

ELECTROCHEMICAL CELL SEPARATOR

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This patent application claims priority from U.S. Provisional Application Ser. No. 62/687,509, filed June 20, 2018, which is incorporated herein by reference in its entirety.

BACKGROUND

[0002] Alkaline electrochemical cells are commercially available in cell sizes commonly known as LR6 (AA), LR03 (AAA), LR14 (C) and LR20 (D). The cells have a cylindrical shape that must comply with the dimensional standards that are set by organizations such as the International Electrotechnical Commission. The electrochemical cells are utilized by consumers to power a wide range of electrical devices, for example, clocks, radios, toys, electronic games, film cameras generally including a flashbulb unit, as well as digital cameras.

[0003] Battery manufacturers have made great strides to improve the capacity of the cells to improve the length of time that electrical devices can be powered, while at the same time complying with the applicable dimensional standards for each cell size. As the shape and size of the batteries are often fixed, battery manufacturers must modify cell characteristics to provide increased performance. For example, battery manufacturers generally seek to maximize the total amount of active material, including both the positive electrode (cathode) material and negative electrode (anode) material, while still providing reliable cell constructions that are not prone to undesirable internal cell short circuits.

[0004] Due to consumers' increasing need for high-capacity electrochemical cells offering maximal run-time, there is a constant need for improved electrochemical cell constructions offering improved discharge performance.

BRIEF SUMMARY

[0005] To provide increased electrochemical cell discharge performance, various embodiments are directed to electrochemical cell constructions comprising a hollow container housing having a tubular cathode ring surrounding an interior of the hollow

container and having an anode positioned therein. The anode and cathode are separated by a continuous separator sheet folded to form a two-ply separator barrier between the cathode and anode. The separator encompasses a single elongated separator sheet folded perpendicularly to a longitudinal axis of the paper to form two sheet ends on opposite sides of the folds. Each of the sheet ends are then rolled into concentric cylinders having central axes parallel with a longitudinal axis of the elongated separator sheet, with opposing edges of each sheet end (parallel to the longitudinal axis of the sheet) meeting without overlap. The resulting tubular separator includes a two-ply cylindrical sidewall and single-ply bottom wall (formed from the sheet material extending between the sheet ends).

[0006] Certain embodiments are directed to a method of manufacturing an electrochemical cell. In certain embodiments, the method comprises: providing a cylindrical electrochemical cell can having an active material ring disposed proximate an interior surface of the cell can; forming a cylindrical separator comprising a continuous separator sheet defining a closed bottom end and a two-layer cylindrical sidewall; inserting the cylindrical separator end into the interior of the active material ring; disposing a second active material within an interior of the separator; and sealing the electrochemical cell can.

[0007] Moreover, forming the cylindrical separator may comprise forming a seam within each of the two layers of the cylindrical sidewall, wherein the seams are aligned with a diameter of the cylindrical sidewall. Forming the cylindrical separator may further comprise forming a first end of the continuous separator sheet into a first cylindrical layer; and forming a second end of the continuous separator sheet, opposite from the first end, into a second cylindrical layer around an exterior of first cylindrical layer.

[0008] In certain embodiments, forming the first end of the continuous separator sheet into a first cylindrical layer comprises rolling opposite longitudinal edges of the first end of the continuous separator sheet to meet at a first seam; and forming the second end of the continuous separator sheet into a second cylindrical layer comprises rolling opposite longitudinal edges of the second end of the continuous separator sheet to meet at a second seam. Moreover, the method may further comprise positioning a separator reinforcement layer adjacent the closed bottom end of the cylindrical separator. Positioning a separator reinforcement layer adjacent the closed bottom end may comprise positioning a reinforcing cup adjacent a bottom exterior surface of the closed bottom end. Positioning a separator

reinforcement layer adjacent the closed bottom end of certain embodiments comprises positioning a reinforcing pad adjacent a bottom exterior surface of the closed bottom end.

[0009] Various embodiments are directed to an electrochemical cell comprising: a container; a ring-shaped cathode disposed within the container wherein the cathode includes an exterior surface in contact with the container and an interior surface surrounding a hollow interior; an anode disposed within the hollow interior of the cathode; and a separator positioned between the cathode and the anode, wherein the separator comprises a continuous separator sheet defining a closed bottom end and a two-layer cylindrical sidewall.

