

1 FILAMENT WOUND HOUSING FOR A
2 REVERSE OSMOSIS FILTER CARTRIDGE

3 FIELD OF THE INVENTION

4 The present invention relates to a housing for a
5 reverse osmosis filter cartridge. The housing utilizes a
6 unique assembly at each of its ends for sealing and
7 providing fluid connections to the housing ends.

8 BACKGROUND OF THE INVENTION

9 Reverse osmosis is a well-known process for the
10 separation of solvent from a solvent-solute solution. The
11 process utilizes a semipermeable membrane and high
12 pressures to selectively diffuse solvent molecules through
13 the membrane resulting in separation of pure solvent from
14 the solvent-solute solution.

15 Reverse osmosis systems typically utilize a
16 cylindrical filter having walls formed from a semipermeable
17 membrane material. A solvent-solute solution, from which
18 pure solvent is to be removed, is contacted with the outer
19 circumferential membrane wall of the filter. Upon
20 application of sufficient pressure to the solution and
21 filter exterior, i.e. typically at least about 100 psi and
22 often from about 500 psi to about 1500 psi, solution is
23 driven toward the interior of the filter. Pure solvent is
24 then typically collected from the ends of the filter.

25 Filter housings are provided for containing reverse
26 osmosis filters. The housings are commonly formed from
27 steel in view of the relatively high pressures existing
28 within the housing during separation. As will be
29 appreciated, steel housings are expensive and so have to
30 some extent, limited the applicability and use of reverse
31 osmosis systems.

32 Plastic filter housings have been introduced which

1 although satisfactory in many respects, still present
2 several significant drawbacks. Currently available plastic
3 filter housings for reverse osmosis filters utilize end
4 caps that are bonded or otherwise affixed to the filter
5 housing. Such attachment renders accessing the interior of
6 the housing exceedingly difficult. Even if an end cap is
7 successfully removed without damaging the cap or housing,
8 such as to replace a filter cartridge, the end cap must
9 then be re-attached. Re-attached end caps are often
10 susceptible to failure upon pressurization of the filter
11 housing. Thus, there is a need for an improved end cap
12 assembly that enables ready removal of an end cap and
13 secure re-attachment thereof to a plastic filter housing,
14 without a loss in the integrity of the housing upon re-
15 assembly.

16 Another drawback to currently known filter housings,
17 metal or plastic, is the limited degree of installation
18 flexibility. That is, except for custom designed housings
19 and systems which are typically relatively expensive,
20 commercially available housings are available in only a
21 limited number of connection configurations. Thus, it
22 would be desirable to provide a filter housing with an
23 increased number of connection configurations.

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SUMMARY OF THE INVENTION

26 The present invention achieves all of the foregoing
27 objectives and provides a filter and housing assembly
28 comprising a filament wound hollow housing having a sleeve
29 member at one or both ends, a reverse osmosis filter, and
30 end members adapted to fit within and sealingly engage a
31 respective sleeve member to thereby sealingly enclose the
32 filter. In another aspect, the invention provides a filter
33 housing assembly comprising a tubular inner liner, a hollow
34 cylindrical end cap aligned and disposed next to an end of
35 the inner liner, an outer liner disposed upon the outer
36 circumferential surfaces of the inner liner and the end cap

1 and extending beyond the end cap to thereby define a
2 sleeve, and a head adapted to fit within the sleeve and
3 sealingly engage the end cap. In yet another aspect, the
4 invention provides an assembly for retaining a filter
5 element comprising a tubular inner liner, first and second
6 hollow cylindrical end caps each disposed at an end of the
7 inner liner, an outer liner disposed over the inner liner
8 and the end caps, and first and second heads disposed
9 within and sealingly engaged with the corresponding end
10 caps.

11 BRIEF DESCRIPTION OF THE DRAWINGS

12 FIG. 1 is an exploded view illustrating the components
13 of a preferred embodiment housing in accordance with the
14 present invention;

15 FIG. 2 is an exploded view of one end of the preferred
16 embodiment housing without an outer liner, illustrating in
17 greater detail the primary components of the subject
18 assembly;

19 FIG. 3 illustrates an end of the preferred embodiment
20 housing when the components of FIG. 2 are assembled;

21 FIG. 4 illustrates an end of a partially assembled
22 preferred embodiment housing abutted against a winding
23 mandrel prior to formation of an outer liner;

24 FIG. 5 illustrates the assembly of FIG. 4 after
25 deposition of an outer liner;

26 FIG. 6 is a perspective sectional view of an end cap
27 component utilized in the preferred embodiment housing;

28 FIG. 7 is a perspective sectional view of a head
29 component utilized in the preferred embodiment housing;

30 FIG. 8 illustrates typical flow directions of liquid
31 entering and exiting the assembled preferred embodiment
32 housing; and

33 FIG. 9 is a perspective partial sectional view of one
34 end of the preferred embodiment housing illustrating one
35 possible configuration of side and endports.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

FIG. 1 illustrates the primary components of a preferred embodiment filament wound housing assembly 1 in accordance with the present invention. The housing 1 generally comprises a cylindrical hollow inner liner 10 having an outer liner 102 disposed about its periphery. The outer liner 102 is preferably formed by depositing a resin coated filament on the outer surface of the inner liner 10 by a process described below. The outer liner 102 is formed upon the inner liner 10 to provide two end regions or sleeves that extend coaxially from the ends of the cylindrical assembly, and that each receive an end cap 30, a head 60, and a snap ring 90. The filament wound housing 1 retains a filter cartridge 2 residing within the housing 1 and provides connections for one or more sideports 110 and/or one or more endports 114 to and from the filter 2. Typically, many commercially available replacement filter cartridges, i.e. filter 2, are provided with coaxially extending endports, such as endports 114.

Referring to FIG. 2 in which the outer liner 102 is not shown, the preferred configuration of each end of the housing 1 is as follows. The end cap 30 couples one end of the inner liner 10 to the head 60. A rear annular edge 32 of the end cap 30 is fitted over the circumferential periphery of one end of the inner liner 10. One or more sealing rings 20 may be used facilitate sealing between those components to prevent leakage. Likewise, a front annular edge 34 of the end cap 30 is fitted over a rear face 62 of the head 60 and preferably around the circumferential periphery of the end of the head 60 proximate to the rear face 62. The head 60 is inserted within the end cap 30 a distance such that another sealing ring 50, disposed around the periphery of the head 60 proximate to the front face 64 of the head 60, engages a lip or ledge 40 formed along the interior periphery of the end cap 30 described in greater detail below. This



1 arrangement provides a novel and unique end construction
2 for a filter housing.

3 FIG. 3 illustrates in greater detail the assembled end
4 portion of the preferred embodiment housing depicted in
5 FIG. 2. As can be seen, the head 60 is fully inserted into
6 the end cap 30 such that the front face 64 of the head 60
7 is flush with the front edge 34 of the end cap 30. FIG. 3
8 also illustrates that the rear edge 32 of the end cap 30 is
9 disposed over the outer periphery of the inner liner 10.

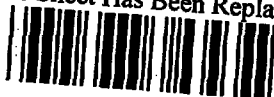
10 The preferred embodiment housing 1 comprises an outer
11 liner 102 that provides a hard rigid outer shell. The
12 outer liner 102 is preferably formed by depositing, for
13 example by filament winding techniques, a resin coated or
14 resin impregnated plurality of fibrous strands about the
15 outer periphery of the inner liner 10 and the end caps 30.
16 As can be seen in FIG. 1, an important feature of the
17 present invention is that the outer liner 102 extends
18 significantly beyond the ends of the inner liner 10 and the
19 end caps 30 and hence provides a sleeve disposed at each
20 end of the housing 1.

21 Referring to FIG. 4, each sleeve is preferably formed
22 by utilizing a winding mandrel 120 that abuts an end of the
23 partially assembled inner liner 10 and end cap 30.
24 Specifically, the end of the winding mandrel 120 abuts the
25 front edge 34 of the end cap 30. Thus, when forming the
26 outer liner 102, i.e. by depositing resin impregnated
27 filaments when a filament winding technique is employed,
28 the outer liner 102 is deposited or formed upon a portion
29 of the winding mandrel 120. The winding mandrel 120 is
30 preferably a cylindrical member having an outer diameter
31 that is about the same as the outer diameter of the end cap
32 30 against which the mandrel 120 abuts. The outer surface
33 of the winding mandrel 120 may be treated or coated to
34 facilitate deposition of the material forming the outer
35 liner 102. Upon completion of forming the outer liner 102,
36 the winding mandrel 120 is removed from the wound assembly
37 to thereby produce the noted sleeve extending coaxially at

1 an end of the housing. Further in this regard, the outer
2 surface of the winding mandrel 120 may be treated or coated
3 to facilitate removal of the winding mandrel 120 from the
4 resulting sleeve portion of the outer liner 102. Details
5 of filament winding techniques are disclosed in U. S.
6 Patents 3,610,420; 3,804,259; 3,879,243; and 4,351,092, all
7 of which are hereby incorporated by reference. Information
8 pertaining to fibers and resin systems, manufacturing
9 processes, and related matters is provided in "Filament
10 Winding Composite Structure Fabrication", S. T. Peters,
11 W. D. Humphrey, and R. F. Foral, Society for the
12 Advancement of Material and Process Engineering, January
13 1991, which is also hereby incorporated by reference.

14 It is preferred to utilize a channel-forming member
15 130 disposed around the outer surface of the winding
16 mandrel 120, preferably positioned toward or proximate the
17 end of the mandrel 120 abutted against the front edge 34 of
18 the end cap 30 to produce a recessed groove on the interior
19 circumferential surface of the sleeve. Placing a channel-
20 forming member 130 on the outer surface of the mandrel 120
21 prior to depositing the material forming the outer liner
22 102 results in the formation of a recess on the interior
23 circumferential surface of the sleeve having a
24 configuration corresponding to that of the channel-forming
25 member 130. The resulting recess is utilized to receive
26 the snap ring 90 described in greater detail below. The
27 channel-forming member 130 can be in the form of a
28 conventional O-ring.

29 FIG. 5 illustrates the assembly of one end of the
30 inner liner 10 and end cap 30 abutted against the winding
31 mandrel 120, upon formation of the outer liner 102. It can
32 be seen from FIG. 5 that the outer liner 102 extends
33 significantly beyond the end of the inner liner 10, the end
34 cap 30, and the channel-forming member 130. In accordance
35 with the preferred embodiment of the present invention, it
36 is desirable to form the outer liner 102 so that it has an
37 increased wall thickness at the ends of the housing 1.





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1 Typically, such thickness, as measured at each distal end
2 portion of a sleeve, ranges between about 1/4 inch to about
3 3/4 inch. Greater or lesser thicknesses may be utilized if
4 desired. Upon completion of winding or deposition of the
5 outer liner 102, the winding mandrel 120 is removed from
6 the assembly. The end portion of the outer liner 102 may
7 be cut or otherwise machined to form the desired end
8 configuration of the sleeve.

9 FIG. 6 is a sectional view of the preferred embodiment
10 end cap 30. The end cap 30 provides a rear annular edge 32
11 which circumscribes the inner liner 10 in the assembled
12 housing 1, a front annular edge 34 which faces outward from
13 the end of the inner liner 10 in the housing 1 and receives
14 the head 60, and an exterior circumferential surface 42 and
15 an interior circumferential surface 44 both extending
16 between the front and rear edges 34 and 32. Formed
17 proximate to the rear edge 32, along the interior
18 circumferential surface 44, is a channel 36 adapted to
19 receive the sealing ring 20. Also formed along the
20 interior surface 44, preferably adjacent or near the
21 channel 36, is a rear ledge 38 that serves as a stop when
22 the end cap 30 is slid over an end of the inner liner 10 so
23 that the rear edge 32 circumscribes the liner 10. That is,
24 in the assembled housing 1, an end or edge of the inner
25 liner 10 abuts or engages the rear ledge 38. With regard
26 to the front of the end cap 30, it is preferred to provide
27 a front ledge 40 formed along the interior surface 44,
28 preferably proximate the front edge 34. The front ledge 40
29 provides a stop for the head 60 when it is inserted within
30 the end cap 30.

