

APPARATUSES, SYSTEMS, AND ASSOCIATED METHODS FOR FORMING POROUS MASSES FOR SMOKE FILTERS

CROSS REFERENCE TO RELATED APPLICATION

5 **[0001]** The present application claims priority to PCT Application Number PCT/US11/56388 filed on October 14, 2011 and published as WO 2012/051548, which claims priority to U.S. Provisional Patent Application Serial Number 61/393,378 filed on October 15, 2010.

BACKGROUND

10 **[0002]** The present invention relates to high-throughput production apparatuses, systems, and associated methods for manufacturing porous masses that may be used in smoke filters.

15 **[0003]** The Centers for Disease Control and Prevention reports that in 2012 over 300 billion cigarettes and over 13 billion cigars were sold in the United States alone. In view of new international recommendations related to tobacco product regulation, there is a need for more efficient tobacco smoke filters and materials used to make tobacco smoke filters. One such technology includes porous masses described in co-pending PCT Application Number PCT/US11/56388 filed on October 14, 2011. Generally porous masses may
20 comprise a plurality of binder particles (*e.g.*, polyethylene) and a plurality of active particles (*e.g.*, carbon particles or zeolites) mechanically bound at a plurality of contact points, typically with the application of heat.

25 **[0004]** While porous masses have been demonstrated to meet, and in some aspects exceed, international filtration regulations, this demonstration has been done on a relatively small scale. High volume production methods are needed to meet the ever-increasing demand for cigarettes and cigars, as illustrated by the U.S. 2012 sales numbers.

SUMMARY OF THE INVENTION

30 **[0005]** The present invention relates to high-throughput production apparatuses, systems, and associated methods for manufacturing porous masses that may be used in smoke filters.

35 **[0006]** One embodiment of the present invention may involve continuously combining a matrix material and a paper wrapper to form a desired cross-sectional shape where the matrix material is confined by the paper wrapper, the matrix material comprising a binder particle and an active particle;

heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length, wherein heating involves irradiating with microwave radiation the at least a portion of the matrix material; cooling the porous mass length; and cutting the porous mass length radially thereby producing a porous mass.

[0007] Another embodiment of the present invention may involve continuously combining a matrix material and a paper wrapper to form a desired cross-sectional shape where the matrix material is confined by the paper wrapper, the matrix material comprising a binder particle and an active particle that comprises a plurality of carbon particles; heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length, wherein heating involves irradiating with microwave radiation the at least a portion of the matrix material; cooling the porous mass length; and cutting the porous mass length radially thereby producing a porous mass.

[0008] Yet another embodiment of the present invention may involve continuously combining a matrix material and a paper wrapper to form a desired cross-sectional shape where the matrix material is confined by the paper wrapper, the matrix material comprising a binder particle and an active particle that comprises a plurality of carbon particles; heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length, wherein heating involves irradiating with microwave radiation the at least a portion of the matrix material, and wherein irradiating with microwave radiation occurs in a residence time of about 10 seconds or less; and wherein the porous mass length is produced at a linear speed of about 800 m/min or less.

[0009] The features and advantages of the present invention will be readily apparent to those skilled in the art upon a reading of the description of the preferred embodiments that follows.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] The following figures are included to illustrate certain aspects of the present invention, and should not be viewed as exclusive embodiments. The subject matter disclosed is capable of considerable modification, alteration, and equivalents in form and function, as will occur to those skilled in the art and having the benefit of this disclosure.

[0011] Figures 1A-B illustrate nonlimiting examples of systems for forming porous masses according to the present invention (not necessarily to scale).

5 **[0012]** Figures 2A-B illustrate nonlimiting examples of systems for forming porous masses according to the present invention (not necessarily to scale).

[0013] Figure 3 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

10 **[0014]** Figure 4 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

15 **[0015]** Figure 5 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

[0016] Figure 6 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

20 **[0017]** Figure 7 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

[0018] Figure 8 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

25 **[0019]** Figure 9 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

30 **[0020]** Figure 10 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

[0021] Figure 11 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

[0022] Figure 12 illustrates a nonlimiting example of a system for forming porous masses according to the present invention (not necessarily to scale).

DETAILED DESCRIPTION

5 **[0023]** The present invention relates to high-throughput production apparatuses, systems, and associated methods for manufacturing porous masses that may be used in smoke filters.

10 **[0024]** The present invention provides methods and apparatuses (and/or systems) for high-throughput production of porous masses that can be used in smoking device filters with increased filtration efficacy of smoke stream components and with acceptable draw characteristics. As used herein, the term "smoking device" refers to articles or devices including, but not limited to, cigarettes, cigarette holders, cigars, cigar holders, pipes, water pipes, hookahs, electronic smoking devices, roll-your-own cigarettes, and/or cigars.

15 **[0025]** Generally porous masses may comprise a plurality of binder particles and a plurality of active particles mechanically bound at a plurality of contact points. The contact points may be active particle-binder contact points, binder-binder contact points, active particle-active particle contact points, and any combination thereof. As used herein, the terms "mechanical bond,"
20 "mechanically bonded," "physical bond," and the like refer to a physical connection that holds two particles at least partially together. Mechanical bonds may be rigid or flexible depending on the bonding material. Mechanical bonding may or may not involve chemical bonding. It should be understood that as used herein, the terms "particle" and "particulate" may be used interchangeably and
25 include all known shapes of materials, including spherical and/or ovular, substantially spherical and/or ovular, discus and/or platelet, flake, ligamental, acicular, fibrous, polygonal (such as cubic), randomly shaped (such as the shape of crushed rocks), faceted (such as the shape of crystals), or any hybrid thereof. Nonlimiting examples of porous masses are described in detail in co-pending
30 applications PCT/US2011/043264, PCT/US2011/043268, PCT/US2011/043269, and PCT/US2011/043270 all filed on July 7, 2012, the entire disclosures of which are included herein by reference.

35 **[0026]** Porous masses may be produced through a variety of methods. For example, some embodiments may involve forming the matrix material (e.g., the active particles and binder particles) into a desired shape (e.g., with a mold),

heating the matrix material to mechanically bond the matrix material together, and finishing the porous masses (e.g., cutting the porous masses to a desired length). Of the various processes/steps involved in the production of porous masses, heating may be one of the steps that limits high-throughput manufacturing. Accordingly, methods that employ rapid heating (e.g., microwave) optionally with a preheating step (e.g., indirect heating or direct contact with heated gases) may be preferred methods for enabling high-throughput manufacturing of porous masses described herein.

[0027] It should be noted that when "about" is provided herein in reference to a number in a numerical list, the term "about" modifies each number of the numerical list. It should be noted that in some numerical listings of ranges, some lower limits listed may be greater than some upper limits listed. One skilled in the art will recognize that the selected subset will require the selection of an upper limit in excess of the selected lower limit.

[0028] The process of forming porous masses may include continuous processing methods, batch processing methods, or hybrid continuous-batch processing methods. As used herein, "continuous processing" refers to manufacturing or producing materials without interruption. Material flow may be continuous, indexed, or combinations of both. As used herein, "batch processing" refers to manufacturing or producing materials as a single component or group of components at individual stations before the single component or group proceeds to the next station. As used herein, "continuous-batch processing" refers to a hybrid of the two where some processes, or series of processes, occur continuously and others occur by batch.

[0029] Generally porous masses may be formed from matrix materials. As used herein, the term "matrix material" refers to the precursors, e.g., binder particles and active particles, used to form porous masses. In some embodiments, the matrix material may comprise, consist of, or consist essentially of binder particles and active particles. In some embodiments, the matrix material may comprise binder particles, active particles, and additives. Nonlimiting examples of suitable binder particles, active particles, and additives are provided in this disclosure.

[0030] Forming porous masses may generally include forming a matrix material into a shape and mechanically bonding at least a portion of the matrix material at a plurality of contact points.

[0031] Forming a matrix material into a shape may involve a mold cavity. In some embodiments, a mold cavity may be a single piece or a collection of single pieces, either with or without end caps, plates, or plugs. In some embodiments, a mold cavity may be multiple mold cavity parts that when assembled form a mold cavity. In some embodiments, mold cavity parts may be brought together with the assistance of conveyors, belts, and the like.

[0032] A mold cavity may have any cross-sectional shape including, but not limited to, circular, substantially circular, ovular, substantially ovular, polygonal (like triangular, square, rectangular, pentagonal, and so on), polygonal with rounded edges, and the like, or any hybrid thereof. In some embodiments, porous masses may have a cross-sectional shape comprising holes, which may be achieved by machining, or any other suitable method (*e.g.*, degradation of a degradable material). In some embodiments, the porous mass may have a specific shape for a cigarette holder or pipe that is adapted to fit within the cigarette holder or pipe to allow for smoke passage through the filter to the consumer. When discussing the shape of a porous mass herein, with respect to a traditional smoking device filter, the shape may be referred to in terms of diameter or circumference (wherein the circumference is the perimeter of a circle) of the cross-section of the cylinder. But in embodiments where a porous mass of the present invention is in a shape other than a true cylinder, it should be understood that the term "circumference" is used to mean the perimeter of any shaped cross-section, including a circular cross-section.

[0033] Generally, mold cavities may have a longitudinal direction and a radial direction perpendicular to the longitudinal direction, *e.g.*, a substantially cylindrical shape. One skilled in the art should understand how to translate the embodiments presented herein to mold cavities without defined longitudinal and radial direction, *e.g.*, spheres and cubes, where applicable. In some embodiments, a mold cavity may have a cross-sectional shape that changes along the longitudinal direction, *e.g.*, a conical shape, a shape that transitions from square to circular, or a spiral. In some embodiments, a mold cavity may be paper rolled or shaped into a desired cross-sectional shape, *e.g.*, a cylinder. In some embodiments, a mold cavity may be a cylinder of paper glued at the longitudinal seam.

[0034] In some embodiments, mold cavities may have a longitudinal axis having an opening as a first end and a second end along said longitudinal

axis. In some embodiments, matrix material may pass along the longitudinal axis of a mold cavity during processing. By way of nonlimiting example, Figure 1 shows mold cavity **120** with a longitudinal axis along material path **110**.

[0035] In some embodiments, mold cavities may have a longitudinal axis having a first end and a second end along said longitudinal axis wherein at least one end is closed. In some embodiments, said closed end may be capable of opening.

[0036] In some embodiments, individual mold cavities may be filled with a matrix material prior to mechanical bonding. In some embodiments, a single mold cavity may be used to continuously produce porous masses by continuously passing matrix material therethrough before and/or during mechanical bonding. In some embodiments, a single mold cavity may be used to produce an individual porous mass. In some embodiments, said single mold cavity may be reused and/or continuously reused to produce a plurality of individual porous masses.

[0037] In some embodiments, mold cavities may be at least partially lined with wrappers and/or coated with release agents. In some embodiments, wrappers may be individual wrappers, *e.g.*, pieces of paper. In some embodiments, wrappers may be spoolable-length wrappers, *e.g.*, a 50 ft roll of paper.

[0038] In some embodiments, mold cavities may be lined with more than one wrapper. In some embodiments, forming porous masses may include lining a mold cavity(s) with a wrapper(s). In some embodiments, forming porous masses may include wrapping the matrix material with wrappers so that the wrapper becomes the mold cavity. In such embodiments, the wrapper may be preformed as a mold cavity, formed as a mold cavity in the presence of the matrix material, or wrapped around matrix material that is in a preformed shape (*e.g.*, with the aid of a tackifier). In some embodiments, wrappers may be continuously fed through a mold cavity. Wrappers may be capable of holding the porous mass in a shape, capable of releasing the porous masses from the mold cavities, capable of assisting in passing matrix material through the mold cavity, capable of protecting the porous mass during handling or shipment, and any combination thereof.

[0039] Suitable wrappers may include, but not be limited to, papers (*e.g.*, wood-based papers, papers containing flax, flax papers, papers produced

from other natural or synthetic fibers, functionalized papers, special marking papers, colorized papers), plastics (e.g., fluorinated polymers like polytetrafluoroethylene, silicone), films, coated papers, coated plastics, coated films, and the like, and any combination thereof. In some embodiments, wrappers may be papers suitable for use in smoking device filters.

[0040] In some embodiments, a wrapper may be adhered (e.g., glued) to itself to assist in maintaining a desired shape, e.g., in a substantially cylindrical configuration. In some embodiments, mechanical bonding of the matrix material may also mechanically bind the matrix material to the wrapper which may alleviate the need for adhering the wrapper to itself.

[0041] Suitable release agents may be chemical release agents or physical release agents. Nonlimiting examples of chemical release agents may include oils, oil-based solutions and/or suspensions, soapy solutions and/or suspensions, coatings bonded to the mold surface, and the like, and any combination thereof. Nonlimiting examples of physical release agents may include papers, plastics, and any combination thereof. Physical release agents, which may be referred to as release wrappers, may be implemented similar to wrappers as described herein.

