



US007040873B2

(12) **United States Patent**  
**Dooley**

(10) **Patent No.:** **US 7,040,873 B2**  
(45) **Date of Patent:** **\*May 9, 2006**

- (54) **MULTI PUMPING CHAMBER  
MAGNETOSTRICTIVE PUMP**
- (75) Inventor: **Kevin Allan Dooley**, Mississauga (CA)
- (73) Assignee: **Pratt & Whitney Canada Corp.**,  
Longueuil (CA)
- (\*) Notice: Subject to any disclaimer, the term of this  
patent is extended or adjusted under 35  
U.S.C. 154(b) by 0 days.

3,150,592 A *	9/1964	Stec	417/322
3,754,154 A	8/1973	Massie	
4,365,942 A	12/1982	Schmidt	
4,585,397 A *	4/1986	Crawford et al.	417/63
4,726,741 A	2/1988	Cusack	
4,795,317 A	1/1989	Cusack	
4,804,314 A	2/1989	Cusack	
4,845,450 A	7/1989	Porzio et al.	
4,927,334 A	5/1990	Engdahl et al.	
5,129,789 A *	7/1992	Thornton et al.	417/53
5,203,172 A	4/1993	Simpson et al.	

(Continued)

This patent is subject to a terminal disclaimer.

**FOREIGN PATENT DOCUMENTS**

DE 40 32 555 A1 4/1992

(Continued)

(21) Appl. No.: **11/056,268**

(22) Filed: **Feb. 14, 2005**

(65) **Prior Publication Data**

US 2005/0147506 A1 Jul. 7, 2005

**Related U.S. Application Data**

(63) Continuation of application No. 10/034,054, filed on  
Dec. 27, 2001, now Pat. No. 6,884,040.

(51) **Int. Cl.**

**F04B 17/00** (2006.01)

(52) **U.S. Cl.** ..... 417/322; 417/418; 417/521

(58) **Field of Classification Search** ..... 417/322,  
417/521, 418, 417, 415

See application file for complete search history.

(56) **References Cited**

**U.S. PATENT DOCUMENTS**

2,690,126 A *	9/1954	Alexis	417/326
2,690,128 A	9/1954	Basilewsky	

**OTHER PUBLICATIONS**

PCT International Search Report—International Application  
No. PCT/CA02/01702—International Filing date: Jul. 11,  
2002—Applicant: Pratt & Whitney Canada Corp.

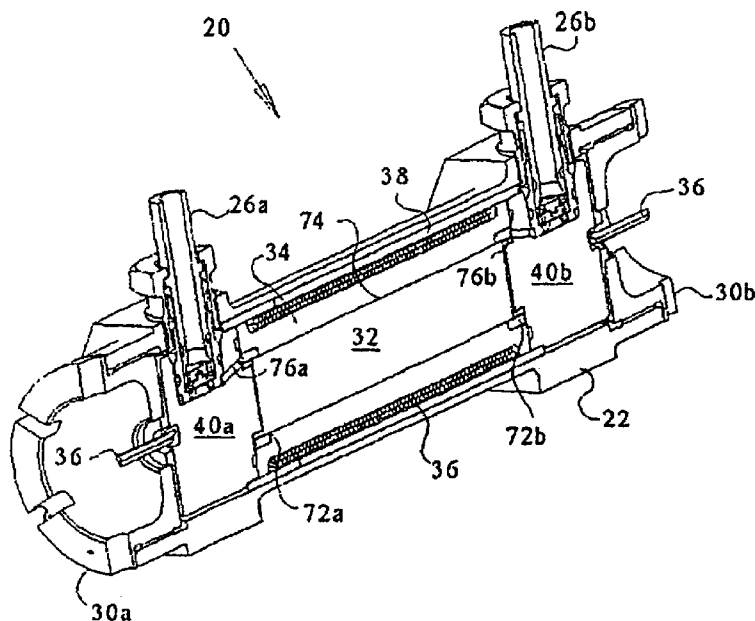
*Primary Examiner*—Charles G. Freay

(74) *Attorney, Agent, or Firm*—Ogilvy Renault LLP

(57) **ABSTRACT**

A positive displacement pump includes a magnetostrictive actuator. A single actuator drives multiple pumping chambers. The pump may include two pumping chambers driven in phase by the linear expansion of the actuator at both its ends. The pump may include a third pumping cavity, driven by the transverse expansion and contraction of the actuator, out of phase with either cavity driven by the lengthwise extension of the actuator. A pump assembly having multiple pumps each including a magnetostrictive element is also disclosed.

**8 Claims, 13 Drawing Sheets**



# US 7,040,873 B2

Page 2

## U.S. PATENT DOCUMENTS

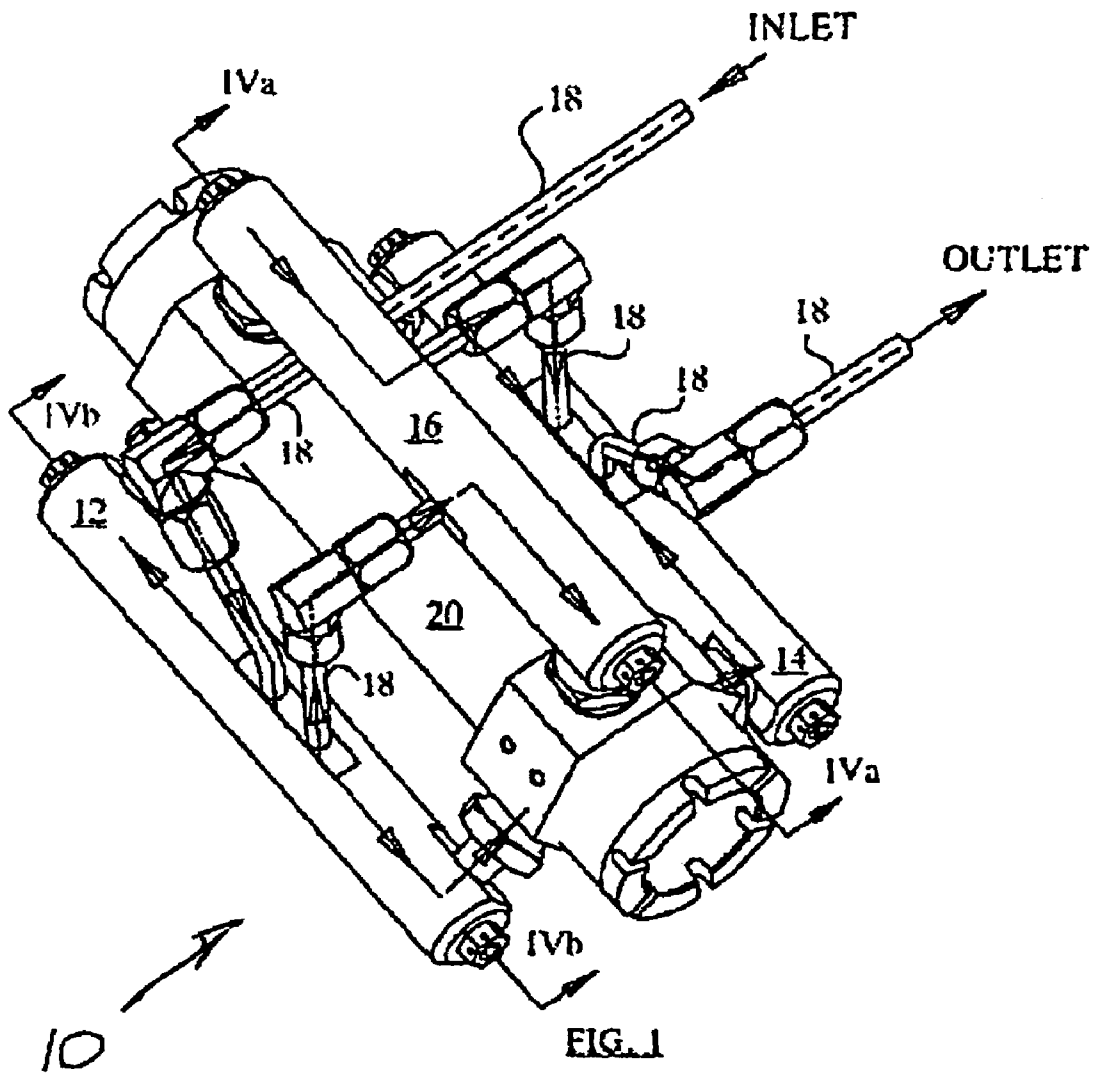
5,215,446 A	6/1993	Takahashi et al.
5,338,164 A	8/1994	Sutton et al.
5,501,425 A	3/1996	Reinicke et al.
5,558,504 A	9/1996	Stridsberg
5,630,709 A	5/1997	Bar-Cohen
5,641,270 A	6/1997	Sgourakes et al.
5,720,415 A	2/1998	Morningstar
5,798,600 A	8/1998	Sager et al.
6,026,847 A	2/2000	Reinicke et al.
6,059,546 A	5/2000	Brenan et al.