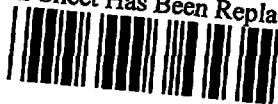
31 FIG. 7 is a detailed sectional view of the head 60
32 illustrating its preferred configuration. The head 60
33 comprises a support ring 66 that is disposed within the end
34 cap 30 in the assembled housing 1, a sealing plate 61
35 disposed at the front edge 34 of the end cap 30 in the
36 assembled housing 1, and a hollow, generally cylindrical
37 bridge member 76 extending between the sealing plate 61 and



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1 the support ring 66. The sealing plate 61 defines the
2 front face 64 that faces outward from the end cap 30 in the
3 assembled housing 1 and an oppositely directed sealing
4 plate rear face 72. The support ring 66 defines the rear
5 face 62 that is inserted within the end cap 30. The
6 support ring 66 preferably includes a plurality of spokes
7 68 radially extending from one end of the centrally
8 disposed bridge member 76 or interior region of the support
9 ring 66 to an outer periphery of the ring 66. The hollow
10 bridge member 76 defines a flow channel 70 extending from
11 the rear face 62 to the front face 64 of the head 60. As
12 explained in greater detail below, the flow channel 70
13 provides fluid communication between the support ring 66
14 and the sealing plate 61. The flow channel 70 also
15 provides fluid communication between a region along the
16 front face 64 of the sealing plate 61 and an endport 114 of
17 the filter 2 (see FIG. 1) that is inserted within the
18 channel 70 from the rear face 62. It is preferred to
19 provide a sealing member 78 within the flow channel 70,
20 such as along the interior surface of the channel 70 and
21 preferably proximate the rear face 62. The sealing member
22 78 may be a conventional O-ring. The sealing member 78 is
23 utilized to effectuate a seal around a filter endport 114
24 when the endport 114 is inserted into the flow channel 70.
25 The head 60 also comprises a sealing member 74 disposed
26 about the periphery of the sealing plate 61 along or toward
27 the front face 64 of the head 60 which facilitates sealing
28 between the head 60 when inserted into the end cap 30.

29 The housing 1 is preferably assembled from two
30 subassemblies. A first subassembly comprising (i) the
31 inner liner 10, (ii) one end cap 30 disposed at one end of
32 the first subassembly (the other end of the first
33 subassembly being closed) or two end caps 30 each disposed
34 at opposing ends of the first subassembly, and (iii) the
35 outer liner 102 disposed upon the outer circumferential
36 surfaces of the inner liner 10 and the end cap(s) 30,
37 thereby providing a sleeve at one or both ends, is mated or



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1 engaged with one or two second subassemblies, each
2 comprising one or more head(s) 60 and corresponding snap
3 ring(s) 90. The number of the second subassemblies
4 utilized, corresponds to the number of end caps 30 utilized
5 in the first subassembly, i.e. one or two.

6 A filter cartridge 2 is placed within the first
7 subassembly, specifically, within the inner liner 10. In
8 the event that the first subassembly comprises two end caps
9 30, engagement between the first and second subassemblies
10 is accomplished by inserting a head 60 into each end of the
11 first subassembly containing the filter 2, the support ring
12 66 of each head 60 being inserted first, so that the
13 sealing plate 61 is received within the sleeve of the first
14 subassembly. Each head 60 is further inserted into a
15 corresponding end cap 30 so that the front face 64 of the
16 sealing plate 61 is flush with the front edge 34 of the end
17 cap 30. In the event the filter cartridge 2 comprises a
18 centrally disposed coaxially extending filter endport 114,
19 the endport 114 is inserted within the flow channel 70.
20 Each head 60, disposed at the ends of the first
21 subassembly, is then secured in place by inserting the snap
22 ring 90 within a recessed groove formed along the interior
23 circumferential surface of a sleeve. As will be recalled,
24 the recessed groove is preferably formed by the channel-
25 forming member 130 described in conjunction with FIGS. 4
26 and 5. With reference to FIG. 1, the snap ring 90
27 preferably comprises an arcuately shaped resilient and
28 deformable member having two ends 92 spaced apart from one
29 another, and an outer circumferential edge 94. The snap
30 ring 90 is inserted within the recessed groove by applying
31 a compressive force at the ends 92, directing the ends
32 toward one another, then placing the snap ring 90 within
33 the groove, and releasing the snap ring 90 whereby the
34 resiliency causes the edge 94 of the ring 90 to engage the
35 inner circumferential surface of the sleeve, specifically
36 within the groove. The snap ring 90 is dimensioned such
37 that upon placement within the recessed groove, at least a

1 portion of the ring extends beyond the interior
2 circumferential surface of the sleeve and toward the
3 cylindrical or longitudinal axis of the housing such that
4 the head 60 disposed on one side of the ring 90, is
5 securely retained within the housing and cannot slide past
6 the ring 90 toward the housing end.

7 FIG. 8 illustrates the assembled preferred embodiment
8 filament wound housing 1. Typically, the housing 1
9 comprises a filter sideport 110 and a filter endport 114 at
10 each end of the assembly. Although as previously noted,
11 the filter 2 typically comprises endports 114 coaxially
12 extending from each of its ends, the present invention
13 housing 1 may provide additional endports 114a as
14 illustrated in FIG. 9. That is, in addition to endports
15 114 coaxially projecting from the ends of a filter 2, the
16 housing 1 may comprise additional supplemental endports
17 114a extending from one or both ends of the housing, such
18 as from the front face 64 of the head 60 and extending
19 along an axis parallel but not coextensive with the
20 longitudinal axis of the housing 1. Furthermore, the
21 housing 1 may in some instances, not contain any sideports
22 110, but instead provide one or more openings through the
23 housing side for connection with conduits or pipes such as
24 might be existing at an installation site. In the event
25 that the housing 1 comprises one or more sideports 110, or
26 openings in the sidewall of the housing 1, it is preferred
27 that the sideport 110 or opening be located in the sidewall
28 of the housing 1 between the sealing plate 61 and the
29 support ring 66 of the head 60. The openings defined in
30 the support ring 66 between the spokes 68 enable fluid flow
31 between an end of the filter 2 and a sideport 110. As will
32 be appreciated, the sealing plate 61 prevents fluid flow
33 from an end of the filter 2 through an end or sleeve
34 portion of the housing 1.

35 Sideports 110 or openings are preferably provided in
36 the sidewall of the housing 1 by utilizing an end cap 30
37 having a corresponding number of access ports formed in the

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1 wall of the end cap 30, as shown in FIG. 9. A typical end
2 cap access port is depicted in FIG. 9 as port 31 defined by
3 a circumferential sidewall 33. The port 31 extends through
4 the sidewall of the end cap 30 perpendicularly from the
5 cylindrical axis of the end cap 30. The outer liner 102 is
6 deposited around the sidewall 33. When forming the outer
7 liner 102 by filament winding techniques, a plug or other
8 member may be inserted within the port 31. It is most
9 preferred to utilize a cone-shaped plug to insert into the
10 port 31 whereby the cone portion of the plug extends above
11 the outer surface of the outer liner 102, and thereby which
12 guides filaments around the opening of the access port 31.
13 Upon completion of filament winding, the plug is removed to
14 reveal the access port 31 ready for accepting a sideport
15 member 110.

16 The present invention includes embodiments in which
17 only one filter sideport 110 or filter endport 114 is
18 utilized on an end of the housing 1, or various
19 combinations of a plurality of sideports 110 and a single
20 endport 114 are used on an end of the housing 1. Moreover,
21 multiple endports 114 and/or 114a may be provided and/or
22 multiple sideports 110 can also be provided on an end of
23 the housing 1. The present invention also includes
24 embodiments in which only one end of the housing 1 contains
25 one or more sideports 110 and/or endports 114 and/or 114a.
26 Furthermore, the present invention includes a filter
27 housing having additional ports for rinsing or flushing the
28 filter, such as with a rinse solution or solvent.

29 It is particularly preferred to provide the following
30 port configurations: (i) one sideport 110 and one endport
31 114 on each end of the housing 1; (ii) no sideports 110 and
32 two endports 114 and 114a on each end; (iii) one sideport
33 110 and one endport 114 on one end and two endports 114 and
34 114a on the other end; (iv) one sideport 110 and no endport
35 on one end and one sideport 110 and one endport 114 on the
36 other end; (v) two endports 114 and 114a on one end and one
37 endport 114 on the other end; (vi) two endports 114 and

1 114a on one end and one sideport 110 on the other end.
2 When utilizing multiple endports 114 and 114a on one end, a
3 first endport 114 can be located along the longitudinal or
4 cylindrical axis of the assembly 1 and one or more other
5 endports 114a can be located along the front face 64 of the
6 head 60, and preferably oriented parallel to the first
7 endport 114. It is contemplated that extra sideports or
8 endports can be provided, and if not used, be blocked off
9 or plugged.

10 It is important to note that the supplemental endports
11 114a, i.e. those that project from a front face 64 of a
12 head 60 and that are parallel with a coaxially extending
13 endport 114, do not generally provide access to the
14 interior of the filter 2 as does a coaxially extending
15 endport 114. Supplemental endports 114a typically provide
16 the same function as the sideports 110, and service the
17 same region proximate a filter end as do the sideports 110.
18 When providing a supplemental endport 114a, it is
19 contemplated that the function of the endport 114a will be
20 to direct inflow or feed to the housing 1 and/or to direct
21 sediment, particulate matter, and/or a waste stream from
22 the interior of the housing 1.

23 The endports 114 and 114a and sideports 110 are sized
24 to provide suitable flow rates to and from the filter 2
25 disposed within the housing. In addition, the ports are
26 sized such that they readily connect to conventional
27 plumbing and hardware. Typically, the ports will be from
28 about 1/2 inch to about 3/4 inch in diameter and can be
29 threaded.

30 The filter housing can be nearly any size and take
31 other forms besides the preferred cylindrical or tubular
32 configuration described herein. It is most preferred that
33 the housing be cylindrical and have a diameter sufficient
34 to accommodate a 4 inch diameter reverse osmosis filter
35 element.

36 A wide array of materials can be utilized for the
37 various components of the housing 1 of the present



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1 invention. Nearly any inert plastic can be employed for the
2 inner liner 10 such as, but not limited to polyethylene or
3 polyvinylidiflouride. Other materials are contemplated for
4 the inner liner 10 depending upon the end use requirements.
5 If for example the housing 1 will contain a filter for
6 processing a liquid for human consumption, the liner
7 material should be in accordance with FDA requirements.
8 The materials for the end cap 30 and head 60 are preferably
9 selected to be the same or similar, or at least compatible
10 with the materials utilized for the inner liner 10. Other
11 suitable materials for the end cap 30 and the head 60
12 include for instance polyvinyl chloride or various nylon
13 alloys. The end caps 30 and heads 60 are preferably
14 injection molded. As previously noted, all the sealing
15 rings, i.e. rings 20, 50, 74, and 78, can be in the form of
16 conventional O-rings. Accordingly, they may be formed from
17 known suitable elastomers such as EPDM. The snap ring 90
18 is preferably formed from a relatively rigid, yet flexible
19 material, such as fiberglass, a strong thermoplastic, or a
20 metal or alloy thereof.

21 Since the preferred embodiment assembly 1 utilizes a
22 separate inner liner 10 that contacts the liquid undergoing
23 filtration, the outer liner 102 does not contact that
24 liquid. Therefore when working with liquids intended for
25 human consumption for instance, the outer liner need not be
26 formed from the same materials dictated by FDA requirements
27 and health concerns, as the inner liner 10. This feature
28 is of particular importance to the industry since it
29 enables housings to be formed from a higher proportion of
30 less expensive materials.

31 Although the preferred embodiment of the present
32 invention filter housing comprises a filament wound outer
33 liner, it is to be understood that the present invention
34 includes housings that are not formed by filament winding
35 techniques. Thus, the present invention encompasses a
36 filter housing that is formed from one or more metals or
37 alloys, such as for instance steel or aluminum, that

1 utilize the end assemblies described herein.

2 Furthermore, while the foregoing details are what is
3 felt to be the preferred embodiments of the present
4 invention, no material limitations to the scope of the
5 claimed invention are intended. Further, features and
6 design alternatives that would be obvious to one of
7 ordinary skill in the art are considered to be incorporated
8 herein. The scope of the invention is set forth and
9 particularly described in the claims herein below.



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WHAT IS CLAIMED IS:

- 1 1. A filter and housing assembly comprising:
2 a housing having a first end, a second end, and a
3 hollow interior extending from said first end to said
4 second end, said housing further having a first and a
5 second sleeve member projecting from said first end and
6 said second end, respectively, wherein said first and said
7 second sleeve members are formed by a filament winding
8 technique;
9 a reverse osmosis filter disposed within said
10 hollow interior;
11 a first end member adapted to fit within and
12 sealingly engage said first sleeve member; and
13 a second end member adapted to fit within and
14 sealingly engage said second sleeve member.
- 1 2. The filter and housing assembly of claim 1
2 wherein the entirety of said housing is formed by a
3 filament winding process.
- 1 3. The filter and housing assembly of claim 1
2 wherein said housing further has a liner disposed within
3 said hollow interior.
- 1 4. The filter and housing assembly of claim 3
2 wherein said reverse osmosis filter is disposed within said
3 liner.
- 1 5. The filter and housing assembly of claim 1
2 wherein said first end member comprises a head unit
3 providing a support ring for fitting within said first
4 sleeve member and a sealing plate for sealingly engaging
5 said first sleeve member.

