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(54) **ANNULAR FUEL PROCESSOR AND METHODS**

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(Continued)

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(21) Appl. No.: **10/877,044**

U.S. Appl. No. 10/131,846, entitled: Microfluidic Fuel Cell Systems with Embedded Materials and Structures and Method Thereof, by inventors: Morse, filed Apr. 24, 2002.

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(57) **ABSTRACT**

(51) **Int. Cl.**
B01J 7/00 (2006.01)
H01M 8/06 (2006.01)
B01J 8/00 (2006.01)
B01J 10/00 (2006.01)
B01J 8/04 (2006.01)
B01J 19/00 (2006.01)

Described herein is a fuel processor that produces hydrogen from a fuel source. The fuel processor comprises a reformer and burner. The reformer includes a catalyst that facilitates the production of hydrogen from the fuel source. Voluminous reformer chamber designs are provided that increase the amount of catalyst that can be used in a reformer and increase hydrogen output for a given fuel processor size. The burner provides heat to the reformer. One or more burners may be configured to surround a reformer on multiple sides to increase thermal transfer to the reformer. Dewars are also described that increase thermal management of a fuel processor and increase burner efficiency. A dewar includes one or more dewar chambers that receive inlet air before a burner receives the air. The dewar is arranged such that air passing through the dewar chamber intercepts heat generated in the burner before the heat escapes the fuel processor.

(52) **U.S. Cl.** **48/61**; 48/127.9; 422/188; 422/196; 422/198

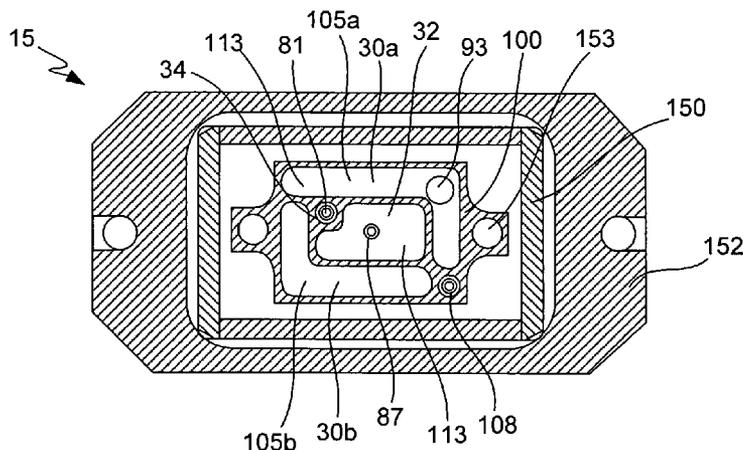
(58) **Field of Classification Search** 48/127.9, 48/61; 422/188, 196, 198
See application file for complete search history.

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40 Claims, 13 Drawing Sheets



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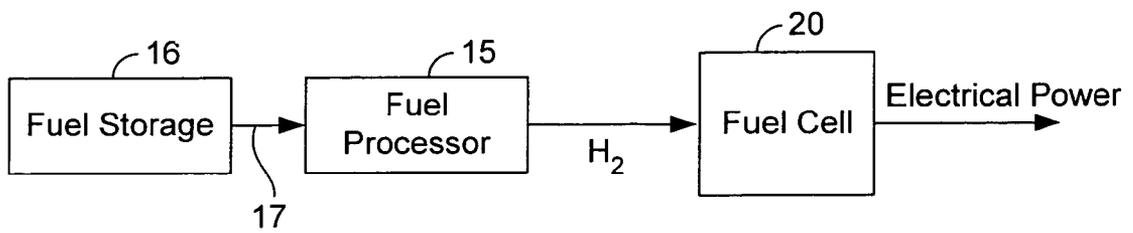