[0042] Once formed into a desired cross-sectional shape with the mold cavity, the matrix material may be mechanically bound at a plurality of contact points. Mechanical bonding may occur during and/or after the matrix material is in the mold cavity. Mechanical bonding may be achieved with heat and/or pressure.

[0043] Heat may be radiant heat, conductive heat, convective heat, and any combination thereof. Heating may involve thermal sources including, but not limited to, heated fluids internal to the mold cavity, heated fluids external to the mold cavity, steam, heated inert gases, secondary radiation from a component of the porous mass (e.g., nanoparticles, active particles, and the like), ovens, furnaces, flames, conductive or thermoelectric materials, ultrasonics, and the like, and any combination thereof. By way of nonlimiting example, heating may involve a convection oven or heating block. Another nonlimiting example may involve heating with a microwave oven. In another nonlimiting example, heating may involve passing heated air, nitrogen, or other gas through the matrix material while in the mold cavity. In some embodiments, heated inert gases may be used to mitigate any unwanted oxidation of active particles and/or additives.

Another nonlimiting example may involve mold cavities made of thermoelectric materials so that the mold cavity heats. In some embodiments, heating may involve a combination of the foregoing, *e.g.*, passing heated gas through the matrix material while passing the matrix material through a microwave oven.

5 **[0044]** Secondary radiation from a component of the porous mass (*e.g.*, nanoparticles, active particles, and the like) may, in some embodiments, be achieved by irradiating the component with electromagnetic radiation, *e.g.*, gamma-rays, x-rays, UV light, visible light, IR light, microwaves, radio waves, and/or long radio waves. By way of nonlimiting example, the matrix material
10 may comprise carbon nanotubes that when irradiated with radio frequency waves emit heat. In another nonlimiting example, the matrix material may comprise active particles like carbon particles that are capable of converting microwave irradiation into heat that mechanically bonds or assists in mechanically bonding the binder particles together. In some embodiments, the
15 electromagnetic radiation may be tuned by the frequency and power level so as to appropriately interact with the component of choice. For example, activated carbon may be used in conjunction with microwaves at a frequency ranging from about 900 MHz to about 2500 MHz with a fixed or adjustable power setting that is selected to match a target rate of heating.

20 **[0045]** One skilled in the art, with the benefit of this disclosure, should understand that different wavelengths of electromagnetic radiation penetrate materials to different depths. Therefore, when employing primary or secondary radiation methods one should consider the mold cavity material, configuration and composition, the matrix material composition, the component that converts
25 the electromagnetic radiation to heat, the wavelength of electromagnetic radiation, the intensity of the electromagnetic radiation, the irradiation methods, and the desired amount of secondary radiation, *e.g.*, heat.

[0046] The residence time for heating (including by any method described herein, *e.g.*, convection oven or exposure to electromagnetic
30 radiation) and/or applying pressure that causes the mechanical bonding to occur may be for a length of time ranging from a lower limit of about a hundredth of a second, a tenth of a second, 1 second, 5 seconds, 30 seconds, or 1 minute to an upper limit of about 30 minutes, 15 minutes, 5 minutes, 1 minute, or 1 second, and wherein the residence time may range from any lower limit to any upper
35 limit and encompasses any subset therebetween. It should be noted that for

continuous processes that utilize faster heating methods, *e.g.*, exposure to electromagnetic radiation like microwaves, short residence times may be preferred, *e.g.*, about 10 seconds or less, or more preferably about 1 second or less. Further, processing methods that utilize processes like convection heating may provide for longer residence times on the timescale of minutes, which may include residence times of greater than 30 minutes. One of ordinary skill in the art should understand that longer times can be applicable, *e.g.*, seconds to minutes to hours or longer provided that an appropriate temperature and heating profile may be selected for a given matrix material. It should be noted that preheating or pretreating methods and/or steps that are not to a sufficient temperature and/or pressure to allow for mechanical bonding are not considered part of the residence time, as used herein.

[0047] In some embodiments, heating to facilitate mechanical bonding may be to a softening temperature of a component of the matrix material. As used herein, the term "softening temperature" refers to the temperature above which a material becomes pliable, which is typically below the melting point of the material.

[0048] In some embodiments, mechanical bonding may be achieved at temperatures ranging from a lower limit of about 90°C, 100°C, 110°C, 120°C, 130°C, or 140°C or an upper limit of about 300°C, 275°C, 250°C, 225°C, 200°C, 175°C, or 150°C, and wherein the temperature may range from any lower limit to any upper limit and encompass any subset therebetween. In some embodiments, the heating may be accomplished by subjecting material to a single temperature. In another embodiment the temperature profile may vary with time. By way of nonlimiting example, a convection oven may be used. In some embodiments, heating may be localized within the matrix material. By way of nonlimiting example, secondary radiation from nanoparticles may heat only the matrix material proximal to the nanoparticle.

[0049] In some embodiments, matrix materials may be preheated before entering mold cavities. In some embodiments, matrix material may be preheated to a temperature below the softening temperature of a component of the matrix material. In some embodiments, matrix material may be preheated to a temperature about 10%, about 5%, or about 1% below the softening temperature of a component of the matrix material. In some embodiments, matrix material may be preheated to a temperature about 10°C, about 5°C, or

about 1°C below the softening temperature of a component of the matrix material. Preheating may involve heat sources including, but not limited to, those listed as heat sources above for achieving mechanical bonding.

[0050] In some embodiments, bonding the matrix material may yield porous mass or porous mass lengths. As used herein, the term “porous mass length” refers to a continuous porous mass (*i.e.*, a porous mass that is not never-ending, but rather long compared to porous masses, which may be produced continuously). By way of nonlimiting example, porous mass lengths may be produced by continuously passing matrix material through a heated mold cavity. In some embodiments, the binder particles may retain their original physical shape (or substantially retained their original shape, *e.g.*, no more than 10% variation (*e.g.*, shrinkage) in shape from original) during the mechanical bonding process, *i.e.*, the binder particles may be substantially the same shape in the matrix material and in the porous mass (or lengths).

[0051] In some embodiments, porous mass lengths may be cut to yield porous mass. Cutting may be achieved with a cutter. Suitable cutters may include, but not be limited to, blades, hot blades, carbide blades, stellite blades, ceramic blades, hardened steel blades, diamond blades, smooth blades, serrated blades, lasers, pressurized fluids, liquid lances, gas lances, guillotines, and the like, and any combination thereof. In some embodiments with high-speed processing, cutting blades or similar devices may be positioned at an angle to match the speed of processing so as to yield porous masses with ends perpendicular to the longitudinal axis. In some embodiments, the cutter may change position relative to the porous mass lengths along the longitudinal axis of the porous mass lengths.

[0052] In some embodiments, porous masses and/or porous mass lengths may be extruded. In some embodiments, extrusion may involve a die. In some embodiments, a die may have multiple holes being capable of extruding porous masses and/or porous mass lengths.

[0053] Some embodiments may involve cutting porous masses and/or porous mass lengths radially to yield porous mass sections. Cutting may be achieved by any known method with any known apparatus including, but not limited to, those described above in relation to cutting porous mass lengths into porous masses.

[0054] The length of a porous mass, or sections thereof, may range from a lower limit of about 2 mm, 3 mm, 5 mm, 10 mm, 15 mm, 20 mm, 25 mm, or 30 mm to an upper limit of about 150 mm, 100 mm, 50 mm, 25 mm, 15 mm, or 10 mm, and wherein the length may range from any lower limit to any upper limit and encompass any subset therebetween.

[0055] The circumference of a porous mass length, a porous mass, or sections thereof (wrapped or otherwise) may range from a lower limit of about 5 mm, 6 mm, 7 mm, 8 mm, 9 mm, 10 mm, 11 mm, 12 mm, 13 mm, 14 mm, 15 mm, 16 mm, 17 mm, 18 mm, 19 mm, 20 mm, 21 mm, 22 mm, 23 mm, 24 mm, 25 mm, or 26 mm to an upper limit of about 60 mm, 50 mm, 40 mm, 30 mm, 20 mm, 29 mm, 28 mm, 27 mm, 26 mm, 25 mm, 24 mm, 23 mm, 22 mm, 21 mm, 20 mm, 19 mm, 18 mm, 17 mm, or 16 mm, wherein the circumference may range from any lower limit to any upper limit and encompass any subset therebetween.

[0056] Some embodiments may involve wrapping porous mass sections, porous masses, and/or porous mass lengths with a wrapper after the matrix material has been mechanically bound, *e.g.*, after removal from the mold cavity or exiting an extrusion die. Suitable wrappers include those disclosed above.

[0057] Some embodiments may involve cooling porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise). Cooling may be active or passive, *i.e.*, cooling may be assisted or occur naturally. Active cooling may involve passing a fluid over and/or through the mold cavity, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise); decreasing the temperature of the local environment about the mold cavity, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise), *e.g.*, passing through a refrigerated component; and any combination thereof. Active cooling may involve a component that may include, but not be limited to, cooling coils, fluid jets, thermoelectric materials, and any combination thereof. The rate of cooling may be random or it may be controlled.

[0058] Some embodiments may involve transporting porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) to another location. Suitable forms of transportation may include, but not be

limited to, conveying, carrying, rolling, pushing, shipping, robotic movement, and the like, and any combination thereof.

[0059] One skilled in the art, with the benefit of this disclosure, should understand the plurality of apparatuses and/or systems capable of producing porous mass sections, porous masses, and/or porous mass lengths. By way of nonlimiting examples, Figures 1-11 illustrate a plurality of apparatuses and/or systems capable of producing porous mass sections, porous masses, and/or porous mass lengths.

[0060] It should be noted that where a system is used, it is within the scope of this disclosure to have an apparatus with the components of a system, and vice versa.

[0061] For ease of understanding, the term "material path" is used herein to identify the path along which matrix material, porous mass lengths, and/or porous masses will travel in a system and/or apparatus. In some embodiments, a material path may be contiguous. In some embodiments, a material path may be noncontiguous. By way of nonlimiting example, systems for batch processing with multiple, independent mold cavities may be considered to have a noncontiguous material path.

[0062] Referring now to **Figures 1A-B**, system **100** may include hopper **122** operably connected to material path **110** to feed the matrix material (not shown) to material path **110**. System **100** may also include paper feeder **132** operably connected to material path **110** so as to feed paper **130** into material path **110** to form a wrapper substantially surrounding the matrix material between mold cavity **120** and the matrix material. Heating element **124** is in thermal communication with the matrix material while in mold cavity **120**. Heating element **124** may cause the matrix material to mechanically bond at a plurality of points thereby yielding a wrapped porous mass length (not shown). After the wrapped porous mass length exits mold cavity **120** and is suitably cooled, cutter **126** cuts the wrapped porous mass length radially, *i.e.*, perpendicular to the longitudinal axis, thereby yielding wrapped porous masses and/or wrapped porous mass sections.

[0063] **Figures 1A-B**, demonstrate that system **100** may be at any angle. One skilled in the art, with the benefit of this disclosure, should understand the configurational considerations when adjusting the angle at which system **100**, or any component thereof, is placed. By way of nonlimiting

example, **Figure 1B** shows hopper **122** may be configured such that the outlet of hopper **122** (and any corresponding matrix feed device) is within mold cavity **120**. In some embodiments, a mold cavity may be at an angle at or between vertical and horizontal.

5 **[0064]** In some embodiments, feeding matrix material to a material path may involve any suitable feeder system including, but not limited to, hand feeding, volumetric feeders, mass flow feeders, gravimetric feeders, augers or screws, chutes, slides, conveyors, tubes, conduits, channels, and the like, and any combination thereof. In some embodiments, the material path may include
10 a mechanical component between the hopper and the mold cavity including, but not limited to, garnitures, compression molds, flow-through compression molds, ram presses, pistons, shakers, extruders, twin screw extruders, solid state extruders, and the like, and any combination thereof. In some embodiments, feeding may involve, but not be limited to, forced feeding, controlled rate
15 feeding, volumetric feeding, mass flow feeding, gravimetric feeding, vacuum-assisted feeding, fluidized powder feeding, pneumatic dense phase feeding, pneumatic dilute phase feeding, and any combination thereof. In some embodiments, feeding may be indexed to enable the insertion of a spacer material at predetermined intervals. Suitable spacer materials may comprise
20 additives, solid barriers (e.g., mold cavity parts), porous barriers (e.g., papers and release wrappers), filters, cavities, and the like, and any combination thereof. In some embodiments, feeding may involve shaking and/or vibrating. One skilled in the art, with the benefit of this disclosure, should understand the degree of shaking and/or vibrating that is appropriate, e.g., a homogeneously
25 distributed matrix material comprising large binder particles and small active particles may be adversely effected by vibrating, i.e., homogeneity may be at least partially lost. Further, one skilled in the art should understand the effects of feeding parameters and/or feeders on the final properties of the porous masses produced, e.g., the effects on at least void volume (discussed further
30 below), encapsulated pressure drop (discussed further below), and compositional homogeneity.

