flow face **55**. The inlet and outlet flutes are typically formed from a fluted or corrugated sheet of media used in the media pack **50**. Z-filter media in general is described in PCT Publication WO 04/007054, published Jan. 22, 2004 and PCT application 04/07927, filed Mar. 17, 2004, each of which is incorporated herein by reference. Z-filter media was also generally described herein above in connection with FIGS. **26-30**, and briefly below in connection with FIG. **22**.

[0138] The z-filter media used can be formed in a variety of manners, the particular one depicted comprises a coiled arrangement **50a** formed from a single strip of z-filter media comprising a corrugated sheet secured to a facing sheet and coiled about itself with the facing sheet directed outwardly. The media coil depicted is an oval coil, in particular a shape having two opposite curved ends, **50b**, **50c** and two opposite sides **50d**, **50e**, see FIGS. **19-21**. The particular oval shape depicted is racetrack, with the opposite sides **50d**, **50e** generally having straight central sections parallel to one another.

[0139] It is noted that alternate shapes can be used for the media pack **50**, from oval shapes. For example media packs having circular shapes in cross-section can be used in alternate embodiments.

[0140] It is also noted that for the arrangements shown the faces **54** and **55** are generally flat or planar. While it is anticipated that such arrangements may be typical for air cleaners according to the present disclosure, alternate configurations can be used. For example, face **54** and/or face **55** can be configured to not be planar, but to rather project outwardly (axially) or inwardly (axially).

[0141] In this disclosure, reference is sometimes meant to an "axial" direction, or the terms "axial" or "axially" are used to characterize a direction of extension. In this context the term "axial" and variants thereof, is meant to refer to a direction of extension parallel to a line from inlet face **54** to outlet face **55** of main filter cartridge **43**, or, analogously, parallel to a line from inlet section **24** to outlet section **28** of the air cleaner **20**. The term "radial," and variants thereof, it is generally meant to refer to a direction perpendicular to axial.

[0142] For the arrangement depicted, the housing seal arrangement **51**, FIG. **21**, comprises a radial seal **57**, in this instance outwardly directed, supported by a frame portion **58**. The radial seal portion **57** comprises a compressible polymeric material such as a foamed polyurethane, secured to the frame portion and also sealing the frame portion to the media pack **50**, generally in accord with U.S. provisional 60/532, 783, filed Dec. 22, 2003, and incorporated herein by reference.

[0143] Grid **52** is preferably integral with frame portion **58**, and serves to support outlet flow face **55** against distortion or damage. Grid **52** and frame portion **58** can comprise a molded plastic component or preform, if desired.

[0144] Referring to FIG. **3**, secondary or safety element **45** comprises an outer skirt **65** having radial seal member **66** mounted thereon. The skirt **65** is generally oval in shape having two opposite curved ends and two, opposite, sides. Preferably the sides have straight central sections, as discussed below. Positioned inside of seal member **66** is media **67**, which can be pleated if desired. The secondary or safety

element **45** also has handle framework **69** thereon, for easy handling of the safety element.

[0145] Still referring to FIG. **3**, safety element **45** includes end projection **70** thereon sized to be received then receiver **70a** of housing end section **28**. Projection **70** can be used to help position safety element **45** during mounting, by insertion into receiver **70a** with operation of safety element **45** as a lever, in coordination with hand engagement of handle **69**. Alternately stated, during installation a service personnel would grasp safety element **45** by handle **69**. The element **45** would be positioned with projection **70** extending into receiver **70a**. The element **45** could then be rocked or pushed (levered) into position, by manual manipulation of handle **69**.

[0146] Referring to FIGS. **3** and **4**, attention is directed to outlet section **28** which defines: receiver **70a** (FIG. **3**), step **71**; side wall **72**; end wall **73**; and, outlet **74** (FIG. **3**). Step **71** is in a portion of outlet section **28** adjoining central main filter cartridge receiving section **27**. An inner radial (annular) surface **71a** of step **71** provides a seal surface for housing seal arrangement **51**, in particular a radial seal surface. Portion **71b** of step **71** provides an inlet stop surface for end **51a** of housing seal arrangement **51**. Thus, for the assembly **20** depicted, although the main filter cartridge **43** is installed in the central section **27**, the cartridge **43** is sealed by engagement between the housing seal arrangement **51** and a portion **71a** of the outlet section **28**. This is advantageous, because there is no issue with any leakage between section **27**, **28** of the housing **21**, since seal **51** engages the housing **21** downstream of this juncture.

[0147] Inner surface **72a** of side wall **72** forms a seal surface for secondary or safety element **45**, i.e., a radial seal engagement surface for radial seal member **66**. An extent of insertion of secondary or safety element **45** into outlet section **28** is limited, by framework **76**, in outlet section **28**. Thus, although the safety element **45** is installed by insertion into the central section **27**, in use it is actually mounted within the outlet section **28**.

[0148] Outlet **74**, FIG. **3**, is a flow outlet, for air from filtered air cleaner **20**. For the particular arrangement depicted, outlet **74** is preferably not centered in end wall **73**, but rather is positioned in one side **74a** thereof. Herein, an outlet **74** not centered in an associated outlet section **28**, FIG. **3**, will be characterized as "eccentrically" positioned. Alternately stated, referring to FIG. **3**, outlet **74** is not centered (vertically) in section **28**. Rather, it is positioned closer to an end **74a** than end **74b**.

[0149] From the above, it is apparent that the outlet section **28** shown, FIG. **1**, has opposite curved ends **28a**, **28b** joined by a pair of opposite sides **28c**, **28d**. (In FIG. **1** side section **28c** is visible, side section **28d** would typically be a mirror image.) In typical preferred arrangements central portions of sides **28c** and **28d** are straight, and parallel to one another.

[0150] Still referring to FIG. **3**, attention is directed to pre-cleaner section **25**. Pre-cleaner section **25** includes outer wall **80**, dust ejector port **81**, and separator tube arrangement **83**. Outer wall **80**, FIG. **1**, generally has an oval perimeter, with opposite curved ends **80a**, **80b** and opposite side walls **80c**, **80d**, FIG. **1**. For the particular preferred arrangement shown, central portions of the opposite sidewalls **80c** and **80d** are straight and parallel with respect to one another. It is noted that in FIG. **1** section **80c** is viewable; section **80d** would typically be a mirror image. In the arrangement shown, ejector port **81** is positioned at one of the curved ends **80b**, although alternatives are possible. In typical use, a tube of a

scavenge system would be attached to dust ejector port **81**, to draw ejected dust out of the housing **21**, from precleaner **25**. In some arrangements a flexible evacuator valve could be positioned over aperture **81a**, when a scavenge system is not used. Such valves are common in air cleaner arrangements, and one is depicted for example in PCT publication WO 03/084641 A2 at FIG. 4.

[0151] Separator tube arrangement **83** generally comprises a plurality of separator tubes **83**, FIGS. **1**, **2** and **3**. Such tubes are generally described, for example, in U.S. provisional 60/556,133, filed Mar. 24, 2004 and PCT Publication WO 03/084641, published Oct. 16, 2003, the complete disclosures of which are incorporated herein by reference.

[0152] The tubes **83** can be used in a variety of different numbers and orientations. Generally they will be selected for the particular instances of use expected. Referring to FIG. **2**, in general the tubes **83** are configured to: (a) impart a circular momentum to inlet air upon passage through use of inlet blades or fins **83a**; (b) as a result, to drive some particulate to an outside portion **83b** of the tube, and eventually out of the tube **83** through outlet **83c**; and, (c) to allow the air to pass into a center exit tube **83d**, and then into the main air cleaner receiving section **27**.

[0153] Referring to FIG. **1**, the precleaner **25** includes an end piece **25a** secured to side wall **80**. The precleaner **25** can be preassembled, before being attached to main filter cartridge receiving section **27**. Referring to FIG. **2**, precleaner **25** can be formed into two molded components comprising end piece **87** (or piece **25a**) with fins **83a** and tubes **83b** thereon; and, body **88**, with tubes **83d** therein and sidewall **80**. The two components **87**, **88** can then be secured together to form the precleaner **25**. This general type of assembly was described for example in PCT publication WO 03/084641, incorporated herein by reference.