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1 6. The filter and housing assembly of claim 5
2 wherein said head unit further provides a bridge member
3 extending between said support ring and said sealing plate.

1 7. The filter and housing assembly of claim 6
2 wherein said head unit has a front face and an oppositely
3 directed rear face, and said bridge member defines a hollow
4 region extending from said front face to said rear face.

1 8. The filter and housing assembly of claim 5
2 wherein said second end member comprises a head unit.

1 9. The filter and housing assembly of claim 1
2 further comprising at least one endport extending coaxially
3 from at least one of said housing first end and said second
4 end, and optionally at least one sideport extending
5 transversely from at least one of said housing first end
6 and said second end.

1 10. The filter and housing assembly of claim 9
2 wherein said housing comprises a port configuration
3 selected from the group consisting of: (i) one sideport and
4 one endport on each of said housing first and second ends,
5 (ii) two endports on each of said housing first and second
6 ends, (iii) one sideport and one endport on said housing
7 first end and two endports on said housing second end, (iv)
8 one sideport on said housing first end and one sideport and
9 one endport on said housing second end, (v) two endports on
10 said housing first end and one endport on said housing
11 second end, and (vi) two endports on said housing first end
12 and one sideport on said housing second end.

1 11. A filter housing assembly comprising:
2 a cylindrical inner liner having a first end and
3 a circumferential outer surface, said inner liner defining
4 a hollow interior accessible from said first end of said
5 inner liner;

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6 a hollow cylindrical end cap having a front edge,
7 a rear edge, an interior surface, and a circumferential
8 outer surface, both said surfaces extending between said
9 front and rear edges, said end cap defining a hollow
10 chamber accessible from both said front and rear edges,
11 said end cap aligned along the cylindrical axis of said
12 inner liner wherein said rear edge of said end cap is
13 disposed proximate to said first end of said inner liner;
14 an outer liner disposed upon said circumferential
15 outer surface of said end cap and at least a portion of
16 said circumferential outer surface of said inner liner,
17 said outer liner coaxially extending beyond said front edge
18 of said end cap to a first end of said outer liner thereby
19 defining a circumferential interior surface between said
20 front edge of said end cap to said first end of said outer
21 liner; and
22 a head disposed within and sealingly engaging
23 said circumferential interior surface of said outer liner.

1 12. The filter housing assembly of claim 11 wherein
2 said circumferential interior surface of said outer liner
3 defines a retaining channel between said front edge of said
4 end cap and said first end of said outer liner, said filter
5 housing assembly further comprising:

6 a retaining ring releasably disposed within said
7 retaining channel thereby securing said head disposed
8 within and sealingly engaging said circumferential interior
9 surface of said outer liner.

1 13. The filter housing assembly of claim 11 wherein
2 said end cap includes a rear ledge extending along the
3 interior surface of said end cap proximate to said rear
4 edge of said end cap, said rear edge of said end cap being
5 disposed over said first end of said inner liner and at
6 least a portion of said circumferential outer surface of
7 said inner liner.

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1 14. The filter housing assembly of claim 13 wherein
2 said rear ledge of said end cap is in contact with said
3 first end of said inner liner.

1 15. The filter housing assembly of claim 10 wherein
2 said end cap includes a channel extending along the
3 interior surface of said end cap proximate to said rear
4 edge of said end cap, said end cap being disposed over said
5 first end of said inner liner and at least a portion of
6 said outer circumferential surface of said inner liner,
7 said filter housing assembly further comprising:
8 a sealing ring disposed within said channel and
9 between said end cap and said outer circumferential surface
10 of said inner liner.

1 16. The filter housing assembly of claim 11 wherein
2 said end cap includes a front ledge extending along the
3 interior surface of said end cap proximate to said front
4 edge of said end cap, said front edge of said end cap being
5 disposed over at least a portion of said head.

1 17. The filter housing assembly of claim 16 wherein
2 said front ledge of said end cap is in contact with said
3 head.

1 18. The filter housing assembly of claim 11 wherein
2 said head includes:
3 an inner support ring having a rear face and a
4 front face, said ring defining a centrally disposed
5 aperture extending through said ring from said rear face to
6 said front face;
7 a sealing plate having a front face and a
8 rearwardly directed sealing face wherein said front face of
9 said inner support ring and said sealing face of said
10 sealing plate are directed towards each other, said sealing
11 plate defining a centrally disposed aperture extending
12 through said plate from said front face to said sealing

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13 face; and

14 a bridge member having first and second ends and
15 defining a flow channel extending between said first and
16 second ends, said bridge member extending between said
17 front face of said support ring and said sealing face of
18 said sealing plate to thereby provide access from said rear
19 face of said support ring to said front face of said
20 sealing plate through said aperture defined in said support
21 ring, said flow channel defined in said bridge member, and
22 said aperture defined in said sealing plate.

1 19. The filter housing assembly of claim 18 wherein
2 said support ring provides a sealing member extending
3 around the interior surface of said aperture defined in
4 said support ring.

1 20. The filter housing assembly of claim 18 wherein
2 said sealing plate defines a circumferential outer edge and
3 includes a sealing member disposed along said
4 circumferential outer edge, said sealing member adapted to
5 promote sealing between said head and said end cap.

1 21. The filter housing assembly of claim 18 wherein
2 said support ring includes a plurality of spokes radially
3 extending from an interior region of said support ring to a
4 peripheral region of said support ring, thereby defining at
5 least one opening between two adjacent spokes and extending
6 through said support ring from said front face to said rear
7 face of said support ring.

1 22. An assembly for retaining a filter element, said
2 assembly comprising:

3 a tubular inner liner having a first end, a
4 second end, an inner circumferential surface, and an outer
5 circumferential surface, said inner liner defining a hollow
6 interior accessible from both said first end and said
7 second end of said inner liner;

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8 a first hollow cylindrical end cap having a front
9 annular edge, a rear annular edge, an interior
10 circumferential surface extending between said front and
11 rear edges, an outer circumferential surface extending
12 between said front and rear edges, and a rear ledge
13 extending along said interior surface proximate to said
14 rear edge, said first end cap defining an interior chamber
15 accessible from both said front edge and said rear edge,
16 said first end cap aligned along the longitudinal axis of
17 said inner liner wherein said rear edge of said first end
18 cap is disposed proximate to said first end of said inner
19 liner;

20 a second hollow cylindrical end cap having a
21 front annular edge, a rear annular edge, an interior
22 circumferential surface extending therebetween, and a rear
23 ledge extending along said interior surface proximate to
24 said rear edge, said second end cap defining an interior
25 chamber accessible from both said front edge and said rear
26 edge, said second end cap aligned along the longitudinal
27 axis of said inner liner wherein said rear edge of said
28 second end cap is disposed proximate to said second end of
29 said inner liner;

30 an outer liner disposed upon said outer
31 circumferential surface of said inner liner, said outer
32 circumferential surface of said first end cap, and said
33 outer circumferential surface of said second end cap, said
34 outer liner coaxially extending beyond said front edge of
35 said first end cap to a first end of said outer liner
36 thereby defining a first circumferential sealing surface
37 along the interior of said outer liner proximate to said
38 first end of said outer liner, and beyond said front edge
39 of said second end cap to a second end of said outer liner
40 thereby defining a second circumferential sealing surface
41 along the interior of said outer liner proximate to said
42 second end of said outer liner;

43 a first head disposed within and sealingly
44 engaged with said interior circumferential surface of said

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45 first end cap; and
46 a second head disposed within and sealingly
47 engaged with said interior circumferential surface of said
48 second end cap.

1 23. The assembly of claim 22 wherein said first
2 circumferential sealing surface of said outer liner defines
3 a first channel disposed between said front edge of said
4 first end cap and said first end of said outer liner, said
5 assembly further comprising:

6 a retaining ring releasably disposed within said
7 first channel thereby securing said first head engaged
8 within said first end cap.

1 24. The assembly of claim 23 wherein said second
2 circumferential sealing surface of said outer liner defines
3 a second channel disposed between said front edge of said
4 second end cap and said second end of said outer liner,
5 said assembly further comprising:

6 a retaining ring releasably disposed within said
7 second channel thereby securing said second head within
8 said second end cap.

1 25. The assembly of claim 22 wherein said rear ledge
2 of said first end cap is in contact with said first end of
3 said inner liner, and said rear ledge of said second end
4 cap is in contact with said second end of said inner liner.

1 26. The filter housing assembly of claim 22 wherein
2 said first head includes:

3 an inner support ring having a rear face and a
4 front face, said ring defining a centrally disposed
5 aperture extending through said ring from said rear face to
6 said front face;

7 a sealing plate having a front face and a
8 rearwardly directed sealing face, wherein said front face
9 of said inner support ring and said sealing face of said

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10 sealing plate are directed towards each other, said sealing
11 plate defining a centrally disposed aperture extending
12 through said plate from said front face to said sealing
13 face; and

14 a bridge member having first and second ends and
15 defining a flow channel extending between said first and
16 second ends, said bridge member extending between said
17 front face of said support ring and said sealing face of
18 said sealing plate to thereby provide access from said rear
19 face of said support ring to said front face of said
20 sealing plate through said aperture defined in said support
21 ring, said flow channel defined in said bridge member, and
22 said aperture defined in said sealing plate.

1 27. The filter housing assembly of claim 26 wherein
2 said support ring provides a sealing member extending
3 around the inwardly facing surface of said aperture defined
4 in said support ring.

1 28. The filter housing assembly of claim 26 wherein
2 said sealing plate defines a circumferential edge and
3 includes a sealing member disposed along said
4 circumferential edge, said sealing member adapted to
5 promote sealing between said first head and said first end
6 cap.

1 29. The filter housing assembly of claim 26 wherein
2 said support ring includes a plurality of spokes radially
3 extending from an interior region of said support ring to a
4 peripheral region of said support ring, thereby defining at
5 least one opening extending through said support ring from
6 said front face to said rear face of said support ring.

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1 FILAMENT WOUND HOUSING FOR A
2 REVERSE OSMOSIS FILTER CARTRIDGE

3 ABSTRACT OF THE DISCLOSURE

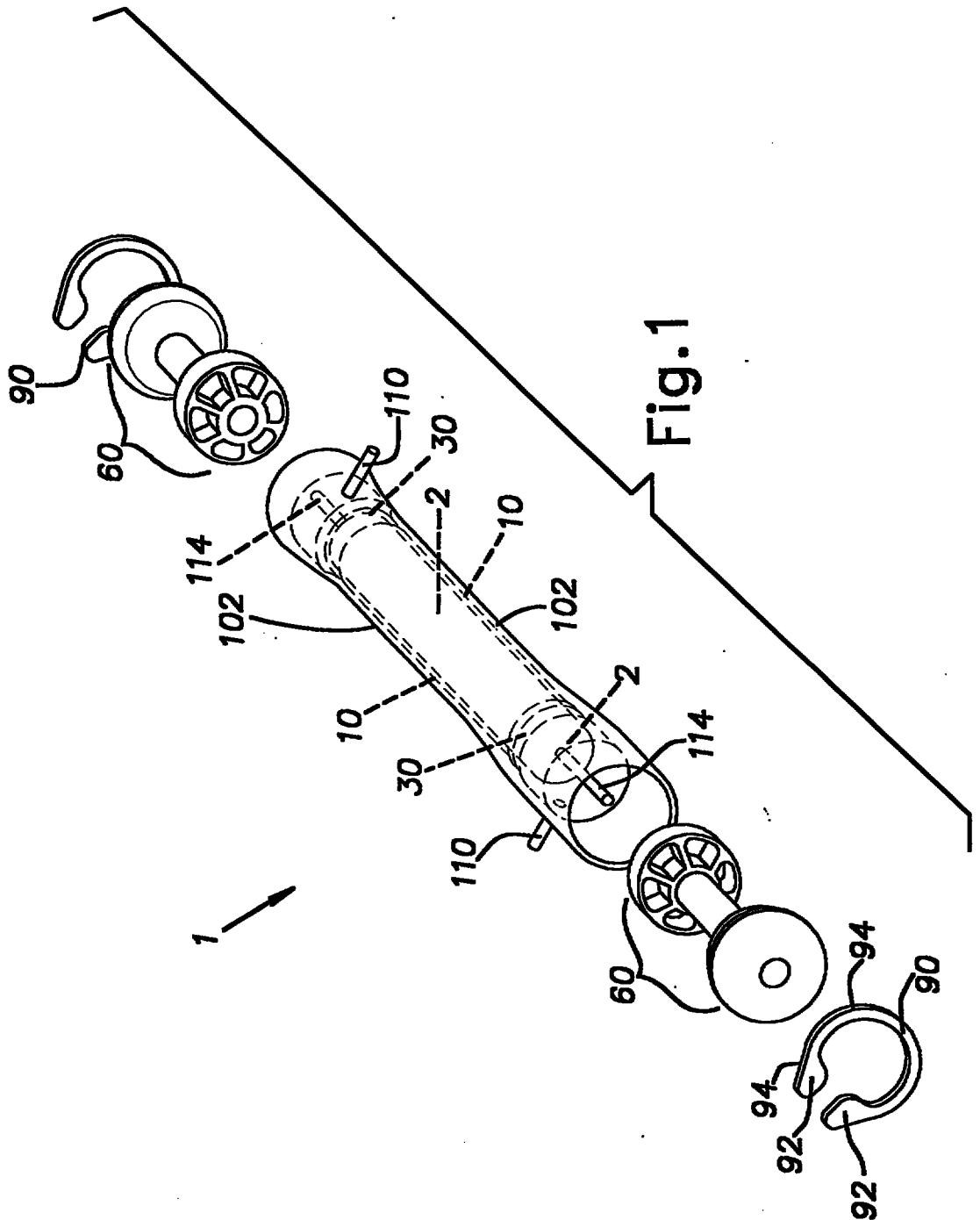
4 Disclosed is a housing for a reverse osmosis filter.
5 The housing is preferably cylindrical and features a unique
6 sealing assembly at each of its ends. The end assemblies
7 enable the interior of the housing to be readily accessed
8 and securely sealed. Each end assembly can be provided
9 with one or more inlet and/or outlet ports.