[0065] In some embodiments, the matrix material or components thereof may be dried before being introduced into the material path and/or while along the material path. Drying may be achieved, in some embodiments, with
35 heating the matrix material or components thereof, blowing dry gas over the

matrix material or components thereof, and any combination thereof. In some embodiments, the matrix material may have a moisture content of about 5% by weight or less, or more preferably about 2% by weight or less, and in some embodiments as low as 0.01% by weight. Moisture content may be analyzed by known methods that involve freeze drying or weight loss after drying.

[0066] Referring now to **Figures 2A-B**, system **200** may include hopper **222** operably connected to material path **210** to feed the matrix material to material path **210**. System **200** may also include paper feeder **232** operably connected to material path **210** so as to feed paper **230** into material path **210** to form a wrapper substantially surrounding the matrix material between mold cavity **220** and the matrix material. Further, system **200** may include release feeder **236** operably connected to material path **210** so as to feed release wrapper **234** into material path **210** to form a wrapper between paper **230** and mold cavity **220**. In some embodiments, release feeder **236** may be configured as conveyor **238** that continuously cycles release wrapper **234**. Heating element **224** is in thermal communication with the matrix material while in mold cavity **220**. Heating element **224** may cause the matrix material to mechanically bond at a plurality of points thereby yielding a wrapped porous mass length. After the wrapped porous mass length exits mold cavity **220** and is suitably cooled, cutter **226** cuts the wrapped porous mass length radially thereby yielding wrapped porous masses and/or wrapped porous mass sections. In embodiments where release wrapper **234** is not configured as conveyor **238**, release wrapper **234** may be removed from the wrapped porous mass length before cutting or from the wrapped porous masses and/or wrapped porous mass sections after cutting.

[0067] Referring now to **Figure 3**, system **300** may include component hoppers **322a** and **322b** that feed components of the matrix material into hopper **322**. The matrix material may be mixed and preheated in hopper **322** with mixer **328** and preheater **344**. Hopper **322** may be operably connected to material path **310** to feed the matrix material to material path **310**. System **300** may also include paper feeder **332** operably connected to material path **310** so as to feed paper **330** into material path **310** to form a wrapper substantially surrounding the matrix material between mold cavity **320** and the matrix material. Mold cavity **320** may include fluid connection **346** through which heated fluid (liquid or gas) may pass into material path **310** and mechanically bond the matrix material at a plurality of points thereby yielding a

wrapped porous mass length. It should be noted that fluid connection **346** can be located at any location along mold cavity **320** and that more than one fluid connection **346** may be disposed along mold cavity **320**. After the wrapped porous mass length exits mold cavity **320** and is suitably cooled, cutter **326** cuts the wrapped porous mass length radially thereby yielding wrapped porous masses and/or wrapped porous mass sections.

[0068] One skilled in the art with the benefit of this disclosure should understand that preheating can also take place for individual feed components before hopper **322** and/or with the mixed components after hopper **322**.

[0069] Suitable mixers may include, but not be limited to, ribbon blenders, paddle blenders, plow blenders, double cone blenders, twin shell blenders, planetary blenders, fluidized blenders, high intensity blenders, rotating drums, blending screws, rotary mixers, and the like, and any combination thereof.

[0070] In some embodiments, component hoppers may hold individual components of the matrix material, *e.g.*, two component hoppers with one holding binder particles and the other holding active particles. In some embodiments, component hoppers may hold mixtures of components of the matrix material, *e.g.*, two component hoppers with one holding a mixture of binder particles and active particles and the other holding an additive like flavorant. In some embodiments, the components within component hoppers may be solids, liquids, gases, or combinations thereof. In some embodiments, the components of different component hoppers may be added to the hopper at different rates to achieve a desired blend for the matrix material. By way of nonlimiting example, three component hoppers may separately hold active particles, binder particles, and active compounds (an additive described further below) in liquid form. Binder particles may be added to the hopper at twice the rate of the active particles, and the active compounds may be sprayed in so as to form at least a partial coating on both the active particles and the binder particles.

[0071] In some embodiments, fluid connections to mold cavities may be to pass a fluid into the mold cavity, pass a fluid through a mold cavity, and/or drawing on a mold cavity. As used herein, the term "drawing" refers to creating a negative pressure drop across a boundary and/or along a path, *e.g.*, sucking. Passing a heated fluid into and/or through a mold cavity may assist in

mechanically bonding the matrix material therein. Drawing on a mold cavity that has a wrapper disposed therein may assist in lining the mold cavity evenly, *e.g.*, with less wrinkles.

[0072] Referring now to **Figure 4**, system **400** may include hopper **422** operably connected to material path **410** to feed the matrix material to material path **410**. Hopper **422** may be configured along material path **410** such that the outlet of hopper **422**, or an extension from its outlet, is within mold cavity **420**. This may advantageously allow for the matrix material to be fed into mold cavity **420** at a rate to control the packing of the matrix material and consequently the void volume of resultant porous masses. In this nonlimiting example, mold cavity **420** comprises a thermoelectric material and therefore includes power connection **448**. System **400** may also include release feeder **436** operably connected to material path **410** so as to feed release wrapper **434** into material path **410** to form a wrapper substantially surrounding the matrix material between mold cavity **420** and the matrix material. Mold cavity **420** may be made of a thermoelectric material so that mold cavity **420** may provide the heat to mechanically bond the matrix material at a plurality of points thereby yielding a wrapped porous mass length. Along material path **410** after mold cavity **420**, roller **440** may be operably capable of assisting the movement of the wrapped porous mass length through mold cavity **420**. After the wrapped porous mass length exits mold cavity **420** and is suitably cooled, cutter **426** cuts the wrapped porous mass length radially thereby yielding wrapped porous masses and/or wrapped porous mass sections. After cutting, the porous masses continue along material path **410** on porous mass conveyor **462**, *e.g.*, for packaging or further processing. Release wrapper **434** may be removed from the wrapped porous mass length before cutting or from the wrapped porous masses and/or wrapped porous mass sections after cutting.

[0073] Suitable rollers and/or substitutes for rollers may include, but not be limited to, cogs, cogwheels, wheels, belts, gears, and the like, and any combination thereof. Further rollers and the like may be flat, toothed, beveled, and/or indented.

[0074] Referring now to **Figure 5**, system **500** may include hopper **522** operably connected to material path **510** to feed the matrix material to material path **510**. Heating element **524** is in thermal communication with the matrix material while in mold cavity **520**. Heating element **524** may cause the

matrix material to mechanically bond at a plurality of points, thereby yielding a porous mass length. After the porous mass length exits mold cavity **520**, die **542** may be used for extruding the porous mass length into a desired cross-sectional shape. Die **542** may include a plurality of dies **542'** (e.g., multiple dies or multiple holes within a single die) through which the porous mass length may be extruded. After the porous mass length is extruded through die **542** and suitably cooled, cutter **526** cuts the porous mass length radially, thereby yielding porous masses and/or porous mass sections.

[0075] Referring now to **Figure 6**, system **600** may include paper feeder **632** operably connected to material path **610** so as to feed paper **630** into material path **610**. Hopper **622** (or other matrix material delivery apparatus, e.g., an auger) may be operably connected to material path **610** so as to place matrix material on paper **630**. Paper **630** may wrap around the matrix material, at least in part, because of passing-through mold cavity **620** (or compression mold sometimes referred to a garniture device in relation to cigarette filter forming apparatuses), which provide the desired cross-sectional shape (or optional, in some embodiments, the matrix material may be combined with paper **630** after formation of the desired cross-section has begun or is complete). In some embodiments, the paper seam may be glued. Heating element **624** (or alternatively an electromagnetic radiation source, e.g., a microwave source) is in thermal communication with the matrix material while and/or after being in mold cavity **620**. Heating element **624** may cause the matrix material to mechanically bond at a plurality of points, thereby yielding a wrapped porous mass length. After the wrapped porous mass length exits mold cavity **620** and is suitably cooled, cutter **626** cuts the wrapped porous mass length radially, thereby yielding wrapped porous masses and/or wrapped porous mass sections. Movement through system **600** may be aided by conveyor **658** with mold cavity **620** being stationary. It should be noted that while not shown, a similar embodiment may include paper **630** as part of a looped conveyor that unwraps from the porous mass length before cutting, which would yield porous masses and/or porous mass sections.

[0076] Referring now to **Figure 7**, system **700** may include paper feeder **732** operably connected to material path **710** so as to feed paper **730** into material path **710**. As shown, mold cavity **720**, a cylindrically-rolled paper glued at the longitudinal seam, may be formed on-the-fly with compression mold

756a (or compression mold sometimes referred to a garniture device in relation to cigarette filter forming apparatuses) causing paper **730** to roll with glue **752** applied with glue-application device **754** (e.g., a glue gun). During the formation of mold cavity **720**, matrix material may be introduced along material path **710** from hopper **722**. Heating element **724** (e.g., a microwave element) in thermal communication with mold cavity **720** may cause the matrix material to mechanically bond at a plurality of points thereby yielding a wrapped porous mass length. Then, compression mold **756b** may be used before complete cooling of the matrix material to size the wrapped porous mass length into a desired cross-sectional size, which may advantageously be used for diameter uniformity. After the wrapped porous mass length is suitably cooled, cutter **726** cuts the wrapped porous mass length radially, thereby yielding wrapped porous masses and/or wrapped porous mass sections. Movement through system **700** may be aided by rollers, conveyors, or the like, not shown. One skilled in the art with the benefit of this disclosure should understand that the processes described may occur in a single apparatus or in multiple apparatus. For example, rolling the paper, introducing the matrix material, exposing to heat (e.g., applying microwaves), and resizing may be performed in a single apparatus and the resultant porous mass length may be conveyed to a second apparatus for cutting.

[0077] In some embodiments, while the matrix material is at an elevated temperature, the porous mass or the like may be resized and/or reshaped with the application of pressure.

[0078] Referring now to **Figure 8**, mold cavity **820** of system **800** may be formed from mold cavity parts **820a** and **820b** operably connected to mold cavity conveyors **860a** and **860b**, respectively. Once mold cavity **820** is formed, matrix material may be introduced along material path **810** from hopper **822**. Heating element **824** is in thermal communication with the matrix material while in mold cavity **820**. Heating element **824** may cause the matrix material to mechanically bond at a plurality of points, thereby yielding a porous mass. After mold cavity **820** is suitably cooled and separated into mold cavity parts **820a** and **820b**, the porous mass may be removed from mold cavity parts **820a** and/or **820b** and continue along material path **810** via porous mass conveyor **862**. It should be noted that **Figure 8** illustrates a nonlimiting example of a noncontiguous material path.

[0079] In some embodiments, removing porous masses from mold cavities and/or mold cavity parts may involve pulling mechanisms, pushing mechanisms, lifting mechanisms, gravity, any hybrid thereof, and any combination thereof. Removing mechanisms may be configured to engage porous masses at the ends, along the side(s), and any combination thereof. Suitable pulling mechanisms may include, but not be limited to, suction cups, vacuum components, tweezers, pincers, forceps, tongs, grippers, claws, clamps, and the like, and any combination thereof. Suitable pushing mechanisms may include, but not be limited to, ejectors, punches, rods, pistons, wedges, spokes, rams, pressurized fluids, and the like, and any combination thereof. Suitable lifting mechanisms may include, but not be limited to, suction cups, vacuum components, tweezers, pincers, forceps, tongs, grippers, claws, clamps, and the like, and any combination thereof. In some embodiments, mold cavities may be configured to operably work with various removal mechanisms. By way of nonlimiting example, a hybrid push-pull mechanism may include pushing longitudinally with a rod, so as to move the porous mass partially out the other end of the mold cavity, which can then be engaged by forceps to pull the porous mass from the mold cavity.

[0080] Referring now to **Figure 9**, mold cavity **920** of system **900** is formed from mold cavity parts **920a** and **920b** or **920c** and **920d** operably connected to mold cavity conveyors **960a**, **960b**, **960c**, and **960d**, respectively. Once mold cavity **920** is formed, or during forming, sheets of paper **930** are introduced into mold cavity **920** via paper feeder **932**. Then matrix material is introduced into paper **930** from hopper **922** along material path **910** lined mold cavity **920** and mechanically bound into porous masses with heat from heating element **924**. After suitable cooling, removal of the porous masses may be achieved by insertion of ejector **964** into ejector ports **966a** and **966b** of mold cavity parts **920a**, **920b**, **920c**, and **920d**. The porous masses may then continue along material path **910** via porous mass conveyor **962**. Again, **Figure 9** illustrates a nonlimiting example of a noncontiguous material path.

[0081] Quality control of porous mass production may be assisted with cleaning of mold cavities and/or mold cavity parts. Referring again to **Figure 8**, cleaning instruments may be incorporated into system **800**. As mold cavity parts **820a** and **820b** return from forming porous masses, mold cavity parts **820a** and **820b** pass a series of cleaners including liquid jet **870** and air or gas jet

872. Similarly in **Figure 9**, as mold cavity parts **960a**, **960b**, **960c**, and **960d** return from forming porous masses, mold cavity parts **960a**, **960b**, **960c**, and **960d** pass a series of cleaners that include heat from heating element **924** and air or gas jet **972**.