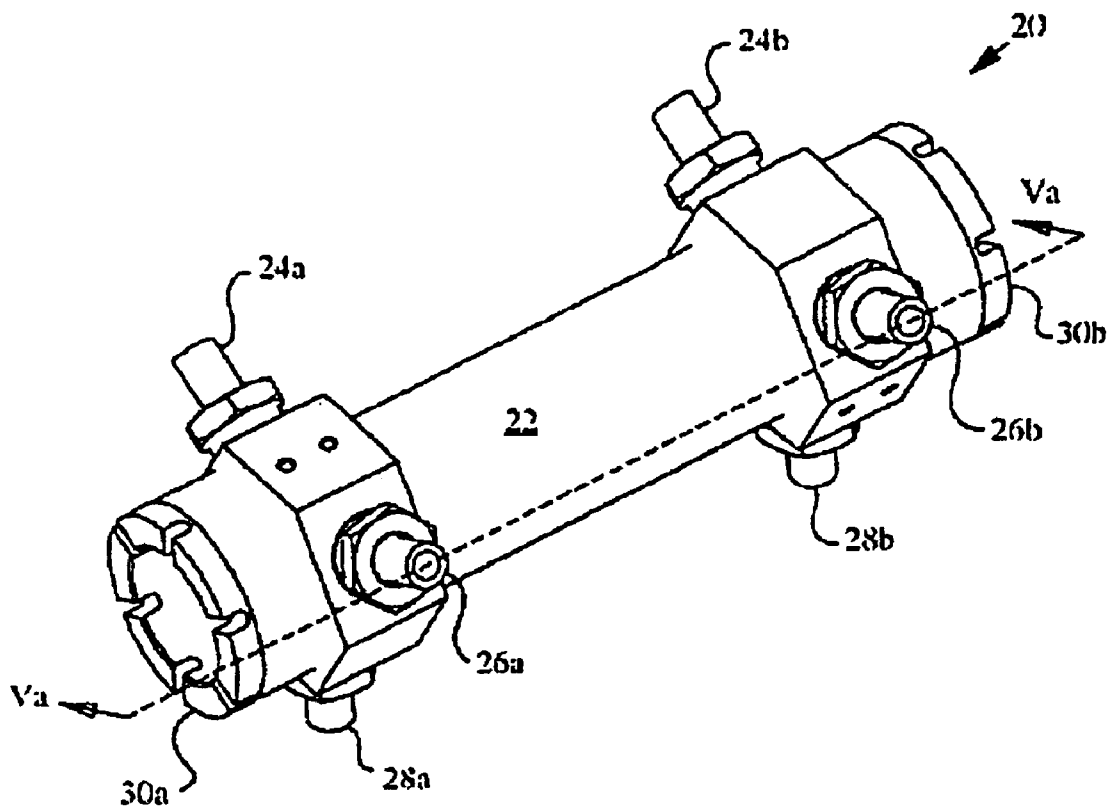
6,074,179 A	6/2000	Jokela et al.
6,170,921 B1	1/2001	Naerheim
6,884,040 B1 *	4/2005	Dooley ..... 417/53