FIG. 1A

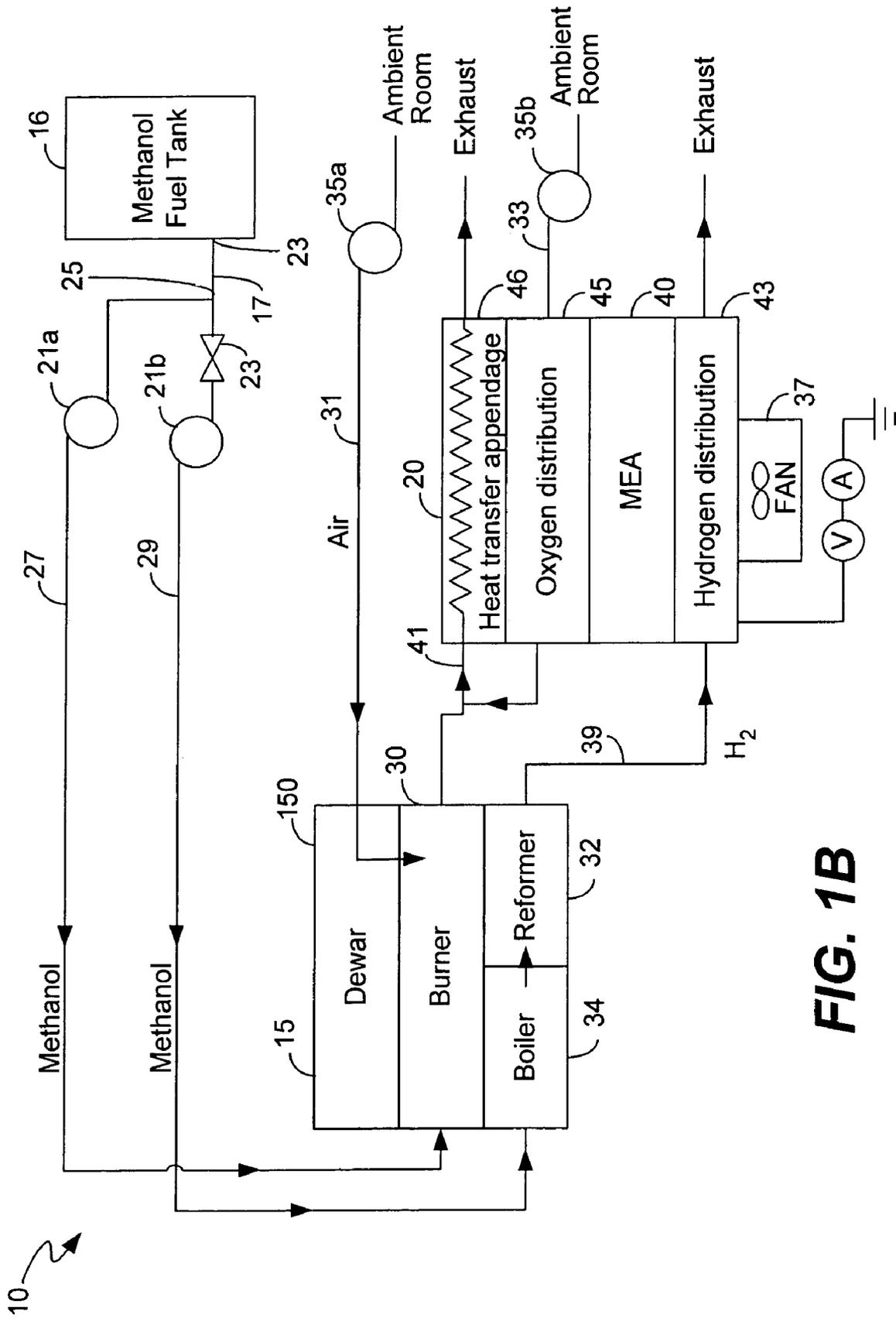


FIG. 1B

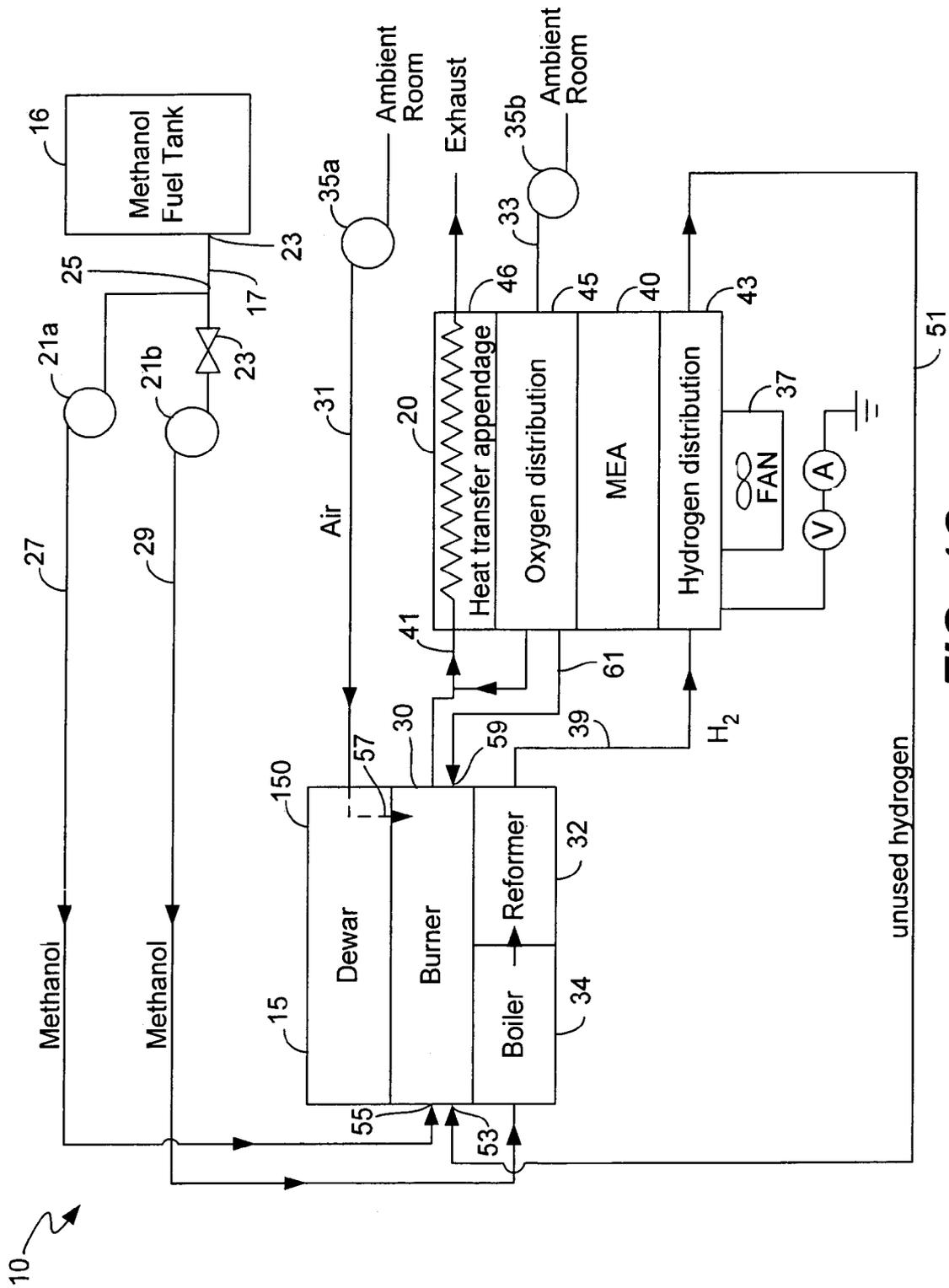


FIG. 1C

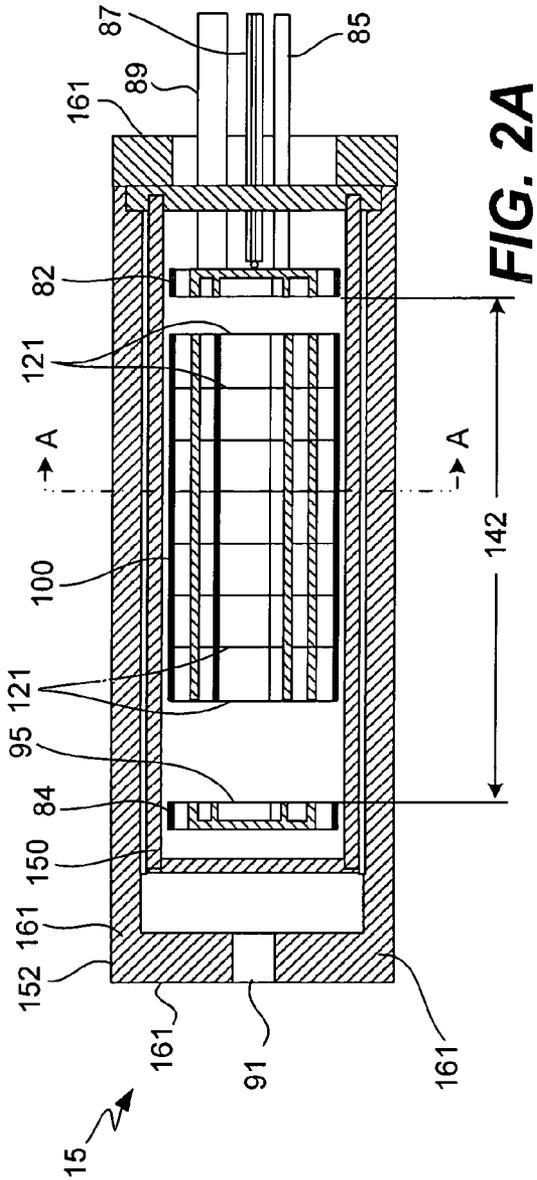


FIG. 2A

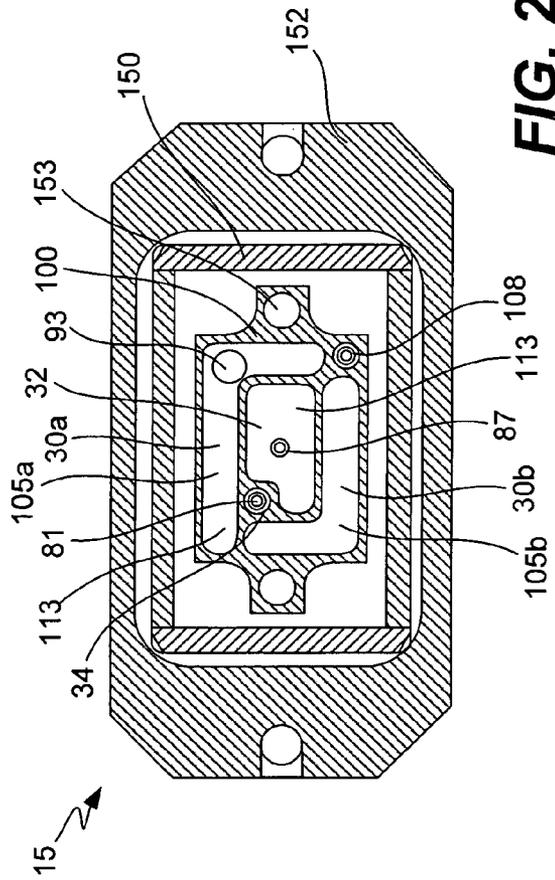


FIG. 2B

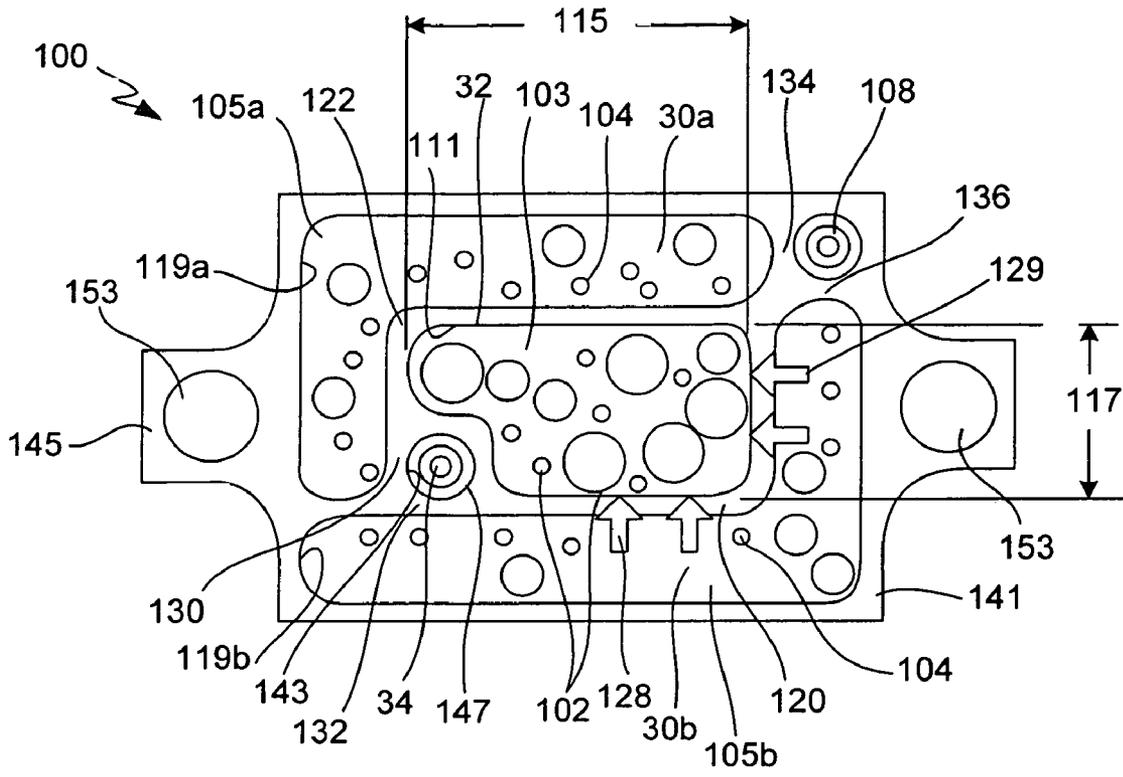


FIG. 3A

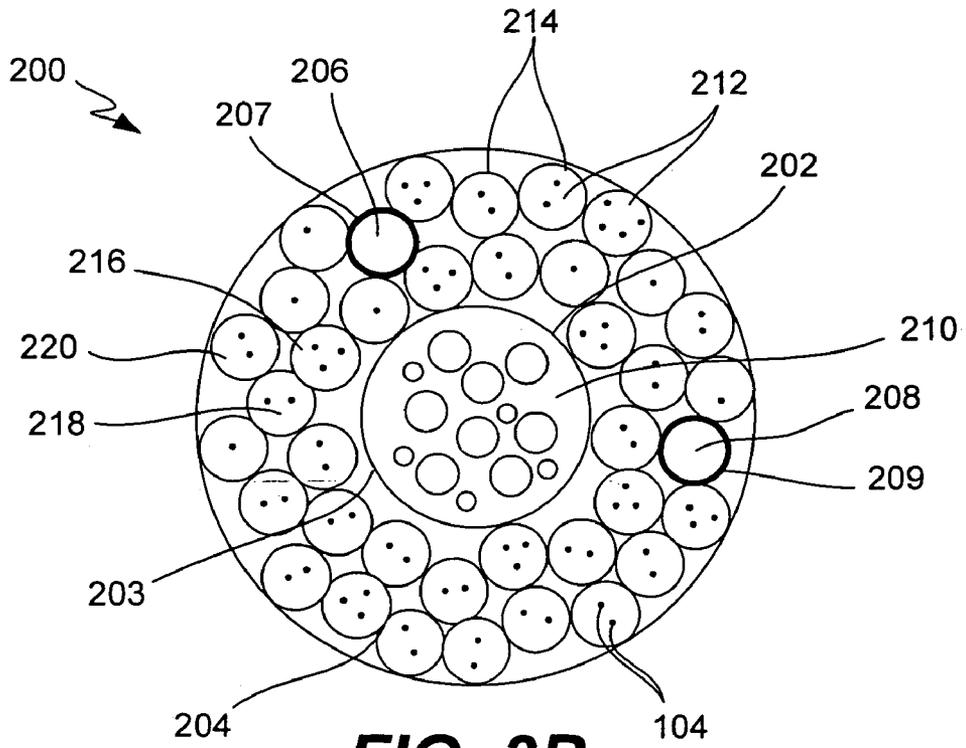


FIG. 3B

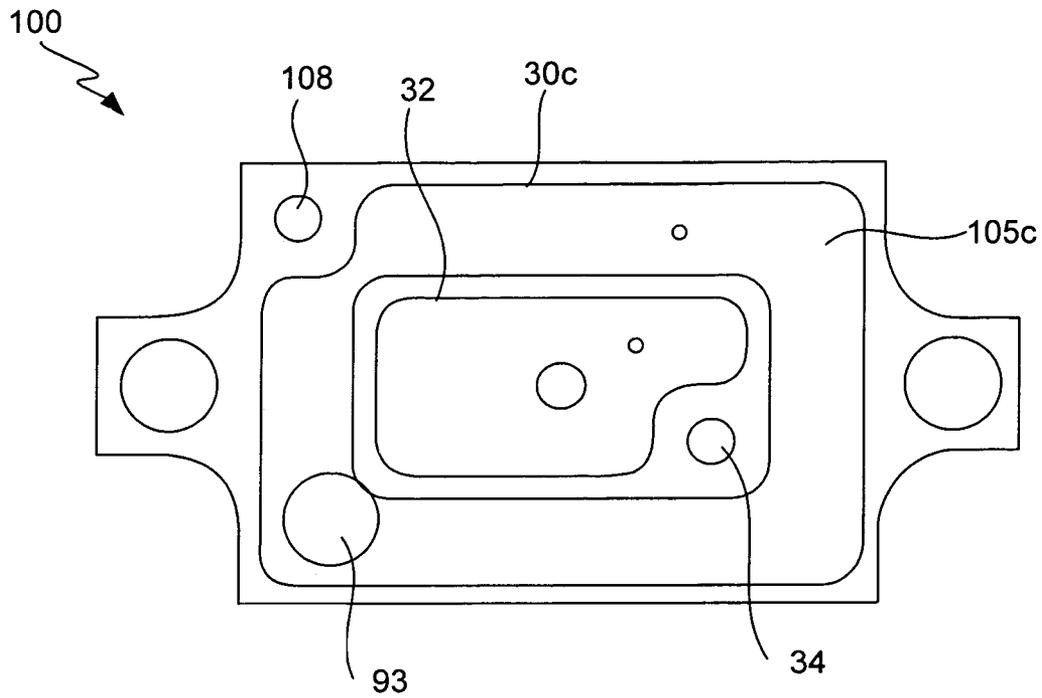


FIG. 3C

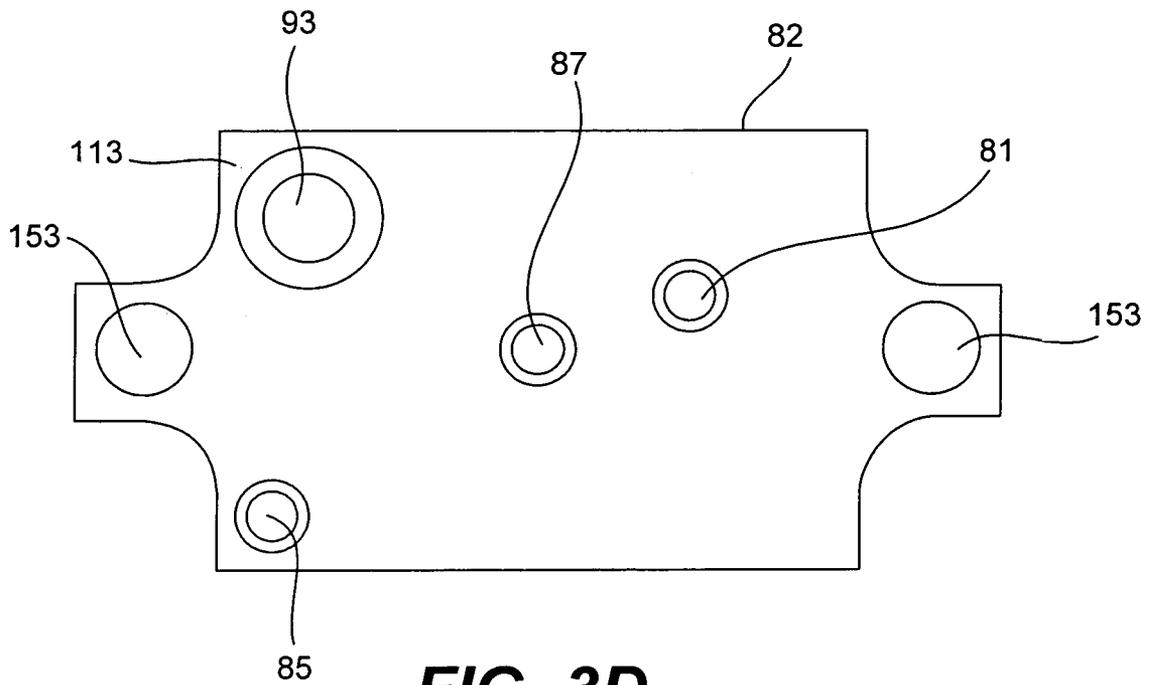


FIG. 3D

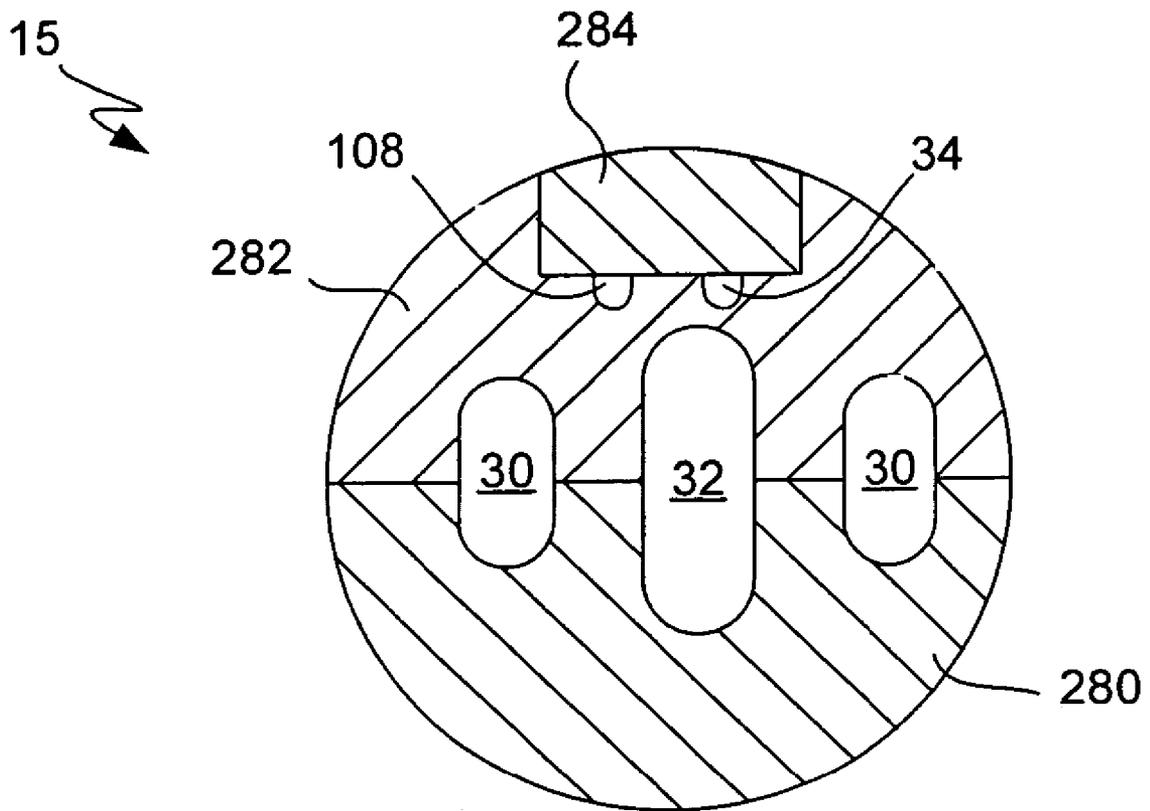


FIG. 3E

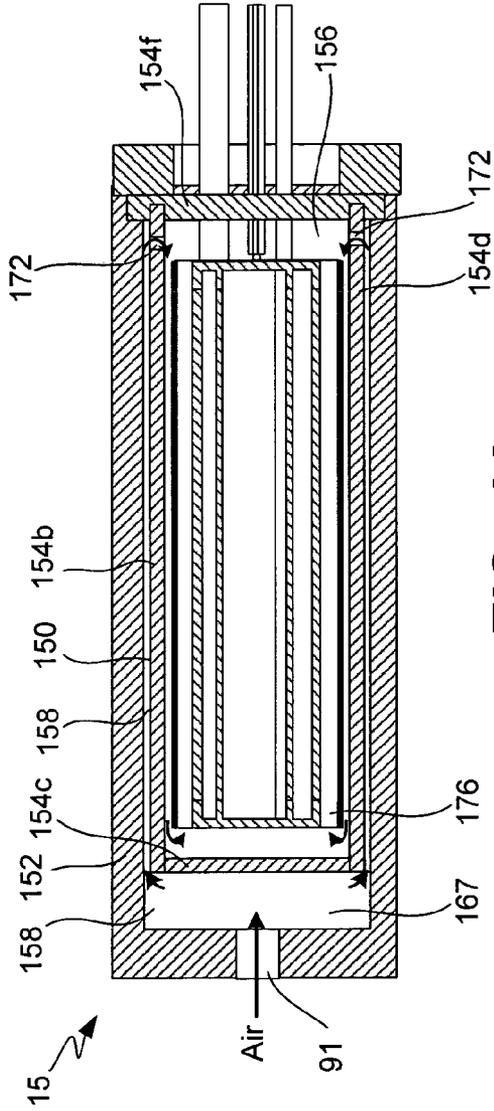


FIG. 4A

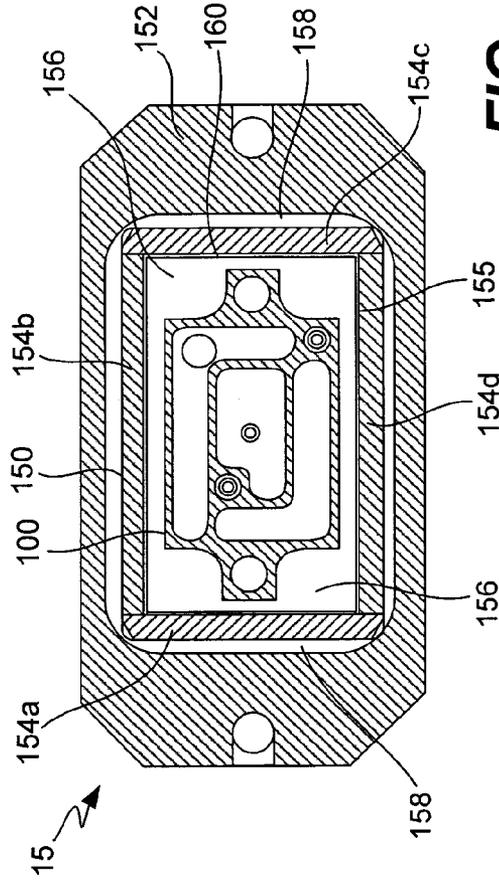


FIG. 4B

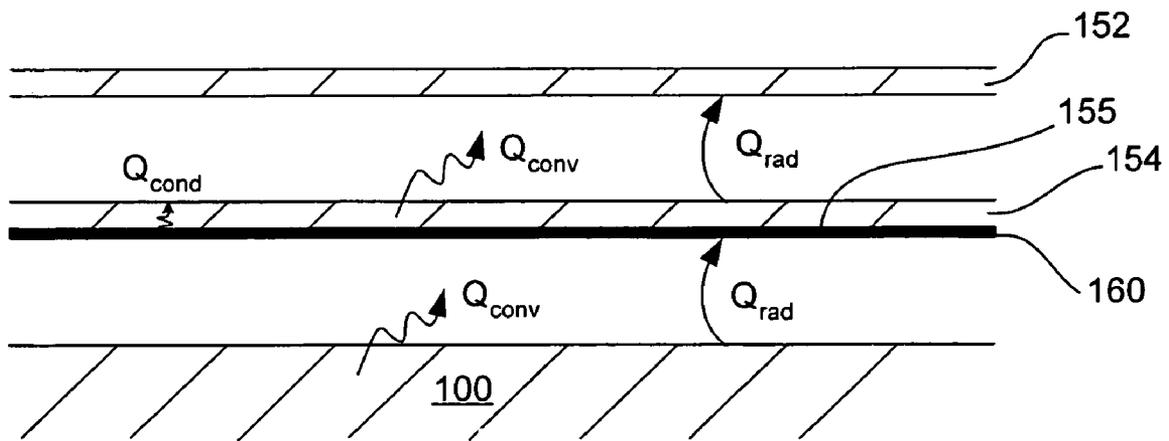


FIG. 4C

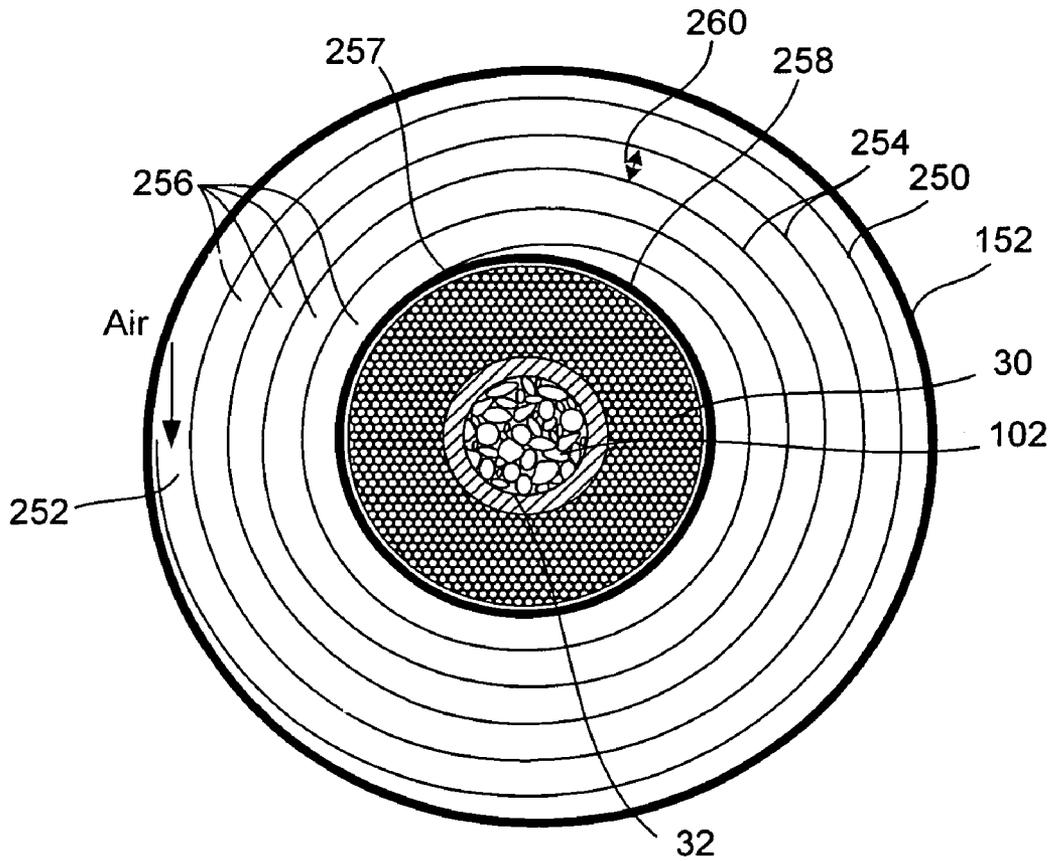


FIG. 4D

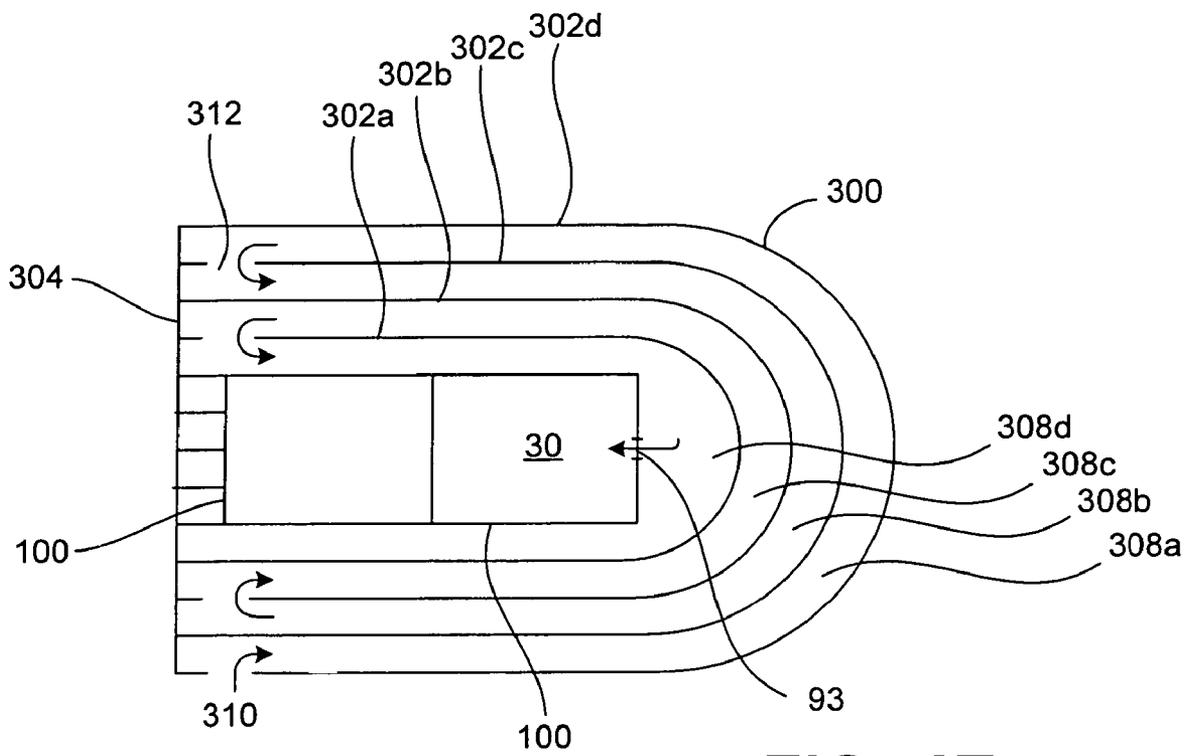


FIG. 4E

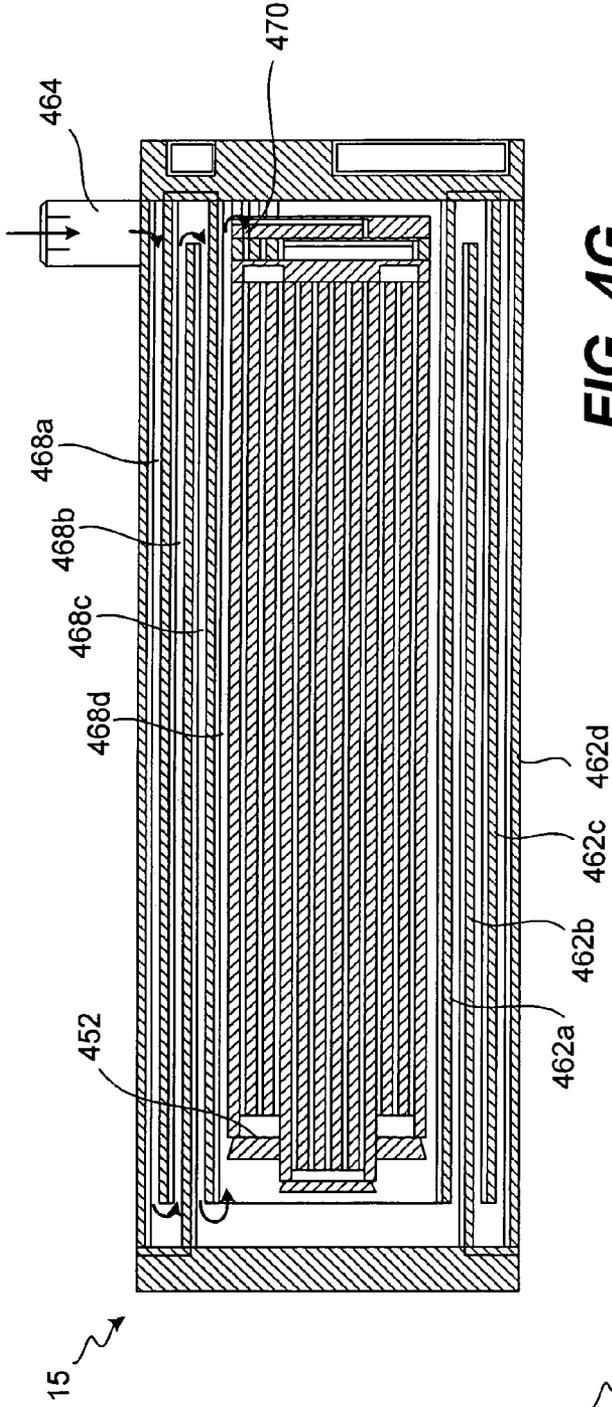


FIG. 4G

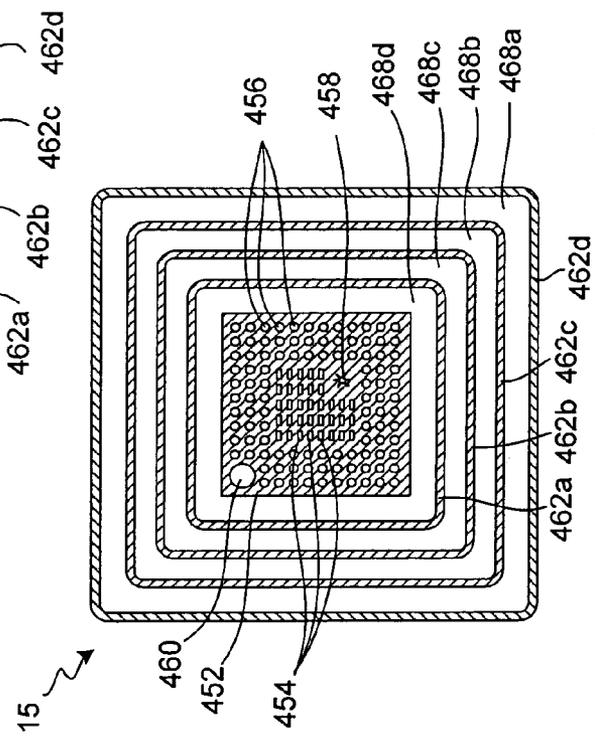