5 **[0082]** Other suitable cleaners may include, but not be limited to, scrubbers, brushes, baths, showers, insert fluid jets (tubes that insert into mold cavities capable of jetting fluids radially), ultrasonic apparatuses, and any combination thereof.

10 **[0083]** In some embodiments, porous mass sections, porous masses, and/or porous mass lengths may comprise cavities. By way of nonlimiting example, referring now to **Figure 10**, mold cavity parts **1020a** and **1020b** operably connected to mold cavity conveyors **1060a** and **1060b** operably connect to form mold cavity **1020** of system **1000**. Hopper **1022** is operably attached to two volumetric feeders **1090a** and **1090b** such that each volumetric
15 feeder **1090a** and **1090b** fills mold cavity **1020** partially with the matrix material along material path **1010**. Between the addition of matrix material from volumetric feeder **1090a** and volumetric feeder **1090b**, injector **1088** places a capsule (not shown) into mold cavity **1020**, thereby yielding a capsule surrounded by matrix material. Heating element **1024**, in thermal contact with
20 mold cavity **1020**, causes the matrix material to mechanically bond at a plurality of points, thereby yielding a porous mass with a capsule disposed therein. After the porous mass is formed and suitably cooled, rotary grinder **1092** is inserted into mold cavity **1020** along the longitudinal direction of mold cavity **1020**. Rotary grinder **1092** is operably capable of grinding the porous mass to a
25 desired length in the longitudinal direction. After mold cavity **1020** separates into mold cavity parts **1020a** and **1020b**, the porous mass is removed from mold cavity parts **1020a** and/or **1020b** and continues along material path **1010** via porous mass conveyor **1062**.

30 **[0084]** Suitable capsules for use within porous masses and the like may include, but not be limited to, polymeric capsules, porous capsules, ceramic capsules, and the like. Capsules may be filled with an additive, *e.g.*, granulated carbon or a flavorant (more examples provided below). The capsules, in some embodiments, may also contain a molecular sieve that reacts with selected components in the smoke to remove or reduce the concentration of the
35 components without adversely affecting desirable flavor constituents of the

smoke. In some embodiments, the capsules may include tobacco as an additional flavorant. One should note that if the capsule is insufficiently filled with a chosen substance, in some filter embodiments, this may create a lack of interaction between the components of the mainstream smoke and the substance in the capsules.

[0085] One skilled in the art, with the benefit of this disclosure, should understand that other methods described herein may be altered to produce porous mass sections, porous masses, and/or porous mass lengths with capsules therein. In some embodiments, more than one capsule may be within a porous mass section, porous mass, and/or porous mass length.

[0086] In some embodiments, the shape, *e.g.*, length, width, diameter, and/or height, of porous mass sections, porous masses, and/or porous mass lengths may be adjusted by operations other than cutting including, but not limited to, sanding, milling, grinding, smoothing, polishing, rubbing, and the like, and any combination thereof. Generally, these operations will be referred to herein as grinding. Some embodiments may involve grinding the sides and/or ends of porous mass sections, porous masses, and/or porous mass lengths to achieve smooth surfaces, roughened surfaces, grooved surfaces, patterned surfaces, leveled surfaces, and any combination thereof. Some embodiments may involve grinding the sides and/or ends of porous mass sections, porous masses, and/or porous mass lengths to achieve desired dimensions within specification limitations. Some embodiments may involve grinding the sides and/or ends of porous mass sections, porous masses, and/or porous mass lengths while in or exiting mold cavities, after cutting, during further processing, and any combination thereof. One skilled in the art should understand that dust, particles, and/or pieces may be produced from grinding. As such, grinding may involve removing the dust, particles, and/or pieces by methods like vacuuming, blowing gases, rinsing, shaking, and the like, and any combination thereof.

[0087] Any component and/or instrument capable of achieving the desired level of grinding may be used in conjunction with systems and methods disclosed herein. Examples of suitable components and/or instruments capable of achieving the desired level of grinding may include, but not be limited to, lathes, rotary sanders, brushes, polishers, buffers, etchers, scribes, and the like, and any combination thereof.

[0088] In some embodiments, the porous mass may be machined to be lighter in weight, if desired, for example, by drilling out a portion of the porous mass.

5 [0089] One skilled in the art, with the benefit of this disclosure, should understand the component and/or instrument configurations necessary to engage porous mass sections, porous masses, and/or porous mass lengths at various points with the systems described herein. By way of nonlimiting example, grinding instruments and/or drilling instruments used while porous masses are in mold cavities (or porous mass lengths are leaving mold cavities)
10 should be configured so as not to deleteriously affect the mold cavity.

[0090] Referring now to **Figure 11**, hopper **1122** is operably attached to chute **1182** and feeds the matrix material to material path **1110**. Along material path **1110**, mold cavity **1120** is configured to accept ram **1180**, which is capable of pressing the matrix material in mold cavity **1120**. Heating element
15 **1124**, in thermal communication with the matrix material while in mold cavity **1120**, causes the matrix material to mechanically bond at a plurality of points, thereby yielding a porous mass length. Inclusion of ram **1180** in system **1100** may advantageously assist in ensuring the matrix material is properly packed so as to form a porous mass length with a desired void volume. Further, system
20 **1100** comprises cooling area **1194**, while the porous mass length is still contained within mold cavity **1120**. In this nonlimiting example, cooling is achieved passively.

[0091] Referring now to **Figure 12**, hopper **1222** of system **1200** operably feeds the matrix material to extruder **1284** (e.g., screw) along material
25 path **1210**. Extruder **1284** moves matrix material to mold cavity **1220**. System **1200** also includes heating element **1224** in thermal communication with the matrix material while in mold cavity **1220** that causes the matrix material to mechanically bond at a plurality of points, thereby yielding a porous mass length. Further, system **1200** includes cooling element **1286** in thermal
30 communication porous mass length while in mold cavity **1220**. Movement of the porous mass length out of mold cavity **1220** is assisted and/or directed by roller **1240**.

[0092] In some embodiments, a control system may interface with components of the systems and/or apparatuses disclosed herein. As used herein,
35 the term "control system" refers to a system that can operate to receive and

send electronic or pneumatic signals and may include functions of interfacing with a user, providing data readouts, collecting data, storing data, changing variable setpoints, maintaining setpoints, providing notifications of failures, and any combination thereof. Suitable control systems may include, but are not limited to, variable transformers, ohmmeters, programmable logic controllers, digital logic circuits, electrical relays, computers, virtual reality systems, and any combination thereof. Suitable system and/or apparatus components that may be operably connected to a control system may include, but not be limited to, hoppers, heating elements, cooling elements, cutters, mixers, paper feeders, release feeders, release conveyors, rollers, mold cavity conveyors, conveyors, ejectors, liquid jets, air jets, rams, chutes, extruders, injectors, matrix material feeders, grinders, and the like, and any combination thereof. It should be noted that systems and/or apparatuses disclosed herein may have more than one control system that can interface with any number of components.

[0093] One skilled in the art, with the benefit of this disclosure, should understand the interchangeability of the various components of the systems and/or apparatuses disclosed herein. By way of nonlimiting example, heating elements may be interchanged with electromagnetic radiation sources (e.g., a microwave source) when the matrix material comprises a component capable of converting electromagnetic radiation to heat (e.g., nanoparticles, carbon particles, and the like). Further, by way of nonlimiting example, paper wrappers may be interchanged with release wrappers.

[0094] In some embodiments, porous mass sections, porous masses, and/or porous mass lengths may be produced at linear speeds of about 800 m/min or less, including by methods that involve very slow linear speeds of less than about 1 m/min. As used herein, the term "linear speed" refers to the speed along a single production line in contrast to a production speed that may encompass several production lines in parallel, which may be along individual apparatuses, within a single apparatus, or a combination thereof. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths may be produced by methods described herein at linear speeds that range from a lower limit of about 1 m/min, 10 m/min, 50 m/min, or 100 m/min to an upper limit of about 800 m/min, 600 m/min, 500 m/min, 300 m/min, or 100 m/min, and wherein the linear speed may range from any lower limit to any upper limit and encompass any subset therebetween. One skilled in the art

would recognized that productivity advancements in machinery may enable linear speeds of greater than 800 m/min (*e.g.*, 1000 m/min or greater). One of ordinary skill in the art should also understand that a single apparatus may include multiple lines (*e.g.*, two or more lines of Figure 7 or other lines illustrated herein) in parallel so as to increase the overall production rate of porous masses and the like, *e.g.*, to several thousand m/min or greater.

[0095] Some embodiments may involve further processing of porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise). Suitable further processing may include, but not be limited to, doping with a flavorant or other additive, grinding, drilling out, further shaping, forming multi-segmented filters, forming smoking devices, packaging, shipping, and any combination thereof.

[0096] Some embodiments may involve doping matrix materials, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) with an additive. Nonlimiting examples of additives are provided below. Suitable doping methods may include, but not be limited to, including the additives in the matrix material; by applying the additives to at least a portion of the matrix material before mechanical bonding; by applying the additives after mechanical bonding while in the mold cavity; by applying the additives after leaving the mold cavity; by applying the additives after cutting; and any combination thereof. It should be noted that applying includes, but is not limited to, dipping, immersing, submerging, soaking, rinsing, washing, painting, coating, showering, drizzling, spraying, placing, dusting, sprinkling, affixing, and any combination thereof. Further, it should be noted that applying includes, but is not limited to, surface treatments, infusion treatments where the additive incorporates at least partially into a component of the matrix material, and any combination thereof. One skilled in the art with the benefit of this disclosure should understand the concentration of the additive will depend at least on the composition of the additive, the size of the additive, the purpose of the additive, and the point in the process in which the additive is included.

[0097] In some embodiments, doping with an additive may occur before, during, and/or after mechanically bonding the matrix materials. One skilled in the art with the benefit of this disclosure should understand that additives which degrade, change, or are otherwise affected by the mechanical bonding process and associated parameter (*e.g.*, elevated temperatures and/or

pressures) should be added after mechanical bonding and/or the parameters should be adjusted accordingly (e.g., use of inert gases or reduced temperatures). By way of nonlimiting example, glass beads may be an additive in the matrix material. Then, after mechanical bonding, the glass beads may be functionalized with other additives like flavorants and/or active compounds.

[0098] Some embodiments may involve grinding porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) after being produced. Grinding includes those methods and apparatuses/components described above.

[0099] Some embodiments may involve operably connecting porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) to filters and/or filter sections. Suitable filters and/or filter sections may include, but not be limited to, those that comprise a section that comprises cavities, other porous masses, polypropylenes, polyethylenes, polyolefin tows, polypropylene tows, polyethylene terephthalates, polybutylene terephthalates, random oriented acetates, papers, corrugated papers, concentric filters, carbon-on-tow, silica, magnesium silicate, zeolites, molecular sieves, salts, catalysts, sodium chloride, nylon, flavorants, tobacco, capsules, cellulose, cellulosic derivatives, cellulose acetate, catalytic converters, iodine pentoxide, coarse powders, carbon particles, carbon fibers, fibers, glass beads, nanoparticles, void chambers, baffled void chambers, cellulose acetate tow with less than about 10 denier per filament, cellulose acetate tow with about 10 denier per filament or greater, and any combination thereof.

[0100] In some embodiments, a filter section may comprise a space that defines a cavity between two filter sections (one section including porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise)). The cavity may, in some embodiments, be filled with an additive, e.g., granulated carbon or a flavorant. The cavity may, in some embodiments, contain a capsule, e.g., a polymeric capsule, that itself contains a flavorant or catalyst. The cavity, in some embodiments, may also contain a molecular sieve that reacts with selected components in the smoke to remove or reduce the concentration of the components without adversely affecting desirable flavor constituents of the smoke. In an embodiment, the cavity may include tobacco as an additional flavorant. One should note that if the cavity is insufficiently filled with a chosen substance, in some embodiments, this may create a lack of

interaction between the components of the mainstream smoke and the substance in the cavity and in the other filter section(s).

[0101] Some embodiments may involve operably connecting smokeable substances to porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) (or segmented filters comprising at least one of the foregoing). In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) (or segmented filters comprising at least one of the foregoing) may be in fluid communication with a smokeable substance. In some embodiments, a smoking device may comprise porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) (or segmented filters comprising at least one of the foregoing) in fluid communication with a smokeable substance. In some embodiments, a smoking device may comprise a housing operably capable of maintaining porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) (or segmented filters comprising at least one of the foregoing) in fluid communication with a smokeable substance. In some embodiments, filter rods, filters, filter sections, sectioned filters, and/or sectioned filter rods may be removable, replaceable, and/or disposable from the housing.

