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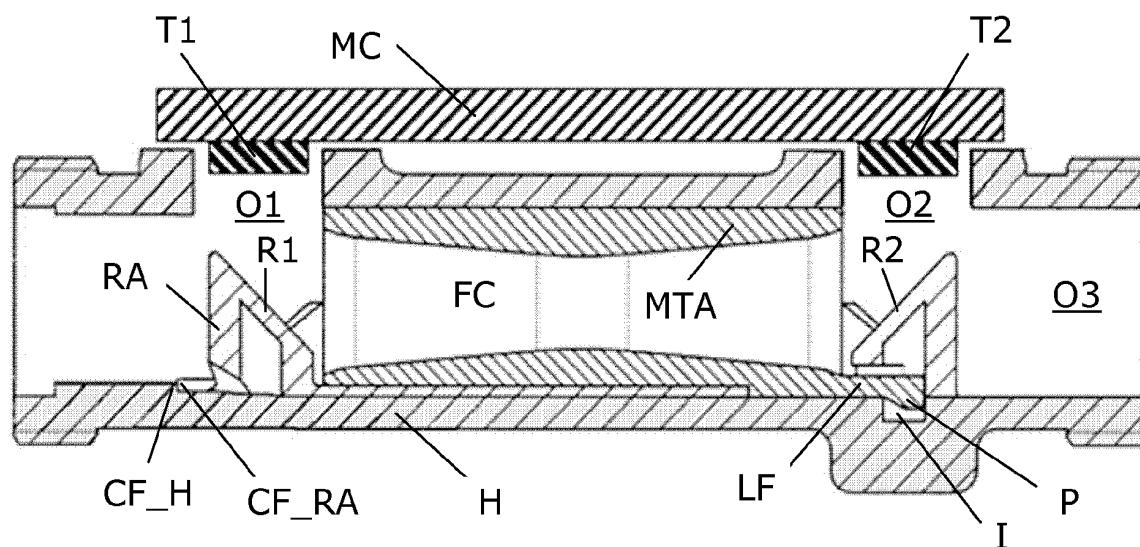
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BA ME RS(71) Applicant: **KAMSTRUP A/S****8660 Skanderborg (DK)**(72) Inventor: **Borring, Peter Nordlund****DK-7100, Vejle (DK)**(74) Representative: **Plougmann & Vingtoft A/S****Sundkrogsgade 9****P.O. Box 831****2100 Copenhagen Ø (DK)**(54) **Ultrasonic flow meter with insert fixed by locking finger**

(57) An ultrasonic flow meter unit arranged to measure a flow rate of a fluid. The unit has a housing, e.g. a metal housing, with a through-going opening with an inner surface and with two openings for ultrasonic transducers. An indentation is positioned in an area of the inner surface being reachable from one of the transducer openings with a straight tool for making the indentation. The unit also includes an insert arranged for insertion into the housing from one end of the through-going opening. The insert has 1) a reflector arrangement with two ultrasound signal reflectors, 2) a measuring tube arrangement with a flow channel for receiving the fluid, and

3) a locking finger with a protrusion arranged for engagement with the indentation, so that the locking finger can lock the insert in both a longitudinal and a rotational direction within the housing. The locking finger may be integrally formed with the insert, e.g. integrally formed with a separate measuring tube arrangement unit which is shaped to fit onto a separate reflector arrangement unit so as to form the insert which can then be inserted into one end of the housing. The unit is advantageous for ultrasonic flow meters such as for use in charging consumption meters as gas meters, heat meters and cooling meters.

**Fig. 1**

Description

FIELD OF THE INVENTION

[0001] The invention relates to an ultrasonic flow meter, such as for ultrasonic measurements of fluid flow as used e.g. in a consumption meter.

BACKGROUND OF THE INVENTION

[0002] Ultrasonic flow meters for measuring fluid flow in connection with charging of a consumed quantity (e. g. heat, cooling, water or gas) typically have a metallic or polymeric housing, with a cavity in the form of a through-going hole for receiving the fluid flow to be measured. Connection means to other fluid flow elements are present in each of the housing's ends. For manufacturing of such flow meters, it is advantageous to be able to pre-assemble a number of elements, since this may lead to a simplified overall assembly process.