FIG. 4F

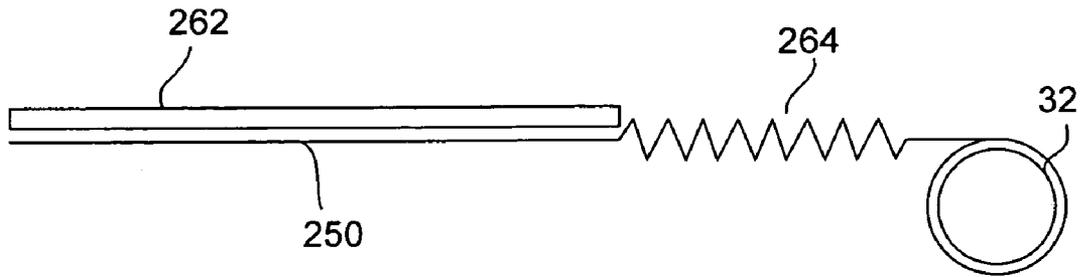


FIG. 4H

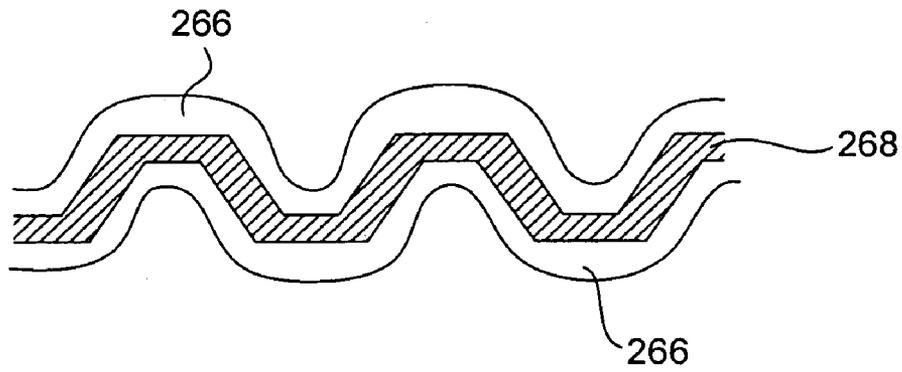


FIG. 4I

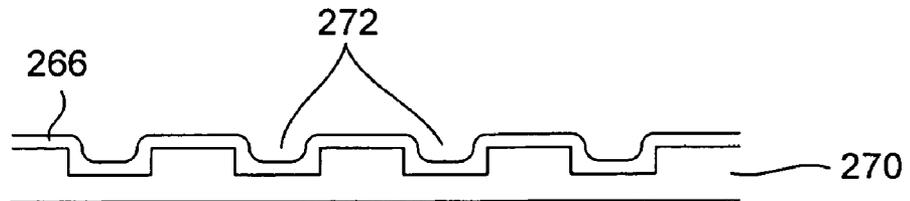


FIG. 4J

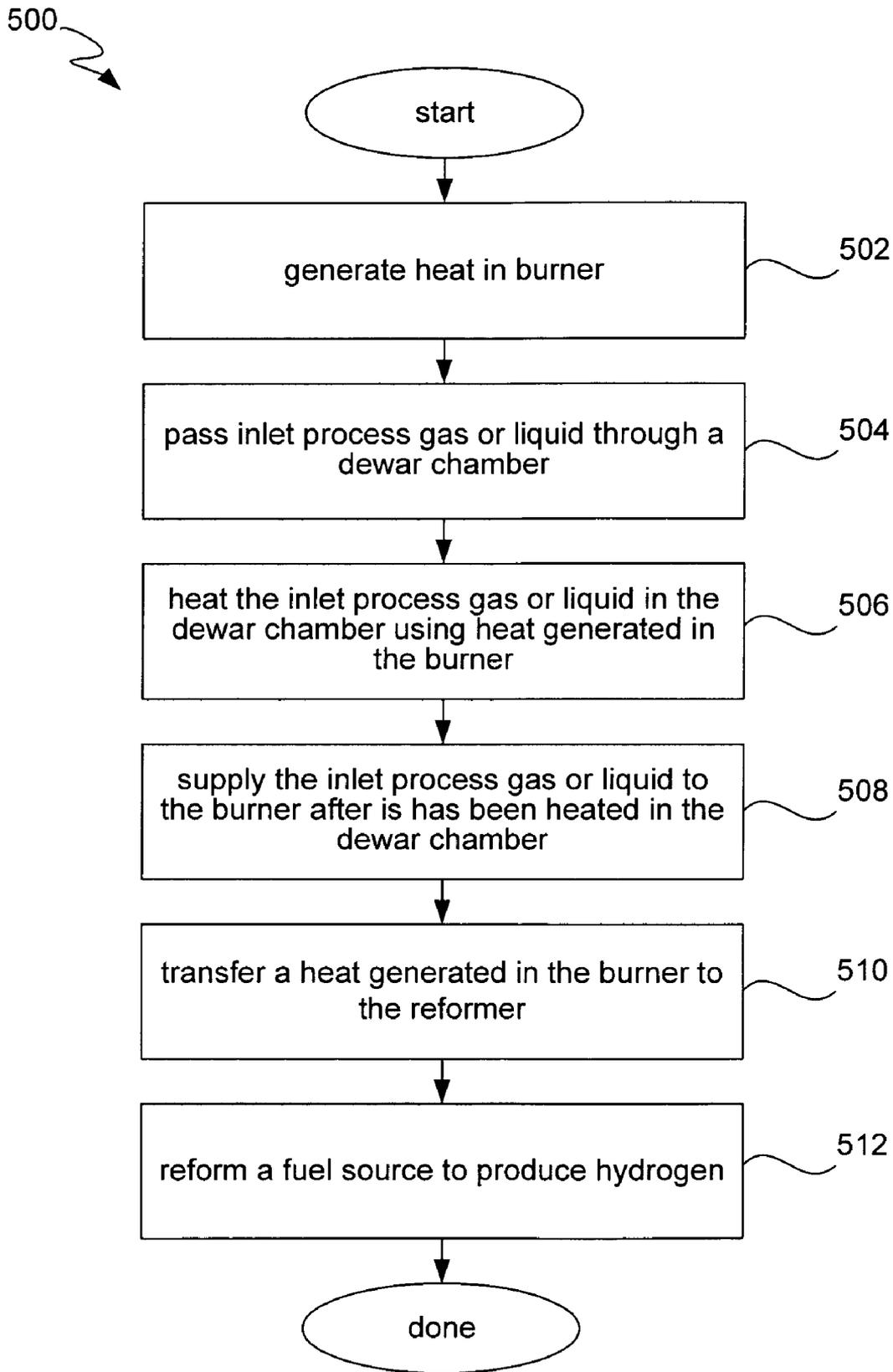


FIG. 5

ANNULAR FUEL PROCESSOR AND METHODS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims priority under 35 U.S.C. §119(e) from U.S. Provisional Patent Application No. 60/482,996 filed Jun. 27, 2003 entitled "Fuel cell system startup procedure and self-heating apparatus", which is incorporated by reference for all purposes; and also claims priority under 35 U.S.C. §119(e) from U.S. Provisional Patent Application No. 60/483,416 filed Jun. 27, 2003 entitled "Fuel Preheat in Portable Electronics Powered by Fuel Cells", which is incorporated by reference for all purposes.