[0154] It is noted that the inlet section **24**, in this instance comprising the precleaner **25**, has an eccentric configuration. The eccentric configuration is provided by the location of the outlet tube **81** in one of the ends **80a**, **80b**, FIG. **1**. Eccentricity is also provided in the particular precleaner **25** depicted, by the pattern of installation of the tubes **83**. From this eccentricity, it can be seen that the precleaner **25** can be mounted in one of two rotational positions, relative to sections **27**. Advantages from this will be apparent from the discussions below.

[0155] Referring to FIG. **3**, the air cleaner **20** includes an internally received loading cam or ramp arrangement **90**. During installation of primary filter cartridge **43** (when cover **35** is removed), the cam or ramp **90** is engaged during the insertion process, biasing the cartridge **45** in the direction of arrow **95**, i.e., into sealing position. When access cover **35** is then secured in place, projection **96**, in cover **35** adjacent end **98** of primary filter cartridge **43** prevents the filter cartridge **43** from backing out of engagement at seal **51**. That is, projection **96** helps secure the cartridge **43** locked in position, for proper operation. A similar loading cam or ramp arrangement **90**, and an access cover arrangement having a projection **96** thereon, are described in U.S. patent application US 03/14350 published as WO 03/095068 on Nov. 20, 2003, the complete disclosure of which is incorporated herein by reference.

[0156] Typically a section of ramp **90** is provided in each side **38**, **39**, of the housing **21**, and in a bottom. Only one side is viewable in FIG. **3**; the opposite side would be a mirror image.

[0157] Herein the cam or ramp **90** will sometimes be referred to as a “stationary” cam or ramp **90**, since in opera-

tion it does not move at all. Rather it is fixed in position in section **27**, and the cartridge **43** is biased during insertion into section **27**. The stationary cam or ramp **90** is positioned to operate to cause biasing without interaction with the cover **35**, if desired. This means that in some preferred arrangements the biasing of cartridge **43** will have occurred even before the cover **35** is in position.

[0158] A filter cartridge similar to that described in U.S. provisional application 60/532,783, incorporated herein by reference, can be used for the filter cartridge **43**. Such an element generally has, on end **50f** of media pack **50**, FIG. **3**, a permanently positioned structural component for engagement with ramp **90**. However, preferably for the particular assembly depicted in FIG. **3**, the media pack **50** does not include such structure positioned thereon at end **50f**. Rather, the air cleaner **20** includes, as depicted, an optional sheath, band, or cassette component **100** that is not permanently secured to the media pack **50**, as discussed in detail in the next section.

#### IV. The Sheath or Cassette Component **100**

[0159] Referring to FIG. **3**, the sheath or cassette component **100** surrounds and contains the media pack **50**. The cassette component **100** is depicted in detail in FIGS. **5-7A**.

[0160] Typically and preferably, the sheath **100** and media pack **50**, are manually separable. By the term “manually separable” in this context, it is meant that the two components can be separated under hand manipulation by service personnel, to allow the cassette **100** to be re-used even when the filter cartridge **43** is replaced. Generally all that is required for the separation, in a preferred arrangement, is pulling the two parts away from one another, axially. This will be understood from further detailed discussion of the cassette **100**.

[0161] Referring to FIG. **7A**, cassette component **100** includes an outer wall **104**, defining interior **104a** configured for receipt therein of the media pack **50**, FIG. **3**.

[0162] The outer wall **104** includes opposite ends **107** and **108**. End **107** is positioned, in use, adjacent inlet face **54** of the media pack **50**; and, end **108** is positioned, in use, adjacent the housing seal arrangement **51**. Thus, end **107** is an inlet end and end **108** is an outlet end, with respect to typical air flow.

[0163] Preferably, end **108** is open, to allow receipt of media pack **50**, by insertion therethrough, into interior **104a**, during use.

[0164] The particular cassette arrangement **100** depicted includes, extending across end **107**, grid arrangement **110** comprising cross pieces **111**. Cross pieces **111** form a grid **110** extending adjacent inlet face **54** of media pack **50**, during use. Preferably the grid **110** is formed integrally to the outer wall **104**; in this context the term “integrally” and variants thereof is meant to refer to parts that cannot be separated. Typically the grid **110** and outer wall **104** are formed as a single molded plastic piece, for example from a polyamide or polyolefin. Typical useable materials would be Nylon 6/6 or polypropylene. The plastics could be glass filled.

[0165] The specific configuration for the grid **110** is a matter of choice, and can be selected with designs for aesthetic or source indicating purposes. For appropriate function, all that is preferred is enough extension across end **107**, to ensure end support for the media pack **50**, FIG. **3**, at this location, in use.

[0166] Herein, end **107** of cassette **100** will sometimes be referred to as closed, since grid **110** extends there across, to prevent insertion of any portion of media pack **50** there-



through, during assembly. It is noted that both ends **107** and **108** are open, with respect to air flow.

[0167] Referring to FIG. 5, cassette **100** generally has an outer perimeter shape comprising opposite curved ends **109a**, **109b** and two opposite sides **109c**, **109d**. In the typical preferred arrangement shown, central sections of sides **109c** and **109d** are straight and parallel to one another. It is noted that curved end **109a** includes structure projecting outwardly therefrom, as discussed below, in a central portion thereof.

[0168] Outer wall **104**, FIG. 7A, includes an outer surface **114** with spaced, radially outwardly projecting, ribs **115** thereon. The ribs **115** generally extend along opposite sides **114a**, **114b** and across bottom **114c**. Referring to FIG. 2, the ribs **115**, on the sides **114a**, **114b**, are preferably sized to extend across gaps **117**, to help support a received media pack **50** centrally within housing interior **20a**. Ribs **115** can actually be sized to engage inner surfaces **116** of walls **117** at these locations, if desired.

[0169] It is noted that one rib **115a**, FIG. 7A, is located at inlet end **107**. This rib **115a** is positioned to engage cam or ramp **90**, as discussed below, during insertion of cassette **100** with a filter cartridge **45** associated therewith, into air cleaner housing **21**, for use.

[0170] Referring to FIG. 7, the preferred outer wall **104** has an inner surface **104b** that tapers to a narrow end section **121** sized to pinch end portion **122** of media pack **50**, FIG. 3 when inserted therein. This will help support the media pack **50** at this location, and secure the media pack **50** against movement at this location, in use. The engagement between the cassette **100** and media pack **50**, merely being by pinching or compression at location **121**, facilitates manual insertion and also manual removal of a media pack **50**, into cassette **100** and thus separation and engagement between the media pack **50** and cassette **100** during servicing operations.

[0171] Referring to FIG. 7, narrow end **121** is formed including transition step **123**, to cause interior **104a** of side wall **104** to have a central region **124** of a first cross-sectional size and an end portion **125** adjacent end **107** of a second, smaller, cross-sectional size. Preferably step **123**, and thus section **125**, projects inwardly, in total, a distance of about 0.5 mm-2 mm, typically about 1 mm, relative to region **124b**. Preferably region **125** is sized to snugly receive the media pack, with no more than 1.5 mm of compression (pinch) therearound. Preferably region **125** extends over an axial length of extension, between ends **125a** and **125b** a distance of at least 5 mm, typically at least 10 mm and usually within the range of 15 to 25 mm. Herein, region **125** will sometimes be referred to as a media pack support shoulder. The particular media pack support shoulder **125** depicted, is continuous. However, the shoulder **125** may comprise spaced structures, as opposed to a continuous shoulder in cassette **100**.

[0172] Typically and preferably, whether continuous or not, support shoulder **125** includes: portions projecting from the opposite curved ends (**50c**, **50b**, FIG. 20) to engage a media pack; and, portions projections from the opposite sides (**50d**, **50e**, FIG. 20) to engage a media pack, with the length of radial extension along each of the side portions engaging a media pack (i.e., around the media pack) being over distance of at least 15 mm, preferably at least 30 mm; and, with the length of radial (arcuate) extension along each curved end portions engaging a media pack being at least 15 mm and preferably at least 30 mm. Again, preferably the shoulder **125** is continuous, and it engages the media pack **50** continuously,

therearound. As a result of being continuous, it compresses the media pack the same amount, there around.

[0173] In general, the media pack support shoulder **125** releasably radially supports the media pack **50**, in this instance at an end thereof opposite the housing seal arrangement **51**, FIG. 3. Again, the engagement is such that the media pack **50** and the filter cartridge **43** can be manually separated from the cassette **100**, so that the cassette **100** can be reused.