[0003] EP 1 978 337 A1 discloses an ultrasonic flow meter with an insert having two ultrasonic reflectors and a measuring tube. This insert is suited for insertion into the housing from one end of the through-going opening through the housing. The position of the insert is fixed in relation to the housing by means of a fixing element mounted in a separate opening of the housing and sealed with an O-ring. It is a problem with the flow meter disclosed in EP 1 978 337 A1 that the fixing of the insert in the housing requires several elements, i.e. a fixing element, a sealing ring, and a separate opening in the housing to enable engagement of the fixing element with the insert. Furthermore, the separate opening and sealing necessitated by the fixing element introduces a source of error in the flow meter, since a leakage may occur here.

[0004] EP 0 897 101 B1 discloses an ultrasonic flow meter, with separate reflector inserts which are arranged for insertion into the housing from respective ends of the through-going opening of the housing. The reflector inserts are fixed in a longitudinal direction by means of snap engagement. The flow meter disclosed in EP 0 897 101 B1 requires a number of assembly steps, since first one of the inserts must be snapped into position from one end of the housing, then the measuring tube must be inserted from the opposite end, and finally the second insert must be snapped into position. Thus, a number of single elements are required, and several steps are required in the final assembly state of the meter. Still further, the insert are not fixed in a rotational direction in relation to the housing.

SUMMARY OF THE INVENTION

[0005] It may be seen as an object of the present invention to provide an improved ultrasonic flow meter which has a low level of complexity regarding manufacturing, in particular in connection with assembly of the flow meter, and still is suited for high precision measure-

ments and provide a long life-time.

[0006] The invention provides an ultrasonic flow meter unit arranged to measure a flow rate of a fluid, the meter unit comprising

- a housing having a through-going opening with an inner surface, at least two openings for receiving at least two associated ultrasonic transducers, and an indentation positioned in an area of the inner surface being reachable from at least one of the openings for receiving the ultrasonic transducers with a straight tool for making the indentation, and
- an insert with dimensions enabling insertion of the insert into the housing from one end of the through-going opening, the insert comprising
 - a reflector arrangement comprising at least two reflectors arranged to reflect an ultrasound signal emitted from an associated ultrasonic transducer,
 - a measuring tube arrangement comprising a measuring tube with a flow channel for receiving the fluid, and
 - a locking finger with a protrusion arranged for engagement with the protrusion, so that the locking finger is adapted to lock the insert in a longitudinal direction and in a rotational direction within the housing in a predetermined fixed relationship relatively to the associated ultrasonic transducers.

[0007] Such flow meter unit is advantageous, since it can be manufactured in a highly automated manufacturing process with a limited number of sub-assembly operations. The insert can be manufactured, and possibly sub-assembled, separate from the housing and secured in the housing by insertion from one end of the through-going opening. Thus, the housing can be assembled with measuring tube and reflectors in a simple operation without the need for subsequent steps of fastening these parts to the housing to fix or lock the position of these parts within the housing. This is obtained by the locking finger and indentation arrangement that can be formed to click or snap lock function.

[0008] With the insert being locked in position relative to the housing, the insert also has a fixed position relative to the openings for the associated ultrasonic transducer, and thus it is ensured that the reflectors have a fixed position relative to the ultrasonic transducers, once they are mounted in these openings.

[0009] In embodiments, the inner diameter of the through-going opening is such that the insert fits into the through-going opening with a suitable clearing. Thus, the inner diameter of the through-going opening should be larger than the largest diameter of the circumscribed circle of the cross section of the insert in the plane perpendicular to the through-going axis and along the through-going axis. In preferred embodiments, the inner diameter

of the through-going opening is within the interval 5 mm to 150 mm, such as within the interval 10 mm to 100 mm, such as within the interval 25 mm to 75 mm, such as 50 mm.