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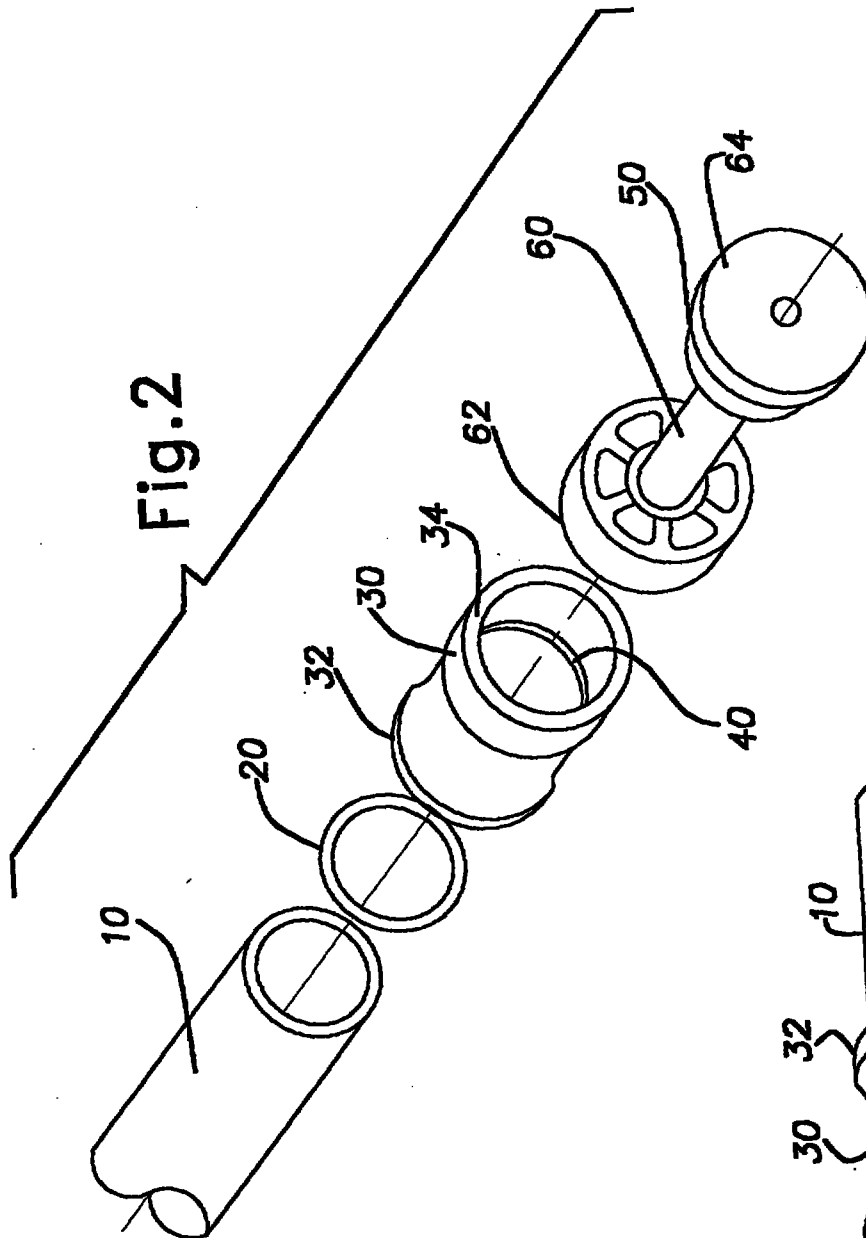
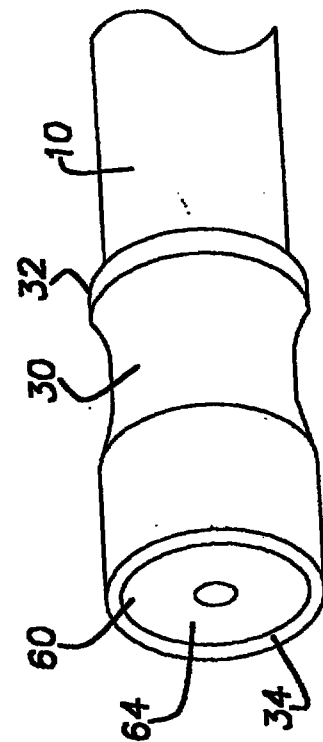


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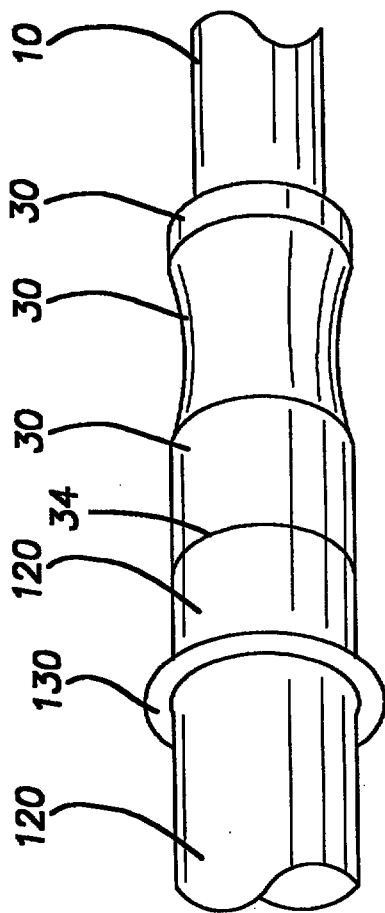


Fig. 4

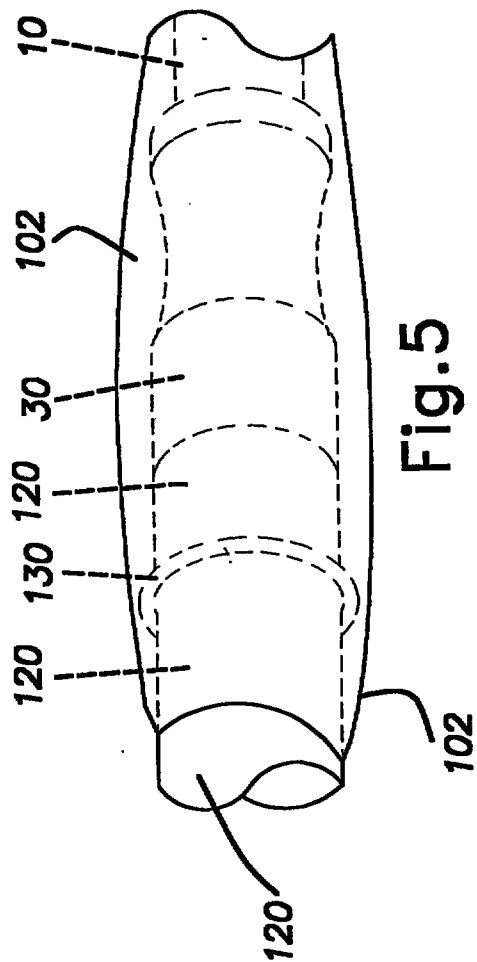


Fig. 5



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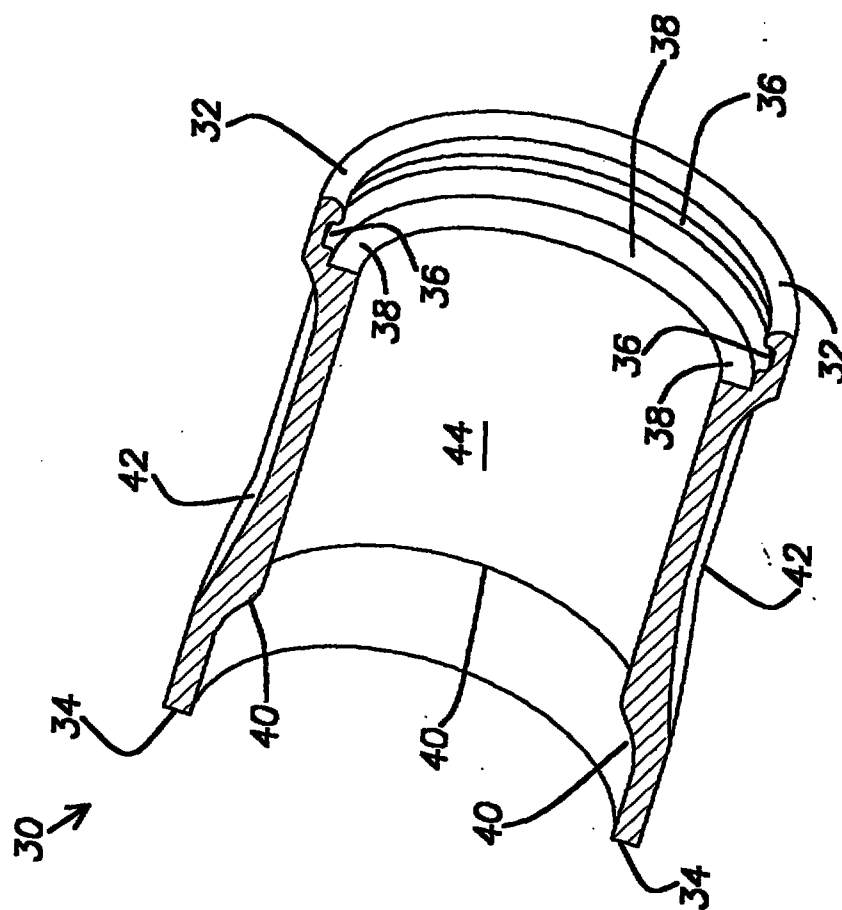


Fig. 6

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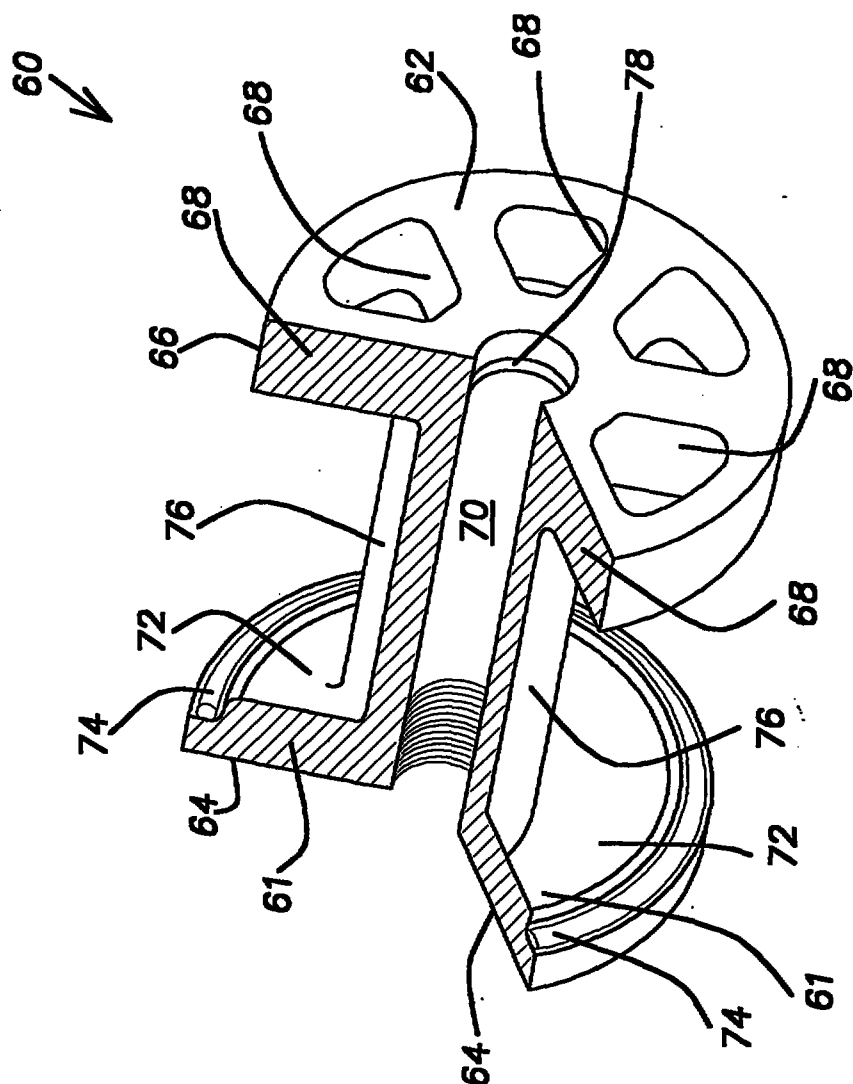