[0174] Again, in use, the support provided by support shoulder **125**, against both the opposite curved ends and the opposite sides of the media pack **50**, operates to support the media pack **50** at end **50f**, FIG. 3, when installed. This means that the media pack **50** is supported adjacent both of opposite end faces **54** and **55**, i.e., adjacent end **54** at support shoulder **125** and adjacent end **55** at housing seal **51**, when the media pack **50** is installed within housing **21**. This helps avoid damage to the media pack **50** during vibration of assembly **20** under operational conditions.

[0175] It is noted that if constructed in the preferred way as characterized above, whether continuous or not, the shoulder **125** will engage the media pack **50** along four portions thereof including: opposite ends **50b**, **50c** and opposite sides **50d**, **50e**, and thus can be characterized as a 360° or four sided pinch or support with forces of pinch or support directed toward the media pack from at least four different directions. Again this will sometimes be referred to as a 360° support, a four sided support of the media pack or support with forces from at least four different directions against the media pack.

[0176] In general, step **123** is preferably tapered and not abrupt, so as to assist in positioning of a media pack with an interior **104a**, without damage. Also, typically section **124** tapers downwardly between regions **124a** and **124b** somewhat, for example at an angle within the range of 0.5°-1.5°.

[0177] Typically cassette **100** is sized such that when a media pack is positioned therein, for use, the media pack is squeezed as described above, adjacent region **121**, and is against region **124** at or near end **124b**, or is not spaced therefrom by more than about 1.5 mm, typically no more than 0.5 mm.

[0178] At end **108** the outer wall **104** can be configured in several different ways. The particular arrangement depicted, FIG. 7, includes an outer flare or flange **128** with step **129** therein, adjacent end **108**. Step **129** and flange **128** are sized to provide an extension of end **108** of outer wall **104** over a portion of peripheral seal portion **130** of the seal material **131** forming radial seal **57**, FIG. 3. The peripheral seal portion **130** generally comprises the portion of seal material integral with radial seal portion **57**, and sealing radial seal portion **57** to media pack **50**. Preferably the axial extension of region **129** is within the range of 5 mm-25 mm, typically 10-20 mm.

[0179] Referring to FIG. 7, transition portion **129a** between step **129** and region **124a**, provides for a gradual increase in size at this location.

[0180] In the alternative, instead of including step **129** and flange **128**, outer wall **104** could be sized such that end **108** simply axially terminates short of, or at, the media pack peripheral seal portion **130**.

[0181] Still referring to FIG. 7, preferably step **129** is configured such that internal surface **128a** of flange **128** is sized relative to section **124a** such that step **129** has a constant value of step outwardly, from region **104**, within the range 0.25 to 2.0 mm, around its perimeter.

[0182] End portion **107** of cassette component **100** is sized and positioned to engage loading cam or ramp **90**, FIG. 3,

during installation. Thus, in typical use, filter cartridge 43 would be installed in interior 104a of cassette component 100 by insertion through end 108, at a location exterior to the air cleaner 20. The cassette component 100 with the filter cartridge 43 installed therein, would then be installed (inserted) through an access opening into interior 27a of main filter element receiving section 27, with access cover 35 removed. During installation, engagement between cassette component 100 and (stationary) loading cam or ramp 90 forces the cassette component 100 and received primary filter cartridge 43, in the direction of arrow 95, FIG. 3, and into a loaded position with the primary filter cartridge 43 sealed at radial seal 57. Access cover 35 can then be positioned, with projection 96 extending to a location preventing primary filter cartridge 43 and cassette component 100 from backing out of the loaded and sealed position.

[0183] If desired, in some assemblies the access cover 35 can be secured to the cassette component 100, to facilitate assembly. This securement can be permanent or temporary, as desired.

[0184] Herein, when it is stated that the filter cartridge 43 or media pack 50 are inserted into the cassette 100, it is not necessarily meant that 100% of the axial length of the filter cartridge 43 is inside of the cassette 100. For example as shown in FIGS. 2 and 3, a portion of seal arrangement 51 projects outwardly, from cassette 100. For typical, preferred, arrangements, the media pack 50 is completely contained within the axial extension cassette 100, or at least 94% of the media pack axial length (i.e., the length between end faces 54 and 55) is so contained.

[0185] There is no requirement that the cassette 100 be continuous and have no apertures or other openings therein, in side wall 104, which expose side portions of the media pack 50. However an arrangement, as shown, with no apertures or openings therein to expose side portions of media pack 50, is preferred for media pack protection.

[0186] It is noted that for the particular arrangement depicted, FIG. 7A, the cassette component 100 includes projection arrangement 131 at curved end 132. The projection arrangement 131 includes platform 131a (in this instance flat) with receivers 133 thereunder (preferably in both sides 133a, 133b) to provide for easy grasping of the cassette component 100 during handling. Referring to FIG. 3, the projection 41 in access cover 35 defines a recess 41a therein, to receive the projection arrangement 131. Preferably the platform 131a has a perimeter area (or outer surface area) of at least 3600 sq. mm., typically at least 7000 sq. mm. Preferably the receivers 131 are positioned so that a user's fingers can project into them in a direction perpendicular to the axial direction of the media pack 50.

[0187] The relatively large platform 131a is convenient to grasp, and helps ensure that the cassette 100, and thus the primary filter cartridge 43, are in proper orientation once installed. Receipt of the projection 131 into the receiver 41 on the access cover 35, helps ensure that proper positioning is maintained after installation.

[0188] Attention is now directed to FIGS. 8-14, which are meant to show, schematically, operation of an arrangement analogous to that of FIGS. 1-7A. It is noted that some of the detail in FIGS. 8-14 is different, for example the access cover does not include a projection thereon, with a receiver toward the inside, since the cartridge component does not include a

projection analogous to projection arrangement 131. However, in general, features are analogous and thus are numbered and described accordingly.

[0189] Referring to FIG. 8, then, air cleaner 20 is schematically depicted, completely assembled and closed. In FIGS. 9 and 10, removal of the access cover 35 is depicted. In FIG. 10, removal of the access cover 35 is shown also removing the cassette component 100 since in this instance the cassette component 100 is connected to the access cover 35. The connection between the axis cover 35 and the cassette 100 can be permanent, or a removable snap fit. A removable snap fit would typically be preferred, if connection is used. In alternate preferred embodiments, such as shown in FIG. 1, the access cover 35 would be removable without also removing the cassette component 100, since the two would not be connected to one another. (It is noted that in FIG. 8 the cassette component 100 is depicted schematically, i.e., without ribs and a grid, for example.)

[0190] Referring to FIG. 11, the assembly 20 is depicted with the access cover 35 and cassette component 100 completely removed, from a remainder of the housing 21. In FIG. 12, the primary filter cartridge 43 is shown removed from the cassette component 100. Within the remainder of the housing 21, the secondary or safety element 45 can be viewed.

[0191] It is noted that in FIG. 12, the safety element 45 is shown mounted inverted, relative to its position in FIG. 3. That is, an opposite end of the safety element 45 is directed upwardly, than for the depiction in FIG. 3. This indicates that alternate possibilities can be accommodated, with principles according to the present disclosure.

[0192] In FIG. 13, the air cleaner 20 is shown during a step of removing the secondary or safety element 45. In FIG. 14, the secondary or safety filter 45 is shown completely removed.

#### V. Configuration of the Housing 21 for Variation in Mounting and Attachment to Other Engine Components

[0193] Attention is now directed to FIG. 15. In FIG. 15, housing components comprising: the inlet section 24 (pre-cleaner section 25); central (main air filter cartridge receiving) section 27; and, outlet section 28, are shown separated from one another. Typically these components to the housing 21 would be separately assembled (i.e., be preformed), and then be secured together to form the air cleaner 20, FIG. 1. The securement together can be by removable attachment, or by an ultrasonic welding or similar technique that prevents the components from being again separable. Typically and preferably components or housing sections 24, 27 and 28 are permanently secured in the assembly 20.

[0194] Herein, certain preferred components such as inlet section 24 (i.e. pre-cleaner section 25) and outlet section 28 will sometimes individually be referred to as a "preform" or as a "preformed component." The term "preform" and variants in this context is meant to refer to a component that is formed separately from central section 27, and is then secured thereto to form the air cleaner housing 21.