[0010] Moreover, the cylindrical separator may comprise a seam within each of the two layers of the cylindrical sidewall, wherein the seams are aligned with a diameter of the cylindrical sidewall. In various embodiments, a first layer of the cylindrical separator is formed from a first end a continuous separator sheet; and a second layer of the cylindrical separator is formed from a second end of the continuous separator sheet, rolled around an exterior surface of the first layer of the cylindrical separator sheet. The first end of the continuous separator sheet may be rolled into a first cylindrical layer such that opposing longitudinal edges of the first end of the continuous separator sheet meet at a first seam; and the second end of the continuous separator sheet is rolled around the first cylindrical layer such that opposing longitudinal edges of the second end of the continuous separator sheet meet at a second seam. Moreover, the continuous separator sheet may define lateral slits perpendicular to a longitudinal axis of the continuous separator sheet, wherein the lateral slits separate the first end and the second end of the continuous separator sheet. In certain embodiments, the first end is longer than the second end of the continuous separator sheet. Moreover, the length of each of the first end and the second end may be greater than the height of the ring-shaped cathode. In certain embodiments, the length of the first end is longer than the combination of the height of the ring-shaped cathode and a diameter of the hollow interior of the ring-shaped cathode.

[0011] In various embodiments, the electrochemical cell further comprises a separator reinforcement layer positioned adjacent the closed bottom end of the cylindrical separator. The separator reinforcement layer may comprise one of a reinforcing cup or a reinforcing pad. Moreover, the separator sheet may comprise a 3mil separator paper.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0012] Reference will now be made to the accompanying drawings, which are not necessarily drawn to scale, and wherein:

[0013] Figures 1A-1B illustrate the formation of a convolute separator as known in the art;

[0014] Figures 2A-2C illustrate the formation of a cross-strip separator as known in the art;

[0015] Figure 3 is a cross-sectional view of a bobbin-style electrochemical cell according to one embodiment;

[0016] Figures 4A-4D illustrate steps for forming a separator according to one embodiment; and

[0017] Figure 5 is an exploded view of a bobbin-style electrochemical cell according to one embodiment.

DETAILED DESCRIPTION

[0018] The present disclosure more fully describes various embodiments with reference to the accompanying drawings. It should be understood that some, but not all embodiments are shown and described herein. Indeed, the embodiments may take many different forms, and accordingly this disclosure should not be construed as limited to the embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will satisfy applicable legal requirements. Like numbers refer to like elements throughout.

[0019] The inventors have found that increasing the thickness of an electrochemical cell separator positioned between active materials of an electrochemical cell beyond a thickness necessary to avoid short circuits through the separator can detrimentally increase the internal electrochemical cell resistance, thereby decreasing the electrochemical cell performance. This generally negative performance characteristic of overly thick separators occurs even when only a portion of a separator positioned within an electrochemical cell is too thick, which may result from overlapping portions of a separator sheet to avoid potentially problematic thin portions of the separator that may lead to short circuits. The problem of including overly thick separator portions is thus common in both convolute

separator **122** configurations (embodied as a rolled separator sheet **133** having a single overlapping portion where opposite end portions of the separator sheet **133** partially overlap, as shown in Figures 1A-1B) and cross-strip separator **222** configurations (embodied as two perpendicular separator sheets **233a**, **233b** overlapping at a central portion of the sheets **233a**, **233b** and each having end portions folded upward to collectively form a cylindrical separator **222**, as shown in Figures 2A-2C). The inventors found that the problem of increased internal cell resistance was more prominent with the use of cross-strip separators, because the number of overlapping portions (and therefore the overall percentage of the separator characterized by overly thick separator portions) is greater than that of convolute separators. Moreover, because cross-strip separators **222** utilize two separate components (e.g., two separate separator material strips **233a**, **233b**), the difficulty of manufacturing the separator is also increased.

[0020] The inventors have found that creating a cylindrical separator from a single, continuous separator sheet such that the continuous separator sheet maintains continuity (e.g., remains connected) among the sidewall layers and closed bottom end, by rolling a first end of the separator sheet into a first separator layer, and then folding the second end of the separator sheet to be tangent to the first separator layer and rolling the second end of the separator around the first separator layer to form a second separator layer, the overall percentage of the separator characterized by overly thick overlapping portions may be minimized. In certain embodiments, the first end and the second end of the separator sheet may separately be rolled such that portions of opposing longitudinal edges of the separator sheet meet without overlapping to form each of the first and second separator layers. The resulting seams of the cylindrical separator are positioned on opposite sides of the separator (e.g., 180 degrees apart from one another and along a common diameter of the separator) to minimize a risk of aligning the seams to create a potential short circuit between the separated active materials of the electrochemical cell.

