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### PANEL ASSEMBLY, REFRIGERATOR, AND HOME APPLIANCES

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#### Abstract

A home appliance includes a refrigerator including a panel assembly. The panel assembly includes: a first panel formed of a glass material; a second panel spaced apart from the first panel and formed of a glass material; a plurality of spacers provided between the first panel and the second panel so as to maintain a gap between the first panel and the second panel, and arranged to be spaced apart from each other; a sealing member disposed between the first panel and the second panel for sealing a space between the first panel and the second panel; an exhaust hole provided in at least one of the first panel and the second panel so as to discharge air such that the space between the first panel and the second panel becomes a vacuum insulation space; and a cover member covering the exhaust hole.

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## Background/Summary

CROSS-REFERENCE TO RELATED APPLICATIONS [0001] This application is continuation of U.S. application Ser. No. 18/611,367, filed on Mar. 20, 2024, which is a continuation of U.S. application Ser. No. 18/094,109, filed on Jan. 6, 2023, now U.S. Pat. No. 11,971,206, which is a continuation of U.S. application Ser. No. 17/057,518, filed on Nov. 20, 2020, now U.S. Pat. No. 11,609,038, which is a National Stage application under 35 U.S.C. § 371 of International Application No. PCT/KR2019/014417, filed on Oct. 30, 2019, which claims the benefit of U.S. Provisional Application No. 62/757,721, filed on Nov. 8, 2018. The disclosures of the prior applications are incorporated by reference in their entirety.

### TECHNICAL FIELD

[0002] The present specification relates to a panel assembly, a refrigerator including the same, and home appliances.

### BACKGROUND

[0003] In general, refrigerators are home appliances for storing food at a low temperature in a storage space that is covered by a door.

[0004] For this, refrigerators cool the inside of the storage space by using cool air generated by being heat-exchanged with a refrigerant circulated through a refrigeration cycle to store foods in an optimum state.

[0005] Such a refrigerator is becoming larger and multifunctioned as dietary changes and user's preferences become more diverse, and thus, a refrigerator having various structures and convenience devices for user's convenience and freshness of stored foods has been introduced.

[0006] The storage space of the refrigerator may be opened/closed by the door. The refrigerators may be classified into various types according to an arranged configuration of the storage space and a structure of the door that opens and closes the storage space.

[0007] A separate accommodation space accessible from the outside may be provided in the door of the refrigerator. The accommodation space may be accessed by opening a partial auxiliary door or a home bar door without opening the entire refrigerator door through the above-described accommodation space.

[0008] Thus, frequently used foods may be stored in the separate accommodation space provided in the refrigerator door. Since the entire refrigerator door is not opened for accommodating food, there is an advantage of minimizing leakage of cold air inside the refrigerator.

[0009] However, even in such a structure, there is a problem in that the food is not checked unless the refrigerator door is opened. That is, the door should be opened to identify whether desired food is received in a space in the refrigerator or in a separate storage space provided in the door. If there is no desired food when opening the auxiliary door or the home bar, there is inconvenience to open the main door again. Here, there is a problem that unnecessary leakage of cold air occurs.

[0010] As a document for solving this problem, there is Korean Patent Publication No. 10-2016-0045545.

[0011] In the prior art document, disclosed is a refrigerator including: a cabinet in which a storage space is provided; a lighting device that illuminates the inside of the storage space; a door rotatably provided on the cabinet to open and close the storage space, defining an opening, and including a panel assembly having a front panel disposed on a front surface; and a controller allowing the lighting device to operate so that light is transmitted through the panel assembly so as to allow the storage space to be viewed from the outside of the door through the opening.

[0012] The front panel is made of a transparent material, and an insulation panel is disposed on a rear surface of the front panel.

[0013] According to the prior art document, when the lighting device is turned on, the light irradiated by the lighting device passes through the front panel made of the transparent material, and thus, a user may see the storage space through the front panel.

[0014] In the case of the prior art document, a vacuum space is defined between the front panel and the insulation panel, and a spacer is arranged between the front panel and the insulation panel.

[0015] In the case of the prior art document, a technique in which the spacer supports the insulation panel to prevent a central portion of the insulation panel from being bent is disclosed, but a technique of maintaining a constant gap across the front panel and the insulation panel by the spacer is not disclosed.

[0016] Also, in the case of the prior art document, when the lighting device is turned on, the light irradiated by the lighting device passes through the insulation panel and the front panel in sequence. However, since the spacer is disposed between the insulation panel and the front panel, there is a problem that the spacer between the insulation panel and the front panel is visible from the outside, and also, the prior art document does not disclose a technique for solving this problem.

[0017] Also, in the case of the prior art document, a hole for defining the vacuum space between the front panel and the insulation panel and a stopper for blocking the hole are disclosed. However, while the light irradiated by the lighting device sequentially passes through the insulation panel and the front panel, there is a concern that the hole and the stopper are exposed to the outside, and also, the prior art document does not disclose a technique for solving this problem.

[0018] Also, when a size of the spacer increases, possibility in which the gap between the front panel and the insulation panel is uniformly maintained is high. On the other hand, an area through which the light passes through the front panel is reduced by the spacer to reduce visibility.

[0019] According to the prior art document as described above, a technique for improving the visibility is not disclosed even if the gap between the front panel and the insulation panel is uniformly maintained.

## SUMMARY

[0020] The embodiments provide a panel assembly, which is capable of being reduced in thickness while maintaining and improving thermal insulation performance and in which a gap between two panels adjacent to each other is uniformly maintained, a refrigerator, and home appliances.

[0021] The embodiments provide a refrigerator including a panel assembly, in which visibility of an inner space from the outside is improved by transmission of light while uniformly maintaining a gap between two panels, and home appliances.

[0022] A panel assembly according to one aspect includes: a first panel made of a glass material; a second panel spaced apart from the first panel and made of a glass material; a plurality of spacers provided between the first panel and the second panel so as to maintain a gap between the first panel and the second panel; a sealing member disposed between the first panel and the second panel for sealing a space between the first panel and the second panel; an exhaust hole provided in at least one of the first panel and the second panel so as to discharge air so that the space between the first panel and the second panel becomes a vacuum insulation space; and a cover member covering the exhaust hole.

[0023] The plurality of spacers may be spaced apart from each other in a first direction and a second direction crossing the first direction. The plurality of spacers may be disposed to be spaced

apart from each other at a predetermined pitch in the first direction and the second direction.

[0024] The first panel may include a first area through which light is transmitted and a second area disposed outside the first area to restrict light transmission. A printed layer may be provided on a surface of the first panel facing the second panel, and the first area and the second area may be divided by the printed layer. The second area may be disposed to surround the first area.

[0025] The exhaust hole and the sealing member may be disposed to correspond to the second area. The exhaust hole and the sealing member may be disposed to face the second area. The first panel may have a size greater than that of the second panel.

[0026] The exhaust hole may be provided in the second panel. A getter for absorbing moisture may be provided in the exhaust hole. Alternatively, a getter for absorbing moisture may be provided at a position adjacent to the exhaust hole in the second panel.

[0027] The panel assembly may further include a third panel disposed at a side opposite to the second panel with respect to the first panel. The third panel may have a size greater than that of each of the first panel and the second panel.

[0028] The third panel may include a first area through which light is transmitted and a second area disposed outside the first area to restrict light transmission. The exhaust hole and the sealing member may be disposed to correspond to the second area.

[0029] An additional spacer may be provided between the third panel and the first panel. The additional spacer may be aligned with the spacer between the first panel and the second panel. The additional spacer may be disposed to face the spacer between the first panel and the second panel.

[0030] A gap between the third panel and the first panel may be less than a thickness of the first panel or a thickness of the third panel.

[0031] A contact area between the plurality of spacers and the first panel or a contact area between the plurality of spacers and the second panel may correspond to 0.01% to 0.05% of an area of the first panel or the second panel.

[0032] The sealing member may include a first portion disposed between the first panel and the second panel and a second portion disposed outside the first portion and having a thickness greater than that of the first portion. The sealing member may further include a third portion disposed outside the second portion to contact a side surface of the second panel.

[0033] A refrigerator according to another aspect includes: a cabinet provided with a storage space; and a door configured to open and close the storage space, the door being provided with a panel assembly.

[0034] The door may include a frame having an opening, and the panel assembly may be disposed to cover the opening.

[0035] The panel assembly may include: a first panel made of a glass material; a second panel spaced apart from the first panel, the second panel being made of a glass material; and a plurality of spacers disposed between the first panel and the second panel to maintain a gap between the first panel and the second panel, the plurality of spacers being disposed to be spaced apart from each other in a first direction and a second direction crossing the first direction.

[0036] The panel assembly may include: a sealing member disposed between the first panel and the second panel to seal a space between the first panel and the second panel; an exhaust hole provided in at least one of the first panel or the second panel to exhaust air so that the space between the first panel and the second panel serves as a vacuum insulation space; and a cover member configured to cover the exhaust hole. An insulation material may be provided in the frame and in contact with the second panel.

[0037] The first panel may include a first area through which light is transmitted and a second area disposed outside the first area to restrict light transmission. The exhaust hole and the sealing member may be disposed to correspond to the second area. At least a portion of the insulation material may be disposed to face the second area.

[0038] The refrigerator may further include a knock sensing device configured to contact the first

panel and sense a knock input applied to the first panel.

[0039] The panel assembly may further include a third panel disposed at a side opposite to the second panel with respect to the first panel, wherein the third panel has a size greater than that of each of the first panel and the second panel.

[0040] The refrigerator may further include a knock sensing device configured to contact the third panel and sense a knock input applied to the third panel.