[0195] Referring to FIG. 15, central main air filter cartridge receiving section 27 includes an upstream or inlet edge 27a and a downstream or outlet edge 27b. Typically the inlet component 24 (pre-cleaner 25) would be preformed from plastic and be assembled, and then be secured to upstream edge 27a by welding (for example sonic welding). Typically outlet

section 28 would be preformed from plastic and would be secured to downstream edge 27b by welding (for example sonic welding).

[0196] This assembly approach allows the outlet section 28 to be positioned with the outlet tube 74 near cover 35 (not as shown in FIG. 15) or away from cover 35 (as shown in FIG. 15). Further it allows the option of positioning the precleaner section 25, with dust ejector port 81 directed opposite cover 35, as shown, or alternatively toward cover 35. This allows for four different overall assembly configurations, using the same components. Alternate configurations of outlet sections 28 can be used, as well as alternate configurations for inlet section 24 allowing for still more possibilities.

[0197] Still referring to FIG. 15, for the particular assembly 20 depicted therein, or in FIG. 1, the inlet section 24 (pre-cleaner 25) is capable of being mounted in two different rotational positions, since this section 24 is asymmetric. The two orientations, in FIG. 15, would be with outlet 81 directed downwardly or upwardly. An inlet section 24 which is capable of two different rotational positions for mounting on central section 27, will be referred to herein as an eccentric component, or as a component having two different possible mounting orientations.

[0198] Similarly, outlet section 28 is eccentric, since outlet 74 is not centrally positioned. Thus section 28 is mountable in two possible rotational positions on section 27: a first position in which outlet 74 is positioned where shown in FIG. 15; and, a second position in which section 28 is rotated 180°, in section 74 this position, vertically in FIG. 15, near access cover 35.

[0199] These possibilities can be used to advantage, in providing for a unit mounted on equipment, with respect to: ease of access to the service cover for servicing; appropriate projection of the dust ejector outlet; and, preferred positioning of the outlet 74 for engagement with other equipment in the system. This is illustrated for example in FIGS. 16A-X, which provide for some but not all of the possibilities.

[0200] It is noted that above the mounting arrangement 31 for air cleaner 20 was characterized above as preferably being a 3-sided mounting arrangement 31a, or a boxed-U shaped arrangement 31a. This is because the mounting arrangement, shown in FIG. 16A, has three sides, comprising opposite, preferably parallel, sides 31b and 31c with base 31d extending therebetween, the angle of engagement between the sides 31b, 31c typically being perpendicular to the base 31d.

[0201] Referring to FIG. 15, typically when a three-sided boxed U-shaped mounting arrangement is used, on a center section 27, the access cover 35 is positioned opposite the central base 31d of the mounting arrangement. This is also shown in FIG. 1.

[0202] FIG. 16A, for example, shows the configuration of FIG. 15 mounted on central, bottom, or base section 31d of the mounting arrangement; the equipment mounting surface or structure being schematically shown at A. FIG. 16B shows an analogous mounting of the air cleaner housing portion 27, but with the outlet section 28 inverted (or mounted on section 27 rotated 180° relative to FIG. 16A). FIG. 16C depicts the arrangement mounted inverted, relative to FIG. 1. To accomplish the configuration of FIG. 16C, the assembly, FIG. 15, is to be made with the precleaner section 25 inverted or rotated 180° from the position of FIG. 15. Also, the cover 28 is rotated 180° from the position of FIG. 15.

[0203] FIG. 16D shows an analogous mounting to FIG. 16C, but with the outlet section 28 inverted relative to FIG. 16C, and thus in the same orientation, relative to the cover 35, as shown in FIG. 15.

[0204] FIG. 16E shows a side mounting, on one of the two sides (side 31c) of the housing section 27, in this instance with the outlet section 28 and precleaner section 25 in the same orientation as FIGS. 16A and 15. In FIG. 16F, the same mounting orientation is shown, but with the outlet section 28 inverted.

[0205] FIG. 16G shows a mounting on the opposite side (side 31b) but with the outlet section 28 and precleaner section 25 oriented in the same positions as FIGS. 16E, 16A and 15.

[0206] FIG. 16H shows the same mounting orientation as FIG. 16G, but with the outlet section 28 inverted.

[0207] FIG. 16I depicts the air cleaner mounted with the main filter cartridge receiving section 27 inverted relative to FIG. 16G, and with the outlet section 28 and precleaner section 25 oriented analogously to FIG. 16C. FIG. 16J depicts an analogous mounting of the main filter cartridge receiving section 27 to FIG. 16I, but with the outlet section 28 inverted.

[0208] FIG. 16K shows the assembly in the same configuration as FIGS. 16C and 16I, but mounted on an opposite side from 16I. FIG. 16L shows the assembly in the same orientation as FIGS. 16D and 16J, but with the mounting on an opposite side of section 27 from 16J.

[0209] In FIG. 16A-L, the mounting was generally in a “vertical” orientation; the term “vertical” in this context meaning mounted with the access cover 35, FIG. 1, directed either up or down; or, alternatively stated, with base 31d directed either up or down. In FIG. 16M-X, orientations and alternatives for horizontal mounting are shown. When an arrangement such as that described herein as characterized as “horizontally mounted” or by variants thereof, it is meant that the cover 35 is neither directed upwardly or downwardly, but rather is directed horizontally.

[0210] For the depictions in FIGS. 16M-16R, it is assumed that the dust ejector outlet would be attached to a scavenge system. When this is the case, the ejector does not need to be directed downwardly because a scavenge system typically applies a vacuum draw to remove the dust through the ejector tube.

[0211] In FIG. 16M the assembly is depicted and mounted horizontal instead of vertical, but configured with the outlet section 28, central main filter cartridge 27 and precleaner section 25 oriented analogously to FIG. 16A.

[0212] FIG. 16N shows the assembly with the outlet section 28, precleaner section 25 and main filter cartridge section 27 oriented analogously to FIG. 16B, except mounted horizontally on a side. FIG. 16O shows the assembly in an orientation analogous to FIG. 16M, except suspended from an opposite side; and FIG. 16P shows an analogous configuration to that shown in FIG. 16N, except suspended from an opposite side.

[0213] FIG. 16Q shows the air cleaner configured as shown in FIG. 16D except mounted in a horizontal orientation. FIG. 16R is analogous to FIG. 16Q, except with outlet section 28 rotated 180°.

[0214] FIG. 16S-X shows that still other alternate configurations are possible, by using a precleaner section 200 alternate to precleaner section 25, FIG. 1. The precleaner section 200 used, would include the outlet projection 201 in one of the sides 140, 141, FIG. 1, instead at one of the ends. Also, the

inlet separator tubes **83** may be positioned differently. In other fashions, the componentry could be the same as the embodiments of previous figures.

[0215] FIG. 16T is analogous to 16S, except outlet section **28** has been rotated 180°. FIG. 16U is analogous to 16S, except the arrangement is mounted on a side. FIG. 16V is analogous to 16U, except with section **28** rotated 180°. FIG. 16W is analogous to 16U except mounted from an opposite side. FIG. 16X is analogous to 16V except mounted suspended from an opposite side.

[0216] It is also noted that in some systems instead of a precleaner, an inlet arrangement could be provided mounted at edge **27a**, FIG. 15. The inlet arrangement can simply be an inlet tube, as opposed to a precleaner.

#### VI. Alternate Cover Configurations

[0217] Attention is now directed to FIG. 17, which shows an alternate assembly **300**. It differs from the assembly **20**, FIG. 1, in that projection **301** in access cover **302** is of different configuration, and an internally received cassette, not shown, would have an analogous projection on an outer region thereof. It is noted that such a projection would be curved, with a central, axial, ridge.

[0218] Referring to FIG. 3, it is noted that projection **131** and receiver **41** help ensure the cartridge **100** is in an appropriate position, for operation, when cover **35** is positioned in place and the assembly **20** is used. Analogous features in assembly **300** will operate in an analogous manners.

#### VII. The Primary or Main Filter Cartridge 45

[0219] In FIGS. 19-21, the cartridge **43** is depicted. Referring to FIG. 19, cartridge **43** includes media pack **50** having housing seal arrangement **51** secured thereto. Typically and preferably the housing seal arrangement **51** comprises a region of molded in place compressible seal material, for example a polyurethane foam, having a region forming a radial seal as described above. In FIG. 19, the seal region is indicated at **51b**.

[0220] The seal arrangement **51** further includes a portion of seal material **130** engaging media pack **50** and securing the seal arrangement **51** thereto. Preferably region **130** is integral with region **51b**; i.e., they are molded simultaneously from one pool of resin.

