

FILTER DISK SEGMENTS

BACKGROUND OF THE INVENTION

[0001] Commercially available filter disk segments include a plurality of separately produced components, for example, a spacer, filter media, and a slotted support. However, there is a need for improved filter disk segments.

[0002] The present invention provides for ameliorating at least some of the disadvantages of the prior art. These and other advantages of the present invention will be apparent from the description as set forth below.

BRIEF SUMMARY OF THE INVENTION

[0003] An aspect of the invention provides a filter disk segment comprising (a) a filter element disk comprising a central hub having a central hub opening; (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end, and a lower surface facing a drainage component; (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component and a lower surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end; (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening; wherein the central hub supports the first porous component, the second porous component, and the drainage component.

[0004] In another aspect of the invention, a filter disk segment is provided comprising (a) a filter element disk comprising a central hub having a central hub opening; (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the

second end, and a lower surface facing a drainage component, the lower surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end; (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component, the upper surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end, and a lower surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the second end; (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening; wherein the central hub supports the first porous component, the second porous component, and the drainage component.

[0005] Another aspect of the invention comprises a filter device comprising at least two filter disk segments according to an aspect of the invention, the filter device comprising an inlet and an outlet and defining a fluid flow path between the inlet and the outlet, with the at least two filter disk segments arranged in the housing across the fluid flow path.

[0006] A method of filtering fluid according to an aspect of the invention is also provided, the method comprising passing the fluid through at least one filter disk segment, preferably, at least two filter disk segments, more preferably passing the fluid through a filter device comprising at least two filter disk segments according to an aspect of the invention.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWING(S)

[0007] Figure 1A is a perspective view of two filter disk segments each having two porous components according to an aspect of the invention, wherein the filter disk segments do not show the drainage component between the porous components, before welding the edges of each filter segment together; Figure 1B shows the filter disk segments shown in Figure 1A, wherein the edges of each filter disk segment are welded together; Figure 1C is an exploded view of a commercially available filter disk segment.

[0008] Figure 2A is an enlarged diagrammatic partial cross-sectional view showing fluid flow through a portion of the filter disk segment according to an aspect of the invention, also showing that fluid passing through the curved fluid flow channel accesses more surface area;

Figure 2B is an enlarged diagrammatic partial cross-sectional view showing fluid flow through a portion of a commercially available filter disk segment.

[0009] Figure 3A is a diagrammatic view showing fluid flow through the gap between adjacent filter disk segments before passing through the filter media according to an aspect of the invention, also showing less flow area due to raised fluid flow channels, resulting in lower residence time in the gap; Figure 3B is a diagrammatic view showing fluid flow through the gap due to the spacer between adjacent filter disk segments before passing through the filter media in a commercially available filter disk segment.

[0010] Figure 4A is a top view of a filter element disk including a porous component according to an aspect of the invention; Figure 4B is a bottom view of the filter element disk including the porous component shown in Figure 4A, also showing the cross-sectional areas of the fluid flow channels decreasing from the outer end of the element disk toward the inner end by the central hub of the element disk; Figure 4C is a side view of the porous component shown in Figure 4A; Figure 4D is an enlarged view of region “A” shown in Figure 4C; and Figure 4E is a cross-sectional view along line B-B of the porous component of the filter element disk shown in Figure 4A.

[0011] Figure 5A is an isometric top view of a filter disk segment according to an aspect of the invention (before sealing the edges); Figure 5B is a partial cut-away view of the filter disk segment shown in Figure 5A, also showing the drainage component between the porous components; Figure 5C is a side view of the filter disk segment shown in Figure 5A; Figure 5D is an enlarged view of region “A” shown in Figure 5C; and Figure 5E shows fluid flow channels in one porous component through the other porous component in broken lines.