[0010] In embodiments, the at least two openings for receiving the associated ultrasonic transducers are circular holes, or holes of other shapes, with sizes arranged to receive ultrasonic transducers, or groups of ultrasonic transducers. In case of holes with a circular cross sections, a diameter of such holes may be such as 5 mm to 40 mm, such as 10 mm to 20 mm.

[0011] Especially, the flow meter unit is suited for flow meters with a metal housing which requires machining during manufacture, such as a metal housing which is formed by hot press moulding followed by machining. Due to the positioning of the indentation that forms part of the locking mechanism, the indentation can be made without special tools, e.g. the indentation can be a hole positioned such that it can be drilled through one of the openings for receiving a transducer.

[0012] In one embodiment, the indentation is provided in an area of the inner surface defined by a perpendicular projection of the area of one of the openings for receiving an associated ultrasonic transducer onto the inner surface. Hereby it is easy to provide the indentation in the form of a hole drilled through one of the openings for receiving a transducer. The indentation is typically circularly or elongated, since these shapes are easily made with standard drills.

[0013] The locking finger may comprise an elongated member integrally formed with a structure of the insert, having a section of attachment at one end and the protrusion positioned in the opposite end, and wherein the elongated member is shaped such that the protrusion is movable relative to the insert structure. In this embodiment, the locking finger can be shaped as a rather simple structure integrally formed together, e.g. cast, with a part of the insert. The elongated member may be bendable and thus allow the protrusion to move in relation to the insert structure, e.g. the protrusion may be able to move in a resilient manner. Thereby, the locking finger can serve to provide the effect of locking the insert together with the housing, thus fixing the position of measuring tube and reflectors relative to the housing, once it has been inserted in the housing and the protrusion has moved into engagement with the indentation.

[0014] In one embodiment the reflector arrangement is provided with a cavity for receiving at least part of the locking finger, so that the locking finger is able to bend into the reflector arrangement, e.g. during insertion of the insert into the housing.

[0015] The reflector arrangement and the measuring tube arrangement may be provided as separate entities that can be assembled to form the insert. Furthermore, one design of a reflector arrangement can be combined with different measuring tube arrangements, e.g. having different measuring channel diameters, thus allowing a high versatility of single pre-fabricated parts.

[0016] In one embodiment, the locking finger is formed integrally with the measuring tube arrangement. Alternatively, the locking finger may be formed integrally with the reflector arrangement. In embodiments, the reflector arrangement and/or the measuring tube arrangement are provided as separate monolithic entities. E.g. the reflector arrangement and the measuring tube arrangement may be formed by polymeric materials, e.g. formed in a casting process. The polymeric material may be selected from, but is not limited to, the group consisting of polyphenylene sulphide (PPS), polyether sulphone (PES) and Polyether Sulphone (PSU). It is noted that the properties of the polymeric materials can be customized by adding certain additives prior to the moulding process, affecting the material properties such as stiffness, density or the acoustic impedance. Examples of potential additives include reinforcement materials such as glass fibres, density increasing fillers such as chalk (calcium carbonate, CaCO_3) or powdery stainless steel raising the acoustic impedance of the material.

[0017] The inner surface may be provided with a contact face to engage with an associated contact face of the insert, the contact face of the inner surface being position upstream in a flow direction with respect to the locking finger. Hereby, the insert is further supported in withstanding the flow pressure.

[0018] In embodiments, the housing is a metal housing, such as a housing made of a metal alloy such as brass, red brass, stainless steel, or other suitable casting alloys.

[0019] In embodiments, the flow meter unit is or is part of an ultrasonic flow meter. Especially, such flow meter may be or may be part of a charging consumption meter, e.g. a water meter, gas meter, heat meter, or cooling meter. The consumption meter may be a legal meter, i.e. a meter which is subdued to regulatory demands. Such regulatory demands may be demands to the precision of the measurements.