[0041] The refrigerator may further include a lighting unit provided in the door and configured to irradiate light. When a normal knock input is sensed by the knock sensing device, the lighting unit may be turned on while the door is closed to irradiate the light. The light may pass through the panel assembly.

[0042] A contact area between the plurality of spacers and the first panel or a contact area between the plurality of spacers and the second panel may correspond to 0.01% to 0.05% of an area of the first panel or the second panel.

[0043] The sealing member may include a first portion disposed between the first panel and the second panel and a second portion disposed outside the first portion and having a thickness greater than that of the first portion. The sealing member may further include a third portion disposed outside the second portion to contact a side surface of the second panel.

[0044] A home appliance according to further another aspect includes: a cabinet provided with an inner space; and a door configured to open and close the inner space, the door being provided with a panel assembly,

[0045] The door may include a frame having an opening, and the panel assembly may be disposed to cover the opening.

[0046] According to the proposed invention, there may be the advantage in that the thickness of the panel assembly is reduced while the insulation performance is maintained or increases.

[0047] Also, there may be the advantage in that the gap between the two adjacent panels is uniformly maintained during the assembly process or the use process of the panel assembly, and the possibility of damage due to the external force may be reduced.

[0048] Also, according to the present invention, the visibility of the inner space from the outside may be improved by light transmission while the gap between the two panels is uniformly maintained.

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## Description

### BRIEF DESCRIPTION OF THE DRAWINGS

[0049] FIG. 1 is a perspective view of a panel assembly according to a first embodiment of the present invention.

[0050] FIG. 2 is a cutaway cross-sectional view taken along line 2-2 of FIG. 1.

[0051] FIG. 3 is a view illustrating a position of a getter in FIG. 2 according to another embodiment.

[0052] FIG. 4 is a view illustrating a printed layer of a first panel according to the first embodiment of the present invention.

[0053] FIG. 5 is an enlarged view of a portion B of FIG. 2.

[0054] FIG. 6 is a view illustrating an arrangement of a spacer on a second panel according to the first embodiment of the present invention.

[0055] FIG. 7 is a view illustrating another example of the arrangement of the spacer according to the present invention.

[0056] FIG. 8 is a view illustrating various shapes of the spacer.

[0057] FIG. 9 is a view of a door to which a panel assembly is applied according to the first embodiment of the present invention.

[0058] FIG. **10** is an explode perspective view of FIG. **9**.  
[0059] FIG. **11** is a cross-sectional view taken along line A-A of FIG. **9**.  
[0060] FIG. **12** is a view illustrating another example of FIG. **9**.  
[0061] FIG. **13** is a sectional view taken along line B-B of FIG. **9**.  
[0062] FIG. **14** is a perspective view illustrating a state in which an injection hole is defined in the door according to the first embodiment.  
[0063] FIG. **15** is a cross-sectional view of a panel assembly according to a second embodiment of the present invention.  
[0064] FIG. **16** is a view of a door to which the panel assembly is applied according to the second embodiment of the present invention.  
[0065] FIG. **17** is a cutaway cross-sectional view taken along line C-C of FIG. **16**.  
[0066] FIG. **18** is a cutaway cross-sectional view taken along line D-D of FIG. **17**.  
[0067] FIG. **19** is a cross-sectional view of a panel assembly according to a third embodiment of the present invention.  
[0068] FIG. **20** is a cross-sectional view of a panel assembly according to a fourth embodiment of the present invention.  
[0069] FIG. **21** is a view illustrating another example of FIG. **20**.  
[0070] FIG. **22** is a view of a door to which the panel assembly is applied to a refrigerator according to the first embodiment of the present invention.  
[0071] FIG. **23** is a view of a state in which a door lighting unit is turned on in the refrigerator of FIG. **22**.  
[0072] FIG. **24** is a block diagram of the refrigerator of FIG. **22**.  
[0073] FIG. **25** is an exploded perspective view of a knock sensing device according to an embodiment of the present invention.  
[0074] FIG. **26** is a cross-sectional view of a microphone module according to an embodiment of the present invention.  
[0075] FIG. **27** is a view illustrating a state in which the microphone module is in contact with a panel assembly according to an embodiment of the present invention.  
[0076] FIG. **28** is a view of a state in which the microphone module is in contact with the panel assembly of FIG. **20**.  
[0077] FIG. **29** is a cross-sectional view illustrating a state in which a door lighting unit is installed on a door according to an embodiment of the present invention.  
[0078] FIG. **30** is a view illustrating another example in which the panel assembly is applied to the refrigerator according to the present invention.  
[0079] FIG. **31** is a cutaway cross-sectional view taken along line E-E of FIG. **30**.  
[0080] FIG. **32** is a sectional view taken along line F-F of FIG. **30**.  
[0081] FIG. **33** is an enlarged view of a portion B of FIG. **32**.  
[0082] FIG. **34** is a view illustrating another example in which the panel assembly is applied to the refrigerator according to the present invention.  
[0083] FIG. **35** is a view illustrating a state in which the panel assembly is applied to a cloth processor that is an example of a home appliance.

#### DETAILED DESCRIPTION

[0084] Hereinafter, some embodiments of the present invention will be described in detail with reference to the accompanying drawings. Exemplary embodiments of the present invention will be described below in more detail with reference to the accompanying drawings. It is noted that the same or similar components in the drawings are designated by the same reference numerals as far as possible even if they are shown in different drawings. In the following description of the present invention, a detailed description of known functions and configurations incorporated herein will be omitted to avoid making the subject matter of the present invention unclear.

[0085] In the description of the elements of the present invention, the terms first, second, A, B, (a),

and (b) may be used. Each of the terms is merely used to distinguish the corresponding component from other components, and does not delimit an essence, an order or a sequence of the corresponding component. It should be understood that when one component is “connected”, “coupled” or “joined” to another component, the former may be directly connected or joined to the latter or may be “connected”, coupled” or “joined” to the latter with a third component interposed therebetween.

[0086] FIG. 1 is a perspective view of a panel assembly according to a first embodiment of the present invention, and FIG. 2 is a cutaway cross-sectional view taken along line 2-2 of FIG. 1.

[0087] FIG. 3 is a view illustrating a position of a getter in FIG. 2 according to another embodiment. FIG. 4 is a view illustrating a printed layer of a first panel according to the first embodiment of the present invention.

[0088] Referring to FIGS. 1 to 4, a panel assembly 10 according to a first embodiment of the present invention includes a first panel 11 and a second panel 13 disposed to be spaced apart from the first panel 11.

[0089] The first panel 11 may be made of a glass material. The first panel 11 may be tinted glass.

[0090] The first panel 11 may have a thickness of about 3 mm to about 6 mm. The first panel 11 may be reduced in thickness to reduce a total thickness of the panel assembly 10, thereby improving transmittance of light. The light transmittance may be related to visibility to be described later, and if the light transmittance is improved, the visibility may be improved.

[0091] If assuming a state in which the panel assembly 10 is used in a home appliance (see FIG. 20), when the first panel 11 is made of tinted glass, if a lighting unit to be described later is turned on, light may pass through the first panel 11 to see an inner space of the home appliance. On the other hand, if the light unit is turned off, the seeing of the inner space of the home appliance may be restricted by the first panel 11.

[0092] The first panel 11 may include a first surface 110a and a second surface 110b that is an opposite surface to the first surface 110a.

[0093] When the panel assembly 10 is used in the home appliance, the panel assembly 10 may be fixed so that the first surface 110a defines an outer appearance of the home appliance.

[0094] The second panel 13 may be made of a glass material. A thickness of the second panel 13 may be the same as or different from a thickness of the first panel 11. The thickness of the second panel 13 may be about 3 mm to about 6 mm.

[0095] The second panel 13 may be reduced in thickness to reduce the total thickness of the panel assembly 10, thereby improving the light transmittance.

[0096] The second panel 13 may include a first surface 131 facing the second surface 110b of the first panel 11 and a second surface 131b that is an opposite surface of the first surface 131a.

[0097] A low-emission coating layer 14 for reducing heat transfer due to radiation may be provided on the first surface 131a. Glass provided with the low-emission coating layer 14 may be referred to as low-s glass.

[0098] In this embodiment, when the low-emission coating layer 14 is formed on the first surface 131a of the second panel 13, the low-emission coating layer 14 may be prevented from being damaged while the panel assembly 10 is manufactured or used after the manufacturing.

[0099] As the low-emission coating layer 14 is formed on the second panel 13, the thickness of the second panel 13 may be reduced to improve performance of the insulation glass.

[0100] The second panel 13 may be hard low- $\epsilon$  glass or soft low- $\epsilon$ .

[0101] The hard low- $\epsilon$  glass may be manufactured by spraying metal oxide (SnO.sub.2) as a thermal coating material onto the glass surface and then performing a heat treatment process. The soft low- $\epsilon$  glass may be drafted by placing plate glass in a vacuum chamber and applying metals such as silver, titanium, and stainless steel in the form of multilayer thin film coating.

[0102] Alternatively, the second panel 13 may be transparent electrically conductive (TEC) glass formed by applying fluorine doped tin oxide (FTO) under an atmospheric pressure while using the

same method as the hard low- $\epsilon$  glass.

[0103] A size of the first panel **11** may be larger than a size of the second panel **13**. For example, a horizontal length **L1** of the first panel **11** may be longer than a horizontal length **L2** of the second panel **13**.

[0104] A vertical length **L3** of the first panel **11** may be longer than a vertical length **L4** of the second panel **13**.

[0105] In the panel assembly **10**, positions of the first panel **11** and the second panel **13** may be determined so that a side surface of the second panel **13** and a side surface of the first panel **11** are spaced apart from each other.

[0106] Thus, the first panel **11** and the second panel **13** may be arranged in a stepped shape.