[0221] Referring to FIG. 21, a grid **52** is depicted with projection **58** thereon. The projection **58** provides a back up to seal region **51** and in particular radial seal region **51b**. Preferably the grid **52** and support **58** are integral with one another and form a molded preform (molded from a rigid material such as a nylon or polypropylene) secured to end **55** of media pack **50**, and sealed thereto by region **130** of sealant material.

[0222] As an example only, a useable cartridge **43** would have a longer dimension, between curved ends **50b**, **50c**, about 330 mm and a shorter dimension, between opposite sides **50d**, **50e**, of about 203 mm. The axial length of the media pack can be chosen for the amount of dust load desired, for a given air cleaner configuration.

[0223] Referring to FIG. 21, it is noted that at the outlet end, individual inlet flutes, shown schematically at **500** are darted closed, as illustrated schematically at **501**. This is an optional approach to closure, as described for example in PCT publication WO 04/007054, published Jan. 22, 2004, incorporated herein by reference. Also as indicated in FIG. 21, seal material forming the housing seal arrangement **57** and seal region

**130** also projects inside of the outermost wrap or coil **502** of media. The optional approach is described for example in U.S. provisional application 60/532,783, incorporated herein by reference.

[0224] The media material is a matter of choice, for the specific application and level of efficiency desired. The media may have a fine fiber application to one or more sides thereof. Conventional materials, or materials yet to be developed, can be used.

#### VIII. Z-Filter Media Generally

[0225] Z-filter media was described, generally, above in connection with FIGS. 26-30.

[0226] Attention is now directed to FIG. 22. In FIG. 22 z-filter media is generally indicated at reference numeral **300**. In FIG. 22, an example air flow direction opposite to FIG. 26 is shown, as an example. Thus, z-filter media **300** generally comprises a fluted or corrugated sheet **301** secured to a facing sheet **302**, for example by sealant or other means. The facing sheet **302** may be non-corrugated, although in some instances it may also be corrugated for example as described in U.S. provisional application 60/543,804, filed Feb. 11, 2004 and incorporated herein by reference.

[0227] Referring to FIG. 22, the media **300** has opposite ends **305** and **306**. End **305** can form inlet face **54**, FIG. 3; and end **306** can form outlet face **55**, FIG. 3; although an opposite approach is useable and sometimes preferred.

[0228] Corrugated sheet **301** comprises: (a) a plurality of alternating ridges **310** and troughs **311**; and, (b) opposite sides **312** and **313**. Generally troughs **311** on side **312** form inlet flutes **311a**, and air can enter them in the direction of arrows **320** along end **305**. On opposite side **313** the ridges **310** define outlet flutes **310a** which are closed at or near end **305** at **325**. Closure **325** may be formed in a variety of manners including by sealant **325a**, folding or other arrangements. Air cannot enter (or leave) flutes at an end closed by sealant **325a**.

[0229] Adjacent end **306**, flutes formed in side **312** by troughs **311** are closed at **330** in this instance by sealant **331**.

[0230] In general, media strip **300a** is formed by corrugated sheet **301** and facing sheet **302** secured to one another and then either cut and stacked or coiled into a media pack, the media pack of FIG. 3 being coiled with the facing sheet directed outwardly. Air can enter the inlet flutes **311a**, but cannot exit at end **306** unless it passes through the media **301** into outlet flutes **310a**. (Of course if oriented so air flows in an opposite direction, the air enters flutes **310a** at end **306**, and exits flutes **311a** at end **305**.)

[0231] In general, then, z-filter media can be characterized as comprising a corrugated fluted sheet secured to a facing sheet and configured to provide a plurality of inlet flutes and outlet flutes. The inlet flutes are open at an inlet face of the arrangement and closed in an outlet face, for example by sealant. Typically the outlet flutes are closed at the inlet face and open at the outlet face. The closure can be immediately adjacent the associated face, or spaced therefrom slightly, depending upon the nature of the processing steps used to form the arrangement. The z-filter media can then be coiled, or can be cut into strips and stacked, again depending on the arrangement.

#### IX. The Safety Element, FIGS. 23-25

[0232] Attention is now directed to FIG. 23 in which safety element 45 is depicted. The safety element 45 is shown in perspective view, in FIG. 24. Referring to FIG. 24, the safety element 45 comprises a preformed outer skirt 65, radial seal 66, end projection 70, handle 69 and media 45a. The media 45a is preferably pleated, is surrounded by skirt 66 and is secured in position by comb (pleat spacer) projections 340 extending across skirt 66. The skirt 66 generally has an oval shape with opposite curved ends 341, 342 and opposite sides 344, 345.

[0233] Referring to FIGS. 23 and 24, typically projection 70 is centered in one of the curved ends 341. Preferably it has a width (distance of extension between point C and D of FIG. 23) of at least 10 mm, typically at least 20 mm, for example 25-40 mm. Further, it preferably has a distance of projection, radially outwardly from skirt 64, FIG. 25, (i.e., in a direction opposite end 342) of at least 5 mm, typically at least 10 mm. Referring to FIG. 24, projection 70 includes ribs 70b, for engagement with recess 70a, FIG. 3.

[0234] It is noted that in FIG. 3, the safety element 45 is shown mounted with the handle 69 down and the projection 70 up. The assembly 20 could be configured for an opposite mounting.

#### X. Methods of Installation and Assembly

[0235] From the above descriptions, generally a method of installing an air filter cartridge into an air cleaner housing, through a side service access opening in the air cleaner, is provided. The method generally includes steps of: inserting an air filter cartridge comprising a media pack and housing seal arrangement secured to the media pack into a cassette defining an interior; and installing the resulting filter cartridge/cassette combination by insertion through the side access with biasing of the cassette axially upon engagement between the cassette and a stationary cam member positioned within the air cleaner housing. Preferably the method is conducted with an air filter cartridge media pack as defined, and with the housing seal as defined. Most preferably it is conducted such that the step of inserting the media pack into the cassette including pinching an end of the media pack opposite the housing seal arrangement in a media pack support arrangement in the cassette, with pinching being directed against four sides of the media pack.

[0236] Also provided is a method of assembling an air cleaner assembly including steps of securing an outlet section having an eccentrically positioned hollow tube therein to a central housing section having a box U-shape mounting arrangement thereon; and securing an inlet section, preferably comprising a precleaner with an eccentrically positioned dust ejector outlet, to the central housing section. The step of assembly further would preferably include a step of installing an air filter cartridge in the central housing section, the air filter cartridge comprising a media as described and a housing seal arrangement as described. Preferably, the method involves installing the air filter cartridge into the housing using the general method involving insertion of the cartridge into a cassette, and then installing the resulting cassette/filter cartridge combination.

#### XI. Assembly Configuration

[0237] Herein, the preferred assembly depicted is provided to accommodate a media pack having an oval shape in cross-

section or outer perimeter. By oval shape as previously indicated, it is meant that the media pack has at least two opposite curved ends (or sides) and a pair of opposite sides extending therebetween. The opposite sides can be straight, as described, or can be curved.

[0238] Preferred configurations to accommodate this were provided to sections of the housing and the safety element as well.

[0239] Of course alternate configurations are possible. For example the media pack can be provided with a circular configuration and correspondingly the housing sections and safety element can be provided with circular configurations, although still further alternatives are possible.

#### XII. Example Air Cleaner Configurations Having a Two-Stage Construction with: A Precleaner; Side-Load; a Main Filter Element; and, a Safety Filter Element

[0240] A. The Example of Air Cleaner, FIGS. 31-46.

[0241] The reference numeral 600, FIGS. 31, 32, depict an air cleaner assembly embodying any of the principles described previously above. Referring to FIG. 31, air cleaner 600 comprises housing 601. Internally received within housing 601 are included, as described below, a filter cartridge and a safety filter.

[0242] Housing 601 generally comprises a main central body 605, an access cover 606, inlet section 607 and outlet section 608. The inlet section 607, in the air cleaner 600 depicted, comprises a precleaner section 609 generally as described above in connection with FIG. 1 and related descriptions. At 610 a dust ejector or drop tube for the pre-cleaner section 609 is provided. Typically outlet 611 would be provided with a dust ejector valve, as previously described, or it would be attached to a scavenge tube. When used as a drop tube, it is preferably oriented to point down, when air cleaner assembly 600 is installed for use. When used as a scavenge tube, with a suction draw, it will typically be pointed down also, although alternatives are possible.