BACKGROUND OF THE INVENTION

The present invention relates to fuel cell technology. In particular, the invention relates to fuel processors that generate hydrogen and are suitable for use in portable applications.

A fuel cell electrochemically combines hydrogen and oxygen to produce electricity. The ambient air readily supplies oxygen. Hydrogen provision, however, calls for a working supply. Gaseous hydrogen has a low energy density that reduces its practicality as a portable fuel. Liquid hydrogen, which has a suitable energy density, must be stored at extremely low temperatures and high pressures, making storing and transporting liquid hydrogen burdensome.

A reformed hydrogen supply processes a fuel source to produce hydrogen. The fuel source acts as a hydrogen carrier. Currently available hydrocarbon fuel sources include methanol, ethanol, gasoline, propane and natural gas. Liquid hydrocarbon fuel sources offer high energy densities and the ability to be readily stored and transported. A fuel processor reforms the hydrocarbon fuel source and to produce hydrogen.

Fuel cell evolution so far has concentrated on large-scale applications such as industrial size generators for electrical power back-up. Consumer electronics devices and other portable electrical power applications currently rely on lithium ion and similar battery technologies. Fuel processors for portable applications such as electronics would be desirable but are not yet commercially available. In addition, techniques that reduce fuel processor size or increase fuel processor efficiency would be highly beneficial.

SUMMARY OF THE INVENTION

The present invention relates to a fuel processor that produces hydrogen from a fuel source. The fuel processor comprises a reformer and burner. The reformer includes a catalyst that facilitates the production of hydrogen from the fuel source. Voluminous reformer chamber designs are provided that increase the amount of catalyst that can be used in a reformer and increase hydrogen output for a given fuel processor size. The burner provides heat to the reformer. One or more burners may be configured to surround a reformer on multiple sides to increase thermal transfer to the reformer.

Dewars are also described that improve thermal management of a fuel processor by reducing heat loss and increasing burner efficiency. A dewar includes one or more dewar chambers that receive inlet process gases or liquids before a reactor receives them. The dewar is arranged such that inlet process gases or liquids passing through the dewar chamber intercepts heat generated in the burner before the heat escapes the fuel processor. Passing inlet process gases or liquids through a dewar chamber in this manner performs three functions: a)

active cooling of dissipation of heat generated in burner before it reaches outer portions of the fuel processor, and b) heating of the air before receipt by the burner, and c) absorbing and recycling heat back into the burner increasing burner efficiency. When the burner relies on catalytic combustion to produce heat, heat generated in the burner warms cool process gases or liquids in the burner according to the temperature of the process gases or liquids. This steals heat from the reformer, reduces heating efficiency of a burner and typically results in greater consumption of the fuel source. The dewar thus pre-heats the incoming process gases or liquids before burner arrival so the burner passes less heat to the process gases or liquids that would otherwise transfer to the reformer.

In one aspect, the present invention relates to a fuel processor for producing hydrogen from a fuel source. The fuel processor comprises a reformer configured to receive the fuel source, configured to output hydrogen, and including a catalyst that facilitates the production of hydrogen. The fuel processor also comprises a boiler configured to heat the fuel source before the reformer receives the fuel source. The fuel processor further comprises at least one burner configured to provide heat to the reformer and disposed annularly about the reformer. The fuel processor may also comprise a boiler that heats the burner liquid fuel feed.

In another aspect, the present invention relates to a fuel processor for producing hydrogen from a fuel source. The fuel processor comprises a reformer configured to receive the fuel source, configured to output hydrogen, including a catalyst that facilitates the production of hydrogen. The reformer also includes a reformer chamber having a volume greater than about 0.1 cubic centimeters and less than about 50 cubic centimeters and is characterized by a cross sectional width and a cross sectional height that is greater than one-third the cross sectional width. The fuel processor also comprises a boiler configured to heat the fuel source before the reformer receives the fuel source. The fuel processor further comprises at least one burner configured to provide heat to the reformer.

In yet another aspect, the present invention relates to a fuel processor for producing hydrogen from a fuel source. The fuel processor comprises a reformer configured to receive the hydrogen fuel source, configured to output hydrogen, and including a catalyst that facilitates the production of hydrogen. The fuel processor also comprises a burner that is configured to provide heat to the reformer. The fuel processor further comprises a dewar that at least partially contains the reformer and the burner and includes a set of dewar walls that form a dewar chamber that is configured to receive an inlet process gas or liquid before the burner receives the inlet process gas or liquid. The fuel processor additionally comprises a housing including a set of housing walls that at least partially contain the dewar and provide external mechanical protection for the reformer and the burner.

In still another aspect, the present invention relates to a method for managing heat in a fuel processor. The fuel processor comprises a burner, a reformer and a dewar that at least partially contains the burner. The method comprises generating heat in the burner. The method also comprises passing an inlet process gas or liquid through a dewar chamber. The method further comprises heating the inlet process gas or liquid in the dewar chamber using heat generated in the burner.

In another aspect, the present invention relates to a method for generating hydrogen in a fuel processor. The fuel processor comprises a burner, a reformer and a dewar that at least partially contains the burner and reformer. The method comprises generating heat in the burner. The method also comprises passing an inlet process gas or liquid through a dewar

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chamber. The method further comprises heating the inlet process gas or liquid in the dewar chamber using heat generated in the burner. The method additionally comprises supplying the inlet process gas or liquid to the burner after it has been heated in the dewar chamber. The method also comprises transferring heat generated in the burner to the reformer. The method further comprises reforming a fuel source to produce hydrogen.

These and other features and advantages of the present invention will be described in the following description of the invention and associated figures.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1A illustrates a fuel cell system for producing electrical energy in accordance with one embodiment of the present invention.

FIG. 1B illustrates schematic operation for the fuel cell system of FIG. 1A in accordance with a specific embodiment of the present invention.

FIG. 1C illustrates an embodiment of the fuel cell system of FIG. 1A that routes hydrogen from an anode exhaust of the fuel cell back to a burner in the fuel processor.

FIG. 2A illustrates a cross-sectional side view of a fuel processor used in the fuel cell system of FIG. 1A in accordance with one embodiment of the present invention.

FIG. 2B illustrates a cross-sectional front view of the fuel processor used in the fuel cell system of FIG. 1A taken through a mid-plane of fuel processor.

FIG. 3A illustrates a cross-sectional front view of a monolithic structure employed in the fuel processor of FIG. 2A in accordance with one embodiment of the present invention.

FIG. 3B illustrates a cross-sectional layout of a tubular design for use in a fuel processor in accordance with another embodiment of the present invention.

FIG. 3C illustrates a cross-sectional front view of a monolithic structure in a fuel processor that comprises a single burner having an 'O-shape' that completely surrounds a reformer chamber in accordance with one embodiment of the present invention.

FIG. 3D illustrates an outside view of an end plate used in the fuel processor of FIG. 2A.

FIG. 3E illustrates a fuel processor 15 in accordance with another embodiment of the present invention.

FIG. 4A illustrates a side cross-sectional view of the fuel processor of FIG. 2A and movement of air created by a dewar in accordance with one embodiment of the present invention.

FIG. 4B illustrates a front cross-sectional view of the fuel processor of FIG. 2A and demonstrates thermal management benefits gained by the dewar.

FIG. 4C shows a thermal diagram of the heat path produced by a dewar wall used in the fuel processor of FIG. 2A.

FIG. 4D illustrates a cross sectional view of a fuel processor that increases the convective path that air flows over a dewar wall in accordance with another embodiment of the present invention.

FIG. 4E illustrates a dewar in accordance with another embodiment of the present invention.

FIGS. 4F and 4G illustrate a cross section of a fuel processor including a monolithic structure and multipass dewar in accordance with another embodiment of the present invention.

FIG. 4H illustrates spiral dewar in an unrolled form during initial construction in accordance with another embodiment of the present invention.

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FIGS. 4I and 4J illustrate wash coatings on a wall of a burner in accordance with two embodiments of the present invention.

FIG. 5 illustrates a process flow for generating hydrogen in a fuel processor in accordance with one embodiment of the present invention.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

The present invention is described in detail with reference to a few preferred embodiments as illustrated in the accompanying drawings. In the following description, numerous specific details are set forth in order to provide a thorough understanding of the present invention. It will be apparent, however, to one skilled in the art, that the present invention may be practiced without some or all of these specific details. In other instances, well known process steps and/or structures have not been described in detail in order to not unnecessarily obscure the present invention.

FIG. 1A illustrates a fuel cell system 10 for producing electrical energy in accordance with one embodiment of the present invention. Fuel cell system 10 comprises storage device 16, fuel processor 15 and fuel cell 20.

A 'reformed' hydrogen supply processes a fuel source to produce hydrogen. As shown, the reformed hydrogen supply comprises a fuel processor 15 and a fuel source storage device 16. Storage device 16 stores fuel source 17, and may include a portable and/or disposable fuel cartridge. A disposable cartridge offers instant recharging to a consumer. In one embodiment, the cartridge includes a collapsible bladder within a hard plastic dispenser case. A separate fuel pump typically controls fuel source 17 flow from storage device 16. If system 10 is load following, then a control system meters fuel source 17 to deliver fuel source 17 to processor 15 at a flow rate determined by the required power level output of fuel cell 20.

Fuel source 17 acts as a carrier for hydrogen and can be processed to separate hydrogen. Fuel source 17 may include any hydrogen bearing fuel stream, hydrocarbon fuel or other hydrogen fuel source such as ammonia. Currently available hydrocarbon fuel sources 17 suitable for use with the present invention include gasoline, C₁ to C₄ hydrocarbons, their oxygenated analogues and/or their combinations, for example. Several hydrocarbon and ammonia products may also produce a suitable fuel source 17. Liquid fuel sources 17 offer high energy densities and the ability to be readily stored and shipped. Storage device 16 may contain a fuel mixture. When the fuel processor 15 comprises a steam reformer, storage device 16 may contain a fuel mixture of a hydrocarbon fuel source and water. Hydrocarbon fuel source/water fuel mixtures are frequently represented as a percentage fuel source in water. In one embodiment, fuel source 17 comprises methanol or ethanol concentrations in water in the range of 1%-99.9%. Other liquid fuels such as butane, propane, gasoline, military grade "JP8" etc. may also be contained in storage device 16 with concentrations in water from 5-100%. In a specific embodiment, fuel source 17 comprises 67% methanol by volume.

Fuel processor 15 processes the hydrocarbon fuel source 17 and outputs hydrogen. A hydrocarbon fuel processor 15 heats and processes a hydrocarbon fuel source 17 in the presence of a catalyst to produce hydrogen. Fuel processor 15 comprises a reformer, which is a catalytic device that converts a liquid or gaseous hydrocarbon fuel source 17 into hydrogen and carbon dioxide. As the term is used herein, reforming refers to the process of producing hydrogen from a fuel

source. Fuel processor **15** may output either pure hydrogen or a hydrogen bearing gas stream. Fuel processor **15** is described in further detail below.

Fuel cell **20** electrochemically converts hydrogen and oxygen to water, generating electricity and heat in the process. Ambient air commonly supplies oxygen for fuel cell **20**. A pure or direct oxygen source may also be used for oxygen supply. The water often forms as a vapor, depending on the temperature of fuel cell **20** components. The electrochemical reaction also produces carbon dioxide as a byproduct for many fuel cells.

In one embodiment, fuel cell **20** is a low volume polymer electrolyte membrane (PEM) fuel cell suitable for use with portable applications such as consumer electronics. A polymer electrolyte membrane fuel cell comprises a membrane electrode assembly **40** that carries out the electrical energy generating electrochemical reaction. The membrane electrode assembly **40** includes a hydrogen catalyst, an oxygen catalyst and an ion conductive membrane that a) selectively conducts protons and b) electrically isolates the hydrogen catalyst from the oxygen catalyst. A hydrogen gas distribution layer contains the hydrogen catalyst and allows the diffusion of hydrogen therethrough. An oxygen gas distribution layer contains the oxygen catalyst and allows the diffusion of oxygen and hydrogen protons therethrough. The ion conductive membrane separates the hydrogen and oxygen gas distribution layers. In chemical terms, the anode comprises the hydrogen gas distribution layer and hydrogen catalyst, while the cathode comprises the oxygen gas distribution layer and oxygen catalyst.

A PEM fuel cell often includes a fuel cell stack having a set of bi-polar plates. A membrane electrode assembly is disposed between two bi-polar plates. Hydrogen distribution **43** occurs via a channel field on one plate while oxygen distribution **45** occurs via a channel field on a second facing plate. Specifically, a first channel field distributes hydrogen to the hydrogen gas distribution layer, while a second channel field distributes oxygen to the oxygen gas distribution layer. The 'term 'bi-polar' refers electrically to a bi-polar plate (whether comprised of one plate or two plates) sandwiched between two membrane electrode assembly layers. In this case, the bi-polar plate acts as both a negative terminal for one adjacent membrane electrode assembly and a positive terminal for a second adjacent membrane electrode assembly arranged on the opposite face of the bi-polar plate.

In electrical terms, the anode includes the hydrogen gas distribution layer, hydrogen catalyst and bi-polar plate. The anode acts as the negative electrode for fuel cell **20** and conducts electrons that are freed from hydrogen molecules so that they can be used externally, e.g., to power an external circuit. In a fuel cell stack, the bi-polar plates are connected in series to add the potential gained in each layer of the stack. In electrical terms, the cathode includes the oxygen gas distribution layer, oxygen catalyst and bi-polar plate. The cathode represents the positive electrode for fuel cell **20** and conducts the electrons back from the external electrical circuit to the oxygen catalyst, where they can recombine with hydrogen ions and oxygen to form water.

The hydrogen catalyst separates the hydrogen into protons and electrons. The ion conductive membrane blocks the electrons, and electrically isolates the chemical anode (hydrogen gas distribution layer and hydrogen catalyst) from the chemical cathode. The ion conductive membrane also selectively conducts positively charged ions. Electrically, the anode conducts electrons to a load (electricity is produced) or battery (energy is stored). Meanwhile, protons move through the ion conductive membrane, to combine with oxygen. The protons

and used electrons subsequently meet on the cathode side, and combine with oxygen to form water. The oxygen catalyst in the oxygen gas distribution layer facilitates this reaction. One common oxygen catalyst comprises platinum powder very thinly coated onto a carbon paper or cloth. Many designs employ a rough and porous catalyst to increase surface area of the platinum exposed to the hydrogen and oxygen.

In one embodiment, fuel cell **20** comprises a set of bi-polar plates that each includes channel fields on opposite faces that distribute the hydrogen and oxygen. One channel field distributes hydrogen while a channel field on the opposite face distributes oxygen. Multiple bi-polar plates can be stacked to produce a 'fuel cell stack' in which a membrane electrode assembly is disposed between each pair of adjacent bi-polar plates. Since the electrical generation process in fuel cell **20** is exothermic, fuel cell **20** may implement a thermal management system to dissipate heat from the fuel cell. Fuel cell **20** may also employ a number of humidification plates (HP) to manage moisture levels in the fuel cell. Further description of a fuel cell suitable for use with the present invention is included in commonly owned co-pending patent application entitled "Micro Fuel Cell Architecture" naming Ian Kaye as inventor and filed on the same day as this patent application. This application is incorporated by reference for all purposes.