[0107] For example, a gap between the side surface of the first panel **11** and the side surface of the second panel **13** may be **G1**.

[0108] A screen-printed layer **112a** may be provided on the second surface **110b** of the first panel **11**. The printed layer **112a** may be disposed along a circumference of the second surface **110b** of the first panel **11**.

[0109] The printed layer **112a** may restrict or block the light transmission. The first panel **11** may include a first area **111** through which light is transmitted and a second area **112** disposed outside the first area **111** to restrict the light transmission by the printed layer **112a**. The second area **112** may be disposed outside the first area **111** and may be disposed to surround the first area **111**.

[0110] The second area **112** may transmit the light, but may have a light transmittance less than that of the first area **111** or may completely block the light.

[0111] The horizontal length of the first area **111** may be referred to as **D1**, and the vertical length may be referred to as **D2**. The horizontal length **D1** and the vertical length **D2** of the first area **111** may be the same or different from each other according to a kind of home appliances to which the panel assembly **10** is applied.

[0112] In FIG. **4**, for example, the vertical length **D2** are greater than the horizontal length **D1** of the first area **111**.

[0113] A distance **D3** from an end of the first panel **11** to a boundary between the first area **111** and the second area **112** may be greater than a gap **G1** between an edge end of the first panel **11** and an edge end of the second panel **13**.

[0114] Thus, the printed layer **112a** may face an edge portion of the second panel **13** as illustrated in FIG. **2**.

[0115] The distance **D3** from the end of the first panel **11** to the boundary between the first area **111** and the second area **112** may vary depending on the type of home appliances to which the panel assembly **10** is applied.

[0116] Also, the distance **D3** from the end of the first panel **11** to the boundary between the first area **111** and the second area **112** may be the same or different from each other in a circumferential direction of the first panel **11**.

[0117] The low-emission coating layer **14** may be provided on the entire first area **111** of the first panel **11** and may be provided on a portion of the second area **112** or the entire second area **112**.

[0118] Since a portion of the second area **112** is in contact with a sealing member to be described later, the low-emission coating layer **14** may not be present. For example, the low-emission coating layer **14** may be formed from an outer end of the second area **112** to a position spaced apart by a predetermined distance.

[0119] The first panel **11** and the second panel **13** may be spaced apart from each other by a spacer **16**.

[0120] For example, the first panel **11** and the second panel **13** may be entirely spaced a predetermined interval from each other by a plurality of spacers **16** that are spaced apart from each other.

[0121] The spacer **16** may be, for example, any one of stainless steel, glass, and ceramic.



[0122] In this embodiment, when the panel assembly **10** is disposed to allow the light to be transmitted therethrough so that the inner space of the home appliance is seen, the spacer **16** may be preferably made of stainless steel.

[0123] When the spacer **16** is made of a stainless steel material, it may have excellent workability and less light reflection to minimize exposure of the spacer **16**, as well as improve visibility of the inner space of the home appliance by the panel assembly **10**.

[0124] On the other hand, when the spacer **16** is made of a glass material, the spacer **16** may appear white or a similar color due to diffuse reflection of light. Therefore, it is preferable that the spacer **16** is made of a stainless material in terms of the non-exposure of the spacer **16** and the visibility of the inner space of the home appliance.

[0125] A space between the first panel **11** and the second panel **13** may be a vacuum insulation space. An exhaust hole **132** may be defined in the second panel **13** so that the space between the first panel **11** and the second panel **13** becomes a vacuum insulation space.

[0126] Since air is exhausted through the exhaust hole **132**, the space between the first panel **11** and the second panel **13** may become the vacuum insulation space.

[0127] A gap between the first panel **11** and the second panel **13** may be designed in a range of 0.1 mm to 1 mm.

[0128] When the distance between the first panel **11** and the second panel **13** is greater than 1 mm, the spacer **16** for maintaining the distance between the first panel **11** and the second panel **13** may increase in thickness.

[0129] Since the spacer **16** is capable of transferring heat, when the thickness of the spacer **16** increases, the heat transfer amount by the spacer **16** in the panel assembly **10** increases to deteriorate thermal insulation performance. In addition, as the size of the spacer **16** increases, the area of the panel assembly **10**, through which the light is transmitted may be relatively reduced to deteriorate the visibility.

[0130] On the other hand, when a gap between the first panel **11** and the second panel **13** is less than 0.1 mm, a problem in which the first panel **11** and the second panel **13** are in contact with each other due to deformation of the first panel **11** or the second panel **13** while the air is exhausted through the exhaust hole **132** may occur.

[0131] However, according to this embodiment, if the distance between the first panel **11** and the second panel **13** is designed to be in the range of 0.1 mm to 1 mm, the gap between the first panel **11** and the second panel **13** may be maintained while preventing the thermal insulation performance and the visibility from being deteriorated.

[0132] Preferably, the gap between the first panel **11** and the second panel **13** may be designed in a range of 0.1 mm to 0.5 mm.

[0133] The exhaust hole **132** may be defined in a position spaced a predetermined distance inward from the edge end of the second panel **13**. However, in order not to expose the exhaust hole **132** to the outside, the exhaust hole **132** may be disposed at a position corresponding to the second area **112** of the first panel **11**. The exhaust hole **132** may be disposed to face the printed layer **112a** of the first panel **11**.

[0134] A getter **17** for absorbing moisture in the vacuum insulation space may be disposed in the exhaust hole **132**. The getter **17** may be an evaporation type getter or a non-evaporation type getter. It is preferable to use the non-evaporation type getter in views of vacuum maintenance performance and simplification of the process.

[0135] The non-evaporation type getter may be a zirconium (Zr) alloy. For example, the getter **17** according to this embodiment may include zirconium (Zr), vanadium (V), iron (Fe), or the like. This getter **17** may adsorb hydrogen, water, carbon monoxide, carbon dioxide, nitrogen, and the like.

[0136] When air and moisture do not exist in the vacuum insulation space, thermal convection does not occur. A degree of vacuum in the vacuum insulation space may be 10<sup>-3</sup> Torr or less.

[0137] The exhaust hole **132** may be covered by a cover member **18**. The cover member **18** may be, for example, frit glass.

[0138] Alternatively, the getter **17** may be supported by a supporter (not shown), and at least a portion of the supporter may pass through the exhaust hole **132** and be disposed in the vacuum insulation space. That is, the getter **17** may be disposed in the vacuum insulation space. Even in this case, the cover member **18** may cover the supporter and a portion of the second surface **131b** of the second panel **13**.

[0139] As another example, referring to FIG. **3**, the second panel **13** may include an accommodation groove **131d** in which the getter **17a** is accommodated. The accommodation groove **131d** may be disposed around the exhaust hole **132**. For example, the accommodation groove **131d** may be formed by being recessed from the first surface **131a** of the second panel **13** toward the second surface **131b**.

[0140] The accommodation groove **131d** may be disposed at a position corresponding to the second area **112** of the first panel **11** so that the getter **17a** accommodated in the accommodation groove **131d** is prevented from being exposed to the outside. That is, the accommodation groove **131d** may be disposed so as to face the printed layer **112a** of the first panel **11**.

[0141] The panel assembly **10** may further include a sealing member **15** disposed between the edges of the first panel **11** and the second panel **13** to seal a space between the first panel **11** and the second panel **13**.

[0142] The sealing member **15** may be, for example, frit glass. That is, the sealing member **15** may be a glass sealant.

[0143] The sealing member **15** may be made of a material capable of being fired at a temperature of approximately 400° C. or less to prevent performance of the first panel **11** and the second panel **13** from being deteriorated during a firing process.

[0144] As an example, the sealing member **15** may be a lead-free glass composition and may include phosphorus pentoxide (P.sub.2O.sub.5), vanadium trioxide (V.sub.2O.sub.3), and tellurium.

[0145] Although not limited, the sealing member **15** may include 5% to 25% by weight of P<sub>2</sub>O<sub>5</sub>, 40% to 70% by weight of V<sub>2</sub>O<sub>5</sub>, 5% to 25% by weight of TeO<sub>2</sub>, 1% to 5% by weight of copper oxide (CuO), and 1% to 12% by weight of zinc oxide (ZnO), and 1% to 5% by weight of barium oxide (BaO). The sealing member **15** may be fired at a relatively low temperature by the composition of the sealing member **15**.

[0146] Also, the content of P.sub.2O.sub.5, V.sub.2O.sub.5, and TeO.sub.2 in the sealing member **15** may satisfy the following relational expression so as to not only be fired at a low temperature, but also be lowered in crystallization tendency during the firing at a low temperature.

[00001]
$$V_2O_5(\text{wt}\%)P_2O_5(\text{wt}\%) < 3.5P_2O_5(\text{wt}\%) + TeO_2(\text{wt}\%) > 30$$

[0147] Also, in order to provide the sealing member **15** having excellent durability without including an inorganic filler or minimizing a content of the inorganic filler and also matching a coefficient of thermal expansion with the glass substrate so as to prevent peeling or breakage from occurring, the sealing member **15** may further include one or more of bismuth oxide (Bi.sub.2O.sub.3), manganese dioxide (MnO.sub.2), iron oxide (Fe.sub.2O.sub.3), and silver oxide (Ag.sub.2O).

[0148] FIG. **5** is an enlarged view of a portion B of FIG. **2**.

[0149] Referring to FIG. **5**, a portion of the sealing member **15** may be disposed between the first panel **11** and the second panel **13**, and the other portion of the sealing member **15** may be in contact with a side surface **131e** of the second panel **13** outside the second panel **13**.

[0150] That is, the sealing member **15** includes a first portion **151** disposed between the first panel **11** and the second panel **13** and a second portion **152** disposed outside the second panel **13**. Thus, a thickness of the second portion **152** (a thickness in an arrangement direction of the first panel **11** and the second panel **13**) may be greater than a thickness of the first portion **151**.