Electrochemical Cell

[0021] Referring now to Figure 3, a bobbin-style electrochemical cell **10** is shown according to one embodiment of the present invention. In the illustrated embodiment of Figure 3, the electrochemical cell is an alkaline cell having a manganese dioxide cathode

active material and a zinc anode active material. However, it should be understood that the electrochemical cell may have any of a number of active material chemistries.

[0022] The alkaline electrochemical cell **10** shown in the exemplary embodiment and described herein is a cylindrical primary (non-rechargeable) battery cell of size LR6 (AA). However, it should be appreciated that the teachings of the present invention may be applicable to other alkaline electrochemical cells of other shapes and sizes, including LR03 (AAA), LR14 (C) and LR20 (D) size cylindrical battery cells, as examples. Moreover, although the following specifically discusses cylindrical electrochemical cells, it should be understood that various embodiments are applicable for other cell shapes, such as rectangular electrochemical cells, and/or the like. Additionally, the electrochemical cell **10** may be employed as a single cell battery or may be employed in a multiple cell battery.

[0023] The electrochemical cell **10** comprises a cylindrical container **12** that may be embodied as a metallic (e.g., steel) can, having a closed end **14**, an open opposite end **16**, and a cylindrical side wall extending between the opposite ends. The cylindrical container **12** is made of a suitable electrically conductive metal that may be formed into a desired shape and is adapted to seal the internal contents within the cell **10**. In the embodiment shown, the cylindrical container **12** also functions as the cathode current collector, and therefore exhibits good electrical conductivity. In one embodiment, the cylindrical container **12** may be plated with nickel and cobalt, such as may be achieved in an annealing process. The interior surface of the cylindrical container **12** may be coated with a graphite, if desired. In one example of an LR6 size cell, the cylindrical container **12** has a wall thickness of about 0.010 inch (10 mils or 0.025 cm) and the cylindrical wall has an outside diameter of about 0.548 inch (1.392 cm).

[0024] A positive contact terminal **30** comprising a plated steel or other conductive metal material is welded or otherwise secured onto the closed end **14** of the cylindrical container **12** in the illustrated embodiment of Figure 3. However, in certain embodiments, the positive contact terminal **30** may be integrally formed as a portion of the cylindrical container **12**. The positive contact terminal **30** has a protruding nubbin (i.e., protrusion), at its center which serves as the positive contact terminal of the cell **10**. Assembled onto the opposite open end **16** of the cylindrical container **12** is a collector and seal assembly made up of an anode current collector **34** (e.g., nail), a polymeric (e.g., nylon) seal **26** and a

negative contact terminal **32**. The open end **16** of container **12** is crimped onto the seal **26** which abuts bead **28** to seal closed the open end **16** of container **12**. The negative contact terminal **32** forms a negative contact terminal of the cell **10**. Positive and negative contact terminals **30** and **32** are made of electrically conductive metal and serve as the respective positive and negative electrical terminals. Additionally, a jacket **18** may be formed about the exterior surface of the cylindrical container **12**, and may include an adhesive layer, such as a metalized, plastic film layer.

[0025] Disposed within the sealed volume of cylindrical container **12** is a positive electrode, referred to as the cathode ring **20**, generally positioned adjacent the interior surface of the cylindrical container **12**. The cathode has an exterior shape corresponding to the shape of the container (e.g., the cathode positioned within cylindrical container **12** has a generally cylindrical shape) with an interior surface defining an interior cavity therein. For example, the interior cavity may have a generally cylindrical shape having an inside diameter ID. However, it should be understood that the interior cavity may have any of a variety of shapes. As other examples, the interior cavity may have a star-shape, an elliptical shape, a “gear” shape (having a plurality of interconnected cavities extending around a central hub, thus providing the general shape of a gear), and/or the like. A separator **22** is disposed in the interior cavity and contacts the interior surface of the cathode ring **20**. A negative electrode, referred to as the anode **24**, is disposed within the interior cavity inside the separator **22**. Additionally, an alkaline electrolyte solution, which can include water, is disposed within the sealed volume of the container **12** in contact with both the anode **24** and the cathode ring **20**.