While the present invention will mainly be discussed with respect to PEM fuel cells, it is understood that the present invention may be practiced with other fuel cell architectures. The main difference between fuel cell architectures is the type of ion conductive membrane used. In one embodiment, fuel cell **20** is phosphoric acid fuel cell that employs liquid phosphoric acid for ion exchange. Solid oxide fuel cells employ a hard, non-porous ceramic compound for ion exchange and may be suitable for use with the present invention. Generally, any fuel cell architecture may benefit from fuel processor improvements described herein. Other such fuel cell architectures include direct methanol, alkaline and molten carbonate fuel cells.

Fuel cell **20** generates dc voltage that may be used in a wide variety of applications. For example, electricity generated by fuel cell **20** may be used to power a motor or light. In one embodiment, the present invention provides 'small' fuel cells that are designed to output less than 200 watts of power (net or total). Fuel cells of this size are commonly referred to as 'micro fuel cells' and are well suited for use with portable electronics. In one embodiment, fuel cell **20** is configured to generate from about 1 milliwatt to about 200 watts. In another embodiment, fuel cell **20** generates from about 3 W to about 20 W. Fuel cell **20** may also be a stand-alone fuel cell, which is a single unit that produces power as long as it has an a) oxygen and b) hydrogen or a hydrocarbon fuel supply. A fuel cell **20** that outputs from about 40 W to about 100 W is well suited to power a laptop computer.

FIG. 1B illustrates schematic operation for fuel cell system **10** in accordance with a specific embodiment of the present invention. As shown, fuel cell system **10** comprises fuel container **16**, hydrogen fuel source **17**, fuel processor **15**, fuel cell **20**, multiple pumps **21** and fans **35**, fuel lines and gas lines, and one or more valves **23**. While the present invention will now primarily be described with respect to methanol as fuel source **17**, it is understood that the present invention may employ another fuel source **17** such as one provided above.

Fuel container **16** stores methanol as a hydrogen fuel source **17**. An outlet **26** of fuel container **16** provides methanol **17** into hydrogen fuel source line **25**. As shown, line **25** divides into two lines: a first line **27** that transports methanol **17** to a burner **30** for fuel processor **15** and a second line **29** that transports methanol **17** to reformer **32** in fuel processor

15. Lines 25, 27 and 29 may comprise plastic tubing, for example. Separate pumps 21a and 21b are provided for lines 27 and 29, respectively, to pressurize the lines and transmit the fuel source at independent rates if desired. A model P625 pump as provided by Instech of Plymouth Meeting, Pa. is suitable to transmit liquid methanol for system 10 is suitable in this embodiment. A flow sensor or valve 23 situated on line 29 between storage device 16 and fuel processor 18 detects and communicates the amount of methanol 17 transfer between storage device 16 and reformer 32. In conjunction with the sensor or valve 23 and suitable control, such as digital control applied by a processor that implements instructions from stored software, pump 21b regulates methanol 17 provision from storage device 16 to reformer 32.

Fan 35a delivers oxygen and air from the ambient room through line 31 to regenerator 36 of fuel processor 15. Fan 35b delivers oxygen and air from the ambient room through line 33 to regenerator 36 of fuel processor 15. In this embodiment, a model AD2005DX-K70 fan as provided by Adda USA of California is suitable to transmit oxygen and air for fuel cell system 10. A fan 37 blows cooling air over fuel cell 20 and its heat transfer appendages 46.

Fuel processor 15 receives methanol 17 from storage device 16 and outputs hydrogen. Fuel processor 15 comprises burner 30, reformer 32, boiler 34 and dewar 150. Burner 30 includes an inlet that receives methanol 17 from line 27 and a catalyst that generates heat with methanol presence. In one embodiment, burner 30 includes an outlet that exhausts heated gases to a line 41, which transmits the heated gases over heat transfer appendages 46 of fuel cell 20 to pre-heat the fuel cell and expedite warm-up time needed when initially turning on fuel cell 20. An outlet of burner 30 may also exhaust heated gases into the ambient room.

Boiler 34 includes an inlet that receives methanol 17 from line 29. The structure of boiler 34 permits heat produced in burner 30 to heat methanol 17 in boiler 34 before reformer 32 receives the methanol 17. Boiler 34 includes an outlet that provides heated methanol 17 to reformer 32.

Reformer 32 includes an inlet that receives heated methanol 17 from boiler 34. A catalyst in reformer 32 reacts with the methanol 17 and produces hydrogen and carbon dioxide. This reaction is slightly endothermic and draws heat from burner 30. A hydrogen outlet of reformer 32 outputs hydrogen to line 39. In one embodiment, fuel processor 15 also includes a preferential oxidizer that intercepts reformer 32 hydrogen exhaust and decreases the amount of carbon monoxide in the exhaust. The preferential oxidizer employs oxygen from an air inlet to the preferential oxidizer and a catalyst based on, for example ruthenium or platinum, that is preferential to carbon monoxide over carbon dioxide.

Dewar 150 pre-heats a process gas or liquid before the air enters burner 30. Dewar 150 also reduces heat loss from fuel cell 15 by heating the incoming process liquids or gases before the heat escapes fuel processor 15. In one sense, dewar 150 acts as a regenerator that uses waste heat in fuel processor 15 to improve thermal management and thermal efficiency of the fuel processor. Specifically, waste heat from burner 30 may be used to pre-heat incoming air provided to burner 30 to reduce heat transfer to the air in the burner so more heat transfers to reformer 32. Dewar 150 is described in further detail below.

Line 39 transports hydrogen from fuel processor 15 to fuel cell 20. Gaseous delivery lines 31, 33 and 39 may comprise polymeric or metallic tubing, for example. A hydrogen flow sensor (not shown) may also be added on line 39 to detect and communicate the amount of hydrogen being delivered to fuel cell 20. In conjunction with the hydrogen flow sensor and

suitable control, such as digital control applied by a processor that implements instructions from stored software, fuel processor 15 regulates hydrogen gas provision to fuel cell 20.

Fuel cell 20 includes an hydrogen inlet port that receives hydrogen from line 39 and delivers it to a hydrogen intake manifold for delivery to one or more bi-polar plates and their hydrogen distribution channels. An oxygen inlet port of fuel cell 20 receives oxygen from line 33 and delivers it to an oxygen intake manifold for delivery to one or more bi-polar plates and their oxygen distribution channels. An anode exhaust manifold collects gases from the hydrogen distribution channels and delivers them to an anode exhaust port, which outlets the exhaust gases into the ambient room. A cathode exhaust manifold collects gases from the oxygen distribution channels and delivers them to a cathode exhaust port.

The schematic operation for fuel cell system 10 shown in FIG. 1B is exemplary and other variations on fuel cell system design, such as reactant and byproduct plumbing, are contemplated. In addition to the components shown in shown in FIG. 1B, system 10 may also include other elements such as electronic controls, additional pumps and valves, added system sensors, manifolds, heat exchangers and electrical interconnects useful for carrying out functionality of system 10 that are known to one of skill in the art and omitted herein for sake of brevity.

FIG. 1C illustrates an embodiment of fuel system 10 that routes unused hydrogen from fuel cell 20 back to burner 30. Burner 30 includes a catalyst that reacts with the unused hydrogen to produce heat. Since hydrogen consumption within fuel cell 20 is often incomplete and the anode exhaust often includes unused hydrogen, re-routing the anode exhaust to burner 30 allows fuel cell system 10 to capitalize on unused hydrogen in fuel cell 20 and increase hydrogen usage and efficiency in system 10. As the term is used herein, unused hydrogen generally refers to hydrogen output from a fuel cell.

Line 51 is configured to transmit unused hydrogen from fuel cell 20 to burner 30 of fuel processor 15. For FIG. 1C, burner 30 includes two inlets: an inlet 55 configured to receive the hydrogen fuel source 17 and an inlet 53 configured to receive the hydrogen from line 51. Anode gas collection channels, which distribute hydrogen from fuel processor 15 to each membrane electrode assembly layer, collect and exhaust the unused hydrogen. An inlet fan pressurizes line 39 that delivers the hydrogen from an outlet of fuel processor 15 to an anode inlet of fuel cell 20. The inlet fan also pressurizes the anode gas collection channels for distribution of hydrogen within fuel cell 20. In one embodiment, gaseous delivery in line 51 back to fuel processor 15 relies on pressure at the exhaust of the anode gas distribution channels, e.g., in the anode exhaust manifold. In another embodiment, an extra fan is added to line 51 to pressurize line 51 and return unused hydrogen back to fuel processor 15.

Burner 30 also includes an inlet 59 configured to receive oxygen from an oxygen exhaust included in fuel cell 20. Cathode gas collection channels, which distribute oxygen and air from the ambient room to each membrane electrode assembly layer, collect and exhaust the unused oxygen. Line 61 delivers unused oxygen from an exhaust manifold, which collects oxygen from each cathode gas collection channel, to inlet 59. Burner 30 thus includes two oxygen inlets: inlet 59 and an inlet 57 configured to receive oxygen from the ambient room after delivery through dewar 150. Since oxygen consumption within fuel cell 20 is often incomplete and the cathode exhaust includes unused oxygen, re-routing the cathode exhaust to burner 30 allows fuel cell system 10 to capi-

talize on unused oxygen in fuel cell **20** and increase oxygen usage and efficiency in system **10**.

In one embodiment, fuel processor **15** is a steam reformer that only needs steam to produce hydrogen. Several types of reformers suitable for use in fuel cell system **10** include steam reformers, auto thermal reformers (ATR) or catalytic partial oxidizers (CPOX). ATR and CPOX reformers mix air with the fuel and steam mix. ATR and CPOX systems reform fuels such as methanol, diesel, regular unleaded gasoline and other hydrocarbons. In a specific embodiment, storage device **16** provides methanol **17** to fuel processor **15**, which reforms the methanol at about 250° C. or less and allows fuel cell system **10** use in applications where temperature is to be minimized.

FIG. **2A** illustrates a cross-sectional side view of fuel processor **15** in accordance with one embodiment of the present invention. FIG. **2B** illustrates a cross-sectional front view of fuel processor **15** taken through a mid-plane of processor **15** that also shows features of end plate **82**. Fuel processor **15** reforms methanol to produce hydrogen. Fuel processor **15** comprises monolithic structure **100**, end plates **82** and **84**, reformer **32**, burner **30**, boiler **34**, boiler **108**, dewar **150** and housing **152**. Although the present invention will now be described with respect to methanol consumption for hydrogen production, it is understood that fuel processors of the present invention may consume another fuel source, as one of skill in the art will appreciate.

As the term is used herein, 'monolithic' refers to a single and integrated structure that includes at least portions of multiple components used in fuel processor **15**. As shown, monolithic structure **100** includes reformer **32**, burner **30**, boiler **34** and boiler **108**. Monolithic structure **100** may also include associated plumbing inlets and outlets for reformer **32**, burner **30** and boiler **34**. Monolithic structure **100** comprises a common material **141** that constitutes the structure. Common material **141** is included in walls that define the reformer **32**, burner **32** and boilers **34** and **108**. Specifically, walls **111**, **119**, **120**, **122**, **130**, **132**, **134** and **136** all comprise common material **141**. Common material **141** may comprise a metal, such as copper, silicon, stainless steel, inconel and other metal/alloys displaying favorable thermal conducting properties. The monolithic structure **100** and common material **141** simplify manufacture of fuel processor **15**. For example, using a metal for common material **141** allows monolithic structure **100** to be formed by extrusion or casting. In some cases, monolithic structure **100** is consistent in cross sectional dimensions between end plates **82** and **84** and solely comprises copper formed in a single extrusion. Common material **141** may also include a ceramic, for example. A ceramic monolithic structure **100** may be formed by sintering.

Housing **152** provides mechanical protection for internal components of fuel processor **15** such as burner **30** and reformer **32**. Housing **152** also provides separation from the environment external to processor **15** and includes inlet and outlet ports for gaseous and liquid communication in and out of fuel processor **15**. Housing **152** includes a set of housing walls **161** that at least partially contain a dewar **150** and provide external mechanical protection for components in fuel processor **15**. Walls **161** may comprises a suitably stiff material such as a metal or a rigid polymer, for example. Dewar **150** improves thermal heat management for fuel processor **15** and will be discussed in further detail with respect to FIG. **4A**.

Together, monolithic structure **100** and end plates **82** and **84** structurally define reformer **32**, burner **30**, boiler **34** and boiler **108** and their respective chambers. Monolithic struc-

ture **100** and end plates **82** and **84** are shown separate in FIG. **2A** for illustrative purposes, while FIG. **4A** shows them together.

Referring to FIG. **2B**, boiler **34** heats methanol before reformer **32** receives the methanol. Boiler **34** receives the methanol via fuel source inlet **81**, which couples to the methanol supply line **27** of FIG. **1B**. Since methanol reforming and hydrogen production via a catalyst **102** in reformer **32** often requires elevated methanol temperatures, fuel processor **15** pre-heats the methanol before receipt by reformer **32** via boiler **34**. Boiler **34** is disposed in proximity to burner **30** to receive heat generated in burner **30**. The heat transfers via conduction through monolithic structure from burner **30** to boiler **34** and via convection from boiler **34** walls to the methanol passing therethrough. In one embodiment, boiler **34** is configured to vaporize liquid methanol. Boiler **34** then passes the gaseous methanol to reformer **32** for gaseous interaction with catalyst **102**.

Reformer **32** is configured to receive methanol from boiler **34**. Walls **111** in monolithic structure **100** (see cross section in FIG. **3A**) and end walls **113** (FIG. **2B**) on end plates **82** and **84** define dimensions for a reformer chamber **103**. In one embodiment, end plate **82** and/or end plate **84** includes also channels **95** (FIG. **2A**) that route heated methanol exhausted from boiler **34** into reformer **32**. The heated methanol then enters the reformer chamber **103** at one end of monolithic structure **100** and passes to the other end where the reformer exhaust is disposed. In another embodiment, a hole disposed in a reformer **32** wall receives inlet heated methanol from a line or other supply. The inlet hole or port may be disposed on a suitable wall **111** or **113** of reformer **32**.

Reformer **32** includes a catalyst **102** that facilitates the production of hydrogen. Catalyst **102** reacts with methanol **17** and facilitates the production of hydrogen gas and carbon dioxide. In one embodiment, catalyst **102** comprises pellets packed to form a porous bed or otherwise suitably filled into the volume of reformer chamber **103**. In one embodiment, pellet sizes are designed to maximize the amount of surface area exposure to the incoming methanol. Pellet diameters ranging from about 50 microns to about 1.5 millimeters are suitable for many applications. Pellet diameters ranging from about 300 microns to about 1500 microns are suitable for use with reformer chamber **103**. Pellet sizes and packing may also be varied to control the pressure drop that occurs through reformer chamber **103**. In one embodiment, pressure drops from about 0.2 to about 5 psi gauge are suitable between the inlet and outlet of reformer chamber **103**. Pellet sizes may be varied relative to the cross sectional size of reformer chamber **103**, e.g., as reformer chamber **103** increases in size so may catalyst **102** pellet diameters. In one embodiment, the ratio of pellet diameter (d) to cross sectional height **117** (D) may range from about 0.0125 to about 1. A D/d ratio from about 5 to about 20 is also suitable for many applications. A packing density may also characterize packing of catalyst **102** in reformer chamber **103**. For a copper zinc catalyst **102**, packing densities from about 0.3 grams/milliliter to about 2 grams/milliliter are suitable. Packing densities from about 0.9 grams/milliliter to about 1.4 grams/milliliter are appropriate for the embodiment shown in FIG. **3A**.

One suitable catalyst **102** may include CuZn on alumina pellets when methanol is used as a hydrocarbon fuel source **17**. Other materials suitable for catalyst **102** may be based on nickel, platinum, palladium, or other precious metal catalysts either alone or in combination, for example. Catalyst **102** pellets are commercially available from a number of vendors known to those of skill in the art. Pellet catalysts may also be disposed within a baffling system disposed in the reformer

chamber 103. The baffling system includes a set of walls that guide the fuel source along a non-linear path. The baffling slows and controls flow of gaseous methanol in chamber 103 to improve interaction between the gaseous methanol and pellet catalyst 102. Catalyst 102 may alternatively comprise 5 catalyst materials listed above coated onto a metal sponge or metal foam. A wash coat of the desired metal catalyst material onto the walls of reformer chamber 103 may also be used for reformer 32.