## FOREIGN PATENT DOCUMENTS

DE	195 36 491 A1	4/1997
JP	6-101631	4/1994
JP	11 093830	4/1999
JP	11 182437	7/1999
JP	11-182437	* 7/1999

\* cited by examiner





**FIG. 2**

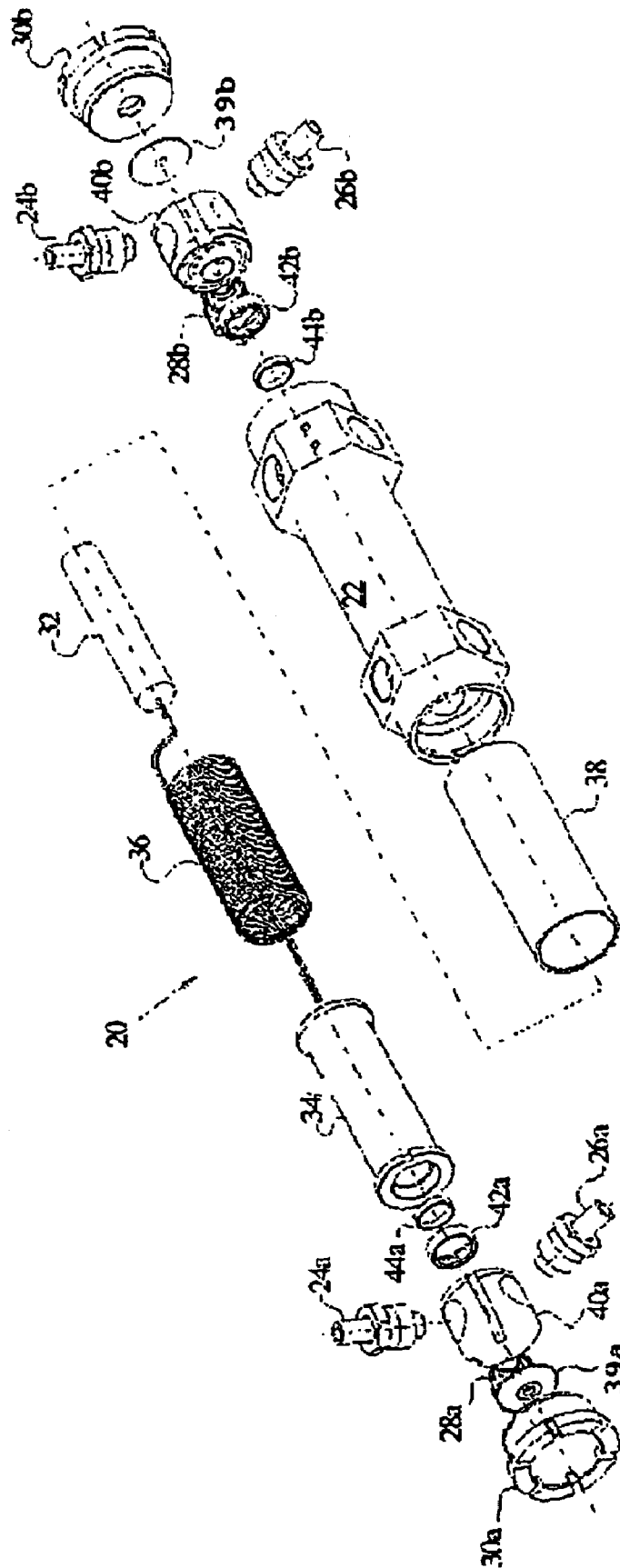