[0102] As used herein, the term "smokeable substance" refers to a material capable of producing smoke when burned or heated. Suitable smokeable substances may include, but not be limited to, tobaccos, *e.g.*, bright leaf tobacco, Oriental tobacco, Turkish tobacco, Cavendish tobacco, corajo tobacco, criollo tobacco, Perique tobacco, shade tobacco, white burley tobacco, flue-cured tobacco, Burley tobacco, Maryland tobacco, Virginia tobacco; teas; herbs; carbonized or pyrolyzed components; inorganic filler components; and any combination thereof. Tobacco may have the form of tobacco lamina in cut filler form, processed tobacco stems, reconstituted tobacco filler, volume expanded tobacco filler, or the like. Tobacco, and other grown smokeable substances, may be grown in the United States, or may be grown in a jurisdiction outside the United States.

[0103] In some embodiments, a smokeable substance may be in a column format, *e.g.*, a tobacco column. As used herein, the term "tobacco column" refers to the blend of tobacco, and optionally other ingredients and flavorants that may be combined to produce a tobacco-based smokeable article, such as a cigarette or cigar. In some embodiments, the tobacco column may

comprise ingredients selected from the group consisting of: tobacco, sugar (such as sucrose, brown sugar, invert sugar, or high fructose corn syrup), propylene glycol, glycerol, cocoa, cocoa products, carob bean gums, carob bean extracts, and any combination thereof. In still other embodiments, the tobacco column
5 may further comprise flavorants, aromas, menthol, licorice extract, diammonium phosphate, ammonium hydroxide, and any combination thereof. In some embodiments, tobacco columns may comprise additives. In some embodiments, tobacco columns may comprise at least one bendable element.

[0104] Suitable housings may include, but not be limited to, cigarettes,
10 cigarette holders, cigars, cigar holders, pipes, water pipes, hookahs, electronic smoking devices, roll-your-own cigarettes, roll-your-own cigars, papers, and any combination thereof.

[0105] Packaging porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may include, but not be limited to, placing
15 in trays or boxes or protective containers, *e.g.*, trays typically used for packaging and transporting cigarette filter rods.

[0106] In some embodiments, the present invention provides a pack of filters and/or smoking devices with filters that comprises porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise). The pack
20 may be a hinge-lid pack, a slide-and-shell pack, a hard-cup pack, a soft-cup pack, a plastic bag, or any other suitable pack container. In some embodiments, the packs may have an outer wrapping, such as a polypropylene wrapper, and optionally a tear tab. In some embodiments, the filters and/or smoking devices may be sealed as a bundle inside a pack. A bundle may contain a number of
25 filters and/or smoking devices, for example, 20 or more. However, a bundle may include a single filter and/or smoking device, in some embodiments, such as exclusive filter and/or smoking device embodiments like those for individual sale, or a filter and/or smoking device comprising a specific spice, like vanilla, clove, or cinnamon.

[0107] In some embodiments, the present invention provides a carton
30 of smoking device packs that includes at least one pack of smoking devices that includes at least one smoking device with a filter (multi-segmented or otherwise) that comprises porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise). In some embodiments, the carton (*e.g.*, a
35 container) has the physical integrity to contain the weight from the packs of

smoking devices. This may be accomplished through thicker cardstock being used to form the carton or stronger adhesives being used to bind elements of the carton.

[0108] Some embodiments may involve shipping porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise). Said porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may be as individuals, as at least a portion of filters, as at least a portion of smoking devices, in packs, in carton, in trays, and any combination thereof. Shipping may be by train, truck, airplane, boat/ship, and any combination thereof.

[0109] In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have a void volume in the range of about 40% to about 90%. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have a void volume of about 60% to about 90%. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have a void volume of about 60% to about 85%. Void volume is the free space left after accounting for the space taken by the active particles.

[0110] To determine void volume, although not wishing to be limited by any particular theory, it is believed that testing indicates that the final density of the mixture was driven almost entirely by the active particle; thus the space occupied by the binder particles was not considered for this calculation. Thus, void volume, in this context, is calculated based on the space remaining after accounting for the active particles. To determine void volume, first the upper and lower diameters based on the mesh size were averaged for the active particles, and then the volume was calculated (assuming a spherical shape based on that averaged diameter) using the density of the active material. Then, the percentage void volume is calculated as follows:

$$\text{Void Volume (\%)} = 1 - \frac{[(\text{porous mass volume, cm}^3) - (\text{Weight of active particles, gm}) / (\text{density of the active particles, gm/cm}^3)] * 100}{\text{porous mass volume, cm}^3}$$

[0111] In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have an encapsulated pressure drop (EPD) in the range of about 0.10 to about 25 mm of water per

mm length of porous mass. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have an EPD in the range of about 0.10 to about 10 mm of water per mm length of porous mass. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have an EPD of about 2 to about 7 mm of water per mm length of porous mass (or no greater than 7 mm of water per mm length of porous mass).

[0112] In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have an active particle loading of at least about 1 mg/mm, 2 mg/mm, 3 mg/mm, 4 mg/mm, 5 mg/mm, 6 mg/mm, 7 mg/mm, 8 mg/mm, 9 mg/mm, 10 mg/mm, 11 mg/mm, 12 mg/mm, 13 mg/mm, 14 mg/mm, 15 mg/mm, 16 mg/mm, 17 mg/mm, 18 mg/mm, 19 mg/mm, 20 mg/mm, 21 mg/mm, 22 mg/mm, 23 mg/mm, 24 mg/mm, or 25 mg/mm in combination with an EPD of less than about 20 mm of water or less per mm of length, 19 mm of water or less per mm of length, 18 mm of water or less per mm of length, 17 mm of water or less per mm of length, 16 mm of water or less per mm of length, 15 mm of water or less per mm of length, 14 mm of water or less per mm of length, 13 mm of water or less per mm of length, 12 mm of water or less per mm of length, 11 mm of water or less per mm of length, 10 mm of water or less per mm of length, 9 mm of water or less per mm of length, 8 mm of water or less per mm of length, 7 mm of water or less per mm of length, 6 mm of water or less per mm of length, 5 mm of water or less per mm of length, 4 mm of water or less per mm of length, 3 mm of water or less per mm of length, 2 mm of water or less per mm of length, or 1 mm of water or less per mm of length.

[0113] By way of example, in some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may have an active particle loading of at least about 1 mg/mm and an EPD of about 20 mm of water or less per mm of length. In other embodiments, the porous mass may have an active particle loading of at least about 1 mg/mm and an EPD of about 20 mm of water or less per mm of length, wherein the active particle is not carbon. In other embodiments, the porous mass may have an active particle comprising carbon with a loading of at least 6 mg/mm in combination with an EPD of 10 mm of water or less per mm of length.

[0114] In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may be effective at the removal of components from tobacco smoke, for example, those in the listing herein. Porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) may be used to reduce the delivery of certain tobacco smoke components targeted by the World Health Organization Framework Convention on Tobacco Control ("WHO FCTC"). By way of nonlimiting example, a porous mass where activated carbon is used as the active particles can be used to reduce the delivery of certain tobacco smoke components to levels below the WHO FCTC recommendations. The components may, in some embodiments, include, but not be limited to, acetaldehyde, acrolein, benzene, benzo[a]pyrene, 1,3-butadiene, and formaldehyde. Porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) with activated carbon may reduce acetaldehydes in a smoke stream by about 3.0% to about 6.5%/mm length of porous mass; acrolein in a smoke stream by about 7.5% to about 12%/mm length of porous mass; benzene in a smoke stream by about 5.5% to about 8.0%/mm length of porous mass; benzo[a]pyrene in a smoke stream by about 9.0% to about 21.0%/mm length of porous mass; 1,3-butadiene in a smoke stream by about 1.5% to about 3.5%/mm length of porous mass; and formaldehyde in a smoke stream by about 9.0% to about 11.0%/mm length of porous mass. In another example, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) where an ion exchange resin is used as the active particles can be used to reduce the delivery of certain tobacco smoke components to below the WHO recommendations. In some embodiments, porous mass sections, porous masses, and/or porous mass lengths (wrapped or otherwise) having an ion exchange resin may reduce: acetaldehydes in a smoke stream by about 5.0% to about 7.0%/mm length of porous mass; acrolein in a smoke stream by about 4.0% to about 6.5%/mm length of porous mass; and formaldehyde in a smoke stream by about 9.0% to about 11.0%/mm length of porous mass. One of ordinary skill in the art should understand that the values reported here relative to the concentration of specific smoke stream components may vary by test protocol and tobacco blend. The reductions cited herein refer to carbonyl testing by a method similar to the CORESTA Recommended Method No. 74, Determination of Selected Carbonyls in Mainstream Cigarette Smoke by High Performance Liquid Chromatography, using the Health Canada Intense Smoking

Protocol. The sample cigarettes were prepared from a US commercial brand by manually replacing the standard cellulose acetate filter with a dual segmented filter consisting of porous mass segments and cellulose acetate segments. The length of the porous mass segment varied between 5 and 15 mm.

5 **[0115]** There may be any weight ratio of active particles to binder particles in the matrix material. In some embodiments, the matrix material may comprise active particles in an amount ranging from a lower limit of about 1 wt%, 5 wt%, 10 wt%, 25 wt%, 40 wt%, 50 wt%, 60 wt%, or 75 wt% of the matrix material to an upper limit of about 99 wt%, 95 wt%, 90 wt%, or 75 wt%
10 of the matrix material, and wherein the amount of active particles can range from any lower limit to any upper limit and encompass any subset therebetween. In some embodiments, the matrix material may comprise binder particles in an amount ranging from a lower limit of about 1 wt%, 5 wt%, 10 wt%, or 25 wt% of the matrix material to an upper limit of about 99 wt%, 95
15 wt%, 90 wt%, 75 wt%, 60 wt%, 50 wt%, 40 wt%, or 25 wt% of the matrix material, and wherein the amount of binder particles can range from any lower limit to any upper limit and encompass any subset therebetween.

[0116] The active particles may be any material adapted to enhance smoke flowing thereover. Adapted to enhance smoke flowing thereover refers to
20 any material that can remove, reduce, or add components to a smoke stream. The removal or reduction (or addition) may be selective. By way of example, in the smoke stream from a cigarette, compounds such as those shown below in the following listing may be selectively removed or reduced. This table is available from the U.S. FDA as a Draft Proposed Initial List of Harmful/Potentially
25 Harmful Constituents in Tobacco Products, including Tobacco Smoke; any abbreviations in the below listing are well-known chemicals in the art. In some embodiments, the active particle may reduce or remove at least one component selected from the listing of components in smoke below, including any combination thereof. Smoke stream components may include, but not be limited
30 to, acetaldehyde, acetamide, acetone, acrolein, acrylamide, acrylonitrile, aflatoxin B-1, 4-aminobiphenyl, 1-aminonaphthalene, 2-aminonaphthalene, ammonia, ammonium salts, anabasine, anatabine, O-anisidine, arsenic, A- α -C, benz[a]anthracene, benz[b]fluoroanthene, benz[j]aceanthrylene, benz[k]fluoroanthene, benzene, benzo(b)furan, benzo[a]pyrene,
35 benzo[c]phenanthrene, beryllium, 1,3-butadiene, butyraldehyde, cadmium,

caffeic acid, carbon monoxide, catechol, chlorinated dioxins/furans, chromium,
 chrysene, cobalt, coumarin, a cresol, crotonaldehyde, cyclopenta[c,d]pyrene,
 dibenz(a,h)acridine, dibenz(a,j)acridine, dibenz[a,h]anthracene,
 dibenzo(c,g)carbazole, dibenzo[a,e]pyrene, dibenzo[a,h]pyrene,
 5 dibenzo[a,i]pyrene, dibenzo[a,l]pyrene, 2,6-dimethylaniline, ethyl carbamate
 (urethane), ethylbenzene, ethylene oxide, eugenol, formaldehyde, furan, glu-P-
 1, glu-P-2, hydrazine, hydrogen cyanide, hydroquinone, indeno[1,2,3-cd]pyrene,
 IQ, isoprene, lead, MeA- α -C, mercury, methyl ethyl ketone, 5-methylchrysene,
 4-(methylnitrosamino)-1-(3-pyridyl)-1-butanone (NNK), 4-(methylnitrosamino)-
 10 1-(3-pyridyl)-1-butanol (NNAL), naphthalene, nickel, nicotine, nitrate, nitric
 oxide, a nitrogen oxide, nitrite, nitrobenzene, nitromethane, 2-nitropropane, N-
 nitrosoanabasine (NAB), N-nitrosodiethanolamine (NDELA), N-
 nitrosodiethylamine, N-nitrosodimethylamine (NDMA), N-
 nitrosoethylmethylamine, N-nitrosomorpholine (NMOR), N-nitrosornicotine
 15 (NNN), N-nitrosopiperidine (NPIP), N-nitrosopyrrolidine (NPYR), N-
 nitrososarcosine (NSAR), phenol, PhIP, polonium-210 (radio-isotope),
 propionaldehyde, propylene oxide, pyridine, quinoline, resorcinol, selenium,
 styrene, tar, 2-toluidine, toluene, Trp-P-1, Trp-P-2, uranium-235 (radio-isotope),
 uranium-238 (radio-isotope), vinyl acetate, vinyl chloride, and any combination
 20 thereof.