[0151] As described in this embodiment, when the sealing member **15** is in contact with the side

surface **131e** of the second panel **13** outside of the second panel **13**, a contact area between the sealing member **15** and the second panel **13** and a contact area between the sealing member **15** and the first panel **11** may increase to increase in close contact strength by the sealing member **15**, thereby improving sealability.

[0152] Also, as the contact area between the sealing member **15** and the second panel **13** and the contact area between the sealing member **15** and the first panel **11** increase, an impact absorption of the sealing member **15** against an impact applied to the panel assembly **10** may increase.

[0153] An edge portion of the first surface **131a** of the second panel **13** may be inclined. That is, the first surface **131a** of the second panel **13** may include an inclined surface **131c**.

[0154] The inclined surface **131c** may be inclined to move away from the second surface **110b** of the first panel **11** toward the outside.

[0155] A portion of the first surface **131a** of the second panel **13** is parallel to the second surface **110b** of the first panel **11**, and the other portion (inclined surface **131c**) of the first surface **131a** of the second panel **13** is not parallel to the second surface **110b** of the first panel **11**.

[0156] Thus, the sealing member **15** may further include a third portion **153** that connects the first portion **151** to the second portion **152** and is in contact with the inclined surface **131c**.

[0157] A thickness of the third portion **153** is greater than that of the first portion **151**. Due to the presence of the third portion **153** by the inclined surface **131c**, the contact area between the sealing member **15** and the second panel **13** may further increase.

[0158] A width W (length from the first portion to the third portion) of the sealing member **15** may be set within a range of 3 mm to 15 mm.

[0159] Since heat is conducted by the sealing member **15**, when the width W of the sealing member **15** is greater than 15 mm in terms of heat conduction, a problem of deteriorating the thermal insulation performance occurs. On the other hand, when the width W of the sealing member **15** is less than 3 mm, there is a concern that the sealing performance of the vacuum insulation space is deteriorated.

[0160] Thus, as in this embodiment, when the width W of the sealing member **15** is set within the range of 3 mm to 15 mm, the sealing of the vacuum insulation space may be secured, and the thermal insulation performance may be prevented from being deteriorated.

[0161] Each of corners of the first panel **11** and the second panel **13** may be rounded at a predetermined curvature.

[0162] In a state in which the sealing member **15** is inserted between the first panel **11** and the second panel **13**, the first panel **11** and the second panel **13** may be pressed in a direction in which the first panel **11** and the second panel are close to each other to increase in coupling force between the sealing member **15** and the panels **11** and **13**.

[0163] If there is no inclined surface on the second panel **13**, the sealing member **15** may move into the vacuum insulation space while the first panel **11** and the second panel **13** are pressed in the direction in which the first panel **11** and the second panel **13** are close to each other. In this case, there is a problem that the sealing member **15** is in contact with the spacer **16** or is spread to the first area **111**. In this case, the first area **111** is reduced by the sealing member **15** to reduce the visibility.

[0164] However, as in the present invention, when the second panel **13** includes the inclined surface **131c**, while the first panel **11** and the second panel **13** are pressed in the direction in which the first panel **11** and the second panel are close to each other, since the sealing member **15** moves to the portion at which the inclined surface **131c** is formed, the movement of the vacuum insulation space may be minimized.

[0165] FIG. **6** is a view illustrating an arrangement of the spacer on the second panel according to the first embodiment of the present invention.

[0166] Referring to FIGS. **2** and **6**, the spacers **16** may be spaced apart from each other in a first direction and may be spaced apart from each other in a second direction crossing the first direction.

[0167] For example, the plurality of spacers **16** may be arranged to be spaced apart in the vertical and horizontal directions.

[0168] The plurality of spacers **16** may be arranged to have a constant pitch P in the horizontal direction and may be arranged to have a constant pitch P in the vertical direction.

[0169] According to this arrangement, not only the plurality of spacers **16** may be arranged in the vertical line direction, but the plurality of spacers **16** may be arranged in the horizontal direction. The arrangement of the spacers in FIG. **6** may be referred to as an orthogonal arrangement.

[0170] However, in the manufacturing process, while the plurality of spacers **16** are orthogonally arranged on the first panel **11** by a separate mechanism (not shown), the second panel **13** is seated on the plurality of spacers **16**.

[0171] Referring to FIG. **6**, in the second panel **13**, the sealing member **15** may be disposed in an area **135** between a dotted line and an edge of the second panel **13**. The area **135** may also be referred to as a sealing member contact area. The contact area is disposed to surround the plurality of spacers **16**. In another aspect, the plurality of spacers **16** are disposed in an area inside the contact area, and the plurality of spacers **16** are spaced apart from the sealing member **15**.

[0172] FIG. **7** is a view illustrating another example of the arrangement of the spacer according to the present invention.

[0173] Referring to FIG. **7**, the plurality of spacers **16** may be disposed to be spaced apart in the horizontal direction and the vertical direction.

[0174] For example, the plurality of spacers **163** in a first row may be disposed to be spaced a predetermined pitch P from each other in the horizontal direction.

[0175] The plurality of spacers **164** in a second row disposed below the first row may be disposed to be spaced a predetermined pitch P from each other in the horizontal direction. However, the plurality of spacers **163** in the first row and the plurality of spacers **164** in the second row may be disposed to be spaced a predetermined pitch P from each other without overlapping each other in the vertical direction.

[0176] In other words, the spacers **164** in the second row may be disposed on an area corresponding to the area between the two adjacent spacers **163** in the first row. The arrangement of the spacers in FIG. **7** may be referred to as a diamond arrangement.

[0177] FIG. **8** is a view illustrating various shapes of the spacer.

[0178] (a) of FIG. **8** illustrates one form of the spacer, and (b) of FIG. **8** illustrates another form of the spacer.

[0179] Referring to (a) of FIG. **8**, the spacer **16** may have a cylindrical shape or a shape similar to a cylinder.

[0180] Referring to (b) of FIG. **8**, the spacer **16a** may have a tube shape. That is, the spacer **16a** may include an outer circumferential surface **161** and an inner circumferential surface **162**. A diameter OD of the outer peripheral surface **161** may be the same as or similar to a diameter of the cylindrical spacer. A diameter ID of the inner peripheral surface **162** may be less than the diameter of the cylindrical spacer.

[0181] In another aspect, the spacer **16a** may have a cylindrical shape having a hollow.

[0182] Although FIG. **8** illustrates that each of the spacers **16** and **16a** has a smooth surface, this is merely an example. For example, it may be possible to form an unevenness on the surface of each of the spacers **16** and **16a**, and the spacers **16** and **16a** may have a polygonal pillar shape.

[0183] A maximum distance between the diameter of each of the spacers **16** and **16a** or the outer circumferential surface and a line connecting two points to each other may be set within a range of 200 microns to 900 microns.

[0184] A contact area between one spacer **16** or **16a** and the second panel **13** may be different depending on the shape of each of the spacers **16** and **16a**.

[0185] If the spacers **16** and **16a** are concentrated into a certain area in relation to the second panel **13**, or the spacers **16** and **16a** are not arranged evenly, possibility in which the spacers **16** and **16a**

are exposed to the outside may be high, and visibility of a certain area of the panel assembly may be significantly lowered due to the spacers **16** and **16a**.

[0186] However, as in this embodiment, when the spacers **16** and **16a** are arranged at a predetermined pitch, the spacers **16** and **16a** itself may be seen from the outside while maintaining the gap between the first panel **11** and the second panel **13** to improve the visibility of the panel assembly **10**.

[0187] In this embodiment, the diameter of each of the plurality of spacers **16** and **16a** and the gap between the spacers may be determined so that the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** corresponds to 0.01% to 0.05% of the area of the first surface **131a** in the second panel **13**.

[0188] When the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** is less than 0.01% of the area of the first surface **131a** in the second panel **13**, the spacer **16** may not maintain the gap between the first panel **11** and the second panel **13** while air is removed from the space between the first panel **11** and the second panel **13**. In this case, a problem occurs in that the first panel **11** and the second panel **13** are in contact with each other (in view of maintaining the gap between the first panel and the second panel).

[0189] On the other hand, when the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** is greater than 0.05% of the area of the first surface **131a** in the second panel **13**, the spacers **16** and **16a** may be exposed to the outside. That is, when light passes through the panel assembly **10**, the spacers **16** and **16a** are visible to the outside, and the area through which the light is transmitted by the spacer **16** relatively decreases. Thus, there is a problem that the visibility of the inner space is deteriorated (in view of the visibility).

[0190] Also, since the areas of the spacers **16** and **16a** increases, an amount of thermal conductivity by the spacers **16** and **16a** may increase to deteriorate the thermal insulation performance (in view of the thermal insulation performance of the panel assembly).

[0191] However, as in this embodiment, when the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** is set within the range of 0.01% to 0.05% of the area of the first surface **131a** in the second panel **13**, there may be an advantage in that the visibility by the panel assembly **10** is improved while the gap between the first panel **11** and the second panel **13** is maintained.

[0192] The pitch of each of the adjacent spacers **16** and **16a** may vary by a ratio of the contact area between each of the plurality of spacers **16** and the second panel **13** and the area of the first surface **131a** in the second panel **13**, but may be determined within a range of approximately 20 mm to 60 mm.

[0193] The thickness of each of the spacers **16** and **16a** is substantially the same as the gap between the first panel **11** and the second panel **13**.

[0194] The ratio between the pitch of each of the adjacent spacers **16** and **16a** and the ratio of the contact area between each of the plurality of spacers **16** and the second panel **13** and the area of the first surface **131a** of the second panel **13** may also be related to impact resistance of the first panel **11** and the second panel **13**.