FIG. 3

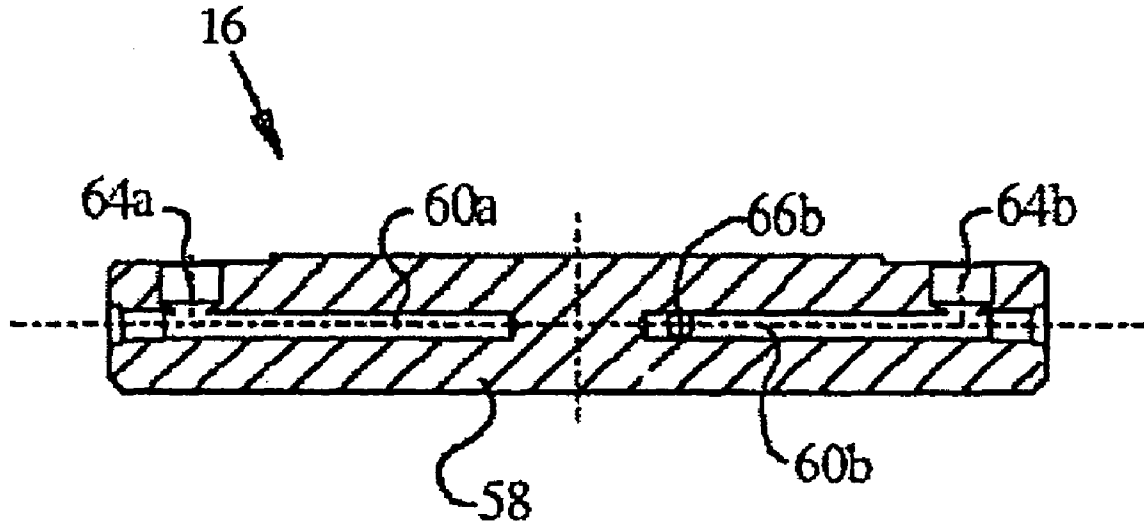


FIG.4A

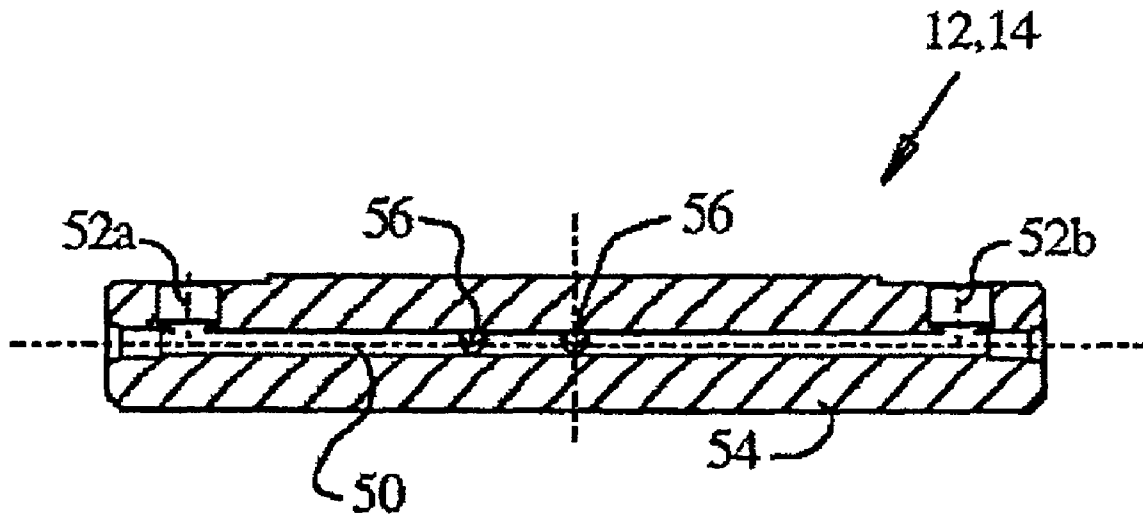


FIG.4B

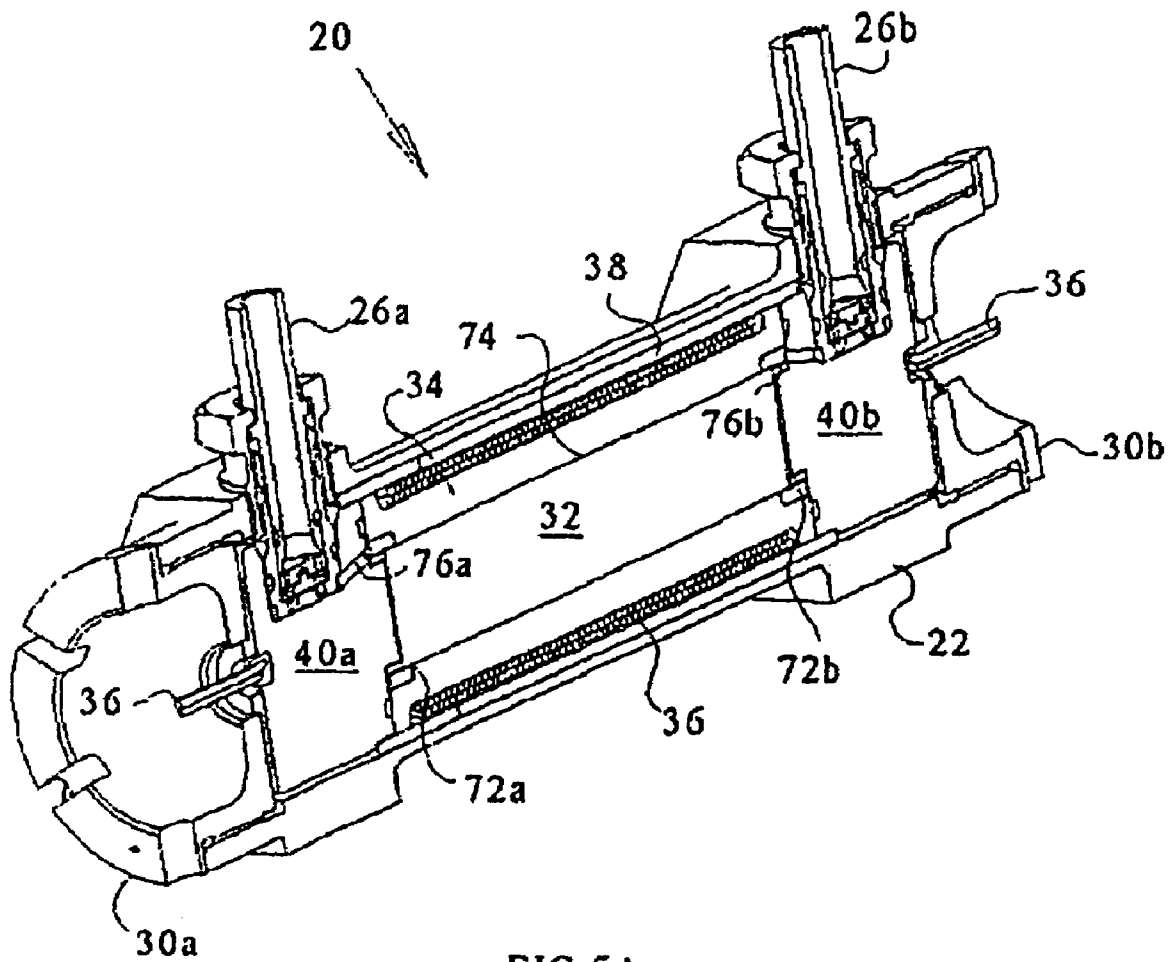


FIG. 5A

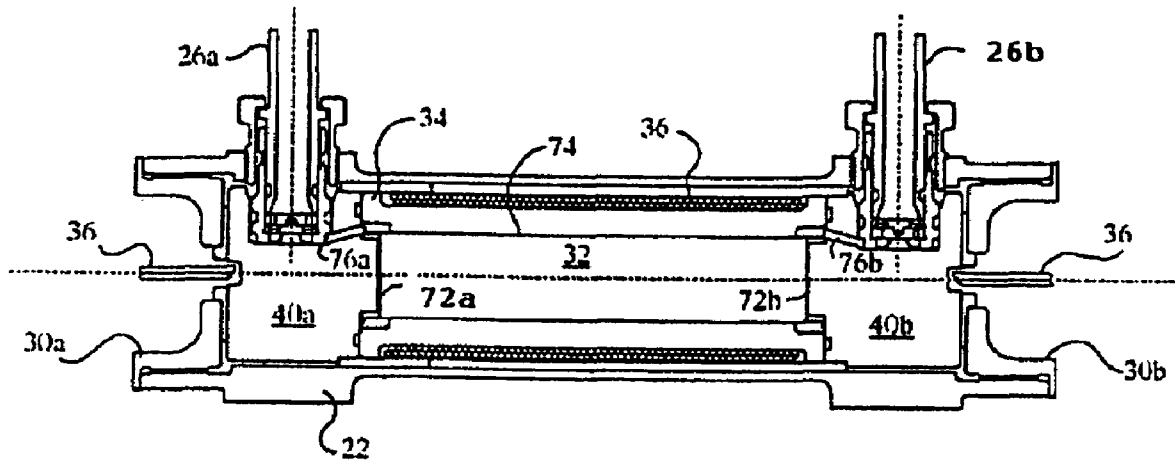