[0117] One example of an active material is activated carbon (or
 activated charcoal or active coal). The activated carbon may be of any activity
 that is available (e.g., carbon capable of 60% CCl₄ adsorption). In some
 embodiments, the active carbon may be nano-scaled carbon particle, such as
 25 carbon nanotubes of any number of walls, carbon nanohorns, bamboo-like
 carbon nanostructures, fullerenes and fullerene aggregates, and graphene
 including few layer graphene and oxidized graphene. Other examples of such
 materials include ion exchange resins, desiccants, silicates, molecular sieves,
 silica gels, activated alumina, zeolites, perlite, sepiolite, Fuller's Earth,
 30 magnesium silicate, metal oxides (e.g., iron oxide and iron oxide nanoparticles
 like about 12 nm Fe₃O₄), nanoparticles (e.g., metal nanoparticles like gold and
 silver; metal oxide nanoparticles like alumina; magnetic, paramagnetic, and
 superparamagnetic nanoparticles like gadolinium oxide, various crystal
 structures of iron oxide like hematite and magnetite, gado-nanotubes, and
 35 endofullerenes like Gd@C₆₀; and core-shell and onionated nanoparticles like gold

and silver nanoshells, onionated iron oxide, and other nanoparticles or microparticles with an outer shell of any of said materials) and any combination of the foregoing (including activated carbon). It should be noted that nanoparticles include nanorods, nanospheres, nanorices, nanowires, nanostars (like nanotripods and nanotetrapods), hollow nanostructures, hybrid nanostructures that are two or more nanoparticles connected as one, and non-nano particles with nano-coatings or nano-thick walls. It should be further noted that nanoparticles include the functionalized derivatives of nanoparticles including, but not limited to, nanoparticles that have been functionalized covalently and/or non-covalently, *e.g.*, pi-stacking, physisorption, ionic association, van der Waals association, and the like. Suitable functional groups may include, but not be limited to, moieties comprising amines (1°, 2°, or 3°), amides, carboxylic acids, aldehydes, ketones, ethers, esters, peroxides, silyls, organosilanes, hydrocarbons, aromatic hydrocarbons, and any combination thereof; polymers; chelating agents like ethylenediamine tetraacetate, diethylenetriaminepentaacetic acid, triglycollamic acid, and a structure comprising a pyrrole ring; and any combination thereof. Functional groups may enhance removal of smoke components and/or enhance incorporation of nanoparticles into a porous mass. Ion exchange resins include, for example, a polymer with a backbone, such as styrene-divinyl benzene (DVB) copolymer, acrylates, methacrylates, phenol formaldehyde condensates, and epichlorohydrin amine condensates; and a plurality of electrically-charged functional groups attached to the polymer backbone. In some embodiments, the active particles are a combination of various active particles. In some embodiments, the porous mass may comprise multiple active particles. In some embodiments, an active particle may comprise at least one element selected from the group of active particles disclosed herein. It should be noted that "element" is being used as a general term to describe items in a list. In some embodiments, the active particles are combined with at least one flavorant.

[0118] Suitable active particles may have at least one dimension of about less than one nanometer, such as graphene, to as large as a particle having a diameter of about 5000 microns. Active particles may range from a lower size limit in at least one dimension of about: 0.1 nanometers, 0.5 nanometers, 1 nanometer, 10 nanometers, 100 nanometers, 500 nanometers, 1 micron, 5 microns, 10 microns, 50 microns, 100 microns, 150 microns, 200

microns, or 250 microns. The active particles may range from an upper size limit in at least one dimension of about: 5000 microns, 2000 microns, 1000 microns, 900 microns, 700 microns, 500 microns, 400 microns, 300 microns, 250 microns, 200 microns, 150 microns, 100 microns, 50 microns, 10 microns, or 500 nanometers. Any combination of lower limits and upper limits above may be suitable for use in the present invention, wherein the selected maximum size is greater than the selected minimum size. In some embodiments, the active particles may be a mixture of particle sizes ranging from the above lower and upper limits. In some embodiments, the size of the active particles may be polymodal.

[0119] The binder particles may be any suitable thermoplastic binder particles. In one embodiment, the binder particles exhibit virtually no flow at its melting temperature. This means a material that when heated to its melting temperature exhibits little to no polymer flow. Materials meeting these criteria include, but are not limited to, ultrahigh molecular weight polyethylene, very high molecular weight polyethylene, high molecular weight polyethylene, and combinations thereof. In one embodiment, the binder particles have a melt flow index (MFI, ASTM D1238) of less than or equal to about 3.5 g/10min at 190°C and 15 kg (or about 0-3.5 g/10min at 190°C and 15 kg). In another embodiment, the binder particles have a melt flow index (MFI) of less than or equal to about 2.0 g/10min at 190°C and 15 Kg (or about 0-2.0 g/10min at 190°C and 15 kg). One example of such a material is ultra high molecular weight polyethylene, UHMWPE (which has no polymer flow, MFI of about 0, at 190°C and 15 kg, or an MFI of about 0-1.0 at 190°C and 15 kg); another material may be very high molecular weight polyethylene, VHMWPE (which may have MFIs in the range of, for example, about 1.0-2.0 g/10min at 190°C and 15 kg); or high molecular weight polyethylene, HMWPE (which may have MFIs of, for example, about 2.0-3.5 g/10min at 190°C and 15 kg). In some embodiments, it may be preferable to use a mixture of binder particles having different molecular weights and/or different melt flow indexes.

[0120] In terms of molecular weight, "ultra-high molecular weight polyethylene" as used herein refers to polyethylene compositions with weight-average molecular weight of at least about 3×10^6 g/mol. In some embodiments, the molecular weight of the ultra-high molecular weight polyethylene composition is between about 3×10^6 g/mol and about 30×10^6

g/mol, or between about 3×10^6 g/mol and about 20×10^6 g/mol, or between about 3×10^6 g/mol and about 10×10^6 g/mol, or between about 3×10^6 g/mol and about 6×10^6 g/mol. "Very-high molecular weight polyethylene" refers to polyethylene compositions with a weight average molecular weight of less than about 3×10^6 g/mol and more than about 1×10^6 g/mol. In some embodiments, the molecular weight of the very-high molecular weight polyethylene composition is between about 2×10^6 g/mol and less than about 3×10^6 g/mol. "High molecular weight polyethylene" refers to polyethylene compositions with weight-average molecular weight of at least about 3×10^5 g/mol to 1×10^6 g/mol. For purposes of the present specification, the molecular weights referenced herein are determined in accordance with the Margolies equation ("Margolies molecular weight").

[0121] Suitable polyethylene materials are commercially available from several sources including GUR[®] UHMWPE from Ticona Polymers LLC, a division of Celanese Corporation of Dallas, TX, and DSM (Netherlands), Braskem (Brazil), Beijing Factory No. 2 (BAAF), Shanghai Chemical, and Qilu (People's Republic of China), Mitsui and Asahi (Japan). Specifically, GUR[®] polymers may include: GUR[®] 2000 series (2105, 2122, 2122-5, 2126), GUR[®] 4000 series (4120, 4130, 4150, 4170, 4012, 4122-5, 4022-6, 4050-3/4150-3), GUR[®] 8000 series (8110, 8020), GUR[®] X series (X143, X184, X168, X172, X192).

[0122] One example of a suitable polyethylene material is that having an intrinsic viscosity in the range of about 5 dl/g to about 30 dl/g and a degree of crystallinity of about 80% or more as described in U.S. Patent Application Publication No. 2008/0090081. Another example of a suitable polyethylene material is that having a molecular weight in the range of about 300,000 g/mol to about 2,000,000 g/mol as determined by ASTM-D 4020, an average particle size, D_{50} , between about 300 μm and about 1500 μm , and a bulk density between about 0.25 g/ml and about 0.5 g/ml as described in U.S. Provisional Application No. 61/330,535 filed May 3, 2010.

[0123] The binder particles may assume any shape. Such shapes include spherical, hyperion, asteroidal, chondular or interplanetary dust-like, granulated, potato, irregular, or combinations thereof. In preferred embodiments, the binder particles suitable for use in the present invention are non-fibrous. In some embodiments the binder particles are in the form of a

powder, pellet, or particulate. In some embodiments, the binder particles are a combination of various binder particles.

[0124] In some embodiments, the binder particles may range from a lower size limit in at least one dimension of about: 0.1 nanometers, 0.5 nanometers, 1 nanometer, 10 nanometers, 100 nanometers, 500 nanometers, 1 micron, 5 microns, 10 microns, 50 microns, 100 microns, 150 microns, 200 microns, and 250 microns. The binder particles may range from an upper size limit in at least one dimension of about: 5000 microns, 2000 microns, 1000 microns, 900 microns, 700 microns, 500 microns, 400 microns, 300 microns, 250 microns, 200 microns, 150 microns, 100 microns, 50 microns, 10 microns, and 500 nanometers. Any combination of lower limits and upper limits above may be suitable for use in the present invention, wherein the selected maximum size is greater than the selected minimum size. In some embodiments, the binder particles may be a mixture of particle sizes ranging from the above lower and upper limits. In some embodiments, smaller diameter particles may be advantageous in faster heating for binding of the binder particles together, which may be especially useful in high-throughput processes for producing porous masses described herein.

[0125] While the ratio of binder particle size to active particle size can include any iteration as dictated by the size ranges for each described herein, specific size ratios may be advantageous for specific applications and/or products. By way of nonlimiting example, in smoking device filters the sizes of the active particles and binder particles should be such that the EPD allows for drawing fluids through the porous mass. In some embodiments, the ratio of binder particle size to active particle size may range from about 10:1 to about 1:10, or more preferably range from about 1:1.5 to about 1:4.

[0126] Additionally, the binder particles may have a bulk density in the range of about 0.10 g/cm³ to about 0.55 g/cm³. In another embodiment, the bulk density may be in the range of about 0.17 g/cm³ to about 0.50 g/cm³. In yet another embodiment, the bulk density may be in the range of about 0.20 g/cm³ to about 0.47 g/cm³.

[0127] In addition to the foregoing binder particles, other conventional thermoplastics may be used as binder particles. Such thermoplastics include, but are not limited to, polyolefins, polyesters, polyamides (or nylons), polyacrylics, polystyrenes, polyvinyls, polytetrafluoroethylene (PTFE), polyether ether ketone

(PEEK), any copolymer thereof, any derivative thereof, and any combination thereof. Non-fibrous plasticized cellulose derivatives may also be suitable for use as binder particles in the present invention. Examples of suitable polyolefins include, but are not limited to, polyethylene, polypropylene, polybutylene, polymethylpentene, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable polyethylenes further include low-density polyethylene, linear low-density polyethylene, high-density polyethylene, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable polyesters include polyethylene terephthalate, polybutylene terephthalate, polycyclohexylene dimethylene terephthalate, polytrimethylene terephthalate, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable polyacrylics include, but are not limited to, polymethyl methacrylate, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable polystyrenes include, but are not limited to, polystyrene, acrylonitrile-butadiene-styrene, styrene-acrylonitrile, styrene-butadiene, styrene-maleic anhydride, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable polyvinyls include, but are not limited to, ethylene vinyl acetate, ethylene vinyl alcohol, polyvinyl chloride, any copolymer thereof, any derivative thereof, any combination thereof, and the like. Examples of suitable cellulose derivatives include, but are not limited to, cellulose acetate, cellulose acetate butyrate, plasticized cellulose derivatives, cellulose propionate, ethyl cellulose, any copolymer thereof, any derivative thereof, any combination thereof, and the like. In some embodiments, a binder particle may be any copolymer, any derivative, and any combination of the above listed binders.

[0128] In some embodiments, matrix materials and/or porous masses may comprise active particles, binder particles, and additives. In some embodiments, the matrix material or porous masses may comprise additives in an amount ranging from a lower limit of about 0.01 wt%, 0.05 wt%, 0.1 wt%, 1 wt%, 5 wt%, or 10 wt% of the matrix material or porous masses to an upper limit of about 25 wt%, 15 wt%, 10 wt%, 5 wt%, or 1 wt% of the matrix material or porous masses, and wherein the amount of additives can range from any lower limit to any upper limit and encompass any subset therebetween. It should

be noted that porous masses as referenced herein include porous mass lengths, porous masses, and porous mass sections (wrapped or otherwise).

[0129] Suitable additives may include, but not be limited to, active compounds, ionic resins, zeolites, nanoparticles, microwave enhancement additives, ceramic particles, glass beads, softening agents, plasticizers, pigments, dyes, flavorants, aromas, controlled release vesicles, adhesives, tackifiers, surface modification agents, vitamins, peroxides, biocides, antifungals, antimicrobials, antistatic agents, flame retardants, degradation agents, and any combination thereof.