[0195] Basically, a vacuum pressure is applied to the first panel **11** and the second panel **13**, which are in contact with the spacers **16** and **16a**. In this state, even if an external impact is applied to the first panel **11** and the second panel **13**, the first panel **11** and the second panel **13** have to be prevented from being damaged.

[0196] As in this embodiment, when the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** increases to 0.01% to 0.05% of the area of the first surface **131a** in the second panel **13**, even if the external impact is applied to the first panel **11** and the second panel **13**, the damage of the first panel **11** and the second panel **13** may be minimized. Preferably, the contact area between each of the plurality of spacers **16** and **16a** and the second panel **13** may satisfy a range of 0.025% to 0.03% of the area of the first surface **131a** in the second panel **13**.

[0197] In summary, according to the spaced arrangement of the spacers **16** and **16a** proposed in this embodiment, the panel assembly **10** may decrease in thickness while maintaining the thermal insulation performance by the area ratio of the spacers **16** and **16a** and the second panel **13**, and the gap between the first panel and the second panel.

[0198] Also, the visibility of the inner space of the home appliance by the panel assembly **10** and the impact resistance to the external impacts may be improved.

[0199] Also, since the spacers **16** and **16a** are not exposed to the outside, an aesthetic feeling of the panel assembly **10** itself may be prevented from being deteriorated.

[0200] FIG. **9** is a view of a door to which a panel assembly is applied according to the first embodiment of the present invention, and FIG. **10** is an explode perspective view of FIG. **9**. FIG. **11** is a cross-sectional view taken along line A-A of FIG. **9**, FIG. **12** is a view illustrating another example of FIG. **9**, and FIG. **13** is a sectional view taken along line B-B of FIG. **9**.

[0201] FIG. **14** is a perspective view illustrating a state in which an injection hole is defined in the door according to the first embodiment.

[0202] In FIG. **11**, it is illustrated that an insulation space is partially filled with an insulation material.

[0203] Referring to FIGS. **9** to **14**, a panel assembly **10** according to this embodiment may be used for a door **30** of a home appliance. That is, the door **30** may include the panel assembly **10**.

[0204] The door **30** may further include a door frame **40** supporting the panel assembly **10** and a door liner **60** connected to the door frame **40**. The door frame **40** and the door liner **60** may be collectively referred to as a frame.

[0205] The door frame **40** may be made of, for example, a metal material. The door frame **40** may include a first opening **41**. The panel assembly **10** may cover the first opening **41**.

[0206] As the door frame **40** and the panel assembly **10** are made of different materials, in order to fix positions of the door frame **40** and the panel assembly **10** to each other, the door **30** may further include a bracket **50**.

[0207] A portion of each of the door frame **40** and the door liner **60** may be directly connected, and other portion may be connected by connection members **70** and **72**. For example, both sides of the door frame **40** may be directly connected to the door liner **60**, and upper and lower sides of the door frame **40** may be connected by connection members **70** and **72**.

[0208] The door frame **40**, the door liner **60**, and the connection members **70** and **72** may be collectively referred to as a frame assembly **90**.

[0209] The door liner **60** may include a second opening **61**. The panel assembly **10** may cover the second opening **61**.

[0210] The door liner **60** may include a bent portion **62** that is bent from the second opening **61** toward the door frame **40**. Alternatively, the door liner **60** may include a bent portion **62** extending toward the first opening **41**, and the bent portion **62** may define the second opening **61**.

[0211] The bracket **50** may be coupled to directly contact the door frame **40** and the panel assembly **10** or may be coupled while indirectly contacting the door frame **40** and the panel assembly **10** by an intermediate member.

[0212] The door frame **40** may be provided as a thin plate and may include a bent portion **42** that is bent inward from the first opening **41**. An inner region of the bent portion **42** substantially becomes the first opening **41**.

[0213] The panel assembly **10** may be disposed at the first opening **41** to cover the first opening **41** or may cover the first opening **41** from an outside of the first opening **41**.

[0214] A side surface of the panel assembly **10** may be in contact with the bent portion **42**. For example, the side surface of the first panel **11** may be in contact with the bent portion **42**.

[0215] The first panel **11** may define a portion of a front appearance of the door **30**.

[0216] A front surface (first surface) of the first panel **11** may define the same surface as a front surface of the door frame **40**, or a line passing through the front surface of the first panel **11** may

pass through the front surface of the door frame **40**. Alternatively, the front surface of the first panel **11** and the front surface of the door frame **40** may be stepped. However, in this case, in order to prevent the first panel **11** from being damaged, the front surface of the first panel **11** may be disposed behind the front surface of the door frame **40**.

[0217] The bracket **50** may include a first portion **51** disposed to face the first panel **11**, a second portion **52** disposed to face the door frame **40**, and a third portion **53** connecting the first portion **51** to the second portion **52**.

[0218] The first portion **51** of the bracket **50** may face a rear surface (second surface) of the first panel **11**, and the second portion **52** of the bracket **50** may face a rear surface of the door frame **40**.

[0219] For example, the first portion **51** of the bracket **50** may be disposed to correspond to the second area **112** of the first panel **11**. That is, the first portion **51** of the bracket **50** may be disposed to face the second area **112** of the first panel **11**.

[0220] Thus, even if the panel assembly **10** is installed on the door **30**, the bracket **50** may be prevented from being exposed to the outside.

[0221] The first portion **51** of the bracket **50** may be provided with a coupling protrusion **54**, and the bent portion **42** may be provided with a protrusion slot (not shown) into which the coupling protrusion **54** is inserted.

[0222] A heater accommodation groove **502** may be defined in the first portion **51** of the bracket **50**. A heater **58** may be accommodated in the heater accommodation groove **502**.

[0223] The heater **58** may be fixed to the rear surface of the first panel **11** or be fixed to the first portion **51** of the bracket **50** by an adhesive tape (for example, an aluminum tape). Alternatively, an aluminum sheet may be attached to a portion corresponding to the heater **58** on the rear surface of the first panel **11**, and the heater **58** may be disposed to be in contact with the aluminum sheet. Even in this case, the heater **58** may be fixed to the bracket **50** by an adhesive tape (for example, an aluminum tape) while being accommodated in the heater accommodation groove **502**.

[0224] The heater **58** may prevent dew condensation from being generated by allowing a surface temperature of a peripheral portion of the side surface of the panel assembly **10** to increase. Heat of the heater **58** may be transferred to the first panel **11** and may also be transferred to the second panel **13** and the sealing member **15**.

[0225] In the case of this embodiment, since the panel assembly has a vacuum insulation space, a thickness of the panel assembly may be reduced compared to a structure in which a gas is filled between two panels.

[0226] When the panel assembly **10** according to this embodiment is applied to the structure of the existing door **30**, a gap between the panel assembly **10** and the bent portion **62** of the door liner **60** may occur by a reduced thickness of the panel assembly **10**.

[0227] If, without changing the structure of the existing door liner **60**, the panel assembly **10** according to this embodiment is used, as illustrated in FIG. **11** and (a) of FIG. **13**, the door **30** may further include an intermediate member **63** disposed in a spaced portion between the door liner **60** and the panel assembly **10**.

[0228] One side of the intermediate member **63** may be coupled to the door liner **60**, and the other side may be in contact with the panel assembly **10**. For example, the intermediate member **63** may be in contact with the rear surface (second surface) of the second panel **13**.

[0229] The intermediate member **63** may further include a contact portion **64** to increase in contact area between the intermediate member **63** and the second panel **13**. For example, the contact portion **64** is in contact with a rear surface of the second panel **13** and extends from the intermediate portion **63** along the second panel **13** in a direction toward a bottom surface of the door. An angle defined between the contact portion **64** and the intermediate portion **63** is less than 90 degrees.

[0230] Referring to FIG. **12** and (b) of FIG. **13**, as another example of the door liner **60**, the intermediate member may not exist as a separate member **63**, and the bent portion **62** of the door

liner **60** may extend toward the second panel **13**, and the contact portion **64** may extend from the second panel **13**.

[0231] In either case, the door frame **40**, the door liner **60**, the bracket **50**, and the panel assembly **10** may define an insulation space P in which an insulation material **80** is filled. That is, the frame assembly **90** and the panel assembly **10** may define an insulation space P.

[0232] Referring to FIG. **13**, the frame assembly **90** may be provided with a plurality of injection holes for injecting a foaming solution for forming the insulation material **80**.

[0233] For example, the plurality of injection holes may be defined to be spaced apart from a top surface **91** or a bottom surface of the frame assembly **90**. For example, FIG. **13** illustrates that a first injection hole **92** and a second injection hole **93** are defined in the top surface **91** of the frame assembly **90**.

[0234] The first injection hole **92** and the second injection hole **93** may be disposed to face the insulation space P. The first injection hole **92** may face a space defined at one side of the panel assembly **10** in the insulation space P, and the second injection hole **93** may face a space defined at the other side of the panel assembly in the insulation space P. The foaming solution injected through the two injection holes **92** and **93** may not only flow in a horizontal direction in the insulation space P, but also flow in a downward direction so as to be filled into the insulation space P as a whole.

[0235] The contact portion **64** of the door liner **60** may be in contact with a position spaced a predetermined distance from an edge end of the second panel **13**.

[0236] The insulation material **80** may be in contact with the door frame **40**, the door liner **60**, and the bracket **50**. Also, the insulation material **80** may be in contact with a rear surface (second surface) of the second panel **13**.

[0237] A portion of the insulation material **80** may be in contact with the contact portion **64** to press the contact portion **64** toward the second panel **13**. Thus, the insulation material **80** between the contact portion **64** and the second panel **13** may be prevented from leaking.