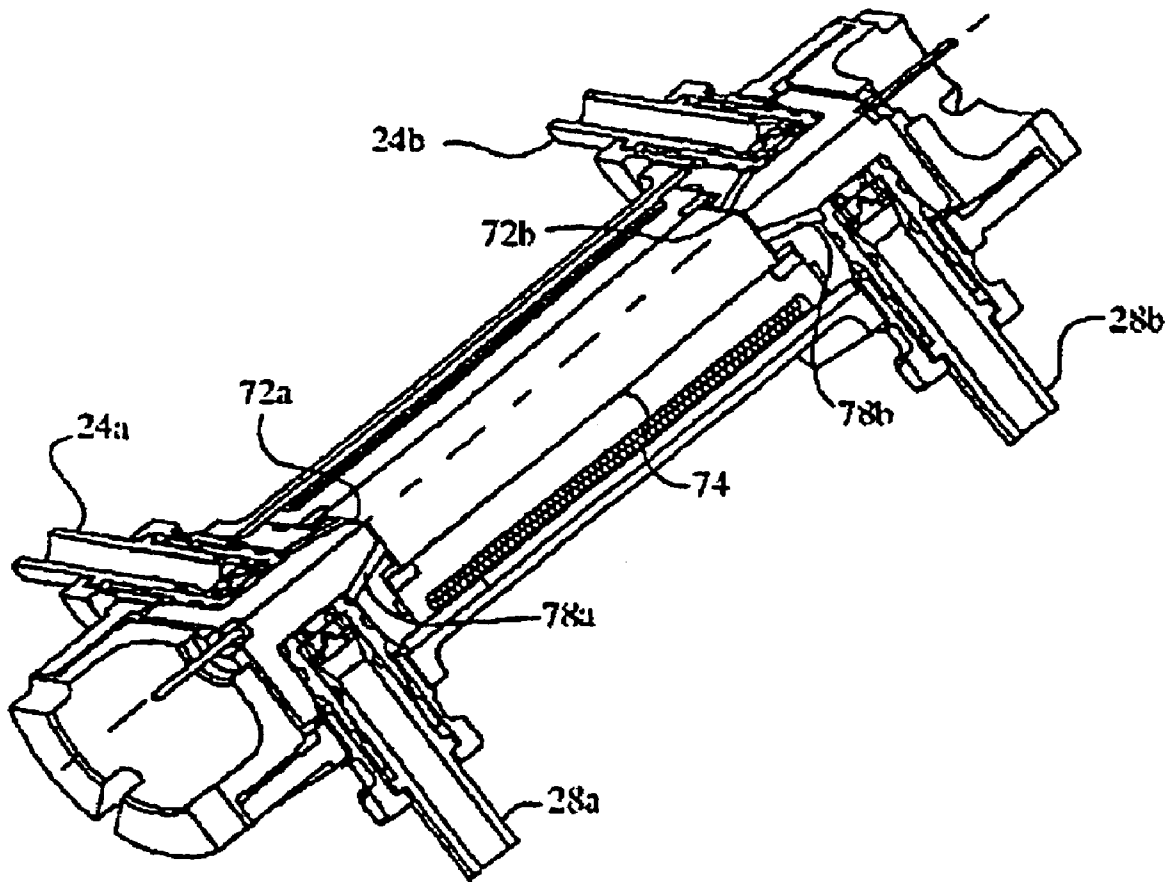
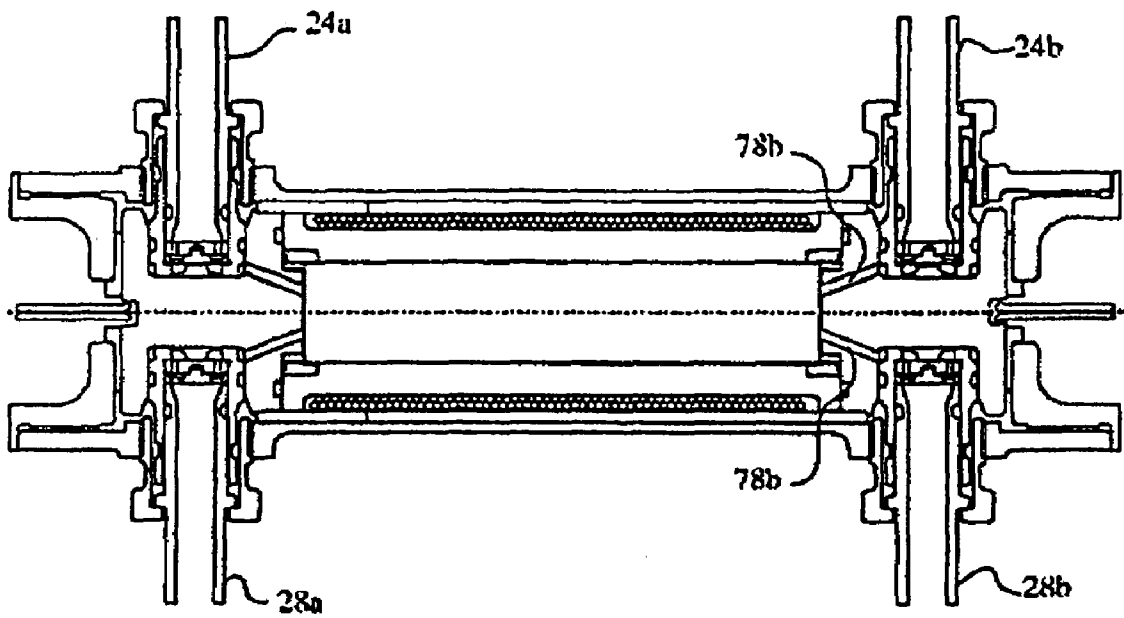


FIG. 5B





**FIG. 6A**



**FIG. 6B**

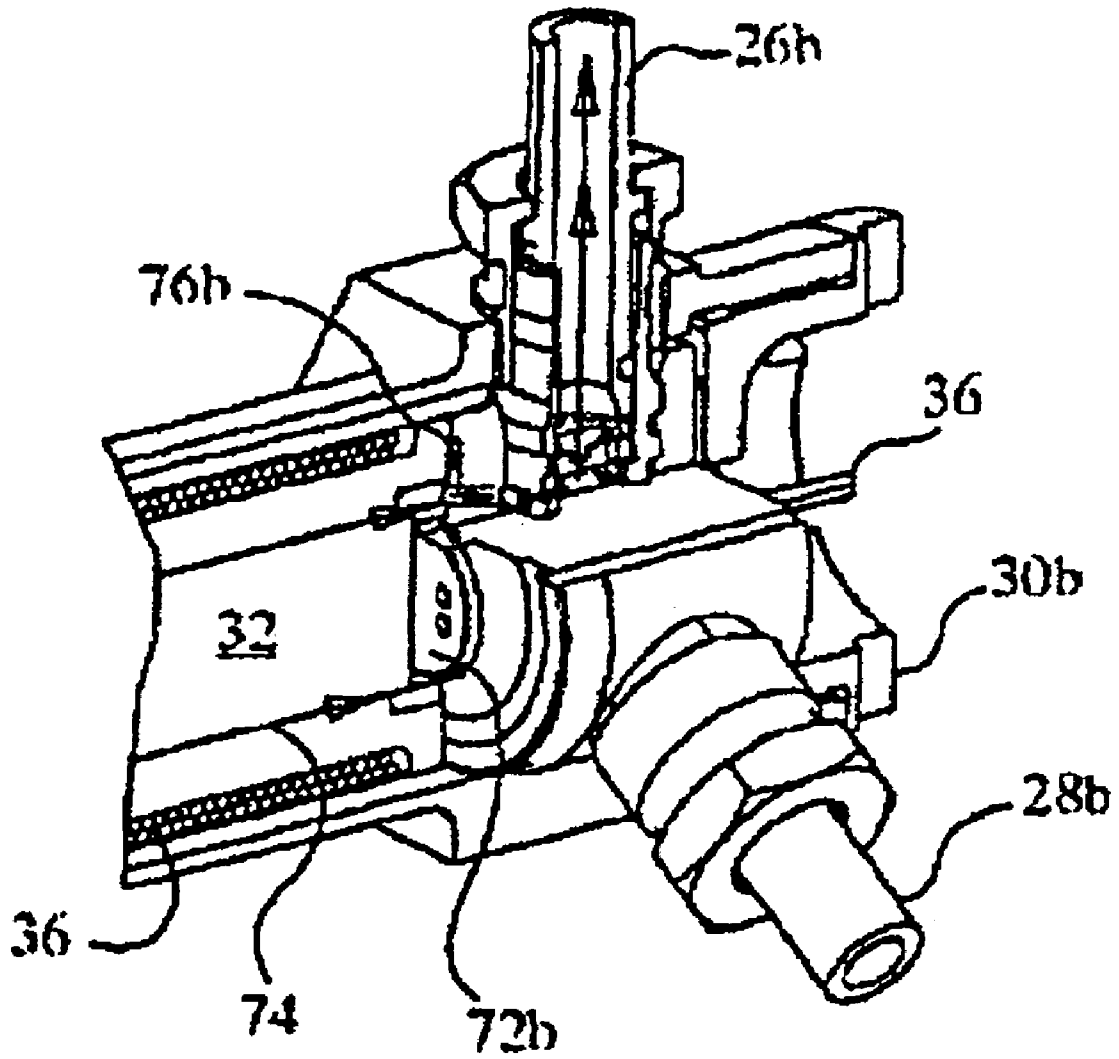
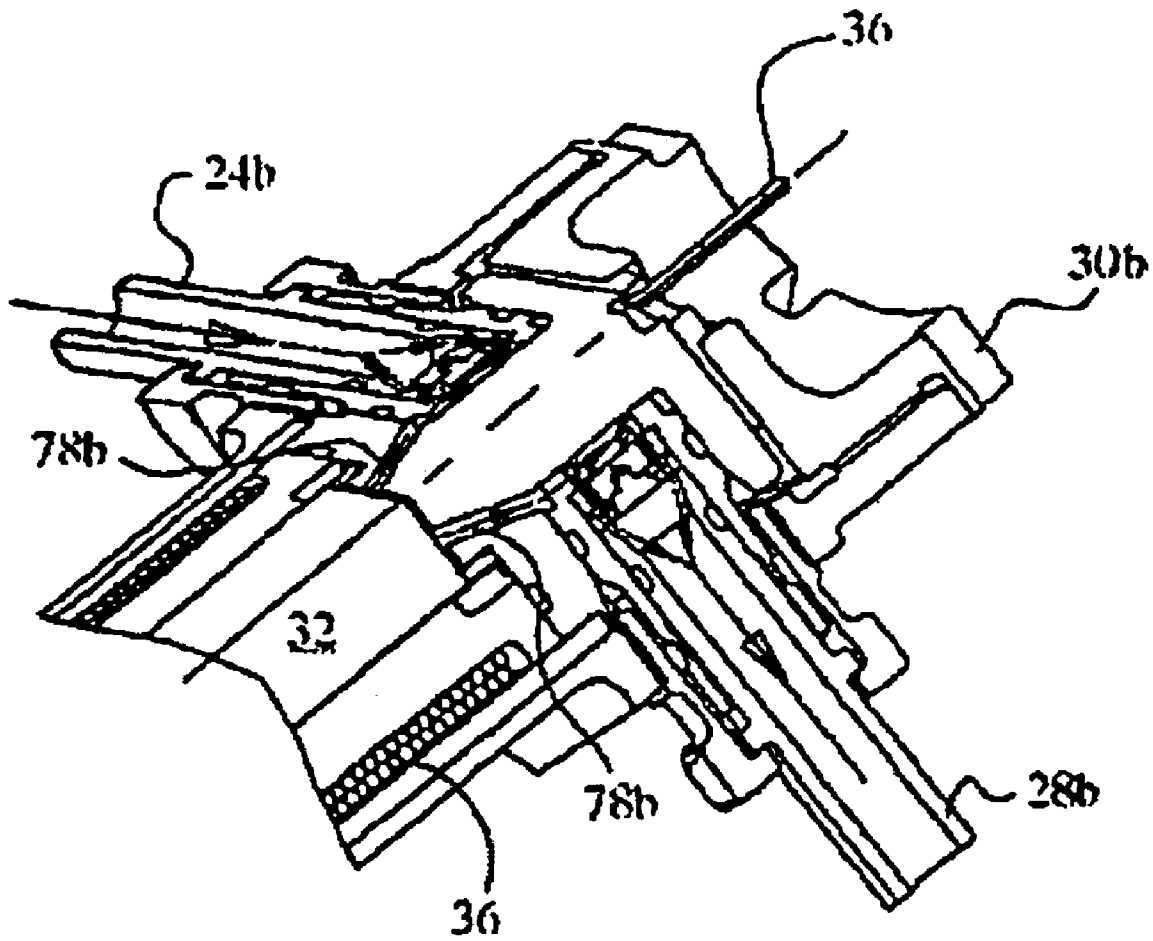