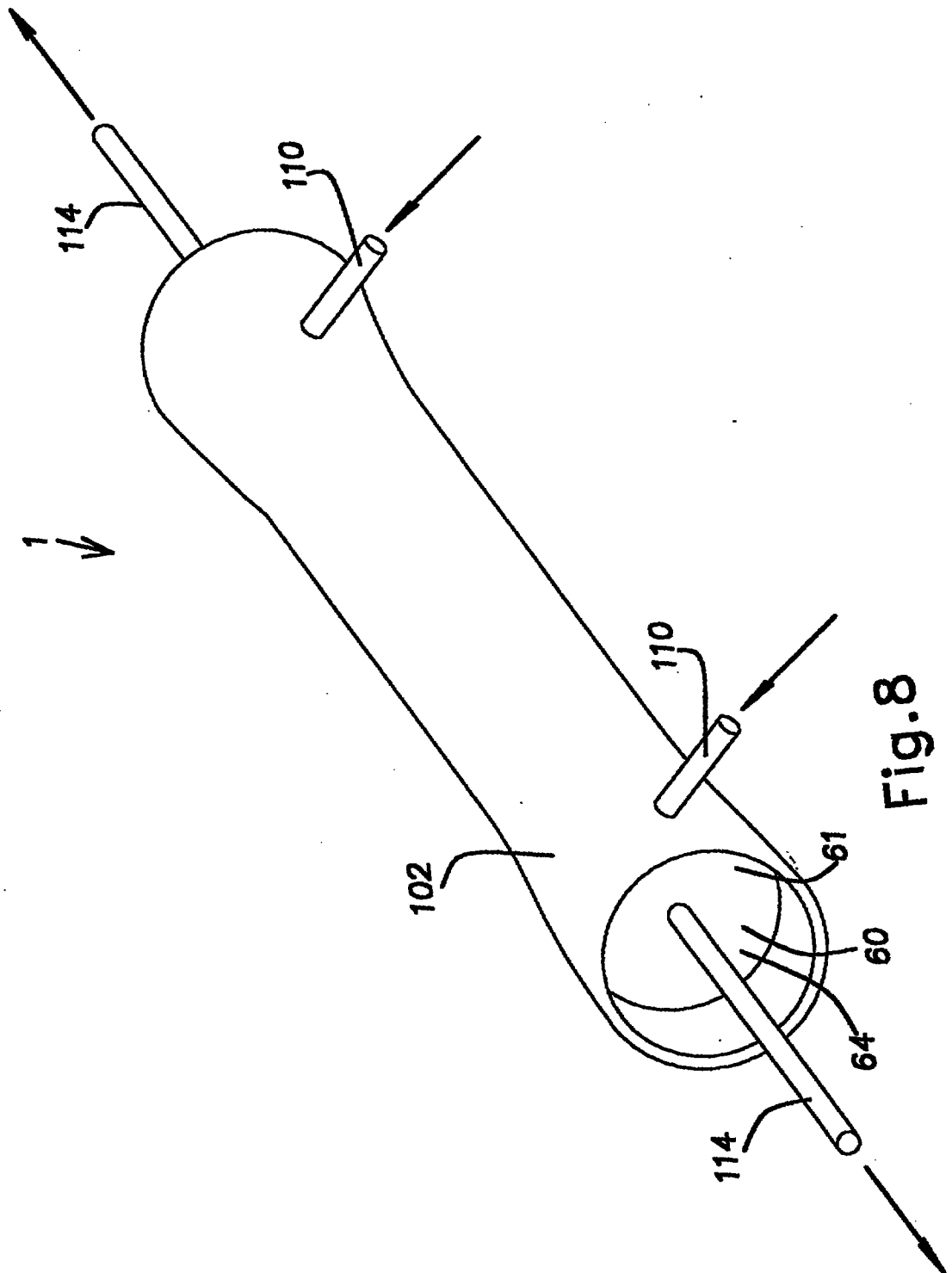
Fig. 7

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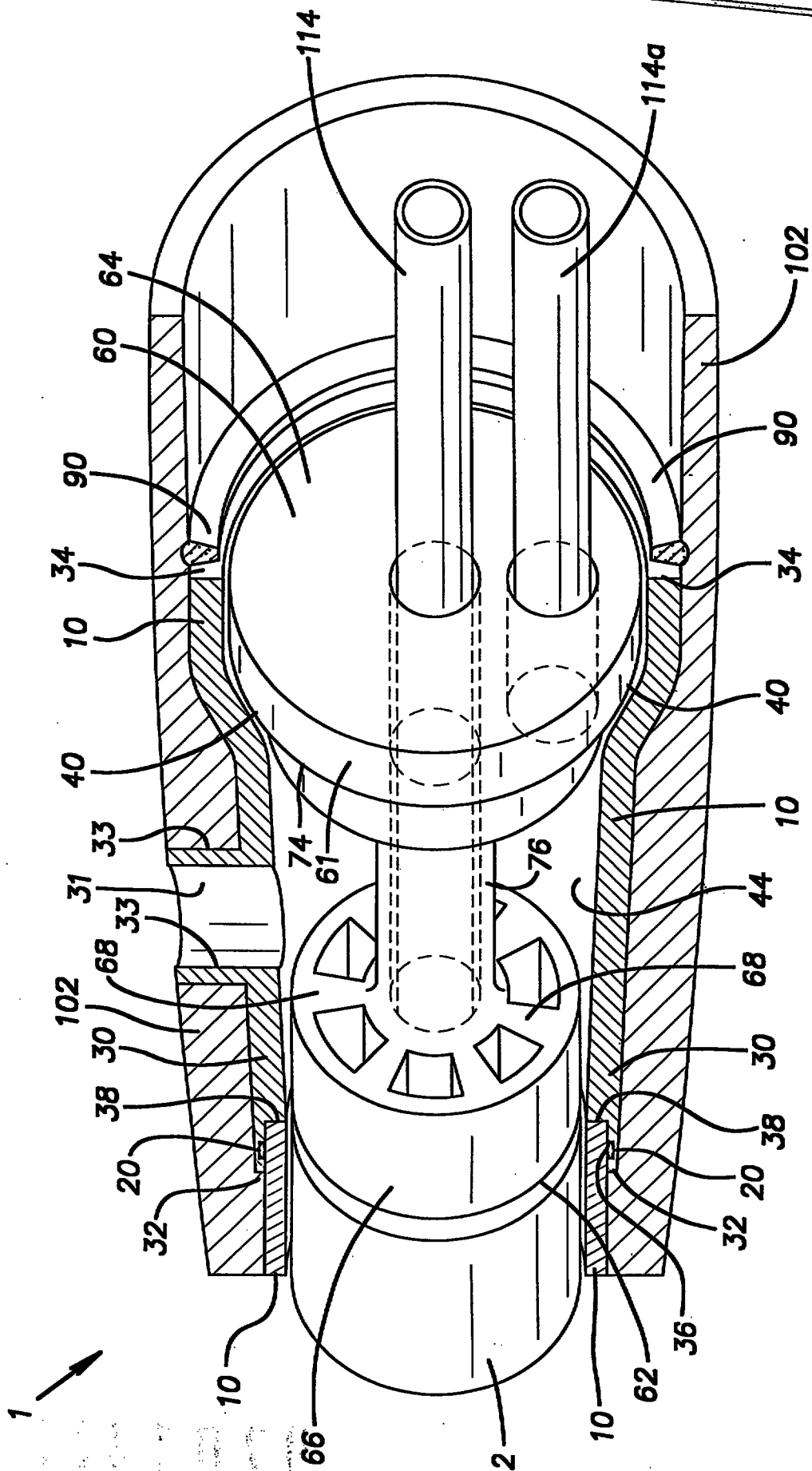


Fig. 9

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1 FILAMENT WOUND HOUSING FOR A
2 REVERSE OSMOSIS FILTER CARTRIDGE

3 ABSTRACT OF THE DISCLOSURE

4 Disclosed is a housing for a reverse osmosis filter.
5 The housing is preferably cylindrical and features a unique
6 sealing assembly at each of its ends. The end assemblies
7 enable the interior of the housing to be readily accessed
8 and securely sealed. Each end assembly can be provided
9 with one or more inlet and/or outlet ports.

(Fig. 1)

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DESCRIPTION OF THE PREFERRED EMBODIMENTS

1
2 FIG. 1 illustrates the primary components of a
3 preferred embodiment filament wound housing assembly 1 in
4 accordance with the present invention. The housing 1
5 generally comprises a cylindrical hollow inner liner 10
6 having an outer liner 102 disposed about its periphery.
7 The outer liner 102 is preferably formed by depositing a
8 resin coated filament on the outer surface of the inner
9 liner 10 by a process described below. The outer liner 102
10 is formed upon the inner liner 10 to provide two end
11 regions or sleeves that extend coaxially from the ends of
12 the cylindrical assembly, and that each receive an end cap
13 30, a head 60, and a snap ring 90. The filament wound
14 housing 1 retains a filter cartridge 2 residing within the
15 housing 1 and provides connections for one or more
16 sideports 110 and/or one or more endports 114 to and from
17 the filter 2. Typically, many commercially available
18 replacement filter cartridges, i.e. filter 2, are provided
19 with coaxially extending endports, such as endports 114.
20 Referring to FIG. 2 in which the outer liner 102 is
21 not shown, the preferred configuration of each end of the
22 housing 1 is as follows. The end cap 30 couples one end of
23 the inner liner 10 to the head 60. A rear annular edge 32
24 of the end cap 30 is fitted over the circumferential
25 periphery of one end of the inner liner 10. One or more
26 sealing rings 20 may be used facilitate sealing between
27 those components to prevent leakage. Likewise, ~~a front~~ the rear
28 annular edge ~~34~~ 32 of the end cap 30 is fitted over a rear
29 face 62 of the head 60 and preferably around the
30 circumferential periphery of the end of the head 60
31 proximate to the rear face 62. The head 60 is inserted
32 within the end cap 30 a distance such that another sealing
33 ring 50, disposed around the periphery of the head 60
34 proximate to the front face 64 of the head 60, engages a
35 lip or ledge 40 formed along the interior periphery of the
36 end cap ~~30~~ and near a front annular edge 34 thereof, described in
greater detail below. This _____

1 an end of the housing. Further in this regard, the outer
2 surface of the winding mandrel 120 may be treated or coated
3 to facilitate removal of the winding mandrel 120 from the
4 resulting sleeve portion of the outer liner 102. Details
5 of filament winding techniques are disclosed in U. S.
6 Patents 3,610,420; 3,804,259; 3,879,243; and 4,351,092, all
7 of which are hereby incorporated by reference. Information
8 pertaining to fibers and resin systems, manufacturing
9 processes, and related matters is provided in "Filament
10 Winding Composite Structure Fabrication", S. T. Peters,
11 W. D. Humphrey, and R. F. Foral, Society for the
12 Advancement of Material and Process Engineering, January
13 1991, which is also hereby incorporated by reference.

14 It is preferred to utilize a channel-forming member
15 130 disposed around the outer surface of the winding
16 mandrel 120, preferably positioned toward or proximate the
17 end of the mandrel 120 abutted against the front edge 34 of
18 the end cap 30 to produce a recessed groove on the interior
19 circumferential surface of the sleeve. Placing a channel-
20 forming member 130 on the outer surface of the mandrel 120
21 prior to depositing the material forming the outer liner
22 102 results in the formation of a recess ~~at~~ 130a in the interior
23 circumferential surface of the sleeve having a
24 configuration corresponding to that of the channel-forming
25 member 130. The resulting recess 130a is utilized to receive
26 the snap ring 90 described in greater detail below. The
27 channel-forming member 130 can be in the form of a
28 conventional O-ring.