Reformer 32 is configured to output hydrogen and includes an outlet port 87 that communicates hydrogen formed in reformer 32 outside of fuel processor 15. In fuel cell system 10, port 87 communicates hydrogen to line 39 for provision to hydrogen distribution 43 in fuel cell 20. Port 87 is disposed on a wall of end plate 82 and includes a hole that passes through 15 the wall (see FIG. 2B). The outlet hole port may be disposed on any suitable wall 111 or 113.

Hydrogen production in reformer 32 is slightly endothermic and draws heat from burner 30. Burner 30 generates heat and is configured to provide heat to reformer 32. Burner 30 is 20 disposed annularly about reformer 32, as will be discussed in further detail below. As shown in FIG. 2B, burner 30 comprises two burners (or burner sections) 30a and 30b and their respective burner chambers 105a and 105b that surround reformer 32. Burner 30 includes an inlet that receives methanol 17 from boiler 108 via a channel in one of end plates 82 or 84. In one embodiment, the burner inlet opens into burner chamber 105a. The methanol then travels the length 142 of burner chamber 105a to channels disposed in end plate 82 that route methanol from burner chamber 105a to burner chamber 105b. The methanol then travels the back through the length 142 of burner chamber 105b to burner exhaust 89. In another embodiment, the burner inlet opens into both chambers 105a and 105b. The methanol then travels the length 142 of both chambers 105a and 105b to burner exhaust 89. 30

In one embodiment, burner 30 employs catalytic combustion to produce heat. A catalyst 104 disposed in each burner chamber 105 helps a burner fuel passed through the chamber generate heat. In one embodiment, methanol produces heat in burner 30 and catalyst 104 facilitates the methanol production of heat. In another embodiment, waste hydrogen from fuel cell 20 produces heat in the presence of catalyst 104. Suitable burner catalysts 104 may include platinum or palladium coated onto a suitable support or alumina pellets for example. Other materials suitable for catalyst 104 include iron, tin oxide, other noble-metal catalysts, reducible oxides, and mixtures thereof. The catalyst 104 is commercially available from a number of vendors known to those of skill in the art as small pellets. The pellets that may be packed into burner chamber 105 to form a porous bed or otherwise suitably filled into the burner chamber volume. Catalyst 104 pellet sizes may be varied relative to the cross sectional size of burner chamber 105. Catalyst 104 may also comprise catalyst materials listed above coated onto a metal sponge or metal foam or wash coated onto the walls of burner chamber 105. A burner outlet port 89 (FIG. 2A) communicates exhaust formed in burner 30 outside of fuel processor 15. 40

Some fuel sources generate additional heat in burner 30, or generate heat more efficiently, with elevated temperatures. Fuel processor 15 includes a boiler 108 that heats methanol before burner 30 receives the fuel source. In this case, boiler 108 receives the methanol via fuel source inlet 85. Boiler 108 is disposed in proximity to burner 30 to receive heat generated in burner 30. The heat transfers via conduction through monolithic structure from burner 30 to boiler 108 and via convection 50 from boiler 108 walls to the methanol passing through.

Air including oxygen enters fuel processor 15 via air inlet port 91. Burner 30 uses the oxygen for catalytic combustion of methanol. As will be discussed in further detail below with respect to FIGS. 4A and 4B, air first passes along the outside 5 of dewar 150 before passing through apertures in the dewar and along the inside of dewar 150. This heats the air before receipt by air inlet port 93 of burner 30.

FIG. 3A illustrates a cross-sectional front view of monolithic structure 100 as taken through a mid-plane 121 in accordance with one embodiment of the present invention. Monolithic structure 100 extends from end plate 82 to end plate 84. The cross section of monolithic structure 100 shown in FIG. 3A extends from one end of structure 100 at end plate 82 to the other end of structure 100 at end plate 84. Monolithic structure 100 includes reformer 32, burner 30, boiler 34 and boiler 108 between end plates 82 and 84. 15

Reformer 32 includes a reformer chamber 103, which is a voluminous space in fuel processor 15 that includes the reforming catalyst 102, opens to the fuel source inlet (from boiler 34 for fuel processor 15), and opens to hydrogen outlet 87. Side walls 111 define a non-planar cross-sectional shape for reformer 32 and its reformer chamber 103. Walls 113 on end plates 82 and 84 close the reformer chamber 103 on either end of the chamber 103 and include the inlet and outlet ports to the chamber 103. 25

Reformer chamber 103 includes a non-planar volume. As the term is used herein, a non-planar reformer chamber 103 refers to a shape in cross section that is substantially non-flat or non-linear. A cross section refers to a planar slice that cuts through the fuel processor or component. For cross sections that include multiple fuel processor components (e.g., both burner 30 and reformer 32), the cross section includes both components. For the vertical and front cross section 121 shown in FIG. 3A, the cross section dimensions shown are consistent for monolithic structure 100 from end plate 82 to end plate 84, and are consistent at each cross section 121 (FIG. 2A). 30

Reformer 32 and its reformer chamber 103 may employ a quadrilateral or non-quadrilateral cross-sectional shape. Four sides define a quadrilateral reformer chamber 103 in cross section. Four substantially orthogonal sides define rectangular and square quadrilateral reformers 32. A non-quadrilateral reformer 32 may employ cross-sectional geometries with more or less sides, an elliptical shape (see FIG. 3B), and more complex cross-sectional shapes. As shown in FIG. 3A, reformer 32 includes a six-sided cross-sectional 'P-shape' with chamfered corners. One corner section of reformer 32 is removed from monolithic structure 100 to allow for boiler 34 proximity to burner 30. 35

Reformer chamber 103 is characterized by a cross-sectional width 115 and a cross-sectional height 117. A maximum linear distance between inner walls 111 of chamber 103 in a direction spanning a cross section of reformer chamber 103 quantifies cross-sectional width 115. A maximum linear distance between inner walls 111 of chamber 103 orthogonal to the width 115 quantifies cross-sectional height 117. As shown, cross-sectional height 117 is greater than one-third the cross-sectional width 115. This height/width relationship increases the volume of reformer chamber 103 for a given fuel processor 15. In one embodiment, cross-sectional height 117 is greater than one-half cross-sectional width 115. In another embodiment, cross-sectional height 117 is greater than the cross-sectional width 115. 40

Referring back to FIG. 2A, reformer chamber 103 includes a length 142 (orthogonal to the width 115 and height 117) that extends from one end of monolithic structure 100 at end plate 82 to the other end of structure 100 at end plate 84. In one 65

embodiment, reformer chamber **103** has a length **142** to width **115** ratio less than 20:1. In a less elongated design, reformer chamber **103** has a length **142** to width **115** ratio less than 10:1.

Reformer **32** provides a voluminous reformer chamber **103**. This three dimensional configuration for reformer chamber **103** contrasts micro fuel processor designs where the reformer chamber is etched as micro channels onto a planar substrate. The non-planar dimensions of reformer chamber **103** permit greater volumes for reformer **32** and permit more catalyst **102** for a given size of fuel processor **15**. This increases the amount of methanol that can be processed and increases hydrogen output for a particular fuel processor **15** size. Reformer **32** thus improves fuel processor's **15** suitability and performance in portable applications where fuel processor size is important or limited. In other words, since the size of inlet and outlet plumbing and ports varies little while increasing the reformer chamber **103** volume, this allows fuel processor **15** to increase hydrogen output and increase power density for portable applications while maintaining size and weight of the associated plumbing relatively constant. In one embodiment, reformer chamber **103** comprises a volume greater than about 0.1 cubic centimeters and less than about 50 cubic centimeters. In some embodiments, reformer **32** volumes between about 0.5 cubic centimeters and about 2.5 cubic centimeters are suitable for laptop computer applications.

Fuel processor **15** includes at least one burner **30**. Each burner **30** includes a burner chamber **105**. For a catalytic burner **30**, the burner chamber **105** is a voluminous space in fuel processor **15** that includes catalyst **104**. For communication or burner reactants and products to and from the burner chamber **105**, the burner chamber **105** may directly or indirectly open to a fuel source inlet (from boiler **108** for fuel processor **15**), open to an air inlet **93**, and open to a burner exhaust **89**.

The number of burners **30** and burner chambers **105** may vary with design. Monolithic structure **100** of FIG. 3A includes a dual burner **30a** and **30b** design having two burner chambers **105a** and **105b**, respectively, forming non-continuous chambers that substantially surround reformer **32** in cross section. Burner **30a** comprises side walls **119a** (FIG. 3A) included in monolithic structure **100** and end walls **113** on end plates **82** and **84** (FIG. 2B) that define burner chamber **105a**. Similarly, burner **30b** includes side walls **119b** (FIG. 3A) included in monolithic structure **100** and end walls **113** on end plates **82** and **84** (FIG. 2B) that define burner chamber **105b**. Monolithic structure **100** of FIG. 3C includes a single burner **30c** with a single burner chamber **105c** that fully surrounds reformer **32**. Tubular arrangement of FIG. 3B includes over forty burners **204** that fully surround reformer **202**. Monolithic structure **452** of FIG. 4F includes a single burner divided into 104 burner chambers that fully surround reformer **32**.

Referring to FIG. 2B, each burner **30** is configured relative to reformer **32** such that heat generated in a burner **30** transfers to reformer **32**. In one embodiment, the one or more burners **30** are annularly disposed about reformer **32**. As the term is used herein, annular configuration of at least one burner **30** relative to reformer **32** refers to the burner **30** having, made up of, or formed by, continuous or non-continuous segments or chambers **105** that surround reformer **32**. The annular relationship is apparent in cross section. For burner and reformer arrangements, surrounding refers to a burner **30** bordering or neighboring the perimeter of reformer **32** such that heat may travel from a burner **30** to the reformer **32**. Burners **30a** and **30b** may surround reformer **32** about the

perimeter of reformer **32** to varying degrees based on design. At the least, one or more burners **30** surround greater than 50 percent of the reformer **32** cross-sectional perimeter. This differentiates fuel processor **15** from planar and plate designs where the burner and reformer are co-planar and of similar dimensions, and by geometric logic, the burner neighbors less than 50 percent of the reformer perimeter. In one embodiment, one or more burners **30** surround greater than 75 percent of the reformer **32** cross-sectional perimeter. Increasing the extent to which burner **30** surrounds reformer **32** perimeter in cross section increases the surface area of reformer **32** that can be used to heat the reformer volume via heat generated in the burner. For some fuel processor **15** designs, one or more burners **30** may surround greater than 90 percent of the reformer **32** cross-sectional perimeter. For the embodiment shown in FIG. 3B, burner **30** surrounds the entire reformer **32** cross-sectional perimeter.

Although the present invention will now be described with respect to burner **30** annularly disposed about reformer **32**, it is understood that monolithic structure **100** may comprise the reverse configuration. That is, reformer **32** may be annularly disposed about burner **30**. In this case, reformer **32** may comprise one or more continuous or non-continuous segments or chambers **103** that surround burner **30**.

In one embodiment, each burner **30** and its burner chamber **105** has a non-planar cross-sectional shape. A non-planar burner **30** may employ cross-sectional shapes such as quadrilaterals, non-quadrilateral geometries with more or less sides, an elliptical shape (see FIG. 3B for circular/tubular burners **30**), or more complex cross-sectional shapes. As shown in FIG. 3A, each burner **30** includes a six-sided cross-sectional 'L' shape (with chamfered corners) that bends 90 degrees about reformer **32**.

Each burner **30** thus bilaterally borders reformer **32**. N-lateral bordering in this sense refers to the number of sides, N, of reformer **32** that a burner **30** (and its burner chamber **105**) borders in cross section. Thus, burner **30b** borders the right and bottom sides of reformer **32**, while burner **30a** borders the top and left sides of reformer **32**. A 'U-shaped' burner **30** may be employed to trilaterally border reformer **32** on three sides. Together, burners **30a** and **30b** quadrilaterally border reformer **32** on all four orthogonal reformer **32** sides. The reformer **32** used in the configuration of FIG. 3B includes multiple tubular burners that quadrilaterally border reformer **32**. FIG. 3C illustrates a cross-sectional front view of monolithic structure **100** that comprises a single burner **30c** having an 'O-shape' that completely surrounds reformer chamber **103** in accordance with one embodiment of the present invention. Burner **30c** is a continuous chamber about the perimeter of reformer **32** and quadrilaterally borders reformer **32**.

Heat generated in burner **30** transfers directly and/or indirectly to reformer **32**. For the monolithic structure **100** of FIG. 3A, each burner **30** and reformer **32** share common walls **120** and **122** and heat generated in each burner **30** transfers directly to reformer **32** via conductive heat transfer through common walls **120** and **122**. Wall **120** forms a boundary wall for burner **30b** and a boundary wall for reformer **32**. As shown, one side of wall **120** opens to burner chamber **105b** while another portion of the wall opens to reformer chamber **103**. Wall **120** thus permits direct conductive heat transfer between burner **30b** and reformer **32**. Similarly, wall **122** forms a boundary wall for burner **30a** and a boundary wall for reformer **32**, opens to burner chamber **105a**, opens to reformer chamber **103**, and permits direct conductive heat transfer between burner **30a** and reformer **32**. Walls **120** and **122** are both non-planar in cross section and border multiple sides of reformer chamber **103** that are neighbored by burners

30b and **30a**. Wall **120** thus provides direct conductive heat transfer in multiple orthogonal directions **128** and **129** from burner **30a** to reformer **32**. Wall **122** similarly provides direct conductive heat transfer in directions opposite to **128** and **129** from burner **30b** to reformer **32**.

Boiler **34** comprises cylindrical walls **143** included in monolithic structure **100** and end walls **113** on end plates **82** and **84** (see FIG. 2B) that define boiler chamber **147**. Circular walls **143** in cross section form a cylindrical shape for boiler **34** that extends from routing end **82** to routing end **84**. Boiler **34** is disposed in proximity to burners **30a** and **30b** to receive heat generated in each burner **30**. For monolithic structure **100**, boiler **34** shares a common wall **130** with burner **30a** and a common wall **132** with burner **30b**. Common walls **130** and **132** permit direct conductive heat transfer from each burner **30** to boiler **34**. Boiler **34** is also disposed between burners **30** and reformer **32** to intercept thermal conduction consistently moving from the high temperature and heat generating burners **30** to the endothermic reformer **32**.

Boiler **108** is configured to receive heat from burner **30** to heat methanol before burner **30** receives the methanol. Boiler **108** also comprises a tubular shape having a circular cross section that extends through monolithic structure **100** from end plate **82** to end plate **84**. Boiler **108** is disposed in proximity to burners **30a** and **30b** to receive heat generated in each burner **30**, which is used to heat the methanol. Boiler **108** shares a common wall **134** with burner **30a** and a common wall **136** with burner **30b**. Common walls **134** and **136** permit direct conductive heat transfer from burners **30a** and **30b** to boiler **108**.

FIG. 3D illustrates an outside view of end plate **82** in accordance with one embodiment of the present invention. End plate **82** includes fuel source inlet **81**, fuel source fuel source inlet **85**, hydrogen outlet port **87** and burner air inlet **93**. Fuel source inlet **81** includes a hole or port in end wall **113** of end plate **82** that communicates methanol (usually as a liquid) from an external methanol supply to boiler **34** for heating the methanol before receipt by reformer **32**. Methanol fuel source inlet **85** includes a hole or port in end wall **113** of end plate **82** that communicates methanol (usually as a liquid) from an external methanol supply to boiler **108** for heating the methanol before receipt by burner **30**. Burner air inlet **93** includes a hole or port in end wall **113** of end plate **82** that communicates air and oxygen from the ambient room after it has been preheated in dewar **150**. Hydrogen outlet port **87** communicates gaseous hydrogen from reforming chamber **103** outside fuel processor **15**.

Bolt holes **153** are disposed in wings **145** of monolithic structure **100**. Bolt holes **153** permit the passage of bolts therethrough and allow securing of structure **100** and end plates **82** and **84**.

FIG. 3B illustrates a cross-sectional layout of a tubular design **200** for use in fuel processor **15** in place of monolithic structure **100** in accordance with another embodiment of the present invention. Structure **200** includes a reformer **202**, burner **204**, boiler **206** and boiler **208**.

The cross-sectional design **200** shown in FIG. 3B is consistent throughout a cylindrical length between end plates (not shown) that include inlet and outlet ports for supply and exhaust of gases to components of design **200**. The circular shape of reformer **202**, burner chambers **212**, boiler **206** and boiler **208** thus extends for the entire cylindrical length between the end plates. The end plates may also be responsible for routing gases between individual tubes, such as between tubular burners **234**.