FIG. 7A



**FIG. 7B**

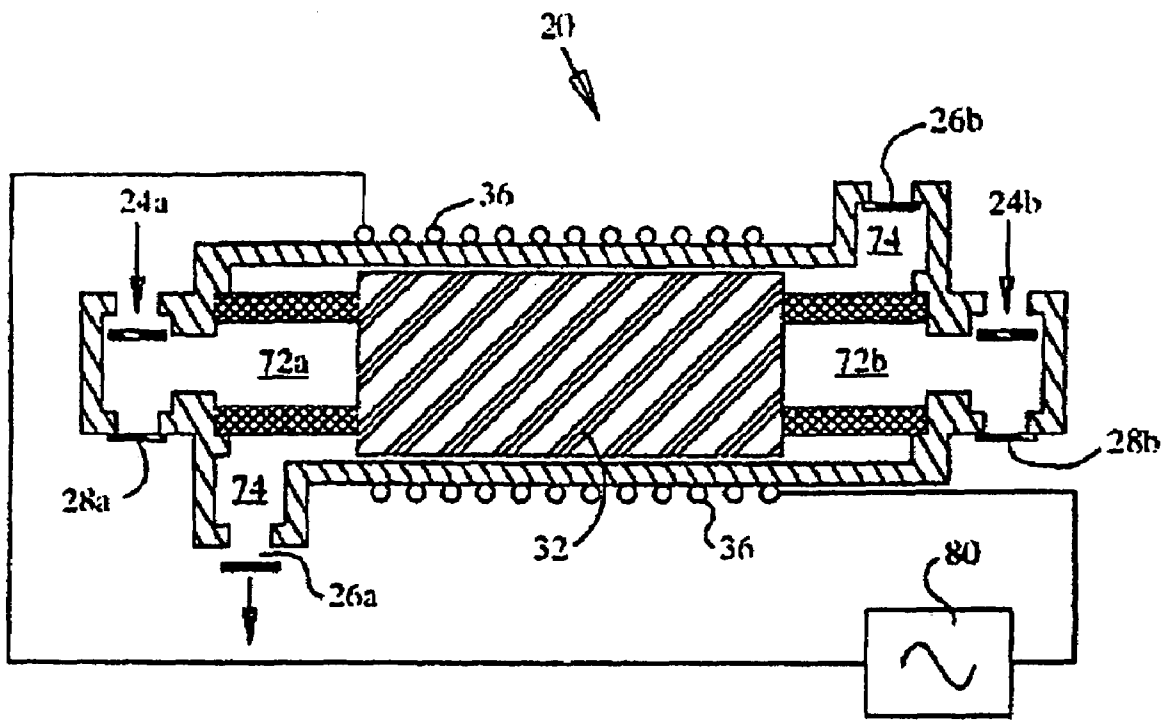


FIG. 8

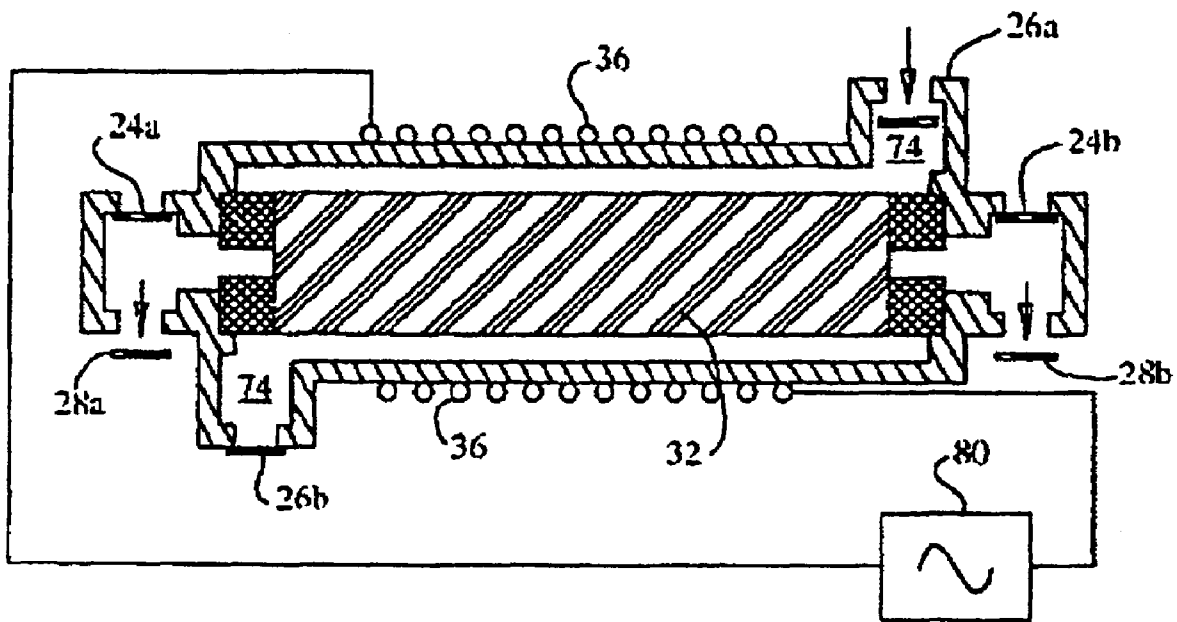


FIG.9

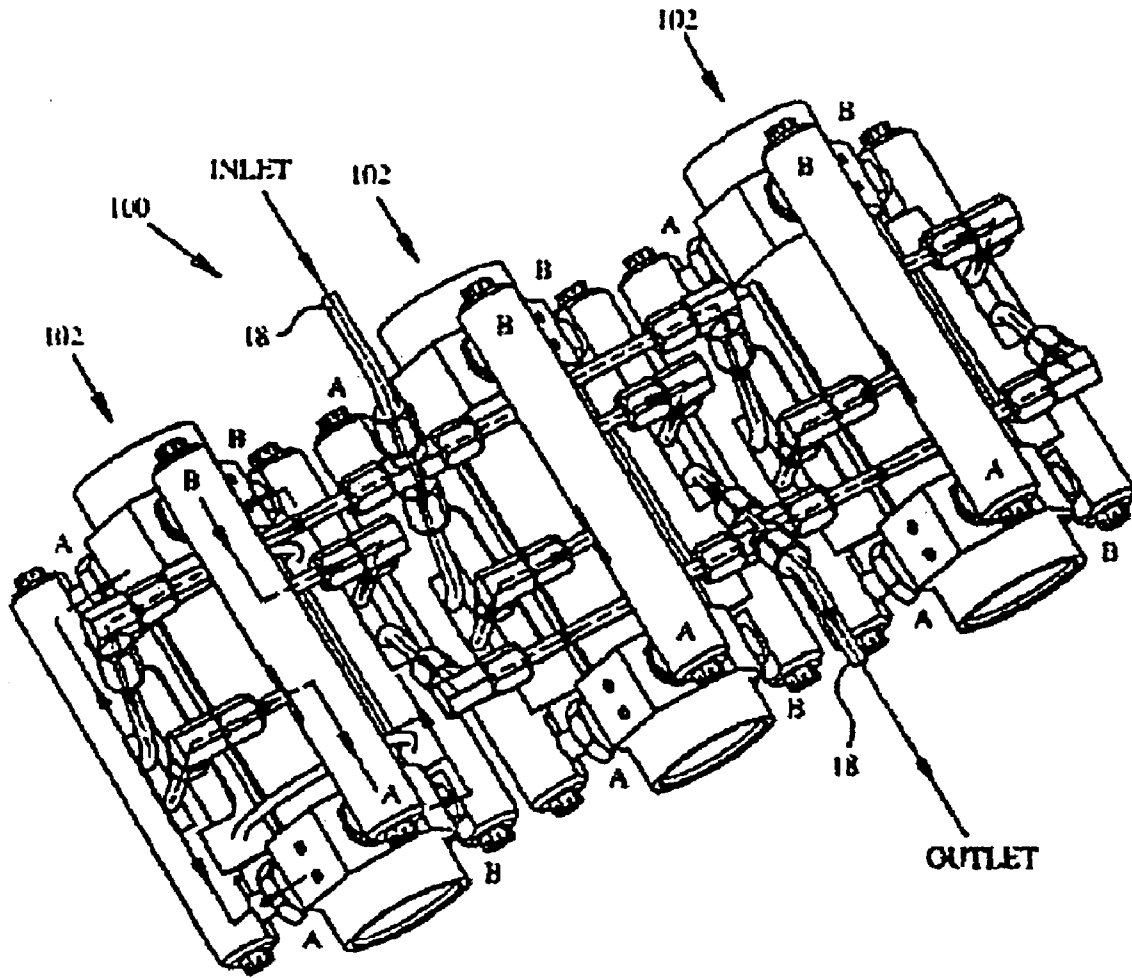


FIG. 10

1

**MULTI PUMPING CHAMBER  
MAGNETOSTRICTIVE PUMP**

## CROSS-RELATED APPLICATION

The present application is a continuation of U.S. patent application Ser. No. 10/034,054, filed Dec. 27, 2001, now U.S. Pat. No. 6,884,040, which is hereby incorporated by reference.

## FIELD OF THE INVENTION

The present invention relates generally to pumps, and more particularly to pumps making use of magnetostrictive actuators.

## BACKGROUND OF THE INVENTION

Conventional positive displacement pumps pump liquids in and out of a pumping chamber by changing the volume of the chamber. Many pumps are bulky with many moving parts, and are driven by a periodic mechanical source of power, such as a motor or engine. Often such pumps require mechanical linkages, including gearboxes, for interconnection to a suitable source of power.

Other types pumps, as for example disclosed in U.S. Pat. No. 5,641,270; and German Patent Publication No. DE 4032555A1 use an actuator made of a magnetostrictive material. As will be appreciated, magnetostrictive material change dimensions in the presence of a magnetic field. Numerous magnetostrictive materials are known. For example, European Patent Application No. 923009280 discloses many such materials. A commercially available magnetostrictive material is sold in association with the trademark TERFENOL-D by Etrema Corporation, of Ames, Iowa.

These magnetostrictive pumps rely on the expansion and contraction of a magnetostrictive element to compress a pumping chamber. Known magnetostrictive pumps however compress a single pumping chamber. As such, these pumps produce a single pumping compression stroke for each cycle of contraction and expansion of the magnetostrictive material. This, in turn, may result in significant pressure fluctuations in the pumped fluid. The flow rate is similarly limited to the displacement of the single-pumping chamber. Moreover, pumps with a single actuator may be mechanically imbalanced and thereby prone to mechanical noise and vibration as the single actuator expands and contracts.

In certain applications, constant pressures and high flow rates per unit weight of a pump are critical. For instance, in fuel delivery systems in aircrafts, pump designs strive to achieve low pump weight to fuel delivery ratios, while still providing for smooth fuel delivery.

Accordingly, an improved magnetostrictive pump facilitating high flow rates, and smooth fluid delivery would be desirable.

## SUMMARY OF THE INVENTION

In accordance with the present invention, a pump includes a magnetostrictive element, and multiple pumping chambers all driven by this magnetostrictive element. The pumping chambers may pump fluid in or out of phase with each other.

Conveniently, a pump having multiple pumping chambers may provide for smoother fluid flow, less pump vibration, and increased flow rates.

2

In accordance with one aspect of the present invention, a pump includes a housing defining a cylindrical cavity; a cylindrical actuator formed of magnetostrictive material, within the housing and coaxial therewith; first and second pumping chambers within the housing at opposite ends of a lengthwise extent of the magnetostrictive element. Each of the pumping chambers is mechanically coupled to the actuator, to compress as the actuator extends in length.

Other aspects and features of the present invention will become apparent to those of ordinary skill in the art upon review of the following description of specific embodiments of the invention in conjunction with the accompanying figures.

## BRIEF DESCRIPTION OF THE DRAWINGS

In the figures which illustrate by way of example only, embodiments of this invention:

FIG. 1 is a left perspective view of a pump exemplary of an embodiment of the present invention;

FIG. 2 is a right perspective view of a pump body of the pump of FIG. 1;

FIG. 3 is an exploded view of the pump body of FIG. 2;

FIG. 4A is a cross sectional view of a component of the pump of FIG. 1 taken across lines IVa—IVa;

FIG. 4B is a cross sectional of a further component of the pump of FIG. 1 taken across lines IVb—IVb;

FIG. 5A is a right perspective cut away view of the pump body of FIG. 2 along lines V—V;

FIG. 5B is a right elevational view of FIG. 5A;

FIG. 6A is a further right perspective cut away view of the pumping body of FIG. 2;

FIG. 6B is a top plan view of FIG. 6A;

FIGS. 7A and 7B are enlarged sectional views of a portion of the pump body of FIG. 2;

FIGS. 8 and 9 are schematic diagrams illustrating the pump of FIG. 1 in operation; and

FIG. 10 illustrates a multi pump assembly exemplary of another embodiment of the present invention.

## DETAILED DESCRIPTION

FIG. 1 illustrates a pump 10 exemplary of an embodiment of the present invention. Pump 10 is well suited to pump fluids at high flow rates and high pressures. Pump 10 includes few moving parts and is relatively lightweight. It is well suited for use in fuel delivery systems and in particular for use in aircraft engines.

As illustrated pump 10 includes a single inlet and outlet. As will become apparent, pump 10 includes three individual pumping chambers housed with a pump body 20. An input manifold 12 distributes a single input to the three chambers. An output manifold 14 combines outputs of the three chambers. A cylindrical connecting pipe 16 interconnects pumping chambers. Pipes 18 interconnect pipe chambers to manifolds 12 and 14, and connecting pipe 16 for fluid coupling as illustrated by the arrows in FIG. 1.

The exterior of pump body 20 is more particularly illustrated in FIG. 2. As illustrated pump body 20 includes an outer housing 22 that is generally cylindrical in shape. At its ends housing 22 is capped by threaded clamps 30a and 30b. Three one way flow valves 24a, 26a, 28a near one end of body 20, and three further one way flow valves 24b, 26b, 28b provide flow communication to three separate pumping chambers within pump body 20. As illustrated, in the exemplary embodiment three valves 24a, 26a, and 28a are spaced at 120.degree. about the periphery of housing 22, and



extend in a generally radial direction from the center axis of housing 22. Valves 24b, 26b and 28b are similarly situated near the opposite end of housing 22.

FIG. 3 is an exploded view of pump body 20, illustrating its assembly. FIGS. 5A, 5B and 6B are sectional views further illustrating this assembly. As illustrated, pump body 20 includes a lengthwise extending actuator 32. Preferably actuator 32 is cylindrical in shape. A multi-turn conducting coil 36 surrounds actuator 32 exterior to ceramic sheath 34. Radially exterior to coil 36 is a further cylindrical sheath 38. Exterior to sheath 34 is outer housing 22. Actuator 32, ceramic sheath 34, coil 36, sheath 38 and outer housing 22 are coaxial with a central axis of pump body 20.