[0026] As discussed herein, the illustrated cathode ring **20** of Figure 3 includes manganese dioxide (MnO_2) as the electrochemically active material of the positive electrode. Cathode ring **20** is generally formed of a mixture of manganese dioxide, graphite, barium sulfate, and aqueous alkaline electrolyte solution. According to an impact molding embodiment, the cathode **20** may be formed by disposing a quantity of the cathode mixture into the open ended container **12** and, with use of an impact molding ram, molding the mixture into a solid tubular (e.g., cylindrical) configuration that defines a cavity generally concentric with the side wall of the container **12**. Alternately, according to a ring molding embodiment, the cathode ring **20** may be formed by preforming a plurality of rings

(e.g., three or four rings) from the cathode mixture and then inserting the preformed rings into the container **12** to form the tubular shaped cathode ring **20**. In certain embodiments, the interior surface of the cathode ring **20** (whether formed via impact molding or ring molding) may have a generally circular cross-section, a generally elliptical cross-section, a generally “star”-shaped cross-section, and/or the like.

[0027] The anode **24**, also referred to herein as the negative electrode, may include a homogeneous mixture of an aqueous alkaline electrolyte, a zinc powder and a gelling agent, such as cross-linked polyacrylic acid. The zinc powder is the electrochemically active material of the anode **24**. The aqueous alkaline electrolyte may include an alkaline metal hydroxide, such as potassium hydroxide (KOH), sodium hydroxide or mixtures thereof. A gelling agent suitable for use in the anode **24** may include a cross-linked polyacrylic acid, such as Carbopol 940®, which is commercially available from Noveon, Inc., of Cleveland, Ohio. Examples of other gelling agents that may be suitable for use in the cell **10** may include carboxymethylcellulose, polyacrylamide and sodium polyacrylate. The zinc powder may include pure zinc or zinc alloy. Additional optional components of the anode **24** may include gassing inhibitors, organic or inorganic anti-corrosive agents, binders or surfactants that may be added to the ingredients listed above. Examples of suitable gassing inhibitors or anti-corrosive agents include indium salts (such as indium hydroxide), perfluoroalkyl ammonium salts, alkali metal sulfides, etc. Examples of suitable surfactants include polyethylene oxide, polyethylene, alkylethers, perfluoroalkyl compounds and the like. The anode **24** may be manufactured by combining the ingredients into a ribbon blender or drum mixer and then working the anode mixture into a wet slurry.

[0028] In addition to the aqueous alkaline electrolyte absorbed by the gelling agent during the anode manufacturing process, an additional quantity of aqueous solution containing a solution of potassium hydroxide and water, also referred to herein as free electrolyte, is added to the electrochemical cell **10** during the manufacturing process. The free electrolyte may be incorporated into the cell **10** by disposing it into the cavity defined by the cathode ring **20** after the separator **22** is inserted and may also be injected after the anode **24** is disposed into the cell. According to one embodiment, the aqueous solution contains approximately thirty-seven percent (37%) by weight KOH, and sixty-three percent (63%) deionized water.

[0029] In the bobbin-type zinc/manganese dioxide alkaline cell **10** shown and described herein, the separator **22** may be provided as a layered ion permeable, non-woven fibrous fabric which separates the cathode ring **20** from the anode **24**. The separator **22** maintains a physical dielectric separation of the cathode electrochemically active material (manganese dioxide) and the anode electrochemically active material (zinc) and allows for the transport of ions between the positive and negative electrode materials. Additionally, the separator **22** acts as a wicking medium for the aqueous electrolyte solution and as a collar that prevents fragmented portions of the anode **24** from contacting the top of the cathode ring **20**. Moreover, as shown and discussed herein, the separator **22** of certain embodiments comprises a continuous separator sheet folded to form a two-layer cylindrical sidewall and a closed bottom end, such that a first layer of the cylindrical sidewall is continuous with the closed bottom end (e.g., across a fold) and the second layer of the cylindrical sidewall is continuous with the closed bottom end (e.g., across a fold), such that the cylindrical separator **22** comprises a single, continuous piece of separator material.

[0030] The separator **22** comprises an ion permeable material having a high electrical resistance (i.e., low electrical conductivity), such as a thin nonwoven fabric. Depending in part on thickness and resistivity, the separator may be a single-ply or multi-ply (e.g., two-ply) construction to provide a desired porosity to achieve the desired electrical resistance and ion-permeability while maintaining a low overall volume within an electrochemical cell. In various embodiments, the separator material may have a 3 mil thickness, a 4 mil thickness, a 5 mil thickness, and/or the like, however it should be understood that other separator material thicknesses may be utilized. As mentioned above, because the overall volume of electrochemical cells is generally fixed, minimizing the overall volume of non-active materials (such as the separator) within an electrochemical cell provides additional volume within the cell that may be occupied by electrochemical materials such as those of the cathode and/or anode.