[0243] Outlet section 608 includes a non-centrally disposed outlet aperture 615, analogous to those described above.

[0244] Preferably, a modular construction is used for housing 601. Thus section 507 can be mounted in either of two rotational orientations. Although alternatives are possible, typically once mounted, it would be permanently secured in place through heat staking, welding or similar attachment. Also, cover outlet section 608 can be mounted in either of two rotational positions, again typically permanently through heat staking, welding or other approaches.

[0245] In FIG. 36, the air cleaner 600 is depicted in exploded view, and the individual sections 605, 607 and 608 are viewable, along with access cover 606.

[0246] Referring again to FIGS. 31 and 32, access cover 606 is secured in place by releasable latches 620, on base or body 605. A variety of latch arrangements can be used, over center wire latches being shown as an example.

[0247] From FIGS. 31-35, it can be seen that central base member 605 is provided with a with a boxed, U-shaped, three-sided mounting arrangement 625, so that it can be mounted in a variety of orientations, as generally indicated and described previously or in for other embodiments.

[0248] It is noted that in alternate embodiments, as described previously (with respect to other sections), pre-cleaner 607 could be provided such that ejector tube 611

extends outwardly from one of the opposite sides, **607b**, FIG. **32**, instead of from an end **607c**, FIG. **31**. This would allow for convenient and effective dust ejection, for instances when the assembly **600** is mounted in a different orientation.

[0249] Typically, section **607** would be provided with one or the other of the two ejector tube locations, one being closed although in some instances both could be provided.

[0250] Referring to FIG. **31**, outlet section **608** is provided with two projections **608a**, **608b**, extending opposite from one another, along opposite narrow curved ends of the section **608**. Internally, a receiver is located within each of these projections **608a**, **608b**, for use as described below.

[0251] In typical operation, air to be filtered will enter inlet **607** at face **630**. Referring to FIG. **33**, it can be seen that in face **630** inlet ends of a plurality of centrifugal separators or cyclonic separators are provided.

[0252] Filtered air would then exit the air cleaner **600** at an opposite end **631** through outlet **615**. In FIG. **34** it can be seen that outlet **615** is provided in section **608**, along with a pressure indicator **635**.

[0253] Attention is now directed to FIG. **36**, in which air cleaner **600** is depicted in exploded, perspective view. In FIG. **36**, the following internally received componentry can be viewed: primary filter element **640**, safety element **641** and filter element receiving cassette **642**.

[0254] Attention is first directed to safety element **641**. In general safety element **641** is similar to safety element **45**, FIG. **24**, except as follows. In particular projection **645** is directed downwardly. It is noted that for the particular embodiment shown in FIG. **36**, outlet section **608** includes recess **608b**, so that projection **645** could be positioned therein, during a step of securing safety element **641** in position, by grasping handle **646**. Of course safety element **641** could be oriented in the opposite rotational mounting position, with projection **645** extending into receiver **608a**. By having two receivers **608a**, **608b**, no matter how section **608** is rotationally mounted, projection **645** can be extended therein, whether directed downwardly or upwardly.

[0255] Filter cartridge **640**, depicted in side elevational view in FIG. **39**, cross-sectional view in FIG. **40** and perspective view in FIG. **41** generally comprises a media pack **650**, in this instance a coiled z-filter media pack. The coiled z-filter media pack **650**, in the example shown, is generally oval cross-section, in this instance racetrack, with opposite curved ends (FIG. **41**) **650a**, **650b** and opposite sides **650c**, **650d**. The sides **650c**, **650d** can be straight and parallel, or can have slight curvature and be opposite one another.

[0256] The filter cartridge **640** further includes a seal arrangement **653**, in this instance oriented to form an outside radial seal. In FIG. **40** it can be seen that the seal arrangement **653** generally comprises a support **655** having seal material **656** thereon. This general approach was described above, in connection with FIGS. **19-21**.

[0257] Referring to FIG. **41**, it can be seen the support **655** includes grid work **656** extending there across.

[0258] Although alternatives are possible, filter cartridge **650** with features as described in connection with FIGS. **39-41**, and previously herein, will be convenient for arrangements according to the present disclosure.

[0259] Referring again to FIG. **36**, cassette **642** is sized to receive filter cartridge **640** therein, with seal arrangement **653** projecting therefrom, during use. This combination of the two components (i.e., cassette **642** and filter **640**), is shown in

FIGS. **45** and **46**. In FIG. **45** the perspective view depicts the air flow outlet end; and, in FIG. **46** the perspective view depicts the air inflow end.

[0260] Referring to FIG. **36**, in this instance the cassette **642** has, adjacent air flow inlet end **660**: grid work **661** extending across opening **662**; and, a plurality of apertures **663**, through a side wall of the cassette. These apertures **663** facilitate manipulation of the cassette, in some applications.

[0261] Referring to FIG. **43**, preferably apertures **663** are located in an end region **664** of cassette **642** adjacent inlet end **660**. Region **664** is preferably a region of smaller inside size, forming an internal shelf **664a**, FIG. **43**, for engagement with the media pack, analogously to region **121**, FIG. **7**.

[0262] Referring to FIG. **44**, preferably apertures **663** are provided in lines on opposite sides **642a**, **642b** of cartridge **642**. In this instance, opposite ends of the lines curve a little, over the opposite curved sides.

[0263] It is noted that the cassette **642** also includes handle arrangement **665** thereon, similar to arrangements previously described herein. Further, cover **606** includes a receiver **666** therein, to accommodate handle **665**, again in accord with previous descriptions.

[0264] Referring to FIG. **36**, at end **670**, opposite end **660**, cassette **642** includes a rim **671** having two central sections therein, a first indicated at **673**, and second not being viewable in FIG. **36** but being located as a mirror image at an opposite portion of rim **671**. Section **673** is a somewhat flexible tab separated from a remainder of rim **671** by sections or divider **674**, **675**.

[0265] In FIG. **43**, cassette **642** is depicted in cross-section, the opposite side being a mirror image. In FIG. **43**, tab **673** is viewable having teeth **678** thereon. The teeth **678** are preferably barb shaped, with a taper to a narrow point toward edge **679**.

[0266] Referring to FIG. **36**, in use when cartridge **640** is pushed into an interior of cassette **642** through end **670**, when seal arrangement **653** is countered, teeth **678** will dig into or grab a portion of the seal arrangement **653**, securing the cartridge **640** and cassette **642** together.

[0267] Generally the barb size will be selected so as to permit disengagement under hand pressure.

[0268] For the particular cassette **642** depicted, FIG. **44**, multiple rows, in this instance four rows of barbs or teeth are provided, in each side of the cassette. Alternative numbers can be used.

[0269] The teeth or barbs are preferably located to engage a portion of the sealing material on the media pack not involved in sealing against the air cleaner housing, in particular a portion of sealing material which overlaps the media pack. The material at this location is preferably a polymeric material which is sufficiently soft for the barbs to dig in and grab sufficiently. Polyurethane materials of the type described above for the seal region, are examples of materials appropriate for this.

[0270] As a twisting force is placed on the cassette, to manipulate the seal arrangement on the media pack into and out of sealing with the housing, the teeth tend to dig into or grab at the seal material, facilitating engagement and manipulation of the media pack. On the other hand, when twisting is stopped, the teeth are generally sized so as not to dig into the seal material as far as to inhibit manual separation. The teeth are preferably shaped and sized, so as not to irreparably damage the seal material where the engagement occurs. Preferred seal materials of the type described herein, along with

tooth arrangements of the type shown and of the relative size shown, are examples of appropriate arrangements.

[0271] The preferred teeth **678** depicted are configured and oriented as one-way barbs. By the term “one-way barbs” in this context, it is meant that the teeth tend to dig into a portion of the seal arrangement **653** (not covering a portion which seals to the housing) when pulled in one direction, but tend to release when pushed or pulled in the other. Teeth **678** are preferably oriented so that they will tend to dig in, when the seal arrangement **653** is pulled out of sealing engagement with the air cleaner housing. This will facilitate removal of the cartridge **640** out of sealing with the housing, as desired. At least one toothed row is useable, preferably at least three rows are used. The preferred points of the teeth have one side generally perpendicular to a central axis of the cassette, and another side at an oblique angle to this axis.

[0272] Release of the cartridge **640** from the cassette **642**, is straight forward when the one-way barb arrangement is used for the teeth **678**. Hand pressure is all that is needed.