[0238] Since the panel assembly **10** itself includes the vacuum insulation space, the thermal insulation performance may be maintained by the vacuum insulation space. On the other hand, since the outer surface of the panel assembly **10**, in particular, the sealing member **15** is capable of conducting heat, there is a need to prevent the thermal insulation performance due to the heat conduction.

[0239] In order to prevent deterioration in thermal insulation performance due to the heat conduction of the panel assembly **10**, the insulation material **80** may be in contact with the rear surface (second surface) of the second panel **13**. Also, the insulation material **80** may be in contact with a side surface of the second panel **13** and a portion of the sealing member **15**.

[0240] The insulation material **80** may be disposed to overlap the second panel **13** in a front and rear direction (which may be defined as an arranged direction of the panels). In order to secure the thermal insulation performance, the vertical or horizontal length (overlapping length) D4 of the portion of the second panel **13** overlapping the insulation material **80** in the front and rear direction may be set within a range of 20 mm to 50 mm.

[0241] When the overlapping length of the insulation material **80** and the second panel **13** is less than 20 mm, a heat conduction blocking effect by the insulation material **80** is low, and thus, there is a concern that dew is generated on the surface of the panel assembly **10**.

[0242] On the other hand, when the overlapping length of the insulation material **80** and the second panel **13** is greater than 50 mm, there may be a disadvantage in that the area on which light is transmitted in the panel assembly **10** is reduced to reduce the visibility of the inner space.

[0243] However, as in the present invention, when the overlapping length D4 of the insulation material **80** and the second panel **13** is set within the range of 20 mm to 50 mm, the visibility may increase, and thermal insulation performance may also be maintained.

[0244] FIG. **15** is a cross-sectional view of a panel assembly according to a second embodiment of



the present invention.

[0245] Referring to FIG. 15, a panel assembly **10a** according to this embodiment includes a first panel **211**, a second panel **212** disposed behind the first panel **211**, and a third panel **213** disposed in front of the first panel **211**. The third panel **213** may be disposed at an opposite side of the second panel **212** with respect to the first panel **211**.

[0246] The first panel **211** and the second panel **212** are spaced apart from each other by a plurality of spacers **221**, and a vacuum insulation space **216** between the first panel **211** and the second panel **212**) is defined.

[0247] All the characteristics described in the first embodiment such as the thickness, the material, the low-emission coating layer of each of the panels described in the first embodiment, the gap between the first panel **11** and the second panel **13**, the degree of the vacuum of the vacuum insulation space, the size or shape of the spacer, the contact ratio of the spacer and the first or second panel, and the structure, the material, and the component of the sealing member may be equally or similarly applied to the second embodiment.

[0248] Thus, only characterized parts in the second embodiment will be described below.

[0249] The first panel **211** may include a first surface **211a** that is a front surface and a second surface **211b** that is a rear surface. The second panel **212** may include a first surface **212a** that is a front surface and a second surface **212b** that is a rear surface. The third panel **213** may include a first surface **213a** that is a front surface and a second surface **213b** that is a rear surface.

[0250] The first surface **212a** of the second panel **212** may face the second surface **211b** of the first panel **211**. The first surface **211a** of the first panel **211** may face the second surface **213b** of the third panel **213**.

[0251] An exhaust hole **211c** for exhausting air may be defined in the first panel **211** to define a vacuum insulation space **216**. A getter **17** is disposed in the exhaust hole **211c**, a getter **17** is installed at a position adjacent to the exhaust hole **211c** in the first panel **211**, or a getter **17** is installed in the second panel **212**.

[0252] Also, a low-emission coating layer may be disposed on at least one of the first panel **211** or the second panel **212**. For example, the low-emission coating layer may be disposed on the first surface **211a** or the second surface **211b** of the first panel **211**, or the low-emission coating layer may be disposed on the first surface **212a** of the second panel **212**.

[0253] The exhaust hole **211c** may be blocked by the cover member **18**. In this case, the cover member **18** may cover the exhaust hole **211c** between the third panel **213** and the first panel **211**. In this case, since the cover member **18** is protected by the third panel **213**, it may be prevented from being damaged by an external force.

[0254] A printed layer **214** may be disposed on the second surface **213b** of the third panel **213**, and the exhaust hole **211c** may be disposed to face the printed layer **214**. That is, the printed layer **214** of the third panel **213** and the exhaust hole **211c** may be disposed to overlap each other in a front and rear direction.

[0255] The first panel **211** and the second panel **212** may have the same size. On the other hand, the third panel **213** may have a size greater than that of the first panel **211**.

[0256] A size relationship between the third panel **213** and the first panel **211** may be the same as the size relationship between the first panel **11** and the second panel **13** described in the first embodiment.

[0257] The third panel **213** may also include the first area and the second area, which are described in the first embodiment, by the printed layer **214** of the third panel **213**.

[0258] The vacuum insulation space **216** between the first panel **211** and the second panel **212** may be sealed by the first sealing member **222**.

[0259] The second surface **211b** of the first panel **211** may include an inclined surface **211d** inclined in a direction that is away from the second panel **212** toward an end side thereof.

[0260] The first surface **212a** of the second panel **212** may include an inclined surface **212c** that

inclines in a direction that is away from the first panel **211** toward an end side thereof.

[0261] The second surface **211b** of the first panel **211** and the first surface **212a** of the second panel **212** except for the inclined surfaces **211d** and **212c** may be parallel to each other.

[0262] The first sealing member **222** may be disposed not only between the two parallel surfaces, but also may be disposed between the inclined surfaces **211d** and **212c**.

[0263] Thus, the first sealing member **222** may include a first portion disposed between the two parallel surfaces and a second portion extending from the first portion and disposed between the inclined surfaces **211d** and **212c**.

[0264] A thickness of the second portion is greater than that of the first portion. When the thickness of the second part is greater than that of the first part, contact areas between the first sealing member **222** and the first panel **211** and between the first sealing member **222** and the second panel **212** may increase to increase in contact strength by the first sealing member **222**, thereby improving sealability.

[0265] The third panel **213** may be spaced apart from the first panel **211** by a spacer **224**. The spacer **224** may also serve to seal a space between the first panel **211** and the third panel **213**.

[0266] An insulation space **217** may also be defined between the third panel **213** and the first panel **211**. The insulation space **217** may be a vacuum insulation space, an insulation space containing air, or an insulation space into which a gas for insulation (e.g., argon gas) is injected.

[0267] If the insulation space **217** between the first panel **211** and the third panel **213** is the vacuum insulation space, an additional exhaust hole may be defined in the first panel **211**, and the first panel **211** and the third panel **213** may be spaced apart from each other by a plurality of additional spacers.

[0268] A gap between the first panel **211** and the third panel **213** may be less than a thickness of the third panel **213** or the first panel **211**.

[0269] In this case, at least a portion of the additional spacer may overlap the spacer **221** disposed between the first panel **211** and the second panel **212** in a front and rear direction. As a result, it may be minimized that visibility is deteriorated by the spacers having a plurality of layers.

[0270] The gap between the first panel **211** and the third panel **213** may be equal to or greater than that between the first panel **211** and the second panel **212**.

[0271] The first surface **211a** of the first panel **211** may include an inclined surface **211e** that moves away from the third panel toward an end thereof. The spacer **224** may be in contact with the inclined surface **211e**. Also, the spacer **224** may also be in contact with a side surface of the first panel **211**.

[0272] Thus, a contact area between the spacer **224** and the first panel **211** and a contact area between the spacer **224** and the third panel **213** may increase.

[0273] FIG. **16** is a view of a door to which the panel assembly is applied according to the second embodiment of the present invention, FIG. **17** is a cutaway cross-sectional view taken along line C-C of FIG. **16**, and FIG. **18** is a cutaway cross-sectional view taken along line D-D of FIG. **17**.

[0274] Referring to FIGS. **16** to **18**, the door **200** according to this embodiment have the same structure as the structure of the door **30** according to the first embodiment except for a structure of a panel assembly **10a**, and thus, the same structure is denoted by the same reference numerals, and the description of the first embodiment will be cited.

[0275] Thus, the door **200** according to this embodiment may also include a door frame **40** supporting the panel assembly **10a** and a door liner **60** connected to the door frame **40**. Also, the door **200** may further include a bracket **50**.

[0276] The door frame **40** may include a first opening **41**, and the door liner **60** may include a second opening **61**. The panel assembly **10a** may cover the first opening **41** and the second opening **61**.

[0277] The door liner **60** may include a bent portion **62** that is bent from the second opening **61** toward the door frame **40**.

[0278] The door frame **40** may be provided as a thin plate and may include a bent portion **42** that is bent inward from the first opening **41**. An inner region of the bent portion **42** substantially becomes the first opening **41**.

[0279] The panel assembly **10a** may be disposed at the first opening **41** to cover the first opening **41** or may cover the first opening **41** from the outside of the first opening **41**.

[0280] When the panel assembly **10a** is disposed inside the first opening **41**, a side surface of the panel assembly **10** may be in contact with the bent portion **42**.

[0281] For example, the side surface of the third panel **213** may be in contact with the bent portion **42**.

[0282] The third panel **213** may define a portion of a front appearance of the door **200**. That is, the panel assembly **10a** may be installed on the door **200** so that the third panel **213** is disposed at the foremost side, and the second panel **212** is disposed at the rearmost side.

[0283] A front surface (first surface) of the third panel **213** may define the same surface as a front surface of the door frame **40**, or a line passing through the front surface of the third panel **213** may pass through the front surface of the door frame **40**. Alternatively, the front surface of the third panel **213** and the front surface of the door frame **40** may be stepped. However, in this case, in order to prevent the third panel **213** from being damaged, the front surface of the third panel **213** may be disposed behind the front surface of the door frame **40**.