Sheath 38 is preferably formed of a low conductivity soft magnetic material. It may for example be made of ferrite or from laminated or thin film rolled magnetic steel. In the exemplary embodiment, sheath 38 is made from a material made available in association with the trademark SM2 by MII Technologies. Valve seats 40a and 40b are similarly preferably formed of a magnetic material.

Sheath 38 and valve seats 40a and 40b are preferably formed of a magnetic material, as these at least partially define a magnetic circuit about actuator 32. The choice of materials affects magnetic losses (such as hysteresis and eddy-current losses) in these components.

Housing 22 is preferably made from a non-magnetic metal such as aluminum, stainless steel, or from a ceramic.

In the example embodiment, coil 36 is formed from about sixty two (62) turns of 15 awg wire. Of course, the number of turns and gauge of coil 36 is governed by its operating voltage, frequency and magnetic requirements (current).

As best illustrated in FIGS. 5A and 5B, actuator 32 is held in its axial position within outer housing 22 at its one end as a result of threaded clamp 30a providing an inward axial load on actuator 32 by way of a spacer 39a, valve housing 40a and spacer rings 42a and 44a. At its other end, actuator 32 is held in its axial position as a result of threaded clamp 30b providing an inward axial load on actuator 32 by way of a spacer 39b, valve housing 40b and spacer rings 42b and 44b. Spacers 39a and 39b are generally disk shaped washers formed of a somewhat resilient material, such as a polymer sold in association with the trademark VESPEL Retaining rings 42a and 44a (and 42b and 44b) are annular nested rings with ring 42a having a smaller diameter than ring 44a. The outer diameter of ring 42a is about equal to the diameter of actuator 32. Rings 42a, 42b, 44a, and 44b, too, are preferably formed of the polymer sold in association with the trademark VESPEL.

The spacer rings 44a and 44b serve three functions. First, spacer rings 44a and 44b act as load springs to provide an axial pre-load to actuator 32. Second, they form a seal at each end of the spacer 44a and 44b. Thirdly, they partially define pumping chambers 72a and 72b, as detailed below.

Spacer rings 42a and 42b similarly serve three functions. First, they provide radial support to actuator 32 to center it coaxial with cylinder 34. Secondly, rings 42a and 42b seal an annular compression chamber 74, at valve seats 40a and 40b and sheath 34. Thirdly, an annular manifold for the annular chamber is formed by the space between the rings 42a and 44b (and rings 42b and 44b).

The thickness of spacers 39a and 39b are chosen so that when the clamps 30a and 30b provide the required axial load on actuator 32 as clamps 30a and 30b are tightened completely to their mechanical stop. Essentially they are also used as springs. Conveniently spacers 39a and 39b also

provide an insulated hole through which leads to coil 36 may be passed. Spacers 39a and 39b could of course, be replaced by a suitable washer.

Valve housings 40a and 40b seat valves 24a, 26a, 28a and 24b, 26b, 28b and provide flow communication between these valves and pumping chambers, as described below.

In the described embodiment of pump 10, actuator 32 has about a 0.787" diameter and a 4.00" length. Sheath 38 has 1.740" outside diameter, and a 1.560" inside diameter. Housing 22 has a total length of about 8.470". Sheath 34 has an inner diameter of about 0.797" and is about 4.350" length.

Valves 24a 24b, 26a, 26b, 28a and 28b are conventional high speed check valves preventing flow into associated pumping chambers, capable of operating at about 2.5 KHz. These valves may, for example, be conventional Reed valves. The pressure drop required to open valves 24a 24b, 26a, 26b, 28a and 28b is preferably less than one (1) psi and the withstanding pressure (in the opposite direction) is over 2000 psi.

Exemplary manifolds 12 and 14 (FIG. 1) are identical in structure illustrated in cross-section in FIG. 4B. Manifold 12 acts as an intake manifold and is thus interconnected with inlet valves 24a and 28a. Manifold 14 acts as an output manifold, and is thus interconnected to outlet valves 24b and 28b. As illustrated in FIG. 4B, manifolds 12 and 14 each include an axial passageway 50 connecting two openings 52a and 52b in a cylindrical body 54, near its ends. Passageway 50 provides flow communication between these openings 52a, 52b. Openings 52a and 52b are spaced for interconnection between valves 24a and 24b or valves 28a and 28b (FIG. 1). Additional openings 56 permit interconnection of pipes 18 to passageway 50. Preferably, manifolds 12 and 14 are machined from a hard material such as metal (e.g. stainless steel, brass, copper, etc.).

Exemplary pipe 16 is similarly illustrated in cross section in FIG. 4A. As illustrated, pipe 16, includes two axial passageways 60a and 60b within an outer, generally cylindrical body 58. Each passageway interconnects and opening 64a or 64b for interconnection with valves 26a and 26b (FIG. 1). Two additional openings 66 (only one shown) are spaced 90. degree. from each other about the central axis of cylindrical body 58. Openings 66 allow interconnection of pipes 18 (FIG. 1) for flow communication with one of passageways 60a and 60b. Pipe 16 may be machined in a manner, and from a material similar to manifolds 12 and 14.

Pumping chambers within pumping body 20 are more particularly illustrated in FIGS. 5A, 5B, 6A and 6B. FIGS. 5A and 6A are sectional views of pump body 20, illustrating its three pumping chambers 72a, 72b and 74. FIG. 5B is a right elevational view of FIG. 5A (and therefore a cross-sectional view of pump body 20). FIG. 6B is a top plan view of FIG. 6A. As illustrated, two end pumping chambers 72a and 72b are generally cylindrical in shape, and are located at distal ends of the lengthwise extent of actuator 32. Preferably, they are located directly between valve housing 40a and actuator 32, and valve housing 40b and actuator 32, respectively. They are defined in part by opposite flat ends of actuator 32 and flat ends of valve housing 40a and 40b. A further axial pumping chamber 74 is located between the exterior round surface of actuator 32, and an interior cylindrical surface of sheath 34. Axial pumping chamber 74 extends axially along the length of actuator 32, and is sealed at its ends by rings 42a and 42b.

As illustrated in FIGS. 5A and 5B, axial pumping chamber 74 is in flow communication with valves 26a and 26b, by way of passageways 76a and 76b formed in valve

housings **40a** and **40b**. Valve housing **40b** is identical to housing **40a** and is illustrated more particularly in FIG. **7A**. As illustrated an annulus between rings **42b** and **44b** isolates end chamber **72b** from axial chamber **74** and further provides flow communication from chamber **74** through passageway **76b** to valve **26b**. As will become apparent, fluid may thus be pumped from valve **26a** through chamber **74** and out of valve **26b**.

Cylindrical chamber **72b** is in flow communication with valves **24b** and **28b**, by way of passageways **78b** formed within valve housing **40b**. As such, valve **24b** and valve **28b** act as inlet and outlet valves for end pumping chamber **72b**. Valves **24a** and **28a** similarly serve as inlet and outlet valves, respectively, for pumping chamber **72a**, as illustrated in FIGS. **6A** and **6B**.

Actuator **32** is preferably a cylindrical rod, formed of a conventional magnetostrictive material such as TERFENOL-D (an alloy containing iron and the rare earth metals terbium and dysprosium). As understood by those of ordinary skill, magnetostrictive materials change shape in the presence of a magnetic field, while, for all practical purposes, retaining their volume. Actuator **32**, in particular, expands and contracts in a direction along its length and radius in the presence and absence of a magnetic field.

Rings **38** loaded by the force of threaded clamps **30a** and **30b** compress actuator **32** so that in the absence of a magnetic field, actuator **32** is contracted lengthwise. In the presence of a magnetic field actuator **32** lengthens in an axial direction, against the force exerted by rings **38**. All the while the volume of actuator **32** remains constant. As such, an axial lengthening is accompanied by a radial contraction of actuator **32**.

The expansion of actuator **32** in the presents of a magnetic field is a complex function of load, magnetic field and temperature but may be linear over a limited range. The expansion of the magnetostrictive material TERFENOL-D is in the range of 1200 to 1400 parts per million under proper load conditions and optimum magnetic field change. Example actuator **32**, which is about 4" long, will expand about 0.0056" along its length while contracting in diameter about 0.00055" (static diameter is 0.787" ).

Operation of pump **10** may better be appreciated with reference to the schematic illustration of pump body **20** depicted in FIGS. **8** to **9**. In operation, a source of alternating current (AC) source of electric energy **80** is applied to lead of coil **36**. The frequency for example of the applied current could in this case be 1.25 KHz resulting in this arrangement of a lengthwise contraction expansion frequency of 2.5 KHz (the rod will expand with either polarity of applied magnetic field). Coil **36**, in turn, generates an alternating magnetic field with flux lines along the axis of actuator **32**. Sheath **38** forms a magnetic guide causing flux generated by coil **36** to be directed into and out of the ends of the rod, through valve seats **40a** and **40b**.

Conveniently, eddy current losses kept at a minimum in housing **22** and the valve seats **40a** and **40b**.