[0012] Figure 6A is a perspective view of a filter device including a housing and a filter unit comprising porous filter comprising plurality of disk segments arranged on a hollow aperture central core between end caps wherein the filter unit is arranged in the housing according to an aspect of the invention; Figure 6B is a cross-sectional view of the device shown in Figure 6A.

[0013] Figure 7 shows filter disk segments sealed at the edges.

[0014] Figure 8A is an isometric top view of a filter disk segment according to another aspect of the invention, including upper and lower porous components each having a plurality of raised porous ribs on one side, and a plurality of fluid flow channels on the other side (before sealing the edges); Figure 8B is an enlarged view of region “A” shown in Figure 8A (Figure 8B showing one porous component); and Figure 8C is an enlarged view of region “B” shown in Figure 8A (Figure 8C showing one porous component).

[0015] Figure 9A is a perspective view of another assembled filter disk segment including filter element disks as shown in Figure 8A (before sealing the edges); Figure 9B is an enlarged view of region “A” shown in Figure 9A; and Figure 9C is an enlarged view of region “B” shown in Figure 9A.

DETAILED DESCRIPTION OF THE INVENTION

[0016] In accordance with an aspect of the invention, a filter disk segment comprises (a) a filter element disk comprising a central hub having a central hub opening; (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end, and a lower surface facing a drainage component; (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component and a lower surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end; (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening; wherein the central hub supports the first porous component, the second porous component, and the drainage component.

[0017] In another aspect of the invention, a filter disk segment is provided comprising (a) a filter element disk comprising a central hub having a central hub opening; (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the

second end, and a lower surface facing a drainage component, the lower surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end; (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component, the upper surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end, and a lower surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the second end; (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening; wherein the central hub supports the first porous component, the second porous component, and the drainage component.

[0018] In typical aspects, each of the at least two raised fluid flow channels in the first porous component and in the second porous component extend continuously from the first end to the second end.

[0019] In some aspects, the at least two raised fluid flow channels in the first porous component are offset from the at least two raised fluid flow channels in the second porous component.

[0020] In some aspects, each of the at least two raised porous ribs and each of the at least two fluid flow channels in the first porous component and in the second porous component extend continuously from the first end to the second end.

[0021] In some aspects, the at least two raised porous ribs in the first porous component are offset from the at least two fluid flow channels in the first porous component, and the at least two raised porous ribs in the second porous component are offset from the at least two fluid flow channels in the second porous component.

[0022] In typical aspects, each of the at least two raised fluid flow channels and/or each of the at least two raised porous ribs in the first porous component and in the second porous component are curved in shape between the first end and the second end. Channel curvature can remain at a constant pitch or can vary continuously along the length of a channel.

[0023] In typical aspects, each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that change between the first end and the second end, preferably, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that decrease from the second end to the first end.

[0024] In the preferred aspects, the ratio between the channel width at the first end to the channel width at the second end is greater than 1, and decreases going outward from the first end to the second end, advantageously keeping the fluid flow rate through the channel at a desirably high rate. For example, the ratio can be in the range from greater to 1 to about 8.

[0025] In a typical aspect, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component have an open area in the respective lower surface or upper surface facing the drainage component.

[0026] A variety of fluid flow channel heights or depths are suitable for use in aspects of the invention. Typically, the height/depth is at least about .04;" in some aspects, in the range of from about .04" to about 0.125".

[0027] A variety of fluid flow channel widths are suitable for use in aspects of the invention. For example, in those aspects wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that decrease from the second end to the first end, the channel width to channel height/depth ratio at the first end is typically in the range of from about 0.12 to about 8, in some aspects, about 1.5

[0028] Porous components can have any number of fluid flow channels and/or raised porous ribs. Typically, the number of fluid flow channels is in the range of from 4 to about 120.

[0029] For efficient fluid flow, there is typically a space between adjacent filter disk segments, typically, a space between the exterior flat portions of the porous components of adjacent filter disk elements of the adjacent filter disk segments of at least about twice the height of the height of the raised channels and/or raised ribs on a single filter element disk.

[0030] Another aspect of the invention comprises a porous filter comprising at least two filter disk segments according to an aspect of the invention.

[0031] Another aspect of the invention comprises a filter device comprising a porous filter comprising at least two filter disk segments according to an aspect of the invention, the filter device comprising an inlet and an outlet and defining a fluid flow path between the inlet and the outlet, with the porous filter arranged in the housing across the fluid flow path.

[0032] A method of filtering fluid according to an aspect of the invention is also provided, the method comprising passing the fluid through at least one filter disk segment, preferably, at least two filter disk segments, more preferably passing the fluid through a filter device comprising at least two filter disk segments according to an aspect of the invention.

[0033] In one preferred aspect of a method for filtering fluid according to the invention, the fluid is passed from the outside of the filter disk segment(s) through the inside (e.g., through the central hub). Illustratively, in operation, a fluid is passed, into the filter disk segments through the top and bottom porous components (filtering media), forming a filtrate that is passed through the drainage component, and the filtrate passes along the fluid flow channels to the central hub and through the outlet of the filter device.

[0034] Advantageously, filter disk segments can be produced with fewer components while eliminating a manufacturing step. Additionally, increased effective filter area can be provided while preserving desirable residence time, without resulting in excess residence time that could degrade the filter media. Eliminating a component such as a separate slotted support plate reduces the disk segment height (thickness) allowing more disk segments to fit in the previously used housings, thus providing increased filtering efficiency. The use of raised fluid flow channels and/or raised ribs can provide additional effective filter areas compared to flat disks of media. Alternatively, or additionally, the raised fluid flow channels and/or raised ribs can provide spacing between adjacent filter disk segments, which can assist in efficient fluid flow.

[0035] Each of the components of the invention will now be described in more detail below, wherein like components have like reference numbers.

[0036] Figures 1A and 1B show a perspective view of two assembled filter disk segments 500 according to an aspect of the invention, each filter disk segment comprising a filter element disk 400 comprising a central hub 401 (in some embodiments the central hub is welded to the porous component) having a central hub opening 402; (i) a first porous component 100 including a first end 101 by the central hub opening 402, and a second end 102 distal to the first end, the first porous component having an upper surface 110 including at least two raised fluid flow channels 112 having porous walls 112A and inner diameters 112B (see Figure 2A), each of the at least two raised fluid flow channels extending toward the first end and the second end (illustrated as curved, and continuous from one end to the other), and a lower surface 120 facing (as shown in Figure 5B) the upper surface 310 of a drainage component 300; (ii) a second porous component 200 including a first end 201 by the central hub opening 402, and a second end 202 distal to the first end, the second porous component having an upper surface 220, facing (as shown in Figure 5B, *see also*, Figure 4B) the lower surface 320 of the drainage component, and a lower surface 210 including at least two raised fluid flow channels 212 having porous walls 212A, each of the at least two raised fluid flow channels extending toward the first end and the second end (illustrated as curved, and continuous from one end to the other); (iii) the drainage component 300 (Figure 5B) allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening 402; wherein the central hub 401 supports the first porous component 100, the second porous component 200, and the drainage component 300. As shown in Figures 1B and 7, the edges of each filter disk segment are sealed (e.g., shown as weld 800) together.

[0037] Typically, the porous components are identical, and one porous component is inverted and the first and second porous components are placed together resulting in the fluid flow channels on the respective porous components curving in opposite directions. As will be discussed in more detail below, adjacent filter disk segments are arranged such that the filter element disc of a first filter disk segment has fluid flow channels curved in one direction and the filter element disc of the second filter disk segment (that faces the filter element disc of the first filter disk segment) has fluid flow channels curved in the other direction (*see*, Figure 3A; *see also*, Figure 5E showing the fluid flow channels in the upper and lower porous components of a filter disk segment curving in opposite directions).

[0038] Figure 1C is an exploded view of two commercially available filter disk segment. In contrast with the aspect of the filter disk segments 500 shown in Figures 1A and 1B, wherein each segment has two porous components and a single drainage component between the porous component, each commercially available filter disk segment has two layers of porous media, two layers of mesh, a slotted support, and a separate intersegment spacer is present between adjacent segments.

[0039] Figure 2A shows fluid flow through the porous wall 112A of the raised flow channel 112 having an inner diameter 112B according to the aspect of the filter disk segment shown in Figure 1A (212A, 212, 212B arranged the same way), illustrating fluid flow accessing more filter surface area before passing through drainage component 300, in contrast with, as shown in Figure 2B, fluid flow through the porous media of the commercially available filter disk segment, wherein the fluid flow accesses less filter surface area.

[0040] Figure 3A is a diagrammatic view showing fluid flow through the gap between adjacent filter disk segments 500 (between the lower porous component of one filter disc segment and the upper porous component of the next filter disc segment, the porous component having flow channels curved in opposite directions) before passing through the porous components (filter media) 100, 200 according to an aspect of the invention, also showing less flow area due to raised fluid flow channels 112, 212 (the raised flow channels take up space and reduce flow volume in the gap between filter disk segments), resulting in lower residence time in the gap, thus minimizing polymer burning; Figure 3B is a diagrammatic view showing fluid flow through the gap between adjacent filter disk segments due to the spacer between adjacent filter disk segments before passing through the filter media in a commercially available filter disk segment, wherein an increased residence time can result in increased polymer burning.

[0041] Figure 4A is a top view of a porous component 100, 200 of a filter element disk 400 according to an aspect of the invention.

[0042] In typical aspects, each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that change between the first end and the second end, preferably, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component

have cross-sectional areas that increase from the second end to the first end. Figure 4B is a bottom view of the aspect of the porous component 101, 201 of the filter element disc 400 shown in Figure 4A, also showing the respective surfaces 120, 220, and the cross-sectional areas of the fluid flow channels 112 (112B), 212 (212B) increasing from the second (outer) end 102, 202 of the element disc toward the first (inner) end 101, 201 by the central hub opening 402; Figure 4C is a side view of the aspect of the porous component of a filter element disc shown in Figure 4A; Figure 4D is an enlarged view of region “A” shown in Figure 4C; and Figure 4E is a cross-sectional view along line B-B of the porous component of the filter element disc shown in Figure 4A, also showing central hub 401, central hub opening 402, and the ends of flow channels 112, 212 at the first (inner) ends 101, 201.

[0043] Figures 5A and 5B are isometric top views of a filter disk segment 500 including filter element disk 400 according to an aspect of the invention including porous components 100, 200 and central hub 401, wherein the central hubs are welded to the porous components, the drainage component 300 (as shown in Figure 5B) having an upper surface 310 and a lower surface 320, welded edge of filter disk segment not shown; Figure 5C is a side view of the filter disk segment shown in Figure 5A; Figure 5D is an enlarged view of region “A” shown in Figure 5C, showing the respective fluid flow channels 112 and 212 are offset from each other. Preferably, the first and second porous components are identical, so when placed on opposite sides of the drainage component in forming a filter disk segment, the fluid flow channels 112, 212 in the respective porous components 100, 200, are curved in opposite directions, as shown in Figure 5E (wherein fluid flow channels 212 are shown through porous component 100 in broken lines).

[0044] Figure 6A is a perspective view of an aspect of a filter device 1000 including a housing 900 having an inlet 901 and an outlet 902, and, as shown in the cross-sectional view of the device in Figure 6B, a filter unit 700 comprising porous filter 600 comprising plurality of disk segments 500 (or 500’ as described below) arranged on a hollow perforated central core 703 (perforations 704) between end caps 701 (open end cap), 702 (closed end cap) wherein the filter unit is arranged in the housing according to an aspect of the invention.

[0045] Figure 7 shows a plurality of filter disk segments 500 (or 500’ as described below) forming porous filter 600 (arranged for outside to inside fluid flow and through the central

hub of the disk segments), also showing space between adjacent filter disk segments, wherein each filter disk segment is sealed (e.g., welded) at the edges.

[0046] Figure 8A is an isometric top view of first and second porous component 100', 200' of filter element disk 400' providing a filter disk segment 500' according to another aspect of the invention (drainage component not shown between porous components 100' and 200'), having first (inner) ends 101', 201' and second (outer) ends 102', 202' and including a plurality of raised porous ribs 115, 215 (with respective porous walls 115A, 215A) on one surface 110', 210', and a plurality of fluid flow channels 116, 216 with porous walls 116A, 216A and having inner diameters 116B, 216B in the other surface 120', 220', wherein the fluid flow channels 116, 216 are offset from each other at the second ends 102', 202'; Figure 8B is an enlarged view of region "A" (showing a single porous component representing the first and second porous components) including the first ends 101', 201' shown in Figure 8A; and Figure 8C is an enlarged view of region "B" (showing a single porous component representing the first and second porous components) including the second ends 102', 202' shown in Figure 8A. Typically, the first and second porous components are identical, so when placed on opposite sides of the drainage component in the respective porous components curved in opposite directions) the flow channels are slightly or completely offset from each other the second ends, though they can be aligned at the second ends if desired.

[0047] Advantageously, the raised porous ribs can assist in providing spacing between adjacent filter element disks.

[0048] Figure 9A is a perspective view of an assembled filter disk segment 500' including porous components as shown in Figure 8A, wherein the fluid flow channels 116, 216 are slightly offset from each other with some overlap at the second ends 102', 202'; Figure 9B is an enlarged view of region "A" shown in Figure 9A; and Figure 9C is an enlarged view of region "B" shown in Figure 9A.

[0049] The porous components can have any suitable pore structure, e.g., a pore size (for example, as evidenced by bubble point, or by K_L as described in, for example, U.S. Patent 4,340,479, or evidenced by capillary condensation flow porometry), a mean flow pore (MFP) size (e.g., when characterized using a porometer, for example, a Porvair Porometer (Porvair plc, Norfolk, UK), or a porometer available under the trademark POROLUX (Porometer.com; Belgium)), a pore rating, a pore diameter (e.g., when characterized using the

modified OSU F2 test as described in, for example, U.S. Patent 4,925,572), or removal rating. The pore structure used depends on the size of the particles to be utilized, the composition of the fluid to be treated, and the desired effluent level of the treated fluid.

[0050] Typically, the porous components 100, 200, 100', 200' each have a pore size in the range from about 0.5 microns to about 100 microns.

[0051] The drainage component 300, that can also provide support, is typically configured as a mesh or screen, having openings larger than the pore structure of the porous components. Preferably, the drainage component pressure drop of the drainage component is about 10% or less than the porous component pressure drop.

[0052] A filter disk segment can have any desired critical wetting surface tension (CWST, as defined in, for example, U.S. Patent 4,925,572). The CWST can be selected as is known in the art, e.g., as additionally disclosed in, for example, U.S. Patents 5,152,905, 5,443,743, 5,472,621, and 6,074,869.

[0053] The filter disk segment, preferably at least two filter disk segments, is/are typically disposed in a housing comprising at least one inlet and at least one outlet and defining at least one fluid flow path between the inlet and the outlet, wherein the filter disk segments) is/are across the fluid flow path, to provide a filter device. Preferably, the filter device is sterilizable. Any housing of suitable shape and providing at least one inlet and at least one outlet may be employed.

[0054] In some aspects, a filter unit comprises a porous filter comprising at least two filter disk segments. Optionally, the filter unit comprises a hollow aperture core. In some aspects, the filter unit further comprises end caps, and the filter unit is arranged in the filter device filter housing across the fluid flow path.

[0055] Porous components according to aspects of the invention are preferably monolithic, preferably manufactured via additive manufacturing (sometimes referred to as "additive layer manufacturing" or "3D printing"). They are typically formed by repeated depositions of a metal powder bound together with an activatable binder (e.g., binder jetting, sometimes referred to as "drop on powder"), typically followed by agglomerating the powder, e.g., by sintering.

[0056] Any suitable additive manufacturing equipment can be used, and a variety of production 3D printers are suitable and commercially available.

[0057] The following examples further illustrate the invention but, of course, should not be construed as in any way limiting its scope.

EXAMPLE 1

[0058] This example demonstrates the simulated performance of a filter disk segment according to an aspect of the invention in comparison to a commercially available filter disk segment having a separate slotted disk between the filter media, using a fixed upstream pressure.

[0059] A 12 inch nominal filter disk segment as generally shown in Figures 5A and 5B, having 54 fluid flow channels, about .08 media thickness and about .10 inch channel width at the hub in each filter element disc, and a commercially available filter disk segment (LEAF DISK, Pall Corporation, East Hills, NY) as generally shown in Figure 1C, are tested, using clean polyethylene terephthalate (PET) fluid and 522 psi upstream pressures.

[0060] The results are as follows:

	Aspect of invention	Commercially Available	
Downstream pressure (psi)	0	0	Same inlet and outlet pressures
Flow rate into disc segment (mL/min.)	217	191	Approx 15% higher
Maximum residence time (min.)	3.5	5.0	Lower residence time
Channel pressure (halfway down) (psi)	55	59	Similar
Pressure drop across media at OD (psi)	446	443	Similar
Pressure drop across media at hub (near ID) (psi)	513	506	Similar

Height of 1 disc (in.)	.286	.342	Greater number of discs can be fit into the same housing
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[0061] The results show a filter disc segment according to an aspect of the invention can provide a higher flow rate, reduced residence time, and allow an increased number of discs fit into the same housing in comparison to a commercially available disc segment with similar pressures and pressure drops.

EXAMPLE 2

[0062] This example demonstrates the simulated performance of a filter disk segment according to an aspect of the invention in comparison to a commercially available filter disk segment having a separate slotted disk between the filter media, using a fixed flow rate of 200 mL/min.

[0063] The tested filter disk segments and test fluid are as described in Example 1.

[0064] The results are as follows:

	Aspect of invention	Commercially Available	
Downstream pressure (psi)	0	0	
Upstream pressure (psi)	459	546	Approx 15% lower
Maximum residence time (min.)	3.31	5.0	Lower residence time
Channel pressure (halfway down) (psi)	50	57	Similar
Pressure drop across media at OD (psi)	379	463	Lower pressure drop
Pressure drop across media at hub (near ID) (psi)	448	532	Lower pressure drop

Height of 1 disc (in.)	.286	.342	Greater number of discs can be fit into the same housing
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[0065] The results show a filter disc segment according to an aspect of the invention can provide a lower downstream pressure, reduced residence time, lower pressure drops and allow an increased number of discs fit into the same housing in comparison to a commercially available disc segment in a test with a similar flow rate.

[0066] All references, including publications, patent applications, and patents, cited herein are hereby incorporated by reference to the same extent as if each reference were individually and specifically indicated to be incorporated by reference and were set forth in its entirety herein.

[0067] The use of the terms “a” and “an” and “the” and “at least one” and similar referents in the context of describing the invention (especially in the context of the following claims) are to be construed to cover both the singular and the plural, unless otherwise indicated herein or clearly contradicted by context. The use of the term “at least one” followed by a list of one or more items (for example, “at least one of A and B”) is to be construed to mean one item selected from the listed items (A or B) or any combination of at least two of the listed items (A and B), unless otherwise indicated herein or clearly contradicted by context. The terms “comprising,” “having,” “including,” and “containing” are to be construed as open-ended terms (i.e., meaning “including, but not limited to,”) unless otherwise noted. Recitation of ranges of values herein are merely intended to serve as a shorthand method of referring individually to each separate value falling within the range, unless otherwise indicated herein, and each separate value is incorporated into the specification as if it were individually recited herein. All methods described herein can be performed in any suitable order unless otherwise indicated herein or otherwise clearly contradicted by context. The use of any and all examples, or exemplary language (e.g., “such as”) provided herein, is intended merely to better illuminate the invention and does not pose a limitation on the scope of the invention unless otherwise claimed. No language in the specification should be construed as indicating any non-claimed element as essential to the practice of the invention.

[0068] Preferred aspects of this invention are described herein, including the best mode known to the inventors for carrying out the invention. Variations of those preferred aspects may become apparent to those of ordinary skill in the art upon reading the foregoing description. The inventors expect skilled artisans to employ such variations as appropriate, and the inventors intend for the invention to be practiced otherwise than as specifically described herein. Accordingly, this invention includes all modifications and equivalents of the subject matter recited in the claims appended hereto as permitted by applicable law. Moreover, any combination of the above-described elements in all possible variations thereof is encompassed by the invention unless otherwise indicated herein or otherwise clearly contradicted by context.

CLAIM(S):

1. A filter disk segment comprising
 - (a) a filter element disk comprising a central hub having a central hub opening;
 - (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end, and a lower surface facing a drainage component;
 - (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component and a lower surface including at least two raised fluid flow channels having porous walls, each of the at least two raised fluid flow channels extending toward the first end and the second end;
 - (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening;
 wherein the central hub supports the first porous component, the second porous component, and the drainage component.
2. A filter disk segment comprising
 - (a) a filter element disk comprising a central hub having a central hub opening;
 - (i) a first porous component including a first end by the central hub opening, and a second end distal to the first end, the first porous component having an upper surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the second end, and a

lower surface facing a drainage component, the lower surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end;

- (ii) a second porous component including a first end by the central hub opening, and a second end distal to the first end, the second porous component having an upper surface facing the drainage component, the upper surface including at least two fluid flow channels, each of the at least two fluid flow channels extending toward the first end and the second end, and a lower surface including at least two raised porous ribs, each of the at least two raised porous ribs extending toward the first end and the second end;
 - (iii) the drainage component allowing fluid flow therethrough arranged between, and in fluid communication with, the first porous component and the second porous component, the drainage component including the central hub opening;
- wherein the central hub supports the first porous component, the second porous component, and the drainage component.

3. The filter disk segment of claim 1, wherein the at least two raised fluid flow channels in the first porous component are offset from the at least two raised fluid flow channels in the second porous component.

4. The filter disk segment of claim 1 or 3, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component are curved in shape between the first end and the second end.

5. The filter disk segment of any one of claims 1, 3, or 4, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that change between the first end and the second end.

6. The filter disk segment of claim 2, wherein the at least two raised porous ribs in the first porous component are offset from the at least two fluid flow channels in the first

porous component, and the at least two raised porous ribs in the second porous component are offset from the at least two fluid flow channels in the second porous component.

7. The filter disk segment of claim 2 or 6, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component are curved in shape between the first end and the second end.

8. The filter disk segment of any one of claims 2, 6, or 7, wherein each of the at least two raised fluid flow channels in the first porous component and in the second porous component have cross-sectional areas that change between the first end and the second end.

9. A porous filter comprising at least two filter disk segments according to any one of claims 1-8.

10. A filter device comprising a housing having an inlet and an outlet and defining a fluid flow path between the inlet and the outlet and the porous filter of claim 9 arranged in the housing across the fluid flow path.

11. A method of filtering fluid, the method comprising passing the fluid through the filter device of claim 10.