[0284] The bracket **50** may include a first portion **51** disposed to face the third panel **213**, a second portion **52** disposed to face the door frame **40**, and a third portion **53** connecting the first portion **51** to the second portion **52**.

[0285] The first portion **51** of the bracket **50** may face a rear surface (second surface) of the third panel **213**, and the second portion **52** of the bracket **50** may face a rear surface of the door frame **40**.

[0286] For example, the first portion **51** of the bracket **50** may be disposed to correspond to the second area (area on which the printed layer is disposed) of the third panel **213**. That is, the first portion **51** of the bracket **50** may be disposed to face the second area of the third panel **213**.

[0287] Thus, even if the panel assembly **10a** is installed on the door **200**, the bracket **50** may be prevented from being exposed to the outside.

[0288] The first portion **51** of the bracket **50** may be provided with a coupling protrusion **54**, and the bent portion **42** may be provided with a protrusion slot (not shown) into which the coupling protrusion **54** is inserted.

[0289] A heater accommodation groove **502** may be defined in the first portion **51** of the bracket **50**. A heater **58** may be accommodated in the heater accommodation groove **502**.

[0290] In the case of this embodiment, since the panel assembly **10a** has a vacuum insulation space, a thickness of the panel assembly may be reduced compared to a structure in which a gas is filled between two panels.

[0291] When the panel assembly **10a** according to this embodiment is applied to the structure of the existing door **30**, a gap between the panel assembly **10a** and the bent portion **62** of the door liner **60** may occur by a reduced thickness of the panel assembly **10a**.

[0292] If, without changing the structure of the existing door liner **60**, the panel assembly **10a** according to this embodiment is used, the door **30** may further include an intermediate member **63** disposed in a spaced portion between the door liner **60** and the panel assembly **10a**.

[0293] One side of the intermediate member **63** may be coupled to the door liner **60**, and the other side may be in contact with the panel assembly **10**. For example, the intermediate member **63** may be in contact with the rear surface (second surface) of the second panel **212**.

[0294] The intermediate member **63** may further include a contact portion **64** to increase in contact area between the intermediate member **63** and the second panel **212**.

[0295] As another example, the door liner **60** may be configured to include the same configuration as the intermediate member **63** by changing the structure of the door liner **60**. In this case, the door

liner **60** may include a contact portion **64** for contacting the second panel **212**.

[0296] In either case, the door frame **40**, the door liner **60**, the bracket **50**, and the panel assembly **10a** may define an insulation space P in which an insulation material **80** is filled.

[0297] The contact portion **64** of the door liner **60** may be in contact with a position spaced a predetermined distance from an edge end of the second panel **212**.

[0298] The insulation material **80** may be in contact with the door frame **40**, the door liner **60**, and the bracket **50**. Also, the insulation material **80** may be in contact with a rear surface (second surface) of the second panel **212**. A portion of the insulation material **80** may be in contact with the contact portion **64** to press the contact portion **64** toward the second panel **212**. Thus, the insulation material between the contact portion **64** and the second panel **212** may be prevented from leaking.

[0299] Since the panel assembly **10a** itself includes the vacuum insulation space, thermal insulation performance may be maintained by the vacuum insulation space, but an outer surface of the panel assembly **10a**, in particular, the sealing member **222** and the spacer **224** may be capable of the heat conduction, and thus, there is a need to prevent the thermal insulation performance by the heat conduction.

[0300] In order to prevent deterioration in thermal insulation performance due to the heat conduction of the panel assembly **10a**, the insulation material **80** may be in contact with the rear surface (second surface) of the second panel **212**. Also, the insulation material **80** may be in contact with a side surface of the second panel **212**, the first sealing member **222**, and a portion of the spacer **16**.

[0301] The insulation material **80** may be disposed to overlap the second panel **212** in a front and rear direction (which may be defined as an arranged direction of the panels). In order to secure the thermal insulation performance, the vertical or horizontal length (overlapping length) **D4** of the portion of the second panel **212** overlapping the insulation material **80** in the front and rear direction may be set within a range of 20 mm to 50 mm. The technical meaning of the overlapping length **D4** of the insulation material **80** and the second panel **212** in the front and rear direction is the same as described in the first embodiment.

[0302] FIG. **19** is a cross-sectional view of a panel assembly according to a third embodiment of the present invention.

[0303] This embodiment is the same as the second embodiment except that there is a difference in distance between a first panel and a third panel at a position of a getter. Thus, only characterized parts in this embodiment will be described below.

[0304] Referring to FIG. **19**, a panel assembly **10c** according to this embodiment includes a first panel **211**, a second panel **212** disposed behind the first panel **211**, and a third panel **213** disposed in front of the first panel **211**.

[0305] The first panel **211** and the second panel **212** are spaced apart from each other by a plurality of spacers **221**, and a vacuum insulation space **216** between the first panel **211** and the second panel **212** is defined.

[0306] In this embodiment, an exhaust hole **212e** may be defined in the second panel **212**. The exhaust hole **212e** may be covered by the cover member **18**. The cover member **18** may cover the exhaust hole **212e** at a side of the second surface **212b** of the second panel **212**.

[0307] An accommodation groove **211f** in which the getter **17** is accommodated may be defined in the second surface **211b** of the first panel **211**. The accommodation groove **211f** may be disposed to face the exhaust hole **212e**. Alternatively, even if the accommodation groove **211f** is not disposed to face the exhaust hole **212e**, the accommodation groove **211f** may be disposed at a position adjacent to the exhaust hole **212e**.

[0308] A printed layer **214** may be disposed on the second surface **213b** of the third panel **213**, and the exhaust hole **211c** and the getter **17** may be disposed to face the printed layer **214**. Thus, the accommodation groove **211f**, the getter **17**, and the exhaust hole **212e** may be prevented from being exposed to the outside by the printed layer **214** provided on the third panel **213**.

[0309] The first panel **211** and the second panel **212** may have the same size. On the other hand, the third panel **213** may have a size greater than that of the first panel **211**.

[0310] The third panel **213** may also include the first area and the second area, which are described in the first embodiment, by the printed layer of the third panel **213**.

[0311] The vacuum insulation space **216** between the first panel **211** and the second panel **212** may be sealed by the first sealing member **222**. The second surface **211b** of the first panel **211** may include an inclined surface **211d** inclined in a direction that is away from the second panel **212** toward an end side thereof.

[0312] The first surface **212a** of the second panel **212** may include an inclined surface **212c** that inclines in a direction that is away from the first panel **211** toward an end side thereof.

[0313] The second surface **211b** of the first panel **211** and the first surface **212a** of the second panel **212** except for the inclined surfaces **211d** and **212c** may be parallel to each other.

[0314] The first sealing member **222** may be disposed not only between the two parallel surfaces, but also may be disposed between the inclined surfaces **211d** and **212c**.

[0315] Thus, the first sealing member **222** may include a first portion disposed between the two parallel surfaces and a second portion extending from the first portion and disposed between the inclined surfaces **211d** and **212c**.

[0316] A thickness of the second portion is greater than that of the first portion. When the thickness of the second part is greater than that of the first part, contact areas between the first sealing member **222** and the first panel **211** and between the first sealing member **222** and the second panel **212** may increase to increase in contact strength by the first sealing member **222**, thereby improving sealability.

[0317] The third panel **213** may be spaced apart from the first panel **211** by a spacer **224**.

[0318] An insulation space **217a** may also be defined between the third panel **213** and the first panel **211**. The insulation space **217a** may be an insulation space into which a gas for insulation (e.g., argon gas) is injected.

[0319] The first surface **211a** of the first panel **211** may include an inclined surface **211e** that moves away from the third panel toward an end thereof. The spacer **224** may be in contact with the inclined surface **211e**. Also, the spacer **224** may also be in contact with a side surface of the first panel **211**. Thus, a contact area between the spacer **224** and the first panel **211** and a contact area between the spacer **224** and the third panel **213** may increase.

[0320] A gap between the first panel **211** and the third panel **213** may be larger than a gap between the first panel **211** and the second panel **212**.

[0321] FIG. **20** is a cross-sectional view of a panel assembly according to a fourth embodiment of the present invention.

[0322] This embodiment is the same as the third embodiment except for a position of a getter and a position of an exhaust hole. Thus, only characterized parts in this embodiment will be described below.

[0323] Referring to FIG. **20**, in case of a panel assembly **10c** according to this embodiment, an exhaust hole **211c** may be defined in a first panel **211**, and an accommodation groove **212f** in which a getter **17** is accommodated may be defined in a second panel **212**.

[0324] The accommodation groove **212f** may be disposed to face the exhaust hole **211c**. Alternatively, even if the accommodation groove **212f** is not disposed to face the exhaust hole **211c**, the accommodation groove **212f** may be disposed at a position adjacent to the exhaust hole **211c**.

[0325] A printed layer **214** may be disposed on the second surface **213b** of the third panel **213**, and the exhaust hole **211c** and the getter **17** may be disposed to face the printed layer **214**. Thus, the accommodation groove **212f**, the getter **17**, and the exhaust hole **211c** may be prevented from being exposed to the outside by the printed layer **214** provided on the third panel **213**.

[0326] FIG. **21** is a view illustrating another example of FIG. **20**.

[0327] Contents of the display of FIG. **21** may be equally applied to the structure of FIG. **19**.

[0328] Referring to FIG. 21, the panel assembly 10c may further include a display 219. The display 219 may be an LCD or an LED.

[0329] The display 219 may be disposed behind, for example, the third panel 213. The display 219 may be disposed in a space 217a between the first panel 211 and the third panel 213. The display 219 may be installed on a rear surface of the third panel 213.