A fluid to be pumped is provided by way of the inlet of pump **10** (FIG. **1**), pipes **16**, and **18**, and inlet manifold **12**. Sheath **38** (FIG. **4**) electrically insulates pump **10**, so that current carried by coil **36** does not create substantial electromagnetic interference beyond housing **22**.

As a result of the varying magnetic field generated by coil **36** and source **80**, the shape of actuator **32** oscillates between a first state as illustrated in FIG. **8**, and a second state as illustrated in FIG. **9**. Transitions between these two states, in

turn, cause changes in volume of pumping chambers **72a**, **72b** and **74**, allowing these to act as positive displacement pumps.

As sheath **34** is made of a hard material such as ceramic, a radial expansion of actuator **38** and resulting displacement of the fluid within cavity **74** is resisted by sheath **34**.

Specifically, as illustrated in exaggeration in FIG. **8**, in a first state, actuator **32** has a minimum length and a maximum diameter. Chambers **72a** and **72b**, in turn, have increased volumes, resulting in reduced pressures therein, allowing passage of liquid through valves **24a** and **24b**, and preventing flow of liquid through valves **28a** and **28b**. Liquid may thus be drawn into chambers **72a** and **72b**. At the same time, the volume of chamber **74** is reduced, and liquid therein is displaced by actuator **32**. One-way valve **26a** remains closed, while valve **26b** is opened, allowing fluid to be expelled from axial chamber **74**.

As current flow of the source **80** varies, actuator **32** begins to expand axially and contract radially. One quarter period of oscillation of the electric source later, actuator **32** is in a second state, as illustrated in exaggeration in FIG. **9**. In this state, actuator **32** has maximum length, and minimum diameter. As the length of actuator **32** increased it, in turn, displaces fluid in chambers **72a** and **72b**, increasing the pressure therein. At the same time, the volume of chamber **74** increases as a result of the radial contraction of actuator **32**. The pressure in chamber **74**, in turn, decreases. Valves **24a** and **24b** are closed, and valves **28a** and **28b** are open, allowing liquid to be expelled from chambers **72a** and **72b** through valves **28a** and **28b**. Similarly, valve **26a** is opened and valve **26b** is closed. Effectively, the pumping cycles of chamber **72a** and **72b** are in phase with each other, and 180.degree. out of phase with chamber **74**.

For example pump **10**, the total change (i.e. between minimum and maximum diameters of actuator **32**) in the volume of axial pumping chamber **74** is 0.02724 cubic inches. As the annular chamber **74** expands and contracts twice in each cycle twice this volume could be displaced if there is little or no leakage and little or no compression of the working fluid. Thus, the displacement volume of chamber **74** is 0.00274 cubic inches per cycle of the actuator. Combining the displacement of chamber **74** with chambers **72a** and **72b** results in a total pump displacement of 0.0054 cubic inches per cycle of actuator **32**. Thus at an excitation frequency (in the coil) of 1.25 KHz (corresponding to an actuator cycle frequency of 2.5 KHz) results in displacement of 2.5 KHz\*0.0054 cu in =13.62 cubic inches per second or about 0.223 L/s. Thus, chambers **72a**, **72b** and **74** may produce a combined flow of up to about 1300 liters per hour at up to 4000 psi.

The pressure delivery of the pump depends on the compressibility of the pumped fluid as the cycle to cycle displacement is relatively small. However the pressure available from the TERFENOL-D is in excess of 8000 psi. Although impractical, if the fluid were not compressible the above noted flow rate previously calculated at 8000 psi might be realizable under ideal non leakage conditions. A practical result is expected to be up to 4000 psi at flow rates of up to 0.12 L/s for a single pump chamber.

Conveniently, pipes **16** and **18**, and outlet manifold **14** join the output of pumping chambers **72a**, **72b** and **74** allowing these to act in tandem. Advantageously, as chambers **72a** and **72b** are 180.degree. out of phase with pumping chamber **74**, interconnection of the three chamber provides a smooth pumping action, with two compression cycles for every cycle of actuator **32**. Additionally, location of pumping chambers around the entire outer surface of actuator **32**

allows forces within pump **10** to be balanced, reducing overall vibration of pump **10**, during operation. Specifically, as the pressure of pumped fluid is equal all round actuator **32**, net side forces are eliminated as a result and lateral vibration of the actuator **32** is reduced. The forces on actuator **32** due to pressure in the axial direction are balanced because the pressures from which the axial cavities are charged and discharged are the same because they are connected together and the end cavities are in phase.

More significantly, however, are the vibrational forces. If actuator **32** were fixed at one end, the acceleration forces related to the vibration of the actuator are reacted at the one end resulting in inertially related vibrations. In pump **10** two opposite ends of the actuator **32** accelerate in equal and opposite directions resulting in equal and opposite inertial forces which cancel. This results in a balanced system resulting in significantly less vibration and noise than could be obtained in conventional imbalanced arrangements.

FIG. **10** further illustrates a multi-pump, pump assembly **100** including a plurality (three are illustrated) of pumps **102**, each substantially identical to pump **10** (FIG. **1**). As illustrated, pipes **18** interconnect pumps **102**. Inputs and outputs of pumps **102** are connected in parallel. Pump assembly **100** may be beneficial if higher flow rates are required.

Conveniently, each pump of the pump assembly **100** may be driven out of phase from the remaining pumps. For example, for a three pump assembly, each pump **102** may be driven from one phase of a three phase power source (not shown), so that each pump **102** further smoothing any pressure fluctuations in output of any pump **102**. Additionally this arrangement allows for redundancy as is often required for high reliability systems. Failure of one of the pumps **102** or one of the electrical phases would not cause total loss of flow.

Pump assembly **100** could similarly be arranged with inputs and outputs of pumps **102** interconnected in series. In this way, each pump **102** would incrementally increase pressure of a pumped fluid.

As should now be appreciated, the above described embodiments may be modified in many ways without departing from the present invention.

For example a pump and pump assembly could be machined and manufactured in many ways. One or more pumps may be cast in a body that does not have an outer cylindrical shape. Fluid conduit from and between pumps could be formed integrally in the cast body. Valves need not be arranged radially at 120° about an axis of an actuator, but could instead be arranged in along one or more axis of a body defining the pump.

An exemplary pump having only two pumping chambers will provide many of the above described benefits. For example, a pump having only two in-phase chambers (like end chambers **72a**, **72b**) driven by a single actuator may provide a balanced pump, with relatively few moving parts having only a single pumping stroke for a cycle of an actuator. Similarly, a pump having two chambers driven by a single actuator, with each of the pump chambers 180° out of phase with the other may provide relatively smooth

pumping action. Of course, a pump having more than three chambers could be similarly formed.

Of course, a pump embodying the present invention may be formed with many configurations, in arbitrary shapes. For example, the pump assembly, housing and actuator need not be cylindrical. Similarly, pumping chambers need not be directly defined by a magnetostrictive element. Instead, an actuator may be mechanically coupled to the pumping chambers in any number of known ways. For example, the pumping chamber could be formed of a bellows driven a magnetostrictive actuator.

All documents referred to herein, are hereby incorporated by reference herein for all purposes.

Of course, the above described embodiments, are intended to be illustrative only and in no way limiting. The described embodiments of carrying out the invention, are susceptible to many modifications of form, arrangement of parts, details and order of operation. The invention, rather, is intended to encompass all such modification within its scope, as defined by the claims.

What is claimed is:

1. A pump comprising: a housing defining a cylindrical cavity; a cylindrical actuator formed of magnetostrictive material disposed within said housing and coaxial therewith; first and second pumping chambers within said housing at opposite ends of a lengthwise extent of said magnetostrictive actuator, said pumping chambers being mechanically coupled to said actuator to compress in equal and opposite directions as said actuator extends in length.

2. The pump of claim 1, wherein fluid in each of said first and second pumping chambers is displaced by a lengthwise extension of said actuator.

3. The pump of claim 2, further comprising a third chamber extending axially along a length of said actuator, fluid in said third chamber displaced by a radial expansion of said actuator.

4. The pump of claim 3, wherein inlets of said first, second, and third pumping chambers are fluidly coupled.

5. The pump of claim 4, wherein outlets of said first, second, and third pumping chambers are fluidly coupled.

6. The pump of claim 1, wherein said actuator has first and second ends, said first and second ends respectively providing a portion of said first and second pumping chambers, the first and second ends having substantially the same diameter.

7. A pump comprising a housing enclosing first and second pumping chambers and a magnetostrictive actuator, the actuator having first and second ends separated by a length of said actuator, the actuator extending between said first and second pumping chambers, said first and second ends respectively providing a portion of said first and second pumping chambers, said first and second pumping chambers compressing when the actuator increases in length, the first and second ends having substantially the same area.

8. The pump of claim 7, further comprising a third chamber extending between the housing and actuator along a length of said actuator, said third chamber compressing when the actuator increases in width.

\* \* \* \* \*