[0130] Suitable active compounds may be compounds and/or molecules suitable for removing components from a smoke stream including, but not limited to, malic acid, potassium carbonate, citric acid, tartaric acid, lactic acid, ascorbic acid, polyethyleneimine, cyclodextrin, sodium hydroxide, sulphamic acid, sodium sulphamate, polyvinyl acetate, carboxylated acrylate, and any combination thereof. It should be noted that an active particle may also be considered an active compound, and vice versa. By way of nonlimiting example, fullerenes and some carbon nanotubes may be considered to be a particulate and a molecule.

[0131] Suitable ionic resins may include, but not be limited to, polymers with a backbone, such as styrene-divinyl benzene (DVB) copolymer, acrylates, methacrylates, phenol formaldehyde condensates, and epichlorohydrin amine condensates; a plurality of electrically charged functional groups attached to the polymer backbone; and any combination thereof.

[0132] Zeolites may include crystalline aluminosilicates having pores, *e.g.*, channels, or cavities of uniform, molecular-sized dimensions. Zeolites may include natural and synthetic materials. Suitable zeolites may include, but not be limited to, zeolite BETA ($\text{Na}_7(\text{Al}_7\text{Si}_{57}\text{O}_{128})$ tetragonal), zeolite ZSM-5 ($\text{Na}_n(\text{Al}_n\text{Si}_{96-n}\text{O}_{192}) \cdot 16 \text{ H}_2\text{O}$, with $n < 27$), zeolite A, zeolite X, zeolite Y, zeolite K-G, zeolite ZK-5, zeolite ZK-4, mesoporous silicates, SBA-15, MCM-41, MCM48 modified by 3-aminopropylsilyl groups, alumino-phosphates, mesoporous aluminosilicates, other related porous materials (*e.g.*, such as mixed oxide gels), and any combination thereof.

[0133] Suitable nanoparticles may include, but not be limited to, nano-scaled carbon particles like carbon nanotubes of any number of walls, carbon nanohorns, bamboo-like carbon nanostructures, fullerenes and fullerene

aggregates, and graphene including few layer graphene and oxidized graphene; metal nanoparticles like gold and silver; metal oxide nanoparticles like alumina, silica, and titania; magnetic, paramagnetic, and superparamagnetic nanoparticles like gadolinium oxide, various crystal structures of iron oxide like hematite and magnetite, about 12 nm Fe_3O_4 , gado-nanotubes, and endofullerenes like $\text{Gd}@C_{60}$; and core-shell and onionated nanoparticles like gold and silver nanoshells, onionated iron oxide, and other nanoparticles or microparticles with an outer shell of any of said materials) and any combination of the foregoing (including activated carbon). It should be noted that nanoparticles may include nanorods, nanospheres, nanorices, nanowires, nanostars (like nanotripods and nanotetrapods), hollow nanostructures, hybrid nanostructures that are two or more nanoparticles connected as one, and non-nano particles with nano-coatings or nano-thick walls. It should be further noted that nanoparticles may include the functionalized derivatives of nanoparticles including, but not limited to, nanoparticles that have been functionalized covalently and/or non-covalently, *e.g.*, pi-stacking, physisorption, ionic association, van der Waals association, and the like. Suitable functional groups may include, but not be limited to, moieties comprising amines (1° , 2° , or 3°), amides, carboxylic acids, aldehydes, ketones, ethers, esters, peroxides, silyls, organosilanes, hydrocarbons, aromatic hydrocarbons, and any combination thereof; polymers; chelating agents like ethylenediamine tetraacetate, diethylenetriaminepentaacetic acid, triglycollamic acid, and a structure comprising a pyrrole ring; and any combination thereof. Functional groups may enhance removal of smoke components and/or enhance incorporation of nanoparticles into a porous mass.

[0134] Suitable microwave enhancement additives may include, but not be limited to, microwave responsive polymers, carbon particles, fullerenes, carbon nanotubes, metal nanoparticles, water, and the like, and any combination thereof.

[0135] Suitable ceramic particles may include, but not be limited to, oxides (*e.g.*, silica, titania, alumina, beryllia, ceria, and zirconia), nonoxides (*e.g.*, carbides, borides, nitrides, and silicides), composites thereof, and any combination thereof. Ceramic particles may be crystalline, non-crystalline, or semi-crystalline.

[0136] As used herein, pigments refer to compounds and/or particles that impart color and are incorporated throughout the matrix material and/or a component thereof. Suitable pigments may include, but not be limited to, titanium dioxide, silicon dioxide, tartrazine, E102, phthalocyanine blue, phthalocyanine green, quinacridones, perylene tetracarboxylic acid di-imides, dioxazines, perinones disazo pigments, anthraquinone pigments, carbon black, titanium dioxide, metal powders, iron oxide, ultramarine, and any combination thereof.

[0137] As used herein, dyes refer to compounds and/or particles that impart color and are a surface treatment. Suitable dyes may include, but not be limited to, CARTASOL[®] dyes (cationic dyes, available from Clariant Services) in liquid and/or granular form (e.g., CARTASOL[®] Brilliant Yellow K-6G liquid, CARTASOL[®] Yellow K-4GL liquid, CARTASOL[®] Yellow K-GL liquid, CARTASOL[®] Orange K-3GL liquid, CARTASOL[®] Scarlet K-2GL liquid, CARTASOL[®] Red K-3BN liquid, CARTASOL[®] Blue K-5R liquid, CARTASOL[®] Blue K-RL liquid, CARTASOL[®] Turquoise K-RL liquid/granules, CARTASOL[®] Brown K-BL liquid), FASTUSOL[®] dyes (an auxochrome, available from BASF) (e.g., Yellow 3GL, Fastusol C Blue 74L).

[0138] Suitable flavorants may be any flavorant suitable for use in smoking device filters including those that impart a taste and/or a flavor to the smoke stream. Suitable flavorants may include, but not be limited to, organic material (or naturally flavored particles), carriers for natural flavors, carriers for artificial flavors, and any combination thereof. Organic materials (or naturally flavored particles) include, but are not limited to, tobacco, cloves (e.g., ground cloves and clove flowers), cocoa, coffee, teas, and the like. Natural and artificial flavors may include, but are not limited to, menthol, cloves, cherry, chocolate, orange, mint, mango, vanilla, cinnamon, tobacco, and the like. Such flavors may be provided by menthol, anethole (licorice), anisole, limonene (citrus), eugenol (clove), and the like, and any combination thereof. In some embodiments, more than one flavorant may be used including any combination of the flavorants provided herein. These flavorants may be placed in the tobacco column or in a section of a filter. Additionally, in some embodiments, the porous masses of the present invention may comprise a flavorant. The amount to include will depend on the desired level of flavor in the smoke taking into account all filter sections,

the length of the smoking device, the type of smoking device, the diameter of the smoking device, as well as other factors known to those of skill in the art.

[0139] Suitable aromas may include, but not be limited to, methyl formate, methyl acetate, methyl butyrate, ethyl acetate, ethyl butyrate, isoamyl acetate, pentyl butyrate, pentyl pentanoate, octyl acetate, myrcene, geraniol, nerol, citral, citronellal, citronellol, linalool, nerolidol, limonene, camphor, terpeneol, alpha-ionone, thujone, benzaldehyde, eugenol, cinnamaldehyde, ethyl maltol, vanilla, anisole, anethole, estragole, thymol, furaneol, methanol, spices, spice extracts, herb extracts, essential oils, smelling salts, volatile organic compounds, volatile small molecules, methyl formate, methyl acetate, methyl butyrate, ethyl acetate, ethyl butyrate, isoamyl acetate, pentyl butyrate, pentyl pentanoate, octyl acetate, myrcene, geraniol, nerol, citral, citronellal, citronellol, linalool, nerolidol, limonene, camphor, terpeneol, alpha-ionone, thujone, benzaldehyde, eugenol, cinnamaldehyde, ethyl maltol, vanilla, anisole, anethole, estragole, thymol, furaneol, methanol, rosemary, lavender, citrus, freesia, apricot blossoms, greens, peach, jasmine, rosewood, pine, thyme, oakmoss, musk, vetiver, myrrh, blackcurrant, bergamot, grapefruit, acacia, passiflora, sandalwood, tonka bean, mandarin, neroli, violet leaves, gardenia, red fruits, ylang-ylang, acacia farnesiana, mimosa, tonka bean, woods, ambergris, daffodil, hyacinth, narcissus, black currant bud, iris, raspberry, lily of the valley, sandalwood, vetiver, cedarwood, neroli, bergamot, strawberry, carnation, oregano, honey, civet, heliotrope, caramel, coumarin, patchouli, dewberry, helonial, bergamot, hyacinth, coriander, pimento berry, labdanum, cassie, bergamot, aldehydes, orchid, amber, benzoin, orris, tuberose, palmarosa, cinnamon, nutmeg, moss, styrax, pineapple, bergamot, foxglove, tulip, wisteria, clematis, ambergris, gums, resins, civet, peach, plum, castoreum, myrrh, geranium, rose violet, jonquil, spicy carnation, galbanum, hyacinth, petitgrain, iris, hyacinth, honeysuckle, pepper, raspberry, benzoin, mango, coconut, hesperides, castoreum, osmanthus, mousse de chene, nectarine, mint, anise, cinnamon, orris, apricot, plumeria, marigold, rose otto, narcissus, tolu balsam, frankincense, amber, orange blossom, bourbon vetiver, opopanax, white musk, papaya, sugar candy, jackfruit, honeydew, lotus blossom, muguet, mulberry, absinthe, ginger, juniper berries, spicebush, peony, violet, lemon, lime, hibiscus, white rum, basil, lavender, balsamics, fo-ti-tieng, osmanthus, karo karunde, white orchid, calla lilies, white rose, rhubrum lily, tagetes, ambergris, ivy, grass,

seringa, spearmint, clary sage, cottonwood, grapes, brimbelle, lotus, cyclamen, orchid, glycine, tiare flower, ginger lily, green osmanthus, passion flower, blue rose, bay rum, cassie, African tagetes, Anatolian rose, Auvergne narcissus, British broom, British broom chocolate, Bulgarian rose, Chinese patchouli, Chinese gardenia, Calabrian mandarin, Comoros Island tuberose, Ceylonese cardamom, Caribbean passion fruit, Damascena rose, Georgia peach, white Madonna lily, Egyptian jasmine, Egyptian marigold, Ethiopian civet, Farnesian cassie, Florentine iris, French jasmine, French jonquil, French hyacinth, Guinea oranges, Guyana wacapua, Grasse petitgrain, Grasse rose, Grasse tuberose, Haitian vetiver, Hawaiian pineapple, Israeli basil, Indian sandalwood, Indian Ocean vanilla, Italian bergamot, Italian iris, Jamaican pepper, May rose, Madagascar ylang-ylang, Madagascar vanilla, Moroccan jasmine, Moroccan rose, Moroccan oakmoss, Moroccan orange blossom, Mysore sandalwood, Oriental rose, Russian leather, Russian coriander, Sicilian mandarin, South African marigold, South American tonka bean, Singapore patchouli, Spanish orange blossom, Sicilian lime, Reunion Island vetiver, Turkish rose, Thai benzoin, Tunisian orange blossom, Yugoslavian oakmoss, Virginian cedarwood, Utah yarrow, West Indian rosewood, and the like, and any combination thereof.

[0140] Suitable tackifiers may include, but not be limited to, methylcellulose, ethylcellulose, hydroxyethylcellulose, carboxy methylcellulose, carboxy ethylcellulose, water-soluble cellulose acetate, amides, diamines, polyesters, polycarbonates, silyl-modified polyamide compounds, polycarbamates, urethanes, natural resins, shellacs, acrylic acid polymers, 2-ethylhexylacrylate, acrylic acid ester polymers, acrylic acid derivative polymers, acrylic acid homopolymers, anacrylic acid ester homopolymers, poly(methyl acrylate), poly(butyl acrylate), poly(2-ethylhexyl acrylate), acrylic acid ester co-polymers, methacrylic acid derivative polymers, methacrylic acid homopolymers, methacrylic acid ester homopolymers, poly(methyl methacrylate), poly(butyl methacrylate), poly(2-ethylhexyl methacrylate), acrylamido-methyl-propane sulfonate polymers, acrylamido-methyl-propane sulfonate derivative polymers, acrylamido-methyl-propane sulfonate co-polymers, acrylic acid/acrylamido-methyl-propane sulfonate co-polymers, benzyl coco di-(hydroxyethyl) quaternary amines, p-T-amyl-phenols condensed with formaldehyde, dialkyl amino alkyl (meth)acrylates, acrylamides, N-(dialkyl amino alkyl) acrylamide, methacrylamides, hydroxy alkyl (meth)acrylates, methacrylic acids, acrylic acids,

hydroxyethyl acrylates, and the like, any derivative thereof, and any combination thereof.