[0020] In a consumption meter, the associated ultrasonic transducers are mounted in the at least two openings of the housing. Moreover, the consumption meter further comprises a measurement circuit operationally connected to the ultrasonic transducers and arranged to determine a value representing the flow rate. The ultrasonic transducers and the measuring circuit may in embodiments be provided as a unit adapted to be mounted onto the housing. Additionally, a consumption meter is normally equipped with a calculator unit which based on the value representing the flow rate is adapted to calculate a consumed quantity, and optionally additional quantities. The calculator unit may be a separate unit or a unit combined with the measuring circuit for operating the transducers.

BRIEF DESCRIPTION OF THE DRAWINGS

[0021] Embodiments of the invention will be described, by way of example only, with reference to the drawings,

in which

Fig. 1 illustrates a schematic cross-sectional view of an ultrasonic flow meter with the insert inserted in the housing,

Fig. 2 illustrates a schematic cross-sectional view of the insert of the embodiment shown in Fig. 1,

Fig. 3 illustrates a schematic side view of the insert of Fig. 2,

Fig. 4 illustrates a schematic 3D view of the bottom part of the insert, and

Fig. 5 illustrates a schematic cross-sectional view of the insert in a semi-assembled state.

DESCRIPTION OF EMBODIMENTS

[0022] Fig. 1 shows a schematic cross-section of an embodiment of an ultrasonic flow meter with a metal housing H, with two openings O1, O2 arranged to receive respective ultrasonic transducers T1, T2. In the shown embodiment, the two transducers T1, T2 are mounted on a PCB with measurement circuit MC electrically connected to the transducers T1, T2 and arranged to operate them. Additional elements, such as protection membranes for the transducers and sealing elements, may be present in an operating flow meter. The housing further comprises a through-going opening O3 for receiving a fluid flow. The housing H may be a machined block of metal alloy, where the openings O1, O2, O3 are drilled.

[0023] The housing H has an indentation I, e.g. a circular hole, positioned directly under the transducer opening O2, thus allowing the indentation I to be formed easily by drilling. As seen, the indentation engages with the protrusion P position at the end of the elongated locking finger LF. The locking finger LF with the protrusion P is formed integrally with the measuring tube arrangement MTA which is formed as a separate monolithic unit separate from the reflector arrangement RA which is formed as another separate unit arranged for engagement with the measuring tube arrangement MTA. The measuring tube arrangement is shaped to provide a flow channel FC inside the measuring tube. The reflector arrangement RA is also preferably formed as one monolithic unit which includes two reflectors R1, R2 which are both angled so as to reflect ultrasonic signals between the two transducers T1, T2 in order to ensure that the ultrasonic signals travel through the flow channel FC. The reflecting surfaces of the reflectors R1, R2 are angled 45° relative to the direction of the fluid flow through the flow channel FC.

[0024] During manufacturing, separate units forming the reflector arrangement RA and the measuring tube arrangement MTA are first assembled to form an insert. Subsequently the insert is inserted into one end of the through-going opening O3 of the housing H where the

protrusion P on the resilient locking finger LF serves to lock the insert into the correct position relative to the housing H, both with respect to rotation and with respect to longitudinal movement. The resilient effect of the locking finger LF is obtained by shaping the finger as an elongated member with dimensions adjusted in relation to the material in which it is formed, such that a suitable resilient effect is obtained to allow bending of the finger LF during insertion of the insert, but still provide a sufficiently tight fit of the protrusion P into the indentation I to ensure that the position of the insert is properly locked.

[0025] In the shown embodiment, the insert is arranged for insertion from the opening O3 to the right, since the reflector arrangement RA has a contact face CF_RA arranged to face a corresponding contact face CF_H on the housing to provide further support to the insert to sustain the pressure from the fluid flow. The locking finger LF and the protrusion P are shaped such that the protrusion P clicks into the indentation I when the insert is inserted in its correct position, i.e. when the contact faces CF_RA, CF_H meet, and thus the resilient locking finger serves to lock the position of the insert within the through-going opening O3 of the housing H.