[0031] The fabric of the separator **22** may be embodied as a fiber paper comprising natural, artificial, and/or synthetic fibers. For example, the fiber paper may comprise a blend of synthetic and artificial fibers, a blend of synthetic fibers and natural materials (e.g., wood pulp), and/or the like. As a specific example, the fiber paper may comprise fibrillated cellulose fibers and synthetic fibers. In certain embodiments, the synthetic fibers

may comprise a thermoplastic material, such as polyvinyl alcohol fibers having a melting point of at least about 60°C, phenylboronic acid fibers (PBA fibers), and/or the like. In certain embodiments, the synthetic fibers may comprise first synthetic fibers that are soluble in water at a temperature of at least 60°C and second synthetic fibers that are insoluble in water. Moreover, the fiber paper may comprise solvent spun cellulose fibers subject to fibrillation in well-known refinement and digestion processes in paper manufacturing.

[0032] The combination of the cellulose fibers and the synthetic fibers provide a porous, nonwoven fabric that may be formed into a tubular shape before being inserted into an electrochemical cell **10**. Figures 2A-2D illustrate a process for forming the separator into a tubular shape according to one embodiment. As shown in Figure 4A, the separator material is initially provided as a continuous, elongated, planar fabric sheet **30**. The width of the fabric sheet (measured perpendicular to the central, longitudinal axis **35**, and parallel to the central, lateral axis **36**) is at least substantially equal to the circumference of the formed tubular separator **22**, which may be at least approximately equal to the circumference of the interior surface of the cathode ring **20**. In certain embodiments, the width of the fabric sheet **30** is greater than a desired circumference of the tubular separator **22** to provide an overlap in each formed layer of the separator **22**. The length of the sheet **30** (along the elongated axis of the sheet) is greater than twice the height of the formed separator **22**, to accommodate forming two separate plies of the formed separator **22** and a bottom surface of the separator **22**. As a specific example, a planar fabric sheet **30** for use in a LR6 electrochemical cell may have a length (measured parallel to the longitudinal axis **35**) of 3.882 inches, and a width (measured parallel to the lateral axis **36**) of 1.200 inches.

[0033] As shown in Figure 4A, the separator sheet **30** is continuous and defines two slits **34** extending perpendicular to the elongated axis **35** of the sheet **30**, from opposing side edges. The two slits **34** are at least substantially aligned relative to one another (e.g., along a single line), and are offset relative to the central lateral axis **36** of the separator sheet **30**. In certain embodiments, the slits **34** are offset relative to the central lateral axis **36** of the separator sheet by a distance at least substantially equal to the radius of the intended cylindrical separator **22**. For example, the slits **34** may be offset by a distance of 0.125 inches relative to the central lateral axis **36**. Once the cylindrical separator **22** is

formed, the slits **34** are aligned with a bottom edge of the cylindrical sidewalls of the separator **22**.

[0034] The slits **34** separate two opposing ends **32**, **33** of the separator sheet, wherein each end **32**, **33** extends between an end of the continuous, elongated separator sheet **30** to the slits **34**. Due to the offset of the slits **34** relative to the central lateral axis **36** of the sheet **30**, the opposing ends **32**, **33** are of different length, defining a long end **33** and a short end **32**. As shown in Figure 4B, one of the ends (e.g., the long end **33**) is formed into a cylinder by curling opposing side edges (edges parallel to the longitudinal axis **35** of the separator sheet **30**) relative to one another until the opposing side edges meet or overlap, while remaining continuous with the opposite end (e.g., the short end **32**) across a fold of the continuous separator sheet **30**. Thus, the end **33** is wrapped at least 360 degrees to form a complete cylinder having a central axis aligned with the longitudinal axis **35** of the continuous separator sheet **30**. In certain embodiments, the end **33** may be wrapped around a cylindrical separator insertion rod (not shown) having a diameter at least substantially equal to a desired diameter of the resulting cylindrical separator **22**. In such embodiments, an edge of a flat bottom end of the separator insertion rod may be positioned offset relative to the centerpoint of the separator sheet **30**. For example, an edge of the bottom end of the separator insertion rod may be offset by a distance at least substantially equal to the radius of the cylindrical separator **22**. In such embodiments, the slits **34** of the separator sheet are aligned with a bottom edge of the separator insertion rod once the separator **22** is formed into a complete cylinder (e.g., such that the slits **34** are at least substantially aligned with a tangent of the cylindrical separator insertion rod).