Reformer **202** includes cylindrical walls **203** that define a substantially circular cross section. Reformer **232** thus

resembles a hollow cylinder in three dimensions that defines a tubular reformer chamber **210**. In general, reformer **202** may include any elliptical shape (a circle represents an ellipse of about equal orthogonal dimensions) suitable for containing the catalyst **102**, for methanol flow through reformer chamber **210**, for hydrogen production in reformer chamber **210**, and for hydrogen flow in reformer chamber **210**. As shown, reformer chamber **210** is defined by a cross sectional width and a cross sectional height that are substantially equal and thus reformer **202** includes a 1:1 cross sectional aspect ratio.

Burner **204** comprises a set of cylindrical walls **214** that each defines a tubular burner chamber **212**. As shown, tubular design **200** includes over forty tubular burner chambers **212** that fully surround the cross sectional perimeter of reformer **32**. Each tubular burner chamber **212** includes a substantially circular cross-section defined by the cylindrical wall **214**. Each tubular burner chamber **212** includes catalyst **104** that facilitates heat generation from methanol. Burner **204** may comprise from about two to about two hundred cylindrical walls **214** and tubular burner chambers **212**. Some designs may include from about ten to about sixty tubular burner chambers **212**. In one embodiment, each cylindrical wall **214** comprises a metal and is extruded to its desired dimensions. In a specific embodiment, cylindrical wall **214** comprises nickel. The nickel wall **214** may be formed by electroplating nickel onto a suitable substrate such as zinc or aluminum that may subsequently be etched out to leave the nickel tube. Other materials that a nickel wall **214** may be formed onto include zinc, tin, lead, wax or plastics. In addition to nickel, wall **214** may include gold, silver, copper, stainless steel, ceramics and materials that display suitable thermal properties without causing complications with burner catalyst **104**.

As shown, burner **204** fully annularly surrounds the cross-sectional perimeter of reformer **202**. In this case, burner **204** comprises three ring-like layers **216**, **218** and **220** of tubes **214** disposed circularly about reformer **202** and at three different radii. The tubes **214** in each layer **216**, **218** and **220** circumscribe reformer **202**. Heat generated in each tubular chamber **212** of burner **30** transfers directly or indirectly to reformer **202** via several paths: a) heat conduction through the tubes **214** in layer **216** to the walls of reformer **202**; b) heat conduction through the tubes **214** in outer layers **218** and **220** to tubes **214** in layer **216** and to the walls of reformer **202**; and/or c) heat radiation between tubes **214** in outer layers **218** and **220** and tubes **214** and then conduction inward to reformer **202**.

Boiler **206** is configured to heat methanol before reformer **202** receives the methanol. Boiler **206** receives heat from burner **204** and comprises a cylindrical wall **207** that defines a tubular shape for the boiler. Boiler **206** is disposed in proximity to burner tubes **214** to receive heat generated in each burner chamber **212**. Specifically, boiler **206** is disposed in the second ring-like layer **218** and receives heat from adjacent burner chambers **212** in layers **216**, **218** and **220**. Burner **204** provides heat to boiler **206** via conduction through the walls of each adjacent tube **214** and through wall **207**.

Boiler **208** is configured to heat methanol before burner **204** receives the methanol. Boiler **208** receives heat from burner **204** and also comprises a cylindrical wall **209** that defines a tubular shape for the boiler. Similar to boiler **206**, boiler **208** is disposed in the second ring-like layer **218** and receives heat from adjacent burner chambers **212** in layers **216**, **218** and **220**.

In one embodiment, a monolithic fuel processor **15** comprises multiple segments joined together in the direction of gas flow in reformer chamber **103** and joined at sectional lines **121**. Each segment has a common profile as shown in FIG. 3A

and may comprise metal or ceramic elements that are bonded or brazed perpendicular to the direction of gas flow. Alternatively, fuel processor 15 may comprise a single long monolithic piece that bounds all of reformer 32, burner 30, boiler 34 and boiler 108 except for areas bound by end pieces 82 and 84.

In another embodiment, fuel processor 15 comprises multiple pieces joined together in cross section. FIG. 3E illustrates a fuel processor 15 in accordance with another embodiment of the present invention. In this case, fuel processor 15 comprises three pieces: lower piece 280, middle piece 282 and cap piece 284. Lower piece 280 and middle piece 282 attach to form reformer 32 and two burner chambers 30. Cap piece 284 and middle piece 282 attach to form boilers 34 and 108. Each piece 208, 282 and 284 comprises a common material and may be extruded or cast to suitable dimensions. Attachment between the pieces may comprise chemical bonding, for example.

FIG. 4A illustrates a side cross-sectional view of fuel processor 15 and movement of air created by dewar 150 in accordance with one embodiment of the present invention. FIG. 4B illustrates a front cross-sectional view of fuel processor 15 and demonstrates thermal management benefits gained by dewar 150. While thermal management techniques described herein will now be described as fuel processor components, those skilled in the art will recognize that the present invention encompasses methods of thermal management for general application.

A burner 30 in fuel processor 15 generates heat and typically operates at an elevated temperature. Burner 30 operating temperatures greater than 200 degrees Celsius are common. Standards for the manufacture of electronics devices typically dictate a maximum surface temperature for a device. Electronics devices such as laptop computers often include cooling, such as a fan or cooling pipe, to manage and dissipate internal heat. A fuel processor internal to an electronics device that loses heat into the device calls upon the device's cooling system to handle the lost heat.

In one embodiment, fuel processor 15 comprises a dewar 150 to improve thermal management for fuel processor 15. Dewar 150 at least partially thermally isolates components internal to housing 152—such as burner 30—and contains heat within fuel processor 15. Dewar 150 reduces heat loss from fuel processor 15 and helps manage the temperature gradient between burner 30 and outer surface of housing 152. And as will be described below, dewar 150 also pre-heats air before it is received by burner 30.

Dewar 150 at least partially contains burner 30 and reformer 32, and includes a set of dewar walls 154 that help form a dewar chamber 156 and a chamber 158. In some embodiments, dewar 150 fully surrounds burner 30 and reformer 32 in a cross sectional view and at both ends of burner 30 and reformer 32. Less containment by dewar 150 is also suitable to provide thermal benefits described herein. The multipass dewar 300 of FIG. 4E only partially encloses burner 30 and reformer 32 in cross section. In some cases, dewar 150 does not extend fully along the length of monolithic structure 100 and provides less than full containment.

As shown in FIG. 4B, dewar 150 annularly surrounds burner 30 in cross section. The set of walls 154 includes side walls 154a and 154c that combine with top and bottom walls 154b and 154d to form the rectangular cross section shown in FIG. 4B; and includes two end walls 154e and 154f that combine with top and bottom walls 154b and 154d to form the rectangular cross section shown in FIG. 4A. End wall 154f includes apertures that permit the passage of inlet and outlet ports 85, 87 and 89 therethrough.

Dewar chamber 156 is formed within dewar walls 154 and comprises all space within the dewar walls 154 not occupied by monolithic structure 100. As shown in FIG. 4B, dewar chamber 156 surrounds monolithic structure 100. As shown in FIG. 4B, chamber 156 comprises ducts between monolithic structure 100 and walls 154 on all four sides of dewar 150. In addition, chamber 156 comprises air pockets between end walls of dewar 150 and outside surfaces of end plates 82 and 84 on both ends of monolithic structure 100 (FIG. 4A).

Chamber 158 is formed outside dewar walls 154 between dewar 150 and housing 152. Chamber 158 comprises all space within housing 152 not occupied by dewar 150. As shown in FIG. 4B, housing 152 encloses dewar 150 and the further internal monolithic structure 100. Chamber 158 comprises ducts between walls 154 on all four sides of dewar 150 and housing 152. In addition, chamber 158 comprises air pockets 167 between dewar 150 and housing 152 on both ends that prevent contact and conductive heat transfer between dewar 150 and housing 152 (FIG. 4A).

Dewar 150 is configured such that a process gas or liquid passing through dewar chamber 156 receives heat generated in burner 30. The process gas or liquid may include any reactant used in fuel processor such as oxygen, air, or fuel source 17, for example. Dewar 150 offers thus two functions for fuel processor 15: a) it permits active cooling of components within fuel processor 15 before the heat reaches an outer portion of the fuel processor, and b) it pre-heats the air going to burner 30. For the former, air moves through fuel processor 15 and across walls 154 of dewar 150 such that the cooler air absorbs heat from the warmer fuel processor 15 components.

As shown in FIG. 4A, housing 152 includes an air inlet port 91 or hole that permits the passage of air from outside housing 152 into air into chamber 158. A fan usually provides the air directly to fuel processor 15 and pressurizes the air coming through port 91. Top and bottom walls 154b and 154d include air inlet ports or holes 172 that allow air to pass from chamber 158 to dewar chamber 156. Air flow through fuel processor 15 then flows: in air inlet port 91, through chamber 158 along the length of the dewar 150, through holes 172 in walls 154b and 154d, through chamber 156 back along the length of the dewar 150 in the opposite direction as in through chamber 158, and into air inlet ports 176 that allow the air to enter burner 30. In chamber 158, the air a) moves across the outside surface of dewar walls 154 and absorbs heat convectively from dewar walls 154, and b) moves across the inside surface of housing 152 and absorbs heat convectively from the housing 152 walls (when housing 152 is at a greater temperature than the air). In chamber 156, the air a) moves across the outside surface of monolithic structure 100 and absorbs heat convectively from the walls of monolithic structure 100, and b) moves across the inside surface of dewar 150 and absorbs heat convectively from dewar walls 154.

Dewar 150 is thus configured such that air passing through the dewar receives heat generated in burner 30 via direct convective heat transfer from walls in monolithic structure 100 on the outside of burner 30 to air passing through dewar chamber 156. Dewar 150 is also configured to such that air passing through chamber 156 receives heat indirectly from burner 30. Indirectly in this sense refers to heat generated in burner 30 moving to another structure in fuel processor 15 before receipt by the air.

FIG. 4C illustrates a thermal diagram of the heat path produced by a wall 154 of dewar 150. Heat from burner 30 conducts through monolithic structure 100 to a surface of structure 100 that opens into dewar chamber 156. From here, the heat a) conducts into the air passing through dewar chamber 156, thereby heating the air; b) radiates to the inner wall

155 of dewar wall **154**, from which the heat convects into the air passing through dewar chamber **156**; c) radiates to the inner wall **155** of dewar wall **154**, conducts through wall **154** to the outer surface **157** of dewar wall **154**, from which the heat convects into the air passing through dewar chamber **158**, and d) radiates to the inner wall **155** of dewar wall **154**, conducts through wall **154** to the outer surface **157** of dewar wall **154**, radiates to a wall of housing **152**, from which the heat convects into the air passing through dewar chamber **158**.

Dewar **150** thus provides two streams of convective heat dissipation and active air-cooling in volumes **156** and **158** that prevent heat generated in burner **30** (or other internal parts of fuel processor **15**) from escaping the fuel processor.

Reflectance of heat back into chamber **156** decreases the amount of heat lost from fuel processor **150** and increases the heating of air passing through chamber **156**. To further improve the radiative reflectance back into chamber **156**, an inside surface of dewar wall **154** may include a radiative layer **160** to decrease radiative heat transfer into wall **154** (see FIG. **4B** or **4C**). Radiative layer **160** is disposed on an inner surface **155** on one or more of walls **154** to increase radiative heat reflectance of the inner surface **155**. Generally, the material used in radiative layer **160** has a lower emissivity than the material used in walls **154**. Materials suitable for use with walls **154** of dewar **150** include nickel or a ceramic, for example. Radiative layer **160** may comprise gold, platinum, silver, palladium, nickel and the metal may be sputter coated onto the inner surface **155**. Radiative layer **160** may also include a low heat conductance. In this case, radiative layer **160** may comprise a ceramic, for example.

When dewar **150** fully encapsulates monolithic structure **100**, the dewar then bounds heat loss from the structure and decreases the amount of heat passing out of dewar **150** and housing **152**. Fuel processors **15** such as that shown in FIGS. **4A** and **4B** are well suited to contain heat within housing **152** and manage heat transfer from the fuel processor. In one embodiment, burner operates at a temperature greater than about 200 degrees Celsius and the outer side of the housing remains less than about 50 degrees Celsius. In embodiments for portable applications where fuel processor **15** occupies a small volume, volumes **156** and **158** are relatively small and comprise narrow channels and ducts. In some cases, the height of channels in volumes **156** and **158** is less than 5 millimeters and a wall of burner **30** on monolithic structure is no greater than 10 millimeters from a wall of housing **152**.

The thermal benefits gained by use of dewar **150** also permit the use of higher temperature burning fuels as a fuel source for hydrogen production, such as ethanol and gasoline. In one embodiment, the thermal management benefits gained by use of dewar **150** permit reformer **32** to process methanol at temperatures well above 100 degrees Celsius and at temperatures high enough that carbon monoxide production in reformer **32** drops to an amount such that a preferential oxidizer is not needed.

As mentioned above, dewar **150** offers a second function for fuel processor **15** by pre-heating the air going to a burner. Burner **30** relies on catalytic combustion to produce heat. Oxygen in the air provided to burner **30** is consumed as part of the combustion process. Heat generated in the burner **30** will heat cool incoming air, depending on the temperature of the air. This heat loss to incoming cool air reduces the heating efficiency of burner **30**, and typically results in a greater consumption of methanol. To increase the heating efficiency of burner **30**, the present invention heats the incoming air so less heat generated in the burner passes into the incoming air. In other words, chambers and air flow formed by dewar **150**

allow waste heat from the burner to pre-heat air before reaching the burner, thus acting as a regenerator for fuel cell **15**.

While fuel processor **15** of FIGS. **4A** and **4B** shows dewar **150** encapsulating monolithic structure **100**, the present invention may also employ other architectures for dewar **150** and relationships between burner **30** or reformer **32** and dewar **150** that carry out one or both of the dewar functions described above. FIG. **4D** illustrates a cross sectional view of a fuel processor **15** that elongates the convective path for cool air flow over a warmer dewar wall **254** in accordance with another embodiment of the present invention. Fuel processor **15** includes a tubular design for the burner **30** and reformer **32**.

Dewar **250** routes cool incoming air across an elongated heat transfer path. Dewar **250** includes a spiral wall **254** in cross section that surrounds burner **30** and reformer **32**. Spiral wall **254** defines a spiral dewar chamber **256**. Cool air enters dewar chamber **256** at a dewar entrance **252**. The innermost portion **257** of wall **254** attaches to an outer wall **258** of burner **30**. Heat from burner **30** conducts linearly through spiral wall **254**. Thus, inner portion **257** is the warmest portion of wall **254**, while wall **254** at entrance **252** is typically the coolest. Air progressively warms as it travels through dewar chamber **256**. As the air travels inward, temperature of wall **254** rises, as does the amount of heat available for transfer to the air. Depending on the transient temperature of the air, the amount of heat lost from wall **154** may also increase as the air progresses inward.

Spiral dewar **250** elongates convection interaction between the incoming cool air and a wall warmed by the burner. Dewar **250** also increases the number of walls and convective layers in a given radial direction from the fuel processor center. As shown in FIG. **4D**, dewar **250** comprises 4-5 walls and convective layers in a given radial direction, depending on where the number is counted. The number of walls and convective in a radial direction may vary with design. In one embodiment, spiral dewar **250** is configured with from 1 layer to about 50 walls and convective layers in a given radial direction from the fuel processor center. Three layers to 20 layers are suitable for many applications. A channel width **260** defines the duct space between adjacent walls **254**. In one embodiment, channel width **260** ranges from about ¼ millimeters to about 5 millimeters.

Spiral dewar **250** may be constructed by electroplating nickel onto a removable layer such as aluminum or zinc. FIG. **4H** illustrates spiral dewar **250** in an unrolled form during initial construction in accordance with another embodiment of the present invention. Initial aluminum or zinc layer **262** is added to control channel width **260** during rolling. The removable layer **262** is subsequently electroplated with the wall **214** choice of material, for example nickel. After which the aluminum or zinc layer is etched out employing an electroforming technique thus leaving a spiral dewar **250**.

The spiral dewar **250** shown in FIG. **4H** also employs an embossed or folded burner structure **264** that wraps around reformer **32**. FIGS. **4I** and **4J** illustrate wash coatings **266** on a wall **268** of burner **30** in accordance with two embodiments of the present invention. For the folded burner structure **264** of FIG. **4I**, a wash coat **266** including the burner catalyst **104** is applied to both sides of wall **268**.