[0273] The apertures **663** facilitate carrying of the assembly resulting from a combination of cassette **642** and cartridge **640**. However the apertures **663** also facilitate operation in a different mode. In particular, in some alternate embodiments, section **507** may be removable, to provide for service access to an interior of the air cleaner, as opposed to the use of a service access cover **606**. In such an arrangement, the cartridge would be loaded through an end load as opposed to a side load. With such an arrangement, the apertures **663** facilitate pulling the cassette **642** and cartridge **640** out of sealing engagement within the assembly.

[0274] In FIG. **44**, a different cross-section of cassette **642** is depicted. Barb-shaped teeth **678** in rim section **671** can be viewed on opposite sides **680**, **681** of the cassette **642**.

[0275] Referring to FIG. **36**, it is noted that for the particular arrangement depicted, an internal cam or ramp **690** is provided in base **605**, so that when cassette **642** is pushed in through an opening (when access cover **606**, FIG. **31**, is removed) the cassette **642** is biased to push seal arrangement **653** into a sealing engagement, in this instance into radial seal engagement, with a sealing surface in the housing **601**. Such a biasing arrangement was previously described herein.

[0276] Still referring to FIG. **36**, cover **606** includes opposite flanges **692**, **693**. Between flange **692** and central portion **695** of cover **606**, is provided indent **696**, which helps retain the cassette **642** and cartridge **640** in an appropriate orientation, from backing out of seal, as previously discussed.

[0277] Attention is now directed to FIG. **47**, in which air cleaner assembly **700** is depicted. Air cleaner assembly **700** is generally analogous to air cleaner **600**, except central section **705** and access cover **706** are dimensionally, axially, longer in dimension between locations X and Y. This allows for acceptance therein of a filter cartridge having a (relatively) longer length, for some applications. It is noted that the inlet section **707** and outlet section **708** may be similar to sections **607** and **608** respectively.

[0278] In FIG. **48**, air cleaner **700** is depicted in exploded view. The larger (longer) filter cartridge **720** is readily viewable, as is a larger cassette **721**, to accommodate the cartridge **720**.

[0279] Attention is now directed to FIG. **49**. In FIG. **49** air cleaner **800** is depicted in exploded view. The air cleaner **800** comprises base **805**, access cover **806**, inlet section **807** and outlet section **808**. The base **805** may be analogous to base **605**; and, the access cover **806** analogous to access cover **606**.

The particular air cleaner **800** depicted, however, is configured to utilization with a filter cartridge **820** without the use of a cassette. It is also configured to be used without a pre-cleaner. Thus, inlet section **807** comprises an air flow inlet **825**, but no air separation tubes. Further, air cleaner **800** is configured to be used without a safety element.

[0280] An air cleaner such as air cleaner **800** may be desirable for certain over-the-road applications, in which high dust volumes are not expected to be encountered.

[0281] Still referring to FIG. **49**, cartridge **820** comprises a z-filter media pack **821** as previously described, with seal arrangement **823** also as previously described thereon. At inlet end **825** is mounted preformed ring **826**, with tabs **827** thereon extending over a portion of flow face **825**. Preforming ring **826** is positioned to engage cam or ramp **830**, FIG. **50**, to bias cartridge **820** into sealing engagement, during installation when access cover **806** is removed. In FIG. **50**, air cleaner **800** is depicted in cross-section, so that this engagement will be understood. It is noted that projection **835** in access cover **806** helps prevent cartridge **820** from backing out of sealing. It is also noted that receiver **836** in cover **806** is not used in this application, however, its configuration allows for a modular assembly using components also appropriate for arrangements having a pre-cleaner.

[0282] It is noted that sections **807**, **808** can be preformed, and secured to central section **805** if desired, and can be provided with symmetry allowing for more than one mounting orientation.

[0283] Referring to FIG. **50**, it is noted that inlet section **807** includes mounting bracket **807a**, **807b** thereon. Further, outlet **808** includes mounting brackets **808a**, **808b**. Air cleaner **800** can be mounted on a vehicle or other equipment system, through the brackets (**807a**, **807b**, **808a**, **808b**) on the inlet and outlet sections **807**, **808**; or, it could be mounted in place by the U-shaped mounting arrangement **870** on central section **805**. Typically one of these two options will be used, but not both, for mounting. In some arrangements, the mounting brackets (**807a**, **807b**, **808a**, **808b**) can be left off. In others, the U-shaped mounting arrangement **870** can be left off.

[0284] It is noted that brackets similar to the mounting brackets on inlet section **807** and outlet section **808** can be used in other air cleaner arrangements described and depicted herein.

[0285] The following dimensions are meant to be indicative of example arrangements that can be constructed according to the presently described principles. A variety of sizes of course can be used. For many applications a typical obround media pack would have a flute length of at least 140 mm, for example 140-280 mm. For many such applications, the longer sectioned dimension of the obround media pack would be typically at least about 300 mm, for example 300-350 mm, with a shorter dimension being at least about 180 mm, for example 180-220 mm. The aspect ratio (longer cross-sectional length over shorter cross-sectional length) would typically be at least 1.4.

[0286] The dimensions of the housing components and cassette components, would be as appropriate for managing such media packs.

[0287] The size of the media pack, and overall size of the system, will generally be chosen based on the need of the air cleaner for managing the vehicle or equipment operational needs. The principles described herein can be used with air cleaners of a variety of sizes, including, for example, ones constructed for operation with equipment having an expected

air flow range of up to about 1,100 cu. ft/min (about 31 cubic meters/min.). In general, air cleaner systems operated with a vacuum scavenger, as opposed to simply a dust drop tube, for any given size, allows for higher air flow demands to be accommodated.

[0288] In general, two approaches to managing larger air flow sizes are provided: lengthening the arrangement with a longer media pack; and, increasing the overall perimeter size (media pack cross-sectional size). In some instances, both can be used.

[0289] B. The Example of Filter Cartridge and Air Cleaner of FIGS. 51-62

[0290] The reference numeral 1000, FIGS. 54-61, depict an air cleaner assembly embodying any of the principles described previously above. The air cleaner 1000 comprises housing 1001. Internally received within the housing 1001 includes filter cartridge 1002 (FIGS. 51-53 and 55) and a safety filter 1003.

[0291] Housing 1001 generally comprises a main central body 1005, an access cover 1004, inlet section 1006, and outlet section 1007. The inlet section 1006 comprises a pre-cleaner section 1008, generally as described above in connection with FIG. 1 and related descriptions. At 1009, a dust ejector or drop tube for the pre-cleaner section 1008 is provided. Typically, the dust ejector 1009 would be provided with a dust ejector valve, as previously described, or it would be attached to a scavenge tube.

[0292] Outlet section 1007 includes a non-centrally disposed outlet aperture 1010 (FIG. 7), analogous to those described above. The safety filter 1003 can be viewed through the outlet aperture 1010.

[0293] Preferably, a modular construction is used for housing 1001. Thus, inlet section 1006 can be mounted in either of two rotational orientations. Also, outlet section 1007 can be mounted in either of two rotational positions, typically permanently through heat staking, welding, or other approaches.

[0294] The access cover 1004 is secured in place by releasable latches 1011 on the body 1005. A variety of latch arrangements can be used, with over-center wire latches being shown as an example.

[0295] In typical operation, air to be filtered will enter inlet section 1006 in the pre-cleaner section 1008. It can be seen in FIG. 55 that pre-cleaner section 1008 has a plurality of centrifugal separators or cyclone separators 1012. Filtered air would then exit the air cleaner 1000 at an opposite end 1013 (FIG. 55) through outlet 1007, specifically through aperture 1010.

[0296] Attention is again directed to FIG. 55, in which the air cleaner 1000 is depicted in cross-sectional view. In FIG. 55, the following internally received componentry can be viewed: primary filter cartridge 1002 and safety filter element 1003.

[0297] Attention is first directed to safety filter element 1003. In general, safety element 1003 is similar to safety element 641 (FIG. 36) and safety element 45 (FIG. 24).

[0298] The filter cartridge 1002 can be viewed in FIGS. 51-53. The filter cartridge 1002 generally comprises a media pack 1014, in this instance, a coiled Z-filter media pack. The coiled Z-filter media pack 1014, in the example shown, is generally oval cross-section, in this instance racetrack, with opposite curved ends 1015, 1016 and opposite sides 1017, 1018. The sides 1017, 1018 can be straight and parallel, or can have slight curvature and be opposite one another.