[0035] As shown in Figure 4C, the separator sheet **30** is folded parallel to the lateral axis **36** of the separator sheet **30** to form a bottom end of the resulting cylindrical separator **22** while maintaining continuity of the separator sheet **30**, and to position the unrolled end (e.g., the short end **32**) tangent to the rolled and now cylindrically-shaped end. This results in two at least substantially parallel folds – one fold at least substantially aligned with the slits **34** of the separator sheet **30**, and another fold positioned opposite the centerpoint of the sheet relative to the slits **34** (within the long end **33**). The two folds are offset relative to the central lateral axis **36** of the sheet **30** by an at least approximately equal distance (e.g., equal to the radius of the cylindrical separator **22**). The portion of the separator sheet

30 located between the two folds (e.g., aligned with the centerpoint of the separator sheet) forms the closed bottom end of the separator **22**. Portions of the separator sheet **30** between the two folds that are outside of the cylindrical shape of the separator **22** (at this point defined by the cylindrical shape of the rolled end) may be folded upward against the cylindrical sidewall of the separator **22** such that they ultimately become positioned between the plies of separator, folded downward under the closed bottom end of the separator **22**, or folded inward onto the top, internal surface of the closed bottom end. As yet another example, the slits may be configured such that no additional separator material is provided outside of the cylindrical sidewalls of the separator **22**.

[0036] Once the unrolled end is positioned tangent to the rolled end (e.g., the short end **32** is positioned against a surface of the cylindrically-formed long end **33**), the remaining planar end is curled around the outer surface of the previously rolled end to form an outer cylindrical layer of the separator **22** that is concentric with the inner cylindrical layer, while maintaining continuity with the closed bottom end of the separator **22** across a fold. Opposing edges (parallel to the longitudinal axis of the separator sheet) of the unrolled end are curled toward one another, around the outer surface of the previously formed cylinder until the opposing edges meet or overlap (thus extending at least 360 degrees around the formed cylinder), thereby forming a two-ply cylindrical separator **22** comprising a continuous separator sheet **30** as shown in Figure 4D.

[0037] The resulting cylindrical separator **22** defines two seams – a first seam **37** where opposing edges of the short end **32** meet or overlap and a second seam **38** where opposing edges of the long end **33** meet or overlap. These seams are positioned on opposite sides of the resulting cylindrical separator **22** (e.g., along a common diameter of the cylindrical separator **22** and on opposite sides of a central axis of the cylindrical separator **22**). In certain embodiments, the seams are at least substantially parallel with the central axis of the cylindrical separator **22**. Moreover, in embodiments in which the opposing side edges of each end abut one another to form respective cylinders, the resulting sidewalls of the cylindrical separator **22** have an at least substantially uniform, two-ply thickness around the perimeter of the cylindrical separator **22**.

[0038] In certain embodiments, the closed bottom end of the cylindrical separator **22** may be reinforced with an additional separator reinforcement layer **23**. The reinforcement

layer **23** may be embodied as an end cup having a closed bottom end and short sidewalls, or an end pad embodied as a circular and planar separator portion that may be aligned with the closed bottom end of the separator **22**. This reinforcement layer **23**, collectively with the closed bottom end of the separator **22** forms an at least two-layer closed bottom end of the separator **22** having a desired resistivity and a desired puncture resistance. In certain embodiments, the reinforcement layer **23** may be positioned external to the separator **22** (e.g., between the closed bottom end of the separator **22** and the closed end **14** of the cylindrical container **12**). However it should be understood that the reinforcement layer **23** may be positioned within the interior of the cylindrical container **22**, adjacent an inner surface of the closed bottom end. In certain embodiments, the reinforcement layer **23** and/or the one or more seams **37**, **38** may be heat sealed to desirably maintain a two-layer construction of the separator **22** during manufacture of the electrochemical cell.

[0039] Once inserted into the electrochemical cell, the resulting separator **22** defines an exterior surface surrounding the outside of the resulting separator **22**. The exterior of the sidewalls are in contact with an interior surface of the cathode, and the exterior bottom surface of the separator is in contact with a portion of the can.

[0040] In certain embodiments, one or more overlapping portions of the separator **22** sidewalls and/or bottom end are heat sealed to at least partially secure overlapping portions of the separator **22** relative to one another. For example portions of the separator **22** may be heat sealed as discussed in co-pending U.S. Appl. No. 15/805,718, filed on November 7, 2017, the contents of which are incorporated herein in their entirety. For example, a portion (e.g., a linear portion) of the separator **22** sidewalls extending between an open upper end of the separator **22** and a closed bottom end of the separator **22** may be heat sealed.