[0026] Fig. 2 shows a schematic cross-section of the insert of the embodiment of Fig. 1. As seen, the measuring tube arrangement MTA unit is shaped to fit together with the reflector arrangement RA unit. The locking finger LF is integrally formed with the measuring tube arrangement MTA and fits into a through-going opening of the reflector arrangement RA such that the two units MTA, RA are locked in relative position. As seen the reflector arrangement RA is shaped such that a cavity C is formed in an area of the reflector support. This cavity C provides space to allow the locking finger LF to bend upwards during insertion into the housing, and thus allow the protrusion P on the locking finger LF to move upward during insertion. Once the correct position is obtained the protrusion snap into locking engagement with the indentation I of the housing H.

[0027] Fig. 3 shows a side view of the same embodiment shown in Fig. 2. In the illustrated embodiment, the reflector arrangement is a single unit with the two reflectors spaced apart with a middle piece. The middle piece is formed to receive and maintain the measuring tube arrangement MTA in correct position between the two reflectors.

[0028] Fig. 4 shows another view of the same insert embodiment as in Figs. 2 and 3, here as a 3D view from below, thus showing that the locking finger LF and the protrusion P formed integrally with the measuring tube arrangement MTA engages with a matching through-going opening in the bottom of the reflector arrangement RA. The contact face CF_RA arranged to face the corresponding face CF_H of the housing H is seen to be formed by two protruding members. The shape of the contact face CF_RA can be of any appropriate shape.

[0029] Fig. 5 shows yet another view of the same insert embodiment, namely a schematic cross-sectional view

of the measuring tube arrangement during assembly with the reflector arrangement. As seen, the protrusion P of the locking finger LF is inserted in the matching through-going opening OP of the reflector arrangement RA which also includes the cavity C to allow bending of the locking finger LF, once the measuring tube arrangement MTA is in position. The measuring tube arrangement MTA has a contact face CF arranged to face a matching face on the reflector arrangement so as to fix their relative position, once these parts MTA, RA are assembled to form an insert.

Claims

1. An ultrasonic flow meter unit arranged to measure a flow rate of a fluid, the meter unit comprising

- a housing (H) having a through-going opening (O3) with an inner surface, at least two openings (O1, O2) for receiving at least two associated ultrasonic transducers (T1, T2), and an indentation (I) positioned in an area of the inner surface being reachable from at least one of the openings (O1, O2) for receiving the ultrasonic transducers (T1, T2) with a straight tool for making the indentation (I), and

- an insert with dimensions enabling insertion of the insert into the housing (H) from one end of the through-going opening (O3), the insert comprising

- a reflector arrangement (RA) comprising at least two reflectors (R1, R2) arranged to reflect an ultrasound signal emitted from an associated ultrasonic transducer (T1, T2),
- a measuring tube arrangement (MTA) comprising a measuring tube with a flow channel (FC) for receiving the fluid, and
- a locking finger (LF) with a protrusion (P) arranged for engagement with the indentation (I), so that the locking finger (LF) is adapted to lock the insert in a longitudinal direction and in a rotational direction within the housing (H) in a predetermined fixed relationship relatively to the associated ultrasonic transducers (T1, T2).

2. Flow meter unit according to claim 1, wherein the indentation (I) is provided in an area of the inner surface defined by a perpendicular projection of the area of one of the openings (O1, O2) for receiving an associated ultrasonic transducer (T1, T2) onto the inner surface.

3. Flow meter unit according to claim 1 or 2, wherein the locking finger (LF) comprises an elongated member integrally formed with a structure of the insert at

one end, wherein the protrusion (P) is positioned in the opposite end of the elongated member, and wherein the elongated member is shaped such that the protrusion (P) is movable relative to the insert structure.

4. Flow meter unit according to any of the preceding claims, wherein the reflector arrangement (RA) is provided with a cavity (C) for receiving at least part of the locking finger (LF), so that the locking finger (LF) is able to bend into the reflector arrangement (RA).

5. Flow meter unit according to any of the preceding claims, wherein the reflector arrangement (RA) and the measuring tube arrangement (MTA) are provided as separate entities that can be assembled to form the insert.

6. Flow meter unit according to claim 5, wherein the locking finger (LF) is formed integrally with the measuring tube arrangement (MTA).