[0330] A signal cable 219a may be connected to the display 219. The signal cable 219a may pass between the spacer 224 and the printed layer 214 and may be drawn out of the panel assembly 10c. As another example, a signal cable 219b connected to the display 219 may pass between the spacer 224 and the front surface of the first panel 211.

[0331] FIG. 22 is a view of a door to which the panel assembly is applied to the refrigerator according to the first embodiment of the present invention, FIG. 23 is a view of a state in which a door lighting unit is turned on in the refrigerator of FIG. 22, and FIG. 24 is a block diagram of the refrigerator of FIG. 22.

[0332] Referring to FIGS. 22 to 24, a refrigerator 300 to which the panel assembly 10 according to this embodiment is applied may include a cabinet defining a storage space and doors 301 and 302 for opening and closing the storage space.

[0333] FIGS. 22 to 24 illustrate the panel assembly 10 according to the first embodiment, but it should be noted that the panel assemblies of the second to fourth embodiments described above may be applied to the refrigerator 300 in the same manner.

[0334] One or more doors 301 and 302 may open and close the storage space. Alternatively, the storage space may be divided into a refrigerating compartment and a freezing compartment, one door 301 may open and close the refrigerating compartment, and the other door 302 may open and close the freezing compartment.

[0335] The panel assembly 10 may be provided on the door 301.

[0336] Since a structure of the door 301 is the same as the structure of the door 30 described in FIG. 9, a detailed description thereof will be omitted.

[0337] The door 301 may include a door storage space 303 in which foods are stored. The door storage space 303 may be a space defined by a basket coupled to the door 301, a space defined between a plurality of baskets, or a space defined by a separate accommodation case.

[0338] The refrigerator 300 may include a door switch 403 for sensing the opening of the door 301, a storage space lighting unit 401 that irradiates light to the storage space of the cabinet, and a controller 400 that controls the storage space lighting unit 401.

[0339] The controller 400 may be turned on the storage space lighting unit 401 when the door switch 403 senses the opening of the door. When the storage space lighting unit 401 is turned on, a user may easily check the foods stored in the storage space.

[0340] The refrigerator 300 may further include a knock sensing device 410 for sensing a knock input to the panel assembly 10 and a door lighting unit 402 for irradiating light so that the door storage space 303 is seen from the outside.

[0341] When it is determined that the knock sensing device 410 senses a normal knock input, the controller 400 may turn on the door lighting unit 402. That is, the door lighting unit 402 may be turned on in a state in which the door 30 is not opened.

[0342] For example, when the normal knock input is sensed, it may be a case that two knock inputs are sensed for a predetermined time.

[0343] As illustrated in FIG. 22, when the door lighting unit 402 is turned off, the door storage space 303 is not visible from the outside in front of the door 301. On the other hand, when the door lighting unit 402 is turned on, as illustrated in FIG. 20, the door lighting unit 402 may irradiate light to the door storage space 303, and some light sequentially pass through the panels of the panel assembly 10.

[0344] Since light passes through the panel assembly 10, the user may check the inside of the door storage space 303 from the outside of the door 301.

[0345] When it is determined that the knock sensing device **410** senses a normal knock input, the controller **400** may turn on the storage space lighting unit **401**.

[0346] Alternatively, when the door lighting unit **402** is not provided in the door **301**, if it is determined that the normal knock input is sensed by the knock sensing device **410**, the storage space lighting unit **401** may be turned on. Even when the storage space lighting unit **401** is turned on, the light irradiated from the storage space lighting unit **401** may pass through the panel assembly **10** to confirm the inside of the door storage space **303** from the outside of the door **301**.

[0347] In the panel assembly **10**, light sequentially passes through the second panel **13** and the first panel **11**. As described above, the first panel **11** is divided into a first area **111** and a second area **112**. Here, the first area **111** is a viewing area through which light is transmitted, and the second area **112** is a non-viewing area through which the transmission of light is restricted.

[0348] FIG. **25** is an exploded perspective view of a knock sensing device according to an embodiment of the present invention, FIG. **26** is a cross-sectional view of a microphone module according to an embodiment of the present invention, and FIG. **27** is a view illustrating a state in which the microphone module is in contact with a panel assembly according to an embodiment of the present invention. FIG. **28** is a view of a state in which the microphone module is in contact with the panel assembly of FIG. **20**.

[0349] Referring to FIGS. **25** to **28**, a knock sensing device **410** according to this embodiment is a device for sensing a knock input of a panel assembly **10** by a user.

[0350] The knock sensing device **410** may include a microphone module **421** that senses a knock input.

[0351] The knock sensing device **410** may further include a holder **423** in which the microphone module **421** is accommodated, an elastic member **424** pressing the holder **423** and the microphone module **421** toward the panel assembly **10**, and a support member **425** supporting the elastic member **424** and the holder **423**.

[0352] The microphone module **421** may include a microphone **4211** that directly senses sound waves and a microphone accommodation portion **4212** that accommodates the microphone **4211**.

[0353] The microphone **4211** directly senses the sound waves and is provided in a circular shape having a predetermined thickness so as to be fixed and mounted inside the microphone accommodation portion **4212**.

[0354] The microphone **4211** may include a sound wave receiving portion **4213** for receiving the sound waves, and the sound wave receiving portion **4213** may be disposed to face an opening **4214** of the microphone accommodation portion **4212**. The sound wave receiving portion **4213** may be disposed at one side of the microphone **4211**.

[0355] A signal line **4216** may be connected to the other side of the microphone **4211**, and the signal line **4216** may be directly or indirectly connected to the controller **400**.

[0356] The microphone accommodation portion **4212** is made of an elastic material such as rubber. For example, the microphone accommodation portion **4212** may be in contact with a rear surface **110b** of the first panel **11** in the panel assembly **10**.

[0357] In practice, since a printed layer **114** may be present on the rear surface **110b** of the first panel **11** in the panel assembly **10**, the microphone accommodation portion **4212** may be described as being in contact with the printed layer **114**.

[0358] Since a second area **112** of the first panel **11** is defined by the printed layer **114**, the microphone accommodation portion **4212** may be described as being in contact with a second area **112** of the first panel **11**.

[0359] The microphone accommodation portion **4212** may have an opening **4214** defined in one side adjacent to the microphone **4211** mounted inside the microphone accommodation portion **4212**, and a circular protrusion **4215** may be provided around the opening **4214**. Thus, the protrusion **4215** may be in close contact with the first panel **11**.

[0360] In a state in which the microphone accommodation portion **4212** and the first panel **11** are in

close contact with each other by the protrusion **4215**, a sealed predetermined space may be defined between the opening **4214** and the sound wave receiving portion **4213**.

[0361] Thus, a front side of the contact space may be sealed by a medium, that is, the first panel **11**. Thus, vibration transmitted through the inside of the medium may allow air to vibrate in a predetermined space, and a sound wave caused by the vibration may be received by the microphone **4211**.

[0362] Due to this sealing, it may be possible to minimize introduction of external noise or vibration into the predetermined space. This may significantly reduce errors in knock input determination and a malfunction due to the external noise to improve a recognition rate of the knock input.

[0363] The holder **423** accommodates the microphone module **421**, and a module seating portion **4231** opened toward the first panel **11** may be provided. In a state in which the microphone module **421** is seated on the module seating portion **4231**, at least the protrusion **4215** may protrude further forward than a front surface of the holder **423**.

[0364] The holder **423** may have a holder slot **4232** through which the signal line connected to the microphone **4211** enters and exits. The holder slot **4232** may be opened at one side of the module mounting portion **4231**.

[0365] Also, a first elastic member fixing portion **4233** may be provided on a rear surface of the holder **423** to protrude so that the elastic member **424** is fixedly mounted. The first elastic member fixing portion **4233** may extend to pass through one end of the coil-shaped elastic member **424**.

[0366] A holder coupling portion **4234** having a hook shape and coupled to the support member **425** may be provided at each of both sides of the holder **423**. The holder **423** may be coupled to the support member **425** by the holder coupling portion **4234**.

[0367] Due to the hook shape of the holder coupling portion **4234**, movement of the holder **423** in an insertion direction toward the inside of the support member **425** may not be restricted by the hook shape of the holder coupling portion **4234**. The support member **425** is provided so that a front surface thereof is opened, and the holder **423** may be inserted through the opened front surface.

[0368] A second elastic member fixing portion (not shown) protruding so that the elastic member **424** is fixedly mounted may be disposed inside the holder **423**. The second elastic member fixing portion may be disposed on the same extension line as the first elastic member fixing portion **4233** and be accommodated inside the elastic member **424**.

[0369] The microphone module **421** may be maintained in the state of being in close contact with the first panel **11** by the elastic member **424**. Particularly, the microphone module **421** may be remained in the state of being in close contact with the first panel **11** without changing a position thereof even due to an impact generated when the door **301** is opened or closed or due to an inertia during rotation of the door **301**.

[0370] A support member slot **4252** may be defined in one side of the support member **425**. The support member slot **4252** may be defined in the same extension line as the holder slot **4232**. Thus, a signal line passing through the holder slot **4242** may pass through the support member slot **4252**.

[0371] A support member fixing portion **4254** may be disposed on the other side of the support member **425**. The support member fixing portion **4254** may be provided to extend outward and be fixed to the door frame **40** or the connection members **70** and **72** or may be fixed to a separate case coupled to the door frame **40** or the connection members **70** and **72**.

[0372] Referring to FIG. **28**, when the panel assembly **10c** additionally includes a third panel **213**, the microphone module **421** may be disposed on an area corresponding to the printed layer **214** of the third panel **213**. For example, the microphone module **421** may be in contact with the printed layer **214** of the third panel **213**.

[0373] FIG. **29** is a cross-sectional view illustrating a state