[0041] Method of Manufacturing an Electrochemical Cell

[0042] Figure 5 illustrates an exploded view of an electrochemical cell **10** schematically illustrating a manufacturing process for an electrochemical cell **10**. Manufacturing of an electrochemical cell **10** according to various embodiments begins by providing a cylindrical container **12** having an open top end and a closed bottom end. In certain embodiments, the closed bottom end may define a protrusion (e.g., in the form of a plate welded onto the closed bottom end or a protrusion integrally formed with the cylindrical

container **12** itself). Active materials are then added to the interior of the cylindrical container **12** through the open top end. Cathode material is first added to the cylindrical container **12** to form a cathode ring **20** adjacent the outer wall of the cylindrical container **12**. As noted above, the cathode material may be premolded into cathode rings, and one or more cathode rings may be added into the interior of the cylindrical container **12**. Alternatively, granular cathode material may be added to the interior of the cylindrical container **12**, and a molding ram may be inserted into the interior of the cylindrical container **12** to impact mold the cathode material into a continuous cathode ring **20**.

[0043] Once the cathode ring **20** is positioned within the interior of the cylindrical container **12**, the cathode ring **20** has an exterior surface adjacent the interior surface of the cylindrical container **12** wall and an interior surface defining an opening (e.g., a cylindrical opening) at least substantially within the center of the cylindrical container **12**. The separator **22** may then be placed within the opening within the interior of the cathode ring **22**. As noted above, the cylindrical separator **22** comprises a continuous, rectangular separator sheet **30** rolled such that a first end of the separator sheet **30** (e.g., a long end **33**) defines a first layer of the cylindrical separator sidewall and a second end of the separator sheet **30** (e.g., a short end **32**) is rolled around the first layer of the cylindrical separator sidewall to define a second layer of the cylindrical separator sidewall. The first end of the separator sheet **30** is longer than the second end of the separator sheet, and accordingly a portion of the first end adjacent the second end forms the closed bottom end of the cylindrical separator **22**. Figures 2A-2D illustrate steps for forming the cylindrical separator **22** according to one embodiment.

[0044] Moreover, the cylindrical separator **22** may be formed about a separator insertion rod having a cylindrical profile. Once the cylindrical separator **22** is formed about the separator insertion rod, the separator insertion rod may press the cylindrical separator **22** into the hollow interior of the cathode ring **20**, and the separator insertion rod may then be removed from the electrochemical cell, leaving the separator **22** behind.

[0045] In certain embodiments, the cylindrical separator **22** may be placed into the interior hollow opening of the cathode ring **20** with a reinforcement layer **23** to provide additional separator layers at the closed bottom end to avoid formation of short circuits through a single layer portion of the separator within the closed bottom end. The

reinforcement layer **23** may be positioned external to the cylindrical separator **22** or the reinforcement layer **23** may be positioned within an interior of the cylindrical separator **22**.

[0046] After removal of the separator insertion tool, anode material may be added to the remaining opening within the interior of the separator **22**, and free electrolyte may be added to the interior of the electrochemical cell **10**. The anode material may be a gelled anode material that may be extruded or otherwise added to the interior of the separator **22**. Thereafter, the anode **24**, current collector **34**, and seal arrangement **32** are put in place to seal the open end of the container **12** and to form a complete electrochemical cell **10**. Again, because the separator **22** is provided substantially free of creases and/or wrinkles, the useful volume occupied by active material, including both cathode and anode material, is maximized within the interior of the electrochemical cell **10**.

[0047] Example

[0048] A plurality of sample LR6 electrochemical cells were created having the separator configuration as discussed herein to test the performance of the electrochemical cells relative to various control samples. All of the electrochemical cells were created with a MnO₂-Zn alkaline chemistry. All of the samples were created using a commercially available separator sheet material having a 3-mil thickness, known as H&V BVA 02530. The control samples were created with a traditional, 2-piece cross-wrap separator design as discussed above, and the test samples were created with the one-piece separator configuration as discussed herein (having a planar sheet dimension of 3.882 inches by 1.200 inches) paired with a bottom cup configuration formed from the same separator material. Other than differences in the separator between the control and test samples, no other variables were introduced during this experiment.

[0049] The electrochemical cell samples (including both test samples and control samples) were subject to standardized high-drain rate service testing performed according to standardized ANSI testing procedures. On average, the test sample cells exhibited a 15% higher drain rate service as compared to the control samples. The inventors believe this increase in high drain rate service is attributable to the decreased internal cell resistance caused by the separator configuration.

[0050] Conclusion

[0051] Many modifications and other embodiments will come to mind to one skilled in the art to which this disclosure pertains having the benefit of the teachings presented in the foregoing descriptions and the associated drawings. Therefore, it is to be understood that the disclosure is not to be limited to the specific embodiments disclosed and that modifications and other embodiments are intended to be included within the scope of the appended claims. Although specific terms are employed herein, they are used in a generic and descriptive sense only and not for purposes of limitation.