7. Flow meter unit according to any of the claims 1 to 5, wherein the locking finger (LF) is formed integrally with the reflector arrangement (RA).

8. Flow meter unit according to any of claims 5-7, wherein the reflector arrangement (RA) and the measuring tube arrangement (MRA) are provided as separate monolithic entities.

9. Flow meter unit according to claim 8, wherein the reflector arrangement (RA) and the measuring tube arrangement (MRA) are formed by polymeric materials.

10. Flow meter unit according to any of the preceding claims, wherein the inner surface is provided with a contact face (CF_H) to engage with an associated contact face (CF_RA) of the insert, the contact face (CF_H) of the inner surface being positioned upstream in a flow direction with respect to the locking finger (LF).

11. Flow meter unit according to any of the preceding claims, wherein the housing (F) is a metal housing.

12. An ultrasonic flow meter comprising an ultrasonic flow meter unit according to any of the preceding claims, and at least two ultrasonic transducers (T1, T2) mounted in the at least two openings (O1, O2) of the housing (H) and a measurement circuit (MC) operationally connected to the two ultrasonic transducers (T1, T2) and arranged to determine a value representing the flow rate.

13. Ultrasonic flow meter according to claim 12, com-

prising a calculator unit connected to receive the value representing the flow rate, wherein the calculator unit is arranged to calculate a consumed quantity based on the value representing the flow rate.

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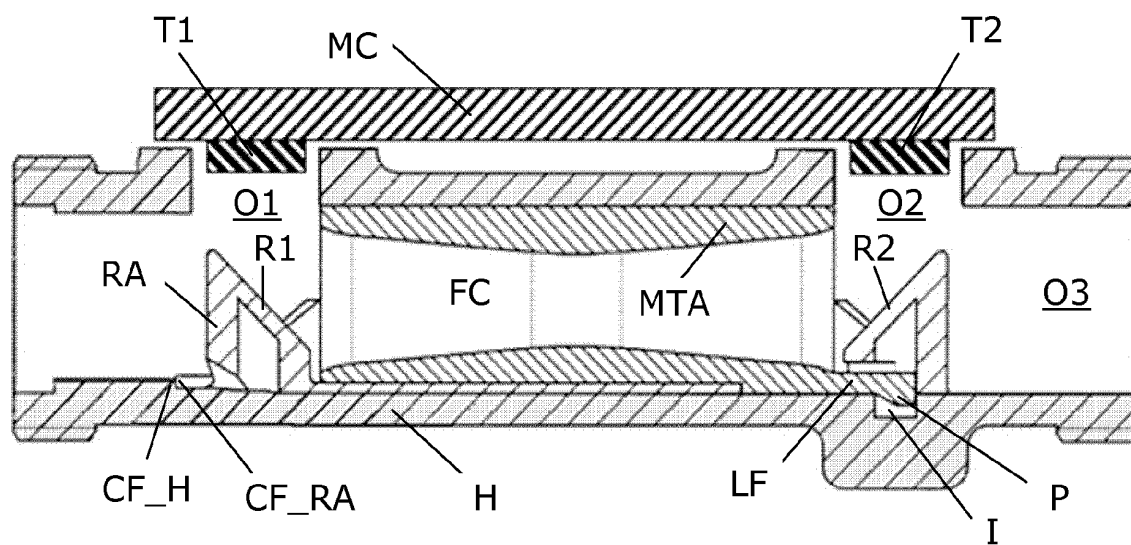