29 FIG. 5 illustrates the assembly of one end of the
30 inner liner 10 and end cap 30 abutted against the winding
31 mandrel 120, upon formation of the outer liner 102. It can
32 be seen from FIG. 5 that the outer liner 102 extends
33 significantly beyond the end of the inner liner 10, the end
34 cap 30, and the channel-forming member 130. In accordance
35 with the preferred embodiment of the present invention, it
36 is desirable to form the outer liner 102 so that it has an
37 increased wall thickness at the ends of the housing 1.

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1 Typically, such thickness, as measured at each distal end
2 portion of a sleeve, ranges between about 1/4 inch to about
3 3/4 inch. Greater or lesser thicknesses may be utilized if
4 desired. Upon completion of winding or deposition of the
5 outer liner 102, the winding mandrel 120 is removed from
6 the assembly. The end portion of the outer liner 102 may
7 be cut or otherwise machined to form the desired end
8 configuration of the sleeve.

9 FIG. 6 is a sectional view of the preferred embodiment
10 end cap 30. The end cap 30 provides a rear annular edge 32
11 which circumscribes the inner liner 10 in the assembled
12 housing 1, ~~the~~ front annular edge 34 which faces outward from
13 the end of the inner liner 10 in the housing 1 and receives
14 the head 60, and an exterior circumferential surface 42 and
15 an interior circumferential surface 44 both extending
16 between the front and rear edges 34 and 32. Formed
17 proximate to the rear edge 32, along the interior
18 circumferential surface 44, is a channel 36 adapted to
19 receive the sealing ring 20. Also formed along the
20 interior surface 44, preferably adjacent or near the
21 channel 36, is a rear ledge 38 that serves as a stop when
22 the end cap 30 is slid over an end of the inner liner 10 so
23 that the rear edge 32 circumscribes the liner 10. That is,
24 in the assembled housing 1, an end or edge of the inner
25 liner 10 abuts or engages the rear ledge 38. With regard
26 to the front of the end cap 30, it is preferred to provide
27 a front ledge 40 formed along the interior surface 44,
28 preferably proximate the front edge 34. The front ledge 40
29 provides a stop for the head 60 when it is inserted within
30 the end cap 30.

31 FIG. 7 is a detailed sectional view of the head 60
32 illustrating its preferred configuration. The head 60
33 comprises a support ring 66 that is disposed within the end
34 cap 30 in the assembled housing 1, a sealing plate 61
35 disposed at the front edge 34 of the end cap 30 in the
36 assembled housing 1, and a hollow, generally cylindrical
37 bridge member 76 extending between the sealing plate 61 and

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1 the support ring 66. The sealing plate ~~61~~ defines the
2 front face 64 that faces outward from the end cap 30 in the
3 assembled housing 1 and an oppositely directed sealing
4 plate rear face 72. The support ring 66 defines the rear
5 face 62 that is inserted within the end cap 30. The
6 support ring 66 preferably includes a plurality of spokes
7 68 radially extending from one end of the centrally
8 disposed bridge member 76 or interior region of the support
9 ring 66 to an outer periphery of the ring 66. The hollow
10 bridge member 76 defines a flow channel 70 extending from
11 the rear face 62 to the front face 64 of the head 60. As
12 explained in greater detail below, the flow channel 70
13 provides fluid communication between the support ring 66
14 and the sealing plate 61. The flow channel 70 also
15 provides fluid communication between a region along the
16 front face 64 of the sealing plate 61 and an endport 114 of
17 the filter 2 (see FIG. 1) that is inserted within the
18 channel 70 from the rear face 62. It is preferred to
19 provide a sealing member 78 within the flow channel 70,
20 such as along the interior surface of the channel 70 and
21 preferably proximate the rear face 62. The sealing member
22 78 may be a conventional O-ring. The sealing member 78 is
23 utilized to effectuate a seal around a filter endport 114
24 when the endport 114 is inserted into the flow channel 70.
25 The head 60 also comprises ~~a the~~ sealing 50 ~~member 74~~ disposed
26 about the periphery of the sealing plate 61 along or toward
27 the front face 64 of the head 60 which facilitates sealing
28 between the head 60 when inserted into the end cap 30.

29 The housing 1 is preferably assembled from two
30 subassemblies. A first subassembly comprising (i) the
31 inner liner 10, (ii) one end cap 30 disposed at one end of
32 the first subassembly (the other end of the first
33 subassembly being closed) or two end caps 30 each disposed
34 at opposing ends of the first subassembly, and (iii) the
35 outer liner 102 disposed upon the outer circumferential
36 surfaces of the inner liner 10 and the end cap(s) 30,
37 thereby providing a sleeve at one or both ends, is mated or

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1 engaged with one or two second subassemblies, each
2 comprising one or more head(s) 60 and corresponding snap
3 ring(s) 90. The number of the second subassemblies
4 utilized, corresponds to the number of end caps 30 utilized
5 in the first subassembly, i.e. one or two.

6 A filter cartridge 2 is placed within the first
7 subassembly, specifically, within the inner liner 10. In
8 the event that the first subassembly comprises two end caps
9 30, engagement between the first and second subassemblies
10 is accomplished by inserting a head 60 into each end of the
11 first subassembly containing the filter 2, the support ring
12 66 of each head 60 being inserted first, so that the
13 sealing plate 61 is received within the sleeve of the first
14 subassembly. Each head 60 is further inserted into a
15 corresponding end cap 30 so that the front face 64 of the
16 sealing plate 61 is flush with the front edge 34 of the end
17 cap 30. In the event the filter cartridge 2 comprises a
18 centrally disposed coaxially extending filter endport 114,
19 the endport 114 is inserted within the flow channel 70.
20 Each head 60, disposed at the ends of the first
21 subassembly, is then secured in place by inserting the snap
22 ring 90 within ~~a~~ the recessed groove 130a formed along the interior
23 circumferential surface of a sleeve. As will be recalled,
24 the recessed groove 130a is preferably formed by the channel-
25 forming member 130 described in conjunction with FIGS. 4
26 and 5. With reference to FIG. 1, the snap ring 90
27 preferably comprises an arcuately shaped resilient and
28 deformable member having two ends 92 spaced apart from one
29 another, and an outer circumferential edge 94. The snap
30 ring 90 is inserted within the recessed groove 130a by applying
31 a compressive force at the ends 92, directing the ends
32 toward one another, then placing the snap ring 90 within
33 the groove 130a, and releasing the snap ring 90 whereby the
34 resiliency causes the edge 94 of the ring 90 to engage the
35 inner circumferential surface of the sleeve, specifically
36 within the groove 130a. The snap ring 90 is dimensioned such
37 that upon placement within the recessed groove 130a, at least a

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1 wall of the end cap 30, as shown in FIG. 9. A typical end
2 cap access port is depicted in FIG. 9 as port 31 defined by
3 a circumferential sidewall 33. The port 31 extends through
4 the sidewall of the end cap 30 perpendicularly from the
5 cylindrical axis of the end cap 30. The outer liner 102 is
6 deposited around the sidewall 33. When forming the outer
7 liner 102 by filament winding techniques, a plug or other
8 member may be inserted within the port 31. It is most
9 preferred to utilize a cone-shaped plug to insert into the
10 port 31 whereby the cone portion of the plug extends above
11 the outer surface of the outer liner 102, and which thereby ~~which~~
12 guides filaments around the opening of the access port 31.
13 Upon completion of filament winding, the plug is removed to
14 reveal the access port 31 ready for accepting a sideport
15 member 110.

16 The present invention includes embodiments in which
17 only one filter sideport 110 or filter endport 114 is
18 utilized on an end of the housing 1, or various
19 combinations of a plurality of sideports 110 and a single
20 endport 114 are used on an end of the housing 1. Moreover,
21 multiple endports 114 and/or 114a may be provided and/or
22 multiple sideports 110 can also be provided on an end of
23 the housing 1. The present invention also includes
24 embodiments in which only one end of the housing 1 contains
25 one or more sideports 110 and/or endports 114 and/or 114a.
26 Furthermore, the present invention includes a filter
27 housing having additional ports for rinsing or flushing the
28 filter, such as with a rinse solution or solvent.

29 It is particularly preferred to provide the following
30 port configurations: (i) one sideport 110 and one endport
31 114 on each end of the housing 1; (ii) no sideports 110 and
32 two endports 114 and 114a on each end; (iii) one sideport
33 110 and one endport 114 on one end and two endports 114 and
34 114a on the other end; (iv) one sideport 110 and no endport
35 on one end and one sideport 110 and one endport 114 on the
36 other end; (v) two endports 114 and 114a on one end and one
37 endport 114 on the other end; (vi) two endports 114 and

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1 invention. Nearly any inert plastic can be employed for the
2 inner liner 10 such as, but not limited to polyethylene or
3 polyvinylidiflouride. Other materials are contemplated for
4 the inner liner 10 depending upon the end use requirements.
5 If for example the housing 1 will contain a filter for
6 processing a liquid for human consumption, the liner
7 material should be in accordance with FDA requirements.
8 The materials for the end cap 30 and head 60 are preferably
9 selected to be the same or similar, or at least compatible
10 with the materials utilized for the inner liner 10. Other
11 suitable materials for the end cap 30 and the head 60
12 include for instance polyvinyl chloride or various nylon
13 alloys. The end caps 30 and heads 60 are preferably
14 injection molded. As previously noted, all the sealing
15 rings, i.e. rings 20, 50, ~~74~~, and 78, can be in the form of
16 conventional O-rings. Accordingly, they may be formed from
17 known suitable elastomers such as EPDM. The snap ring 90
18 is preferably formed from a relatively rigid, yet flexible
19 material, such as fiberglass, a strong thermoplastic, or a
20 metal or alloy thereof.

21 Since the preferred embodiment assembly 1 utilizes a
22 separate inner liner 10 that contacts the liquid undergoing
23 filtration, the outer liner 102 does not contact that
24 liquid. Therefore when working with liquids intended for
25 human consumption for instance, the outer liner need not be
26 formed from the same materials dictated by FDA requirements
27 and health concerns, as the inner liner 10. This feature
28 is of particular importance to the industry since it
29 enables housings to be formed from a higher proportion of
30 less expensive materials.

31 Although the preferred embodiment of the present
32 invention filter housing comprises a filament wound outer
33 liner, it is to be understood that the present invention
34 includes housings that are not formed by filament winding
35 techniques. Thus, the present invention encompasses a
36 filter housing that is formed from one or more metals or
37 alloys, such as for instance steel or aluminum, that



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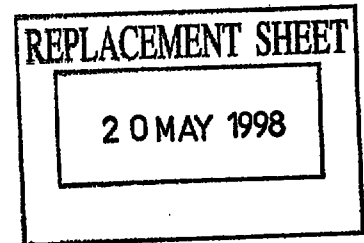
1. A filter and housing assembly, comprising:
 - an inner tubular liner having a filter cartridge housed therein;
 - an outer tubular housing adhered to said inner tubular liner and having a first sleeve member extending axially from a first end of said tubular liner;
 - an end cap disposed within said outer tubular housing and sealing receiving said first end of said inner tubular liner;
 - a first sealing head disposed within said end cap;
 - an outlet tube extending through said first sealing head and communicating with said filter cartridge;
 - a removable snap ring, said snap ring being removably secured within said first sleeve member adjacent said first sealing head and being operable to retain said sealing head in sealing engagement with said end cap;
 - whereby said snap ring may be removed for access to said filter cartridge by axial removal of said first sealing head.
2. The filter and housing assembly according to claim 1, wherein said outer housing is formed by a filament winding process.
3. The filter and housing assembly according to claim 1, wherein said filter cartridge is a reverse osmosis filter.
4. The filter and housing assembly according to claim 1, wherein said first sealing head comprises a support ring and a sealing plate, said support ring being disposed inwardly adjacent said inner liner and said sealing plate being in sealing engagement with said end cap.
5. The filter and housing assembly according to claim 4, wherein the sealing plate is engaged by said snap ring.
6. The filter and housing assembly according to claim 4, wherein said first sealing head further comprises a bridge member which extends between said



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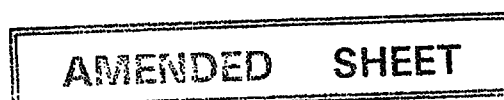


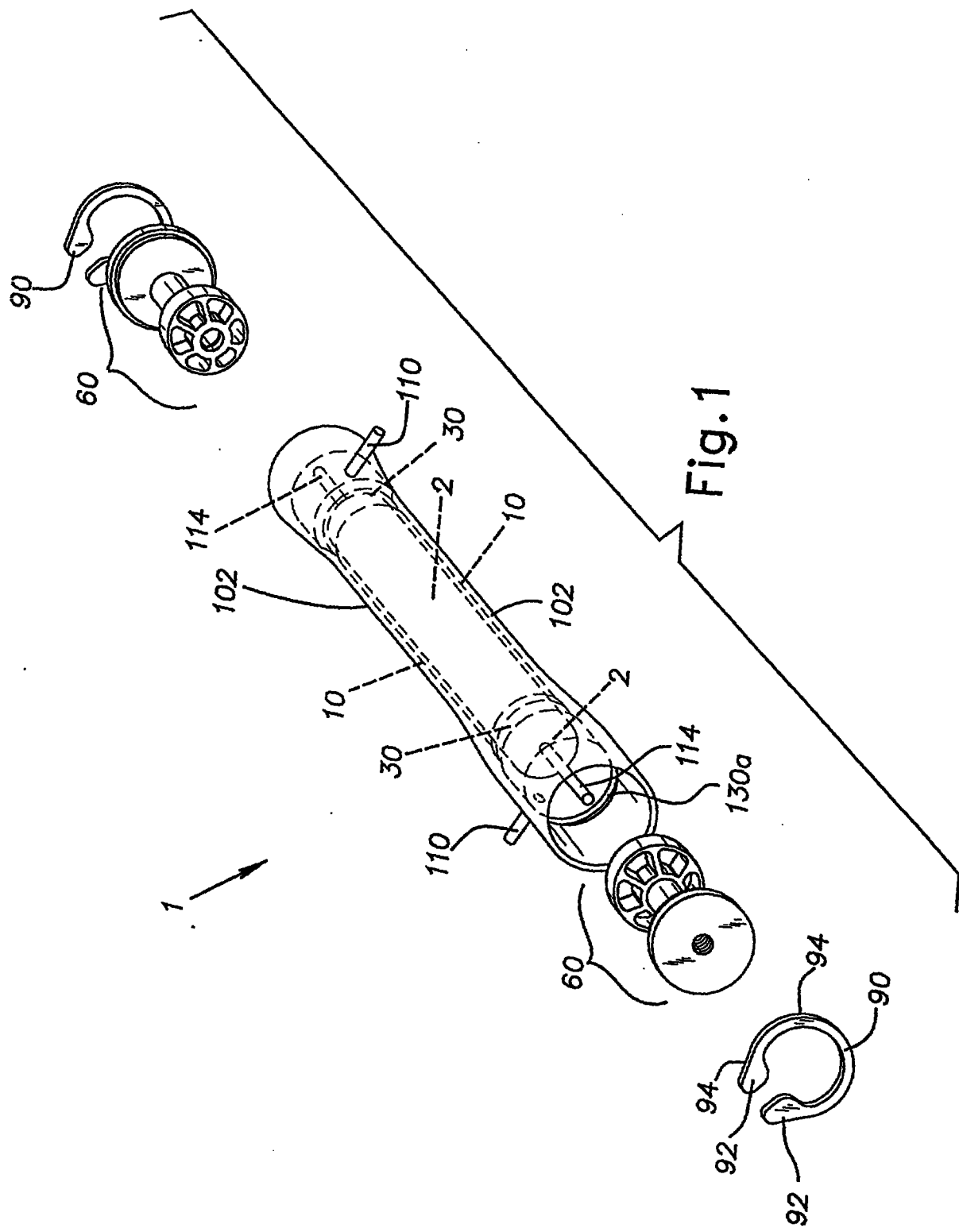
support ring and said sealing plate.

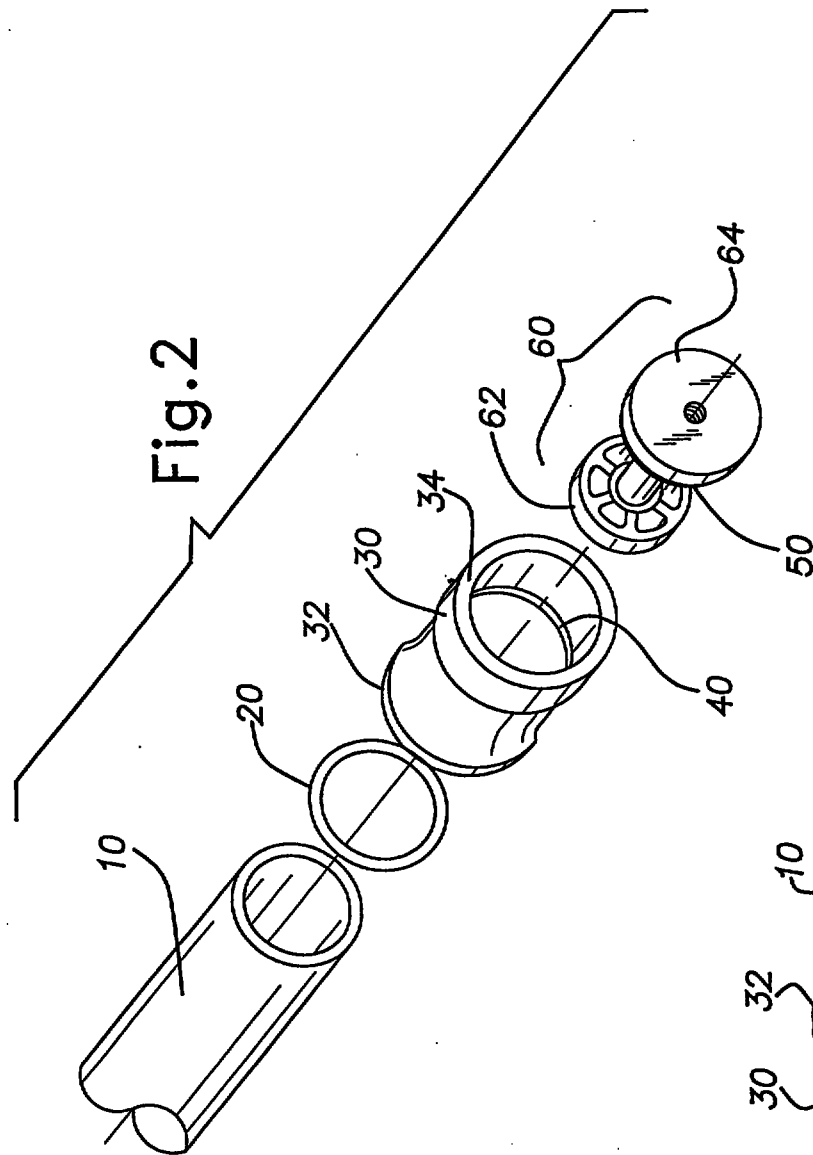
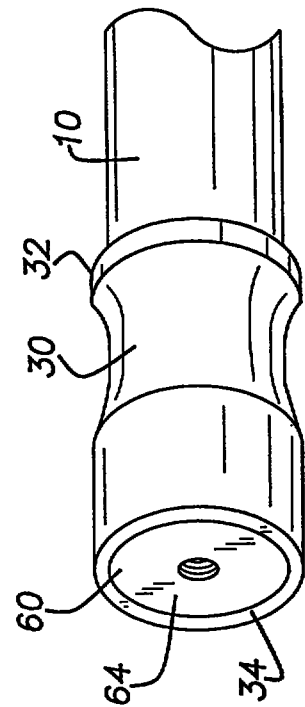
7. The filter and housing assembly according to claim 6, wherein said first sealing head has a front face and an oppositely directed rear face, said bridge member defining a passageway extending from said front face to said rear face.

8. The filter and housing assembly according to claim 6, wherein said support ring defines at least one inlet passage to said filter which communicates with a chamber defined by an interior circumferential surface of said end cap between said support ring and said sealing head, and wherein a side port through said end cap and said sleeve member communicates with said chamber.

9. The filter and housing assembly according to claim 6, wherein said support ring defines at least one inlet passage to said filter which communicates with a chamber defined by an interior circumferential surface of said end cap between said support ring and said sealing head, and wherein an end port through said sealing head communicates with said chamber.







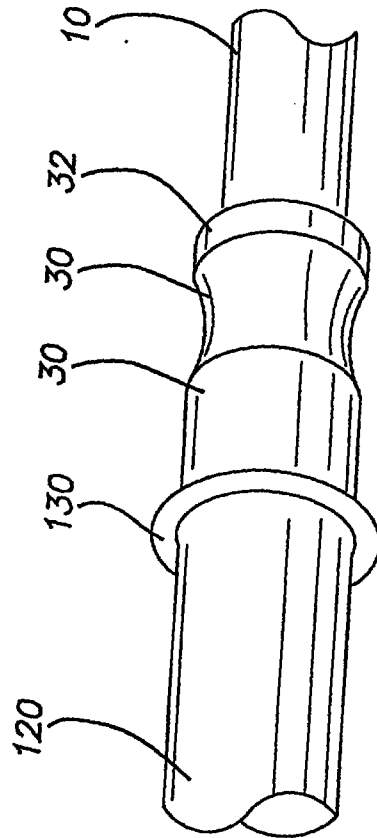


Fig. 4

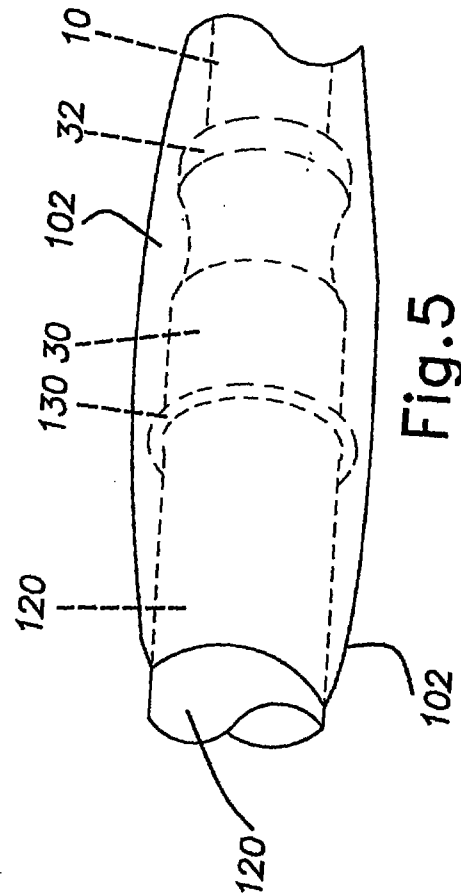


Fig. 5

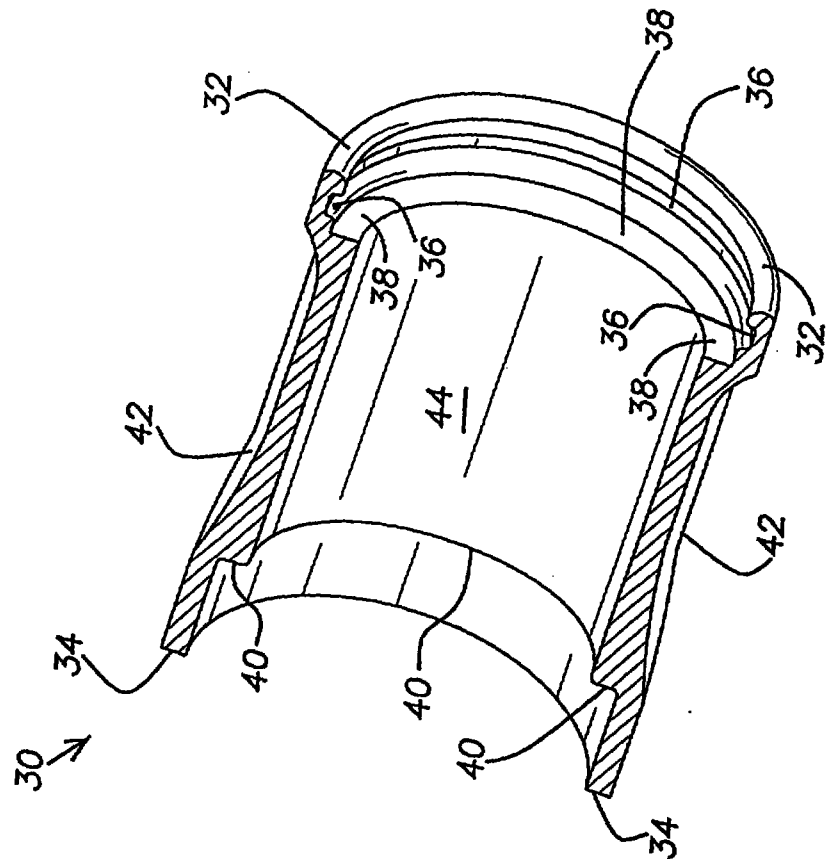


Fig.6

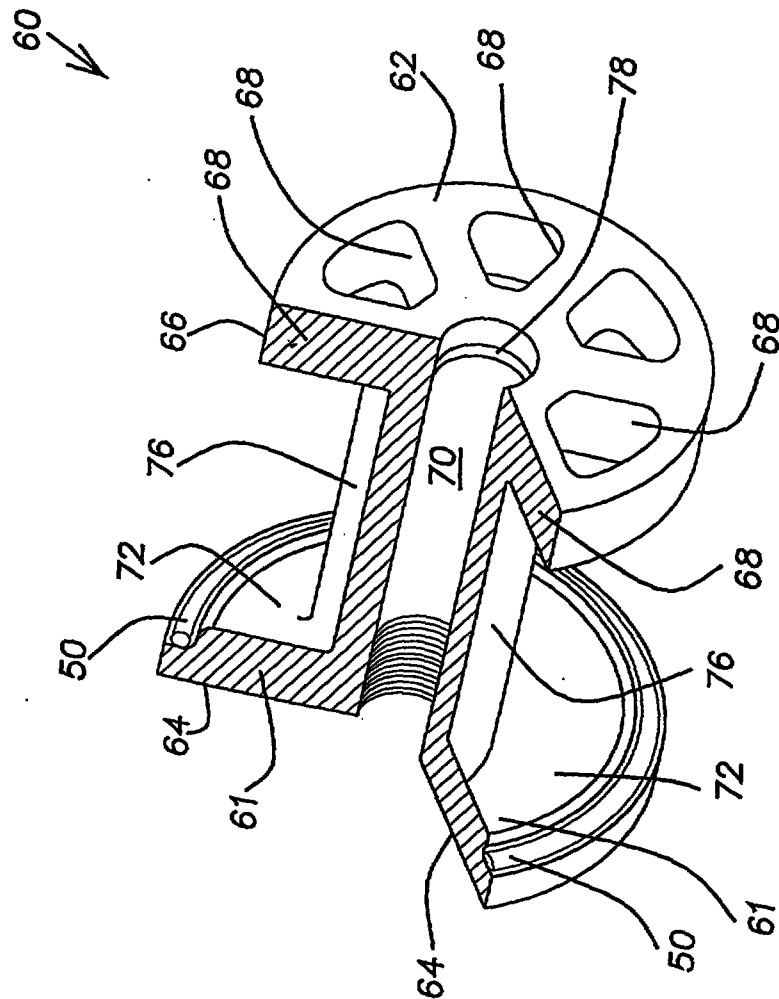
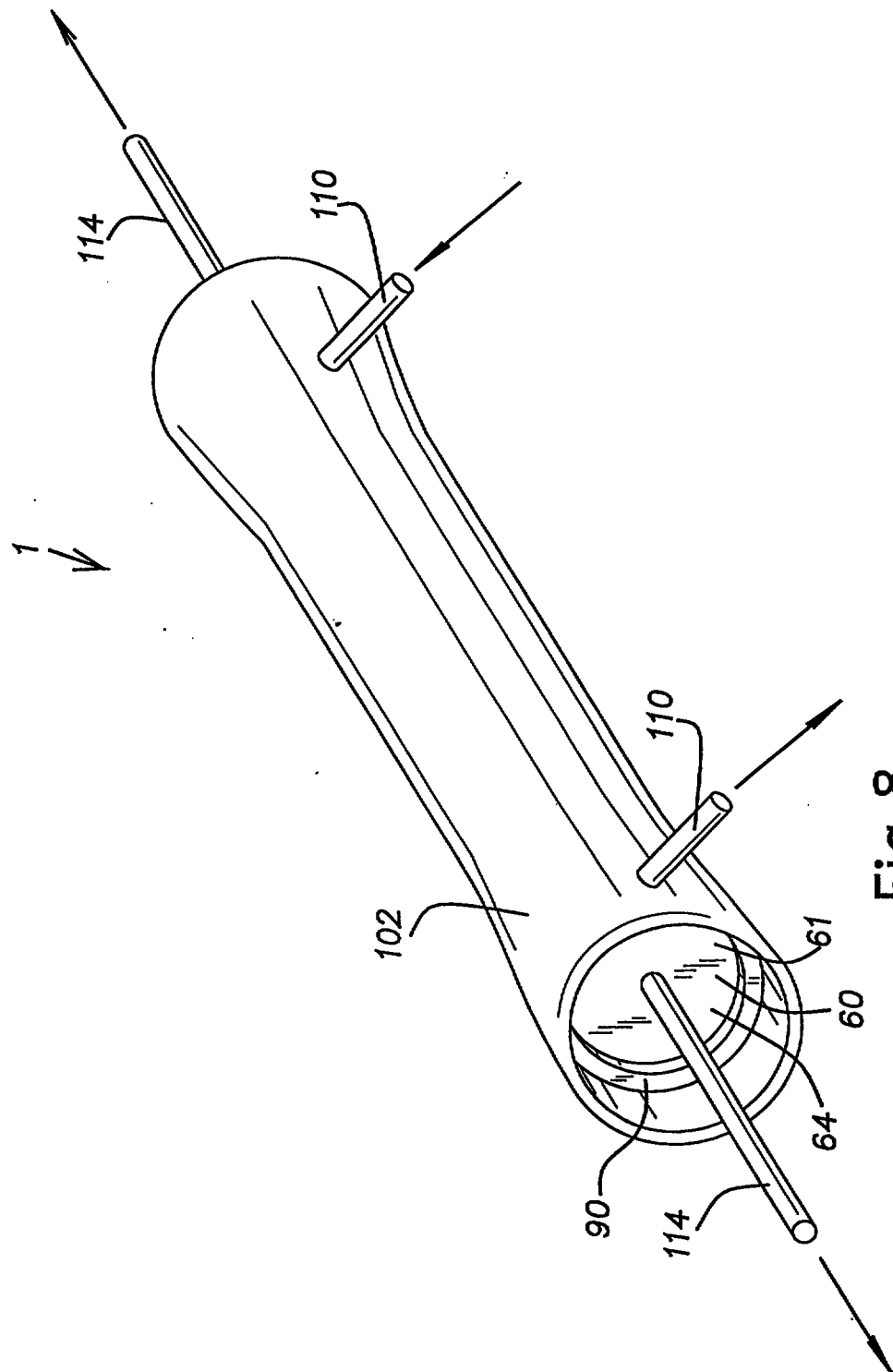


Fig.7



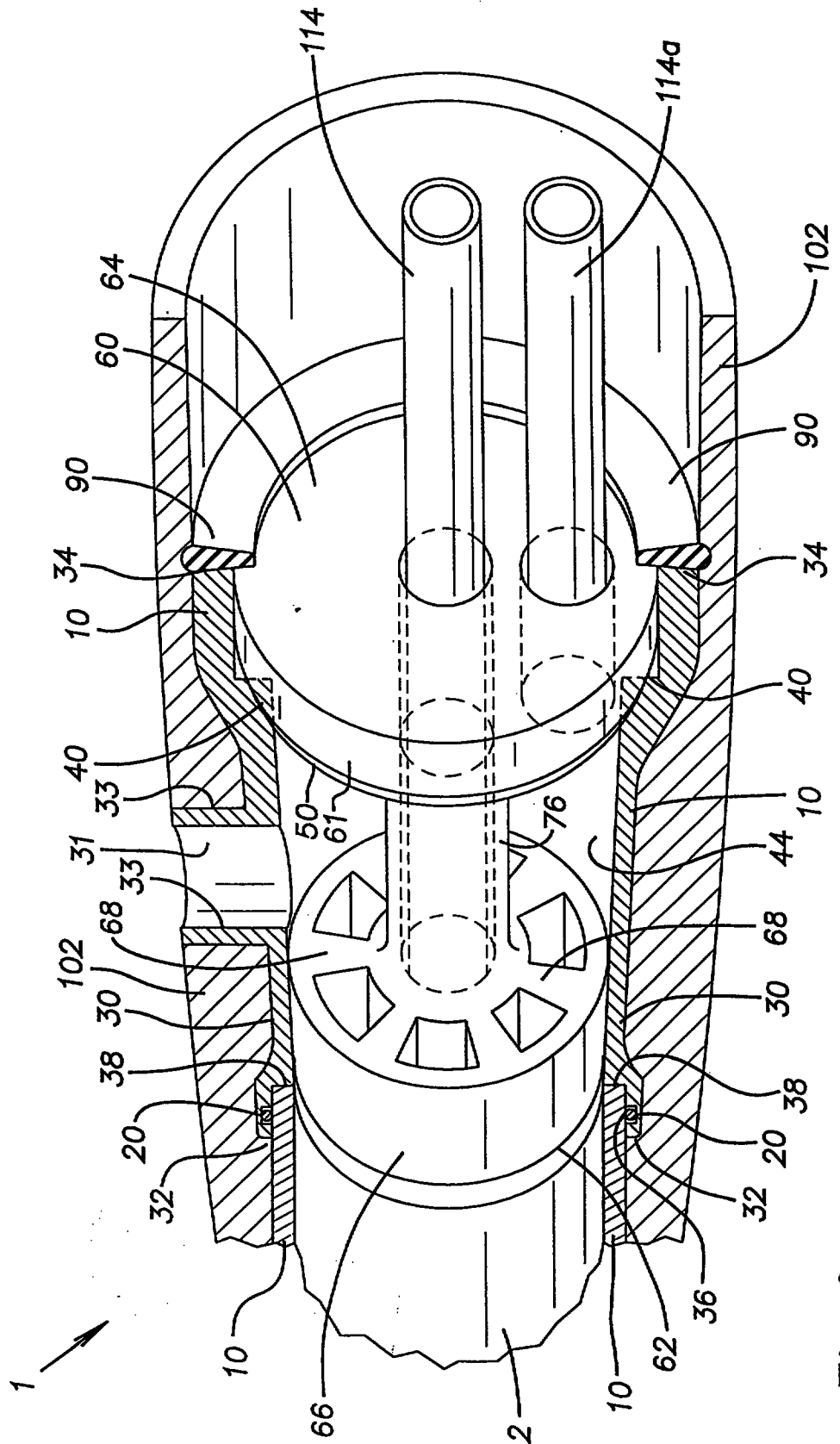


Fig. 9

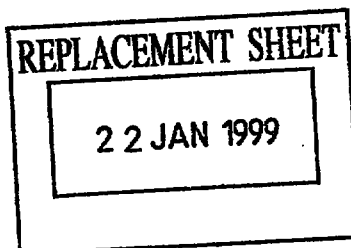


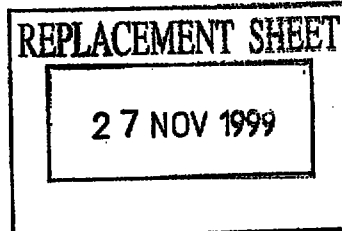
TEXT OF THE ABSTRACT

FILAMENT WOUND HOUSING FOR A REVERSE OSMOSIS FILTER CARTRIDGE

Disclosed is a housing (1) for a reverse osmosis filter. The housing (1) is preferably cylindrical and features a unique sealing assembly at each of its ends. The end assemblies enable the interior of the housing to be readily accessed and securely sealed. Each end assembly can be provided with one or more inlet and/or outlet ports.

(Fig. 1)





CLAIMS

1. A filter and housing assembly, comprising:
 - an inner tubular liner having a filter cartridge housed therein;
 - an outer tubular housing adhered to said inner tubular liner and having a first sleeve member extending axially from a first end of said tubular liner;
 - an end cap disposed within said outer tubular housing and sealing receiving said first end of said inner tubular liner;
 - a first sealing head disposed within said end cap;
 - an outlet tube extending through said first sealing head and communicating with said filter cartridge;
 - a removable snap ring, said snap ring being removably secured within said first sleeve member adjacent said first sealing head and being operable to retain said sealing head in sealing engagement with said end cap;
 - whereby said snap ring may be removed for access to said filter cartridge by axial removal of said first sealing head.
2. The filter and housing assembly according to claim 1, wherein said outer housing is formed by a filament winding process.
3. The filter and housing assembly according to claim 1, wherein said filter cartridge is a reverse osmosis filter.
4. The filter and housing assembly according to claim 1, wherein said first sealing head comprises a support ring and a sealing plate, said support ring being disposed inwardly adjacent said inner liner and said sealing plate being in sealing engagement with said end cap.
5. The filter and housing assembly according to claim 4, wherein the sealing plate is engaged by said snap ring.
6. The filter and housing assembly according to claim 4, wherein said first sealing head further comprises a bridge member which extends between said

AMENDED SHEET