[0141] Suitable vitamins may include, but not be limited to, vitamin A, vitamin B1, vitamin B2, vitamin C, vitamin D, vitamin E, and any combination thereof.

[0142] Suitable antimicrobials may include, but not be limited to, anti-microbial metal ions, chlorhexidine, chlorhexidine salt, triclosan, polymyxin, tetracycline, amino glycoside (*e.g.*, gentamicin), rifampicin, bacitracin, erythromycin, neomycin, chloramphenicol, miconazole, quinolone, penicillin, nonoxynol 9, fusidic acid, cephalosporin, mupirocin, metronidazole, secropin, protegrin, bacteriolcin, defensin, nitrofurazone, mafenide, acyclovir, vancomycin, clindamycin, lincomycin, sulfonamide, norfloxacin, pefloxacin, nalidizic acid, oxalic acid, enoxacin acid, ciprofloxacin, polyhexamethylene biguanide (PHMB), PHMB derivatives (*e.g.*, biodegradable biguanides like polyethylene hexaniethylene biguanide (PEHMB)), chlorhexidine gluconate, chlorhexidine hydrochloride, ethylenediaminetetraacetic acid (EDTA), EDTA derivatives (*e.g.*, disodium EDTA or tetrasodium EDTA), the like, and any combination thereof.

[0143] Antistatic agents may, in some embodiments, comprise any suitable anionic, cationic, amphoteric or nonionic antistatic agent. Anionic antistatic agents may generally include, but not be limited to, alkali sulfates, alkali phosphates, phosphate esters of alcohols, phosphate esters of ethoxylated alcohols, and any combination thereof. Examples may include, but not be limited to, alkali neutralized phosphate ester (*e.g.*, TRYFAC® 5559 or TRYFRAC® 5576, available from Henkel Corporation, Mauldin, SC). Cationic antistatic agents may generally include, but not be limited to, quaternary ammonium salts and imidazolines which possess a positive charge. Examples of nonionics include the poly(oxyalkylene) derivatives, *e.g.*, ethoxylated fatty acids like EMEREST® 2650 (an ethoxylated fatty acid, available from Henkel Corporation, Mauldin, SC), ethoxylated fatty alcohols like TRYCOL® 5964 (an ethoxylated lauryl alcohol, available from Henkel Corporation, Mauldin, SC), ethoxylated fatty amines like TRYMEEN® 6606 (an ethoxylated tallow amine, available from Henkel Corporation, Mauldin, SC), alkanolamides like EMID® 6545 (an oleic diethanolamine, available from Henkel Corporation, Mauldin, SC), and any combination thereof. Anionic and cationic materials tend to be more effective antistatic agents.

[0144] It should be noted that while porous masses, and the like, are discussed herein primarily for smoking device filters, porous masses, and the like, may be used as fluid filters (or parts thereof) in other applications including, but not limited to, liquid filtration, water purification, air filters in motorized vehicles, air filters in medical devices, air filters for household use, and the like. One skilled in the arts, with the benefit of this disclosure, should understand the necessary modification and/or limitations to adapt this disclosure for other filtration applications, *e.g.*, size, shape, size ratio of matrix material components, and composition of matrix material components. By way of nonlimiting example, matrix materials could be molded to other shapes like hollow cylinders for a concentric water filter configuration or pleated sheets for an air filter.

[0145] In some embodiments, a system may include a material path with a mold cavity disposed along the material path, at least one hopper before at least a portion of the mold cavity for feeding a matrix material to the material path, a heat source in thermal communication with at least a first portion of the material path, and a cutter disposed along the material path after the first portion of the material path.

[0146] Some embodiments may include continuously introducing a matrix material into a mold cavity and disposing a release wrapper as a liner of the mold cavity. Further, said embodiments may include heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length and cutting the porous mass length radially thereby yielding a porous mass.

[0147] Some embodiments may include continuously introducing a matrix material into a mold cavity, heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length, and extruding the porous mass length through a die.

[0148] In some embodiments, a system may include a mold cavity comprising at least two mold cavity parts where a first conveyer includes a first mold cavity part and a second conveyer include a second mold cavity part. Said first conveyer and second conveyer may be capable of bringing together the first mold cavity part and the second mold cavity part to form the mold cavity and then separating the first mold cavity part from the second mold cavity part in a continuous fashion. The system may further include a hopper capable for filling

the mold cavity with a matrix material and a heat source in thermal communication with at least a first portion of the mold cavity for transforming the matrix material into a porous mass.

[0149] Some embodiments may include introducing a matrix material into a plurality of mold cavities and heating the matrix material in the mold cavities so as to bind the matrix material at a plurality of contact points, thereby forming a porous mass.

[0150] To facilitate a better understanding of the present invention, the following examples of representative embodiments are given. In no way should the following examples be read to limit, or to define, the scope of the invention.

EXAMPLES

[0151] *Example 1.* To measure integrity, samples are placed in a French square glass bottle and shaken vigorously using a wrist action shaker for 5 minutes. Upon completion, the weight of the samples before and after shaking are compared. The difference is converted to a percent loss value. This test simulates deterioration under extreme circumstances. Less than 2% weight loss is assumed to be acceptable quality.

[0152] Porous mass samples were produced with GUR 2105 with carbon additive and GUR X192 with carbon additive were produced both with and without paper wrappings. Said samples were cylinders measuring 8 mm x 20 mm. The results of the integrity test are given below in Table 1.

Table 1

GUR	Carbon:GUR Ratio	Percent Loss (with paper)	Percent Loss (no paper)
2105	85:15	0.94%	2.64%
2105	80:20	0.59%	3.45%
2105	75:25	0.23%	0.57%
2105	70:30	0.14%	1.00%
X192	80:20	34.51%	60.89%
X192	75:25	13.88%	43.78%
X192	70:30	8.99%	14.33%
plasticized carbon-on- tow filter	4.01 mg/mm carbon	0.98%	n/a

[0153] This example demonstrates that increasing the percent of binder (GUR) in the porous mass and including a wrapper (paper) enhances the integrity of the porous mass. Further, porous masses can be designed to have comparable integrity to a Dalmatian filter (plasticized carbon-on-tow filter), which is used for increased removal of smoke components.

[0154] *Example 2.* To measure the amount of particles released when a fluid is drawn through a filter (or porous mass), samples are dry puffed and the particles released are collected on a Cambridge pad.

[0155] The particle release characteristics of porous masses were compared to a Dalmatian filter (plasticized carbon-on-tow filter). Samples were cylinders measuring 8 mm x 20 mm of (1) a porous mass with 333 mg of carbon, (2) a porous mass with 338 mg of carbon having been water washed, and (3) a Dalmatian filter with 74 mg of carbon. Table 2 below shows the results of the particle release test.

Table 2

Sample	Initial Carbon Loading (mg)	mg Carbon/mm filter length	Carbon Loss (mg)	mg Carbon Loss/g Initial Carbon Loading
porous mass	333	16.65	0.18	0.53
washed porous mass	338	16.9	0.073	0.22
Dalmatian filter	74	3.7	0.15	2.07

[0156] This example demonstrates that porous masses have comparable particle amounts that are released upon drawing as compared to Dalmatian filters even with many times more carbon loading, 4.5 times more in this example. Further, particle release can be mitigated with porous masses with treatments like washing. Other mitigating steps could be increasing the binder concentration in the porous mass, increasing the degree of mechanical binding in the porous mass (e.g., by increasing the time at binding temperatures), optimizing the size and shape of the additive (e.g., carbon), and the like.

[0157] *Example 3.* A matrix material of 80% carbon (PICATIF, 60% active carbon available from Jacobi) and 20% GUR® 2105 were mixed and poured into paper tubes plugged at one end. The filled tubes were placed

irradiated for 75 seconds in a microwave (about 300 W and about 2.45 GHz). A significant portion of the matrix material had bonded together and was cut into two sections, 17 mm and 21 mm. The sections of porous mass were analyzed and demonstrated EPDs of 8.4 mm of water/mm of length and 2.7 mm of water/mm of length, respectively.

[0158] This example demonstrates the applicability of microwave irradiation in the production of porous masses and the like. As discussed above, microwave irradiation may, in some embodiments, be used in addition to other heating techniques in the formation of porous masses and the like described herein.

[0159] Therefore, the present invention is well adapted to attain the ends and advantages mentioned as well as those that are inherent therein. The particular embodiments disclosed above are illustrative only, as the present invention may be modified and practiced in different but equivalent manners apparent to those skilled in the art having the benefit of the teachings herein. Furthermore, no limitations are intended to the details of construction or design herein shown, other than as described in the claims below. It is therefore evident that the particular illustrative embodiments disclosed above may be altered, combined, or modified and all such variations are considered within the scope and spirit of the present invention. The invention illustratively disclosed herein suitably may be practiced in the absence of any element that is not specifically disclosed herein and/or any optional element disclosed herein. While compositions and methods are described in terms of "comprising," "containing," or "including" various components or steps, the compositions and methods can also "consist essentially of" or "consist of" the various components and steps. All numbers and ranges disclosed above may vary by some amount. Whenever a numerical range with a lower limit and an upper limit is disclosed, any number and any included range falling within the range is specifically disclosed. In particular, every range of values (of the form, "from about a to about b," or, equivalently, "from approximately a to b," or, equivalently, "from approximately a-b") disclosed herein is to be understood to set forth every number and range encompassed within the broader range of values. Also, the terms in the claims have their plain, ordinary meaning unless otherwise explicitly and clearly defined by the patentee. Moreover, the indefinite articles "a" or "an," as used in the claims, are defined herein to mean one or more than one of the element that it

introduces. If there is any conflict in the usages of a word or term in this specification and one or more patent or other documents that may be incorporated herein by reference, the definitions that are consistent with this specification should be adopted.

CLAIMS

The invention claimed is:

1. A method comprising:
continuously combining a matrix material and a paper wrapper to
form a desired cross-sectional shape where the matrix material is confined by
the paper wrapper, the matrix material comprising a binder particle and an
active particle;
heating at least a portion of the matrix material so as to bind the
matrix material at a plurality of contact points thereby forming a porous mass
length, wherein heating involves irradiating with microwave radiation the at least
a portion of the matrix material;
cooling the porous mass length; and
cutting the porous mass length radially thereby producing a porous
mass.
2. The method of claim 1, wherein the paper wrapper is removable
from the porous mass.
3. The method of claim 1, wherein the matrix material has a moisture
content of about 5% by weight or less.
4. The method of claim 1, wherein the porous mass is produced at a
linear speed of about 800 m/min or less.
5. The method of claim 1, wherein irradiating with microwave
radiation occurs in a residence time of about 10 seconds or less.
6. The method of claim 1, wherein the matrix material is indexed and
a spacer is disposed between the indexed matrix material.
7. The method of claim 1, wherein heating is to a temperature at or
above a softening temperature of the at least a portion of the matrix material.
8. The method of claim 1, wherein cooling is passive.
9. The method of claim 1 further comprising:
operably connecting the porous mass with a filter or a filter section
not comprising the porous mass so as to form a segmented filter.
10. The method of claim 9 further comprising:
operably connecting the segmented filter with a tobacco column to
form a smoking device.
11. A method comprising:
continuously combining a matrix material and a paper wrapper to

form a desired cross-sectional shape where the matrix material is confined by the paper wrapper, the matrix material comprising a binder particle and an active particle that comprises a plurality of carbon particles;

heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points thereby forming a porous mass length, wherein heating involves irradiating with microwave radiation the at least a portion of the matrix material;

cooling the porous mass length; and

cutting the porous mass length radially thereby producing a porous mass.

12. The method of claim 11, wherein the matrix material has a moisture content of about 5% by weight or less.

13. The method of claim 11, wherein the porous mass is produced at a linear speed of about 800 m/min or less.

14. The method of claim 11, wherein irradiating with microwave radiation occurs in a residence time of about 10 seconds or less.

15. The method of claim 11, wherein the matrix material is indexed and a spacer is disposed between the indexed matrix material.

16. The method of claim 11, wherein heating is to a temperature at or above a softening temperature of the at least a portion of the matrix material.

17. The method of claim 11 further comprising:

operably connecting the porous mass with a filter or a filter section not comprising the porous mass so as to form a segmented filter.

18. The method of claim 17 further comprising:

operably connecting the segmented filter with a tobacco column to form a smoking device.

19. A method comprising:

continuously combining a matrix material and a paper wrapper to form a desired cross-sectional shape where the matrix material is confined by the paper wrapper, the matrix material comprising a binder particle and an active particle that comprises a plurality of carbon particles;

heating at least a portion of the matrix material so as to bind the matrix material at a plurality of contact points, thereby forming a porous mass length, wherein heating involves irradiating with microwave radiation the at least a portion of the matrix material, and wherein irradiating with microwave

radiation occurs in a residence time of about 10 seconds or less; and

wherein the porous mass length is produced at a linear speed of about 800 m/min or less.

20. The method of claim 19, wherein the matrix material has a moisture content of about 5% by weight or less.