Fig. 1

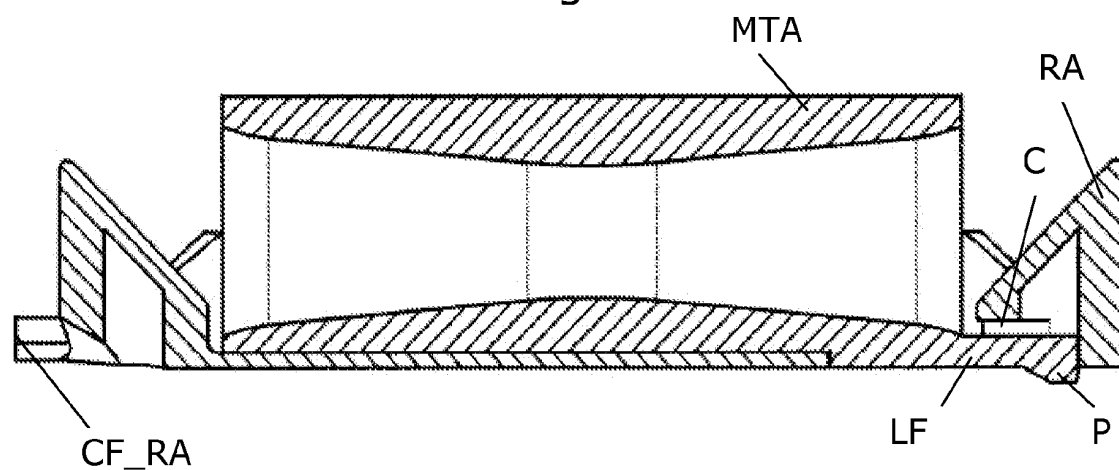


Fig. 2

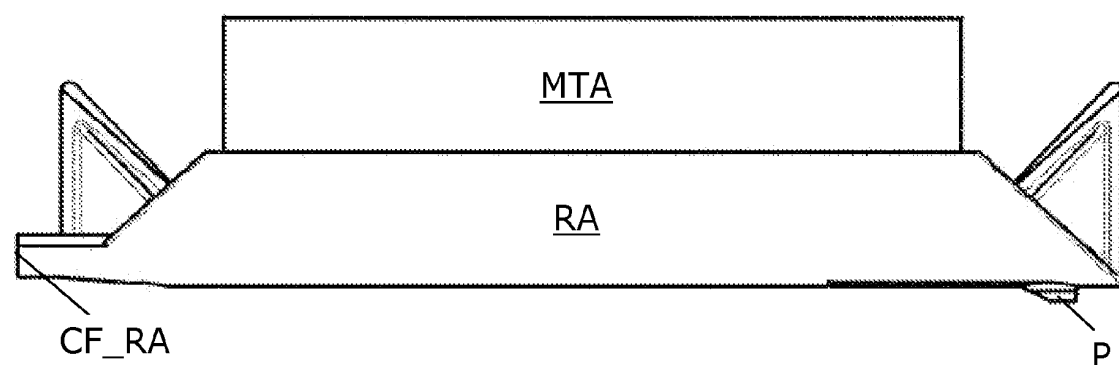


Fig. 3

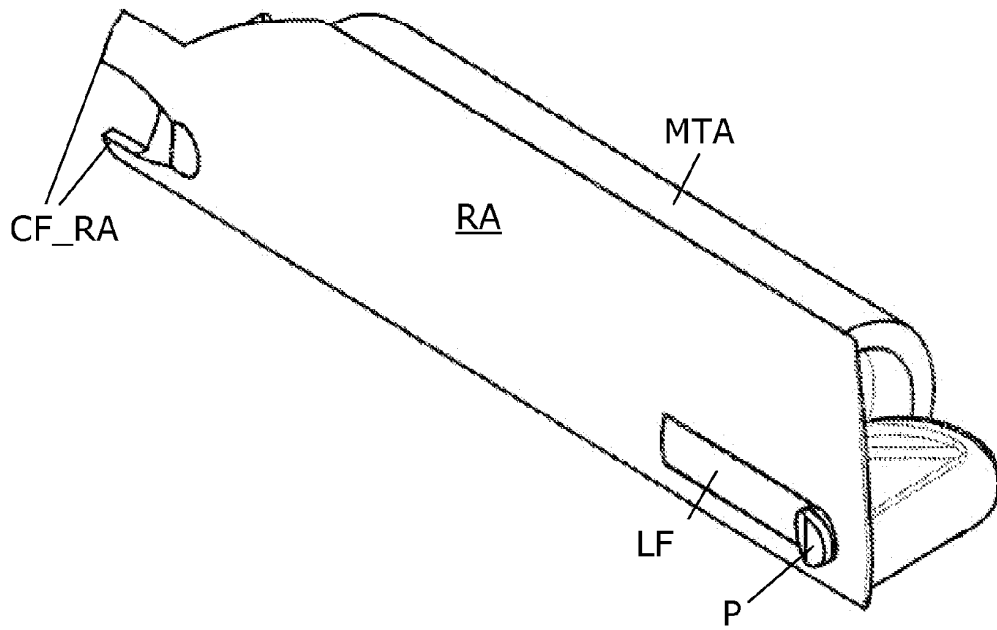


Fig. 4

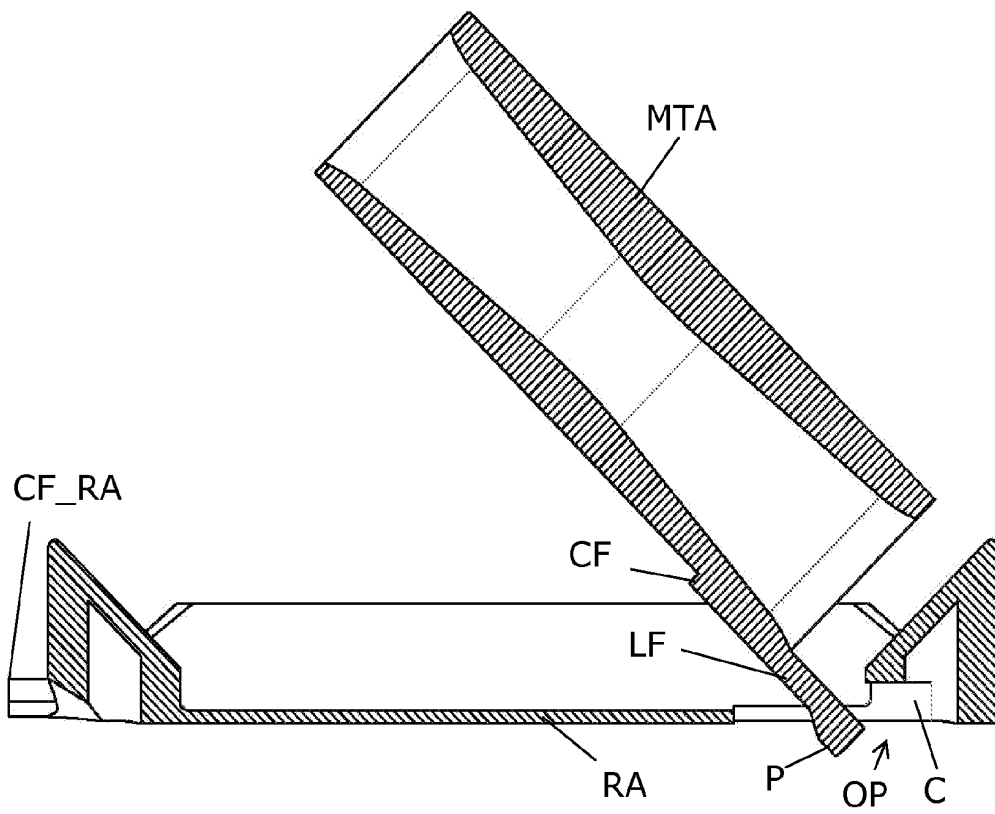


Fig. 5



EUROPEAN SEARCH REPORT

Application Number
EP 10 17 4660

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The present search report has been drawn up for all claims			
Place of search The Hague		Date of completion of the search 27 January 2011	Examiner Kloppenburger, Martin
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			

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EPO FORM 1503 03.82 (P04001)

**ANNEX TO THE EUROPEAN SEARCH REPORT
ON EUROPEAN PATENT APPLICATION NO.**

EP 10 17 4660

This annex lists the patent family members relating to the patent documents cited in the above-mentioned European search report.
The members are as contained in the European Patent Office EDP file on
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27-01-2011

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