A flat wall **270** suitable for use in spiral dewar **250** is shown in FIG. **4J**. Flat wall **270** includes channels **272** etched or otherwise disposed along its surface. A wash coat **266** including the burner catalyst **104** is then added over the surface of flat wall **270** and channels **272**.

Fuel processors **15** such as that shown in FIG. **4D** are very well suited to contain internally generated heat. In one

embodiment, burner **30** operates at a temperature greater than about 350 degrees Celsius and the outer side of the housing remains less than about 75 degrees Celsius. This facilitates the use of higher temperature burning fuel sources within burner **30** such as ethanol and propane, for example.

Dewars as shown in FIGS. **4A** and **4D** may be considered ‘multipass’ since the incoming air passes over multiple surfaces for convective heat transfer between the warmer surfaces and cooler air. The embodiment in FIG. **4A** illustrates a two-pass system where the air passes through two dewar chambers, while the embodiment in FIG. **4D** illustrates an N-pass where N is the number of dewar walls in a given radial direction from the fuel processor center.

FIG. **4E** illustrates a cross sectional view of a multipass dewar **300** in accordance with another embodiment of the present invention. Dewar **300** comprises four dewar walls **302a-d** that connect to a housing wall **304**. Dewar **300** partially contains monolithic structure **100**. Dewar wall **302a** cooperates with housing wall **304** to enclose monolithic structure **100**, which includes burner **30**. Dewar wall **302b** and housing wall **304** enclose dewar wall **302a** and burner **30**. Similarly, dewar wall **302c** and housing wall **304** enclose dewar wall **302b**, while dewar wall **302d** and housing wall **304** enclose dewar wall **302c**. Dewar walls **302a-d** form four volumes for incoming air to pass over warmer walls and receive heat. Air enters dewar inlet port **310** and flows through dewar chamber **308a** and into dewar chamber **308b** through port **312** after travelling through substantially the whole chamber **308a**. Air then serially passes into and through chambers **308c** and **308d** before entering burner inlet **314**.

FIGS. **4F** and **4G** illustrate a cross section of a fuel processor **15** including a monolithic structure **452** and multipass dewar **450** in accordance with another embodiment of the present invention. Monolithic structure **452** includes multiple reformer chambers **454** that are disposed in a central portion of structure **452**. Multiple burner chambers **456** surround and quadrilaterally border the reformer chambers **454**. Reformer boiler **458** is arranged within the cross section of burner chambers **456**, while burner boiler **460** is arranged in external portion of the cross section.

Dewar **462** comprises four dewar walls **462a-d**. In the cross section shown in FIG. **4F**, dewar wall **462a** surrounds monolithic structure **452**. Dewar wall **462b** surrounds and encloses dewar wall **462a**. Dewar wall **462c** surrounds and encloses dewar wall **462b**, while dewar wall **462d** surrounds and encloses dewar wall **462c**. Dewar walls **462a-d** form four dewar volumes for incoming air to pass through and receive heat. As shown in FIG. **4G**, air enters dewar inlet port **464** and flows through dewar chamber **468a** and into dewar chamber **468b** after traveling through substantially the whole chamber **468a** along the length of monolithic structure **452**. Air then serially passes from chamber **468b** to chamber **468c** and chamber **468d** before entering burner inlet **470**.

FIG. **5** illustrates a process flow **500** for generating hydrogen in a fuel processor in accordance with one embodiment of the present invention. The fuel processor comprises a burner, a reformer and a dewar that at least partially contains the burner and reformer. Although the present invention has so far discussed dewars with respect to annular reformer and burner designs described herein, it is also anticipated that dewars described herein are also useful to contain heat in other reformer and burner designs. Many architectures employ a planar reformer disposed on top or below to a planar burner. Micro-channel designs fabricated in silicon commonly employ such stacked planar architectures and would benefit from dewars described herein.

Process flow **500** begins by generating heat in the burner (**502**). Catalytic burner architectures may include those described above or a micro-channel design on silicon. Further description of a micro-channel fuel processor suitable for use with the present invention is included in commonly owned co-pending patent application entitled “Planar Micro Fuel Processor” naming Ian Kaye as inventor and filed on the same day as this patent application. This application is incorporated by reference for all purposes. A catalyst in the burner facilitates heat generation in the presence of the heating fuel. The burner may also employ an electric burner that includes an resistive heating element that produces heat in response to input current.

Air enters a port for the dewar and passes through a dewar chamber (**504**). For the dewar of FIG. **4A**, burner **30** and dewar **150** share a wall and the air passes through the dewar chamber **156** in a direction that at least partially counters a direction that the air passes through burner chamber **105**.

The air is then heated in the dewar chamber using heat generated in the burner (**506**). Heat travels from burner **30** to dewar chamber **156** via conductive heat transfer. Heat may also travel from a burner to a dewar chamber via convective and/or radiative heat transfer. Once in the dewar chamber, the air is typically heated via convective heat transfer from a wall of the dewar to the air. In one embodiment, the dewar shares a wall with the burner and air in the dewar chamber is heated using heat from the shared wall. Heat from the burner wall may also travel to other walls in the dewar and heat air in the dewar chamber after the heat transfers from the shared wall to another non-shared dewar wall. Heat traveling between the shared wall and non-shared dewar wall transfer by conduction between connected walls or radiation between facing walls.

Process flow **500** then supplies the warmed air to the burner after it has been heated in the dewar chamber (**508**). Typically, the fuel processor includes an exit to the dewar chamber and an inlet to the burner—along with any intermittent plumbing—that allow the heated air to pass therebetween. For the fuel processor shown in FIG. **2A**, space between dewar **150** and burner **30** at the ends of the burner route the air from the dewar to the burner.

The air is then used in the burner for catalytic combustion to generate heat. The generated heat is then transferred from the burner to the reformer (**510**). In the reformer, the heat is then used in reforming a fuel source to produce hydrogen (**512**).

The first three elements (**502**, **504**, and **506**) of process flow **500** also form a method of managing heat in a fuel processor. In this case, heat generated in the burner (**502**) passes to air in the dewar (**504**). The dewar **150** at least partially thermally isolates components internal to the fuel processor housing—such as the burner—and contains heat within the fuel processor. The dewar thus reduces heat loss from the fuel processor and helps manage the temperature gradient between the burner and outer surfaces of the housing. The dewar may also contain extended and/or multiple dewar chambers through which the air passes and is heated by heat generated in the burner. FIG. **4A** illustrates a second dewar chamber **158** formed between the dewar and a housing for the fuel processor. Air passes first through chamber **158** then into dewar chamber **156**. FIG. **4D** illustrates a spiral dewar including an extended dewar chamber **408**. In this case, dewar **250** includes one wall that increasingly provides heat as incoming air nears the burner. FIG. **4E** illustrates a dewar **300** including four partially dewar chambers **308** where each dewar chamber heats incoming air in turn as it nears the burner. FIG. **4F** illustrates a dewar including four annular and concentric and

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rectangular dewar chambers **408** that each heat incoming air in turn as it travels to the burner.

While this invention has been described in terms of several preferred embodiments, there are alterations, permutations, and equivalents that fall within the scope of this invention which have been omitted for brevity's sake. For example, although reformer **32** includes chamfered corners as shown in FIG. 3A, the present invention may employ non-chamfered corners in reformer **32**. In addition, although the present invention has been described in terms of a monolithic structure **100** that forms the volumetric reformer **32**, the present invention is not limited to volumetric reformers disposed in monolithic structures. It is therefore intended that the scope of the invention should be determined with reference to the appended claims.

What is claimed is:

1. A fuel processor for producing hydrogen from a fuel source, the fuel processor comprising:

a reformer including two or more reformer chambers in a cross section that are configured to receive the fuel source and configured to output hydrogen, each of the two or more reformer chambers including a reformer catalyst that facilitates the production of hydrogen, wherein the two or more reformer chambers are configured such that reactants move through the two or more reformer chambers in series;

a boiler configured to heat the fuel source before the reformer receives the fuel source;

a burner including two or more burner chambers in a cross section, each of the two or more burner chambers including a burner catalyst, the two or more burner chambers configured to provide heat to the reformer, wherein the two or more burner chambers are configured such that reactants move through the two or more burner chambers in series; and

a dewar that contains the reformer, contains the burner and includes a set of dewar walls that form a dewar chamber that is configured to receive the fuel source or oxygen before one of the two or more burner chambers receives the fuel source or oxygen,

wherein the fuel processor includes a monolithic structure having a common material included in walls that define the two or more reformer chambers, the two or more burner chambers and the boiler, wherein the monolithic structure comprises a wall comprising copper that is shared by one of the two or more reformer chambers and one of the two or more burner chambers and the fuel processor is configured to permit conductive thermal communication from the burner catalyst, through the wall, to one of the two or more reformer chambers.

2. The fuel processor of claim **1** wherein the two or more reformer chambers surrounds greater than 50 percent of the two or more burner chamber cross-sectional perimeter.

3. The fuel processor of claim **2** wherein the two or more reformer chambers surrounds greater than 75 percent of the two or more burner chamber cross-sectional perimeter.

4. The fuel processor of claim **3** wherein the two or more reformer chambers surrounds greater than 90 percent of the two or more burner chamber cross-sectional perimeter.

5. The fuel processor of claim **1** wherein the two or more burner chambers bilaterally neighbors the two or more reformer chambers.

6. The fuel processor of claim **5** wherein the two or more burner chambers trilaterally neighbors the two or more reformer chambers.

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7. The fuel processor of claim **6** wherein the two or more burner chambers quadrilaterally neighbors the two or more reformer chambers.

8. The fuel processor of claim **1** wherein the two or more burner chambers each has a non-planar cross-sectional shape.

9. The fuel processor of claim **1** wherein the two or more burner chambers each has a non-quadrilateral cross-sectional shape.

10. The fuel processor of claim **1** wherein the dewar includes a radiative layer disposed on an inner wall of the set of dewar walls that improves radiative heat reflectance of the inner wall.

11. The fuel processor of claim **1** wherein the dewar is configured such that air passing through the dewar chamber receives heat generated in one of the two or more burner chambers.

12. The fuel processor of claim **1** wherein the dewar annularly surrounds the two or more burner chambers in the cross section.

13. The fuel processor of claim **1** wherein the dewar includes a second dewar chamber.

14. The fuel processor of claim **13** wherein the second dewar chamber is configured to receive heat from the two or more burner chambers.

15. The fuel processor of claim **1** wherein the common material comprises a metal.

16. The fuel processor of claim **15** wherein the monolithic structure is formed in a single extrusion or casting.

17. The fuel processor of claim **1** wherein the wall permits conductive thermal communication between the two or more burner chambers and the two or more reformer chambers in orthogonal directions.

18. The fuel processor of claim **17** wherein the boiler is configured to receive heat from one of the two or more burner chambers.

19. The fuel processor of claim **18** further comprising a second boiler that is configured to heat the fuel source before one of the two or more burner chambers receives the fuel source.

20. A fuel processor for producing hydrogen from a fuel source, the fuel processor comprising:

a reformer including two or more reformer chambers in a cross section that are configured to receive the fuel source and configured to output hydrogen, each of the two or more reformer chambers are configured such that reactants move through the two or more reformer chambers in series and including a catalyst that facilitates the production of hydrogen, each of the two or more reformer chambers having a volume greater than about 0.1 cubic centimeters and less than about 50 cubic centimeters, and each of the two or more reformer chambers is characterized by a cross sectional width and a cross sectional height that is greater than one-third the cross sectional width;

a boiler configured to heat the fuel source before the reformer receives the fuel source;

a burner including two or more burner chambers in a cross section, each of the burner chambers including a burner catalyst, each of the two or more burner chambers are configured to provide heat to the reformer, wherein the two or more burner chambers are configured such that reactants move through the two or more burner chambers in series;

a dewar that contains the reformer, contains the burner and includes a set of dewar walls that form a dewar chamber

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that is configured to receive the fuel source or oxygen before one of the two or more burner chambers receives the fuel source or oxygen,

wherein the fuel processor includes a monolithic structure comprising copper that forms a wall of one of the two or more reformer chambers, a wall of one of the two or more burner chambers, and a wall of the boiler.

21. The fuel processor of claim 20 wherein the two or more reformer chambers each are substantially non-quadrilateral in cross section.

22. The fuel processor of claim 20 wherein the two or more reformer chambers each includes a substantially elliptical cross section.

23. The fuel processor of claim 22 wherein the two or more reformer chambers each include a substantially circular cross section.

24. The fuel processor of claim 20 wherein the two or more reformer chambers each comprises a volume between about 0.5 cubic centimeters and about 2.5 cubic centimeters.

25. The fuel processor of claim 20 wherein the cross sectional height is greater than one-half the cross sectional width.

26. The fuel processor of claim 20 wherein the cross sectional height is greater than the cross sectional width.

27. The fuel processor of claim 20 wherein the two or more burner chambers each has a non-quadrilateral cross-sectional shape.

28. The fuel processor of claim 27 wherein the two or more burner chambers bilaterally neighbors the two or more reformer chambers.

29. The fuel processor of claim 28 wherein the two or more burner chambers collectively quadrilaterally neighbor the two or more reformer chambers.

30. The fuel processor of claim 20 wherein the two or more reformer chambers surrounds greater than 90 percent of the two or more burner chamber perimeter.

31. The fuel processor of claim 20 wherein the boiler is configured to receive heat from at least one of the two or more burner chambers.

32. The fuel processor of claim 20 wherein the fuel processor includes a monolithic structure having a common material included in walls that define the two or more reformer chambers, the two or more burner chambers and the boiler.

33. The fuel processor of claim 32 wherein the common material comprises a metal.

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34. The fuel processor of claim 33 wherein the monolithic structure is formed in a single extrusion.

35. The fuel processor of claim 20 wherein the catalyst comprises pellets.

36. The fuel processor of claim 35 wherein the pellets have a diameter ranging from about 300 microns to about 1500 microns.

37. A fuel processor for producing hydrogen from a fuel source, the fuel processor comprising:

a reformer including two or more reformer chambers in a cross section that are configured to receive the fuel source and configured to output hydrogen, each of the two or more reformer chambers including a reformer catalyst that facilitates the production of hydrogen, wherein the two or more reformer chambers are configured such that reactants move through the two or more reformer chambers in series;

a boiler configured to heat the fuel source before the reformer receives the fuel source;

a burner, including two or more burner chambers in a cross section, each of the two or more burner chambers include a burner catalyst, each of the two or more burner chambers configured to provide heat to the reformer;

a dewar that contains the reformer, contains the burner and includes a set of dewar walls that form a dewar chamber that is configured to receive the fuel source or oxygen before one of the two or more burner chambers receives the fuel source or oxygen,

wherein the fuel processor includes a monolithic structure comprising copper that forms a wall of at least one of the two or more reformer chambers, a wall of at least one of the two or more burner chambers, and a wall of the boiler.

38. The fuel processor of claim 20 wherein the two or more reformer chambers surrounds greater than 50 percent of the two or more burner chamber cross-sectional perimeter.

39. The fuel processor of claim 20 wherein the two or more reformer chambers surrounds greater than 75 percent of the two or more burner chamber cross-sectional perimeter.

40. The fuel processor of claim 37 wherein the two or more burner chambers are configured such that reactants move through the two or more burner chambers in series.

* * * * *

UNITED STATES PATENT AND TRADEMARK OFFICE
CERTIFICATE OF CORRECTION

PATENT NO. : 7,604,673 B2
APPLICATION NO. : 10/877044
DATED : October 20, 2009
INVENTOR(S) : Kaye et al.

Page 1 of 1

It is certified that error appears in the above-identified patent and that said Letters Patent is hereby corrected as shown below:

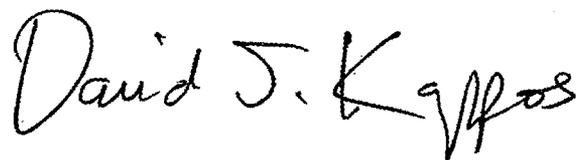
On the Title Page:

The first or sole Notice should read --

Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 929 days.

Signed and Sealed this

Fifth Day of October, 2010

A handwritten signature in black ink that reads "David J. Kappos". The signature is written in a cursive, slightly slanted style.

David J. Kappos
Director of the United States Patent and Trademark Office