[0299] The filter cartridge 1002 further includes a seal arrangement 1019, in this instance, oriented to form an outside radial seal 1020 (FIG. 55). In FIG. 53, it can be seen that the seal arrangement 1019 generally comprises a support 1021 having seal material 1022 thereon. This general approach was described above, in connection with FIGS. 19-21.

[0300] In FIGS. 51 and 52, it can be seen that the support 1021 includes gridwork 1023 extending thereacross. The gridwork 1023 provides some advantage in preventing telescoping of the media pack 1014 and further support to the overall filter cartridge 1002. In addition, the gridwork 1023 is eye catching and attractive. For Donaldson Company, the assignee, this particular gridwork shown in FIGS. 51 and 52 is also distinctive to Donaldson Company.

[0301] Still in reference to FIGS. 51-53, the filter cartridge 1002 includes a cassette or band 1024 preferably permanently mounted as part of the filter cartridge 1002. The band 1024 has a function similar to the cassette 642, described above. In the example of the element shown in FIG. 36, the cassette 642 was removable from the filter cartridge 640. In this instance, the band 1024 is preferred to be permanently mounted as part of the filter cartridge 1002. By "permanently mounted", it is meant that the band 1024 cannot be removed from the rest of the filter cartridge 1002 without destroying the rest of the filter cartridge 1002. The band 1024 circumscribes and is adjacent to one end of the filter cartridge 1002, in this instance, the inlet end 1025. The band 1024 includes a projection arrangement embodied as handle 1026, similar to arrangements previously described herein. Further, the cover 1004 includes a receiver 1027 to accommodate the handle 1026, again in accord with previous descriptions. Because the handle 1026 is located at an end of the filter cartridge 1002 remote from the end with the seal arrangement 1019, the region of the filter cartridge 1002 between the seal arrangement 1019 and the handle 1026 is a lever arm 1031 to help remove the seal arrangement 1019 from engagement when servicing the air cleaner. The lever arm 1031 in this embodiment is longer than the lever arm in previous embodiments. The longer lever arm 1031 is helpful in removal of the filter cartridge 1002 from the air cleaner 1000.

[0302] As can be seen in FIGS. 51 and 52, the band 1024 includes at least two regions of different widths. The first width 1028 is the region of the band 1024 that defines and accommodates the handle 1026. The second region of width 1029 is the section of the band 1024 that does not accommodate the handle 1026. As can be seen in FIGS. 51 and 52, the handle 1026 is located on the curved end 1016. The opposite curved end 1016 has the region of second width 1029. The sides 1017, 1018 have both the first width 1028 and second width 1029 as part of them.

[0303] In FIG. 62, the band 1024 is shown to include a grid 1030 to provide further support for the cartridge 1002.

[0304] The filter cartridge 1002 is loaded and unloaded into the housing 1001 by removing the access cover 1004 and then operably loading the filter cartridge 1002 therein, analogous to the description of previous arrangements.

[0305] In operation, air to be filtered enters the air cleaner 1000 through the pre-cleaner 1008, then through the filter cartridge 1002, then through the safety filter 1003, and then exits the air cleaner 1000 through the aperture 1010 in the outlet section 1007.



What is claimed:

**1.** An air cleaner assembly comprising:

(a) a housing including: an inlet section; a central section; and an outlet section;

(i) the inlet section comprising a precleaner arrangement including a plurality of dust separator tubes; and,

(ii) the housing being openable for installation and removal of an internally received filter cartridge; and,

(b) a first air filter cartridge removably positioned within the housing; the first air filter cartridge including:

(i) a media pack having:

(A) an inlet flow end and an opposite outlet flow end; and,

(B) media comprising a coiled arrangement including coils of fluted media secured to facing media and configured so that air entering the inlet flow end cannot exit the outlet flow end without filtering passage through the media;

(C) the media pack having a non-circular perimeter;

(ii) a housing seal arrangement including a seal portion removably sealed to the housing; and,

(iii) a preform arrangement secured to the media pack and including: a portion surrounding the media pack; and, a handle arrangement including a stationary portion under which a portion of a person's fingers can fit, between a portion of the handle arrangement and the media;

(A) the stationary portion under which a portion of a person's fingers can fit being closer to the inlet flow end of the media pack than to the outlet flow end of the media pack; and,

(B) the first air filter cartridge including no preform portion at a location surrounded by coils of the media.

**2.** An air cleaner assembly according to claim 1 wherein:

(a) the housing includes a side access cover thereon.

**3.** An air cleaner assembly according to claim 1 wherein:

(a) the housing seal arrangement includes a radially directed housing seal portion.

**4.** An air cleaner assembly according to claim 1 wherein:

(a) the housing seal arrangement includes a portion molded to the media.

**5.** An air cleaner assembly according to claim 1 wherein:

(a) the preform arrangement includes a seal support; and,

(b) the seal portion is molded-in-place on the seal support and includes a portion molded to, and surrounding, the media pack.

**6.** An air cleaner assembly according to claim 1 wherein:

(a) the preform arrangement includes a first preform adjacent the inlet flow end of the media pack;

(b) the preform arrangement includes a second preform adjacent the outlet flow end of the media pack; and,

(c) the preform arrangement includes: a portion extending across the inlet flow end of the media pack; and, a portion extending across the outlet flow end of the media pack.

**7.** An air cleaner assembly according to claim 6 including:

(a) a safety filter element, separate from the first air filter cartridge, positioned within the housing.

**8.** An air cleaner assembly according to claim 7 wherein:

(a) the safety filter element includes: an outer frame having two opposite curved ends, and two, opposite, sides; pleated media positioned surrounded by the frame; and, a handle member projecting toward the inlet section.

**9.** An air cleaner assembly according to claim 1 including:

(a) a safety filter element, separate from the first air filter cartridge, positioned within the housing.

**10.** An air cleaner assembly according to claim 9 wherein:

(a) the safety filter element includes: an outer frame having two opposite curved ends, and two, opposite, sides; pleated media positioned surrounded by the frame; and, a handle member projecting toward the inlet section.

**11.** An air cleaner filter cartridge arrangement installable in an air cleaner housing during use; the air cleaner filter cartridge arrangement comprising:

(a) a media pack having:

(i) an inlet flow end and an opposite outlet flow end; and,

(ii) media comprising a coiled arrangement including coils of fluted media secured to facing media and configured so that air entering the inlet flow end cannot exit the outlet flow end without filtering passage through the media;

(iii) the media pack having a non-circular perimeter;

(b) a preform arrangement including: a portion surrounding the media pack; and, a handle arrangement including a stationary portion under which a portion of a person's fingers can fit, between a portion of the handle arrangement and the media;

(i) the stationary portion under which a portion of a person's fingers can fit being closer to the inlet flow end of the media pack than to the outlet flow end of the media pack and projecting further away from the media pack than adjacent portions of the preform arrangement; and,

(ii) the preform arrangement including a seal support; and,

(c) a housing seal arrangement including: a seal portion molded-in-place on the media; and, a portion molded-in-place on the seal support;

(d) the cartridge including no preform portion at a location surrounded by coils of the media.

**12.** An air cleaner filter cartridge arrangement according to claim 11 wherein:

(a) the housing seal arrangement comprises an outwardly directed radial seal.

**13.** An air cleaner filter cartridge arrangement according to claim 11 wherein:

(a) the stationary portion, of the handle arrangement, under which a portion of a person's fingers can fit is oriented in overlap with a side of the media pack.

**14.** An air cleaner filter cartridge arrangement according to claim 11 including:

(a) a preform portion extending across the outlet flow end of the media pack.

**15.** An air cleaner filter cartridge arrangement according to claim 14 including:

(a) a preform portion extending across the inlet flow end of the media pack.

**16.** An air cleaner filter cartridge arrangement according to claim 11 wherein:

(a) the media has an oval perimeter.

**17.** An air cleaner filter cartridge arrangement according to claim 16 wherein:

(a) the media has a perimeter shape with two opposite straight sides joined by two opposite curved ends.

**18.** An air cleaner filter cartridge arrangement according to claim 17 wherein:

(a) the housing seal portion has an oval perimeter shape.

19. An air cleaner filter cartridge arrangement according to claim 11 wherein:  
(a) the housing seal portion has an oval perimeter shape.

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