Claims:

1. A method of manufacturing an electrochemical cell, the method comprising:
 - providing a cylindrical electrochemical cell can having an active material ring disposed proximate an interior surface of the cell can;
 - forming a cylindrical separator comprising a continuous separator sheet defining (a) a closed bottom end and (b) a two-layer cylindrical sidewall, wherein forming the cylindrical separator comprises:
 - providing the continuous separator sheet;
 - forming lateral slits perpendicular to a longitudinal axis of the continuous separator sheet to separate a first end and a second end of the continuous separator sheet;
 - rolling the first end to form a first cylindrical layer having a first seam; and
 - rolling the second end around an exterior of the first cylindrical layer to form a second cylindrical layer having a second seam;
 - inserting the cylindrical separator end into the interior of the active material ring;
 - disposing a second active material within an interior of the separator; and
 - sealing the electrochemical cell can.
2. The method of manufacturing an electrochemical cell of claim 1, wherein the first seam and the second seam are aligned with a diameter of the cylindrical sidewall.
3. The method of manufacturing an electrochemical cell of claim 1, further comprising positioning a separator reinforcement layer adjacent the closed bottom end of the cylindrical separator.

4. The method of manufacturing an electrochemical cell of claim 3, wherein positioning a separator reinforcement layer adjacent the closed bottom end comprises positioning a reinforcing cup adjacent a bottom exterior surface of the closed bottom end.
5. An electrochemical cell comprising:
 - a container;
 - a ring-shaped cathode disposed within the container wherein the cathode includes an exterior surface in contact with the container and an interior surface surrounding a hollow interior;
 - an anode disposed within the hollow interior of the cathode; and
 - a cylindrical separator positioned between the cathode and the anode, wherein the cylindrical separator comprises a continuous separator sheet defining (a) a closed bottom end, (b) a two-layer cylindrical sidewall defining a seam within each layer of the two-layer cylindrical sidewall, and (c) lateral slits perpendicular to a longitudinal axis of the continuous separator sheet, wherein the lateral slits separate a first end and a second end of the continuous separator sheet; andwherein the two-layer cylindrical sidewall comprises:
 - a first cylindrical layer formed by the first end of the continuous separator sheet; and
 - a second cylindrical layer formed by the second end of the continuous separator sheet, wherein the second end of the continuous separator sheet is formed around an exterior surface of the first cylindrical layer of the two-layer cylindrical sidewall.
6. The electrochemical cell of claim 5, wherein the seams comprise a first seam within the first cylindrical layer and a second seam within the second cylindrical layer and wherein the first seam and the second seam are aligned with a diameter of the two-layer cylindrical sidewall.
7. The electrochemical cell of claim 6, wherein:

the first end of the continuous separator sheet is rolled into the first cylindrical layer such that opposing longitudinal edges of the first end of the continuous separator sheet meet at the first seam; and

the second end of the continuous separator sheet is rolled around the first cylindrical layer such that opposing longitudinal edges of the second end of the continuous separator sheet meet at the second seam.

8. The electrochemical cell of claim 6, wherein the first seam is defined by overlapping portions of the first end of the continuous separator sheet and the second seam is defined by overlapping portions of the second end of the continuous separator sheet.

9. The electrochemical cell of claim 6, wherein the first seam is defined by abutted edges of the first end of the continuous separator sheet and the second seam is defined by abutted edges of the second end of the continuous separator sheet.

10. The electrochemical cell of claim 5, wherein the first end is longer than the second end of the continuous separator sheet.

11. The electrochemical cell of claim 10, wherein the length of each of the first end and the second end is greater than the height of the ring-shaped cathode.

12. The electrochemical cell of claim 11, wherein the length of the first end is longer than the combination of the height of the ring-shaped cathode and a diameter of the hollow interior of the ring-shaped cathode.

13. The electrochemical cell of claim 5, further comprising positioning a separator reinforcement layer adjacent the closed bottom end of the cylindrical separator.

14. The electrochemical cell of claim 13, wherein the separator reinforcement layer comprises one of a reinforcing cup or a reinforcing pad.

15. The electrochemical cell of claim 5, wherein the continuous separator sheet comprises 3 mil separator paper.
16. The method of manufacturing an electrochemical cell of claim 1, wherein rolling the second end around an exterior of the first cylindrical layer comprises forming the closed bottom end with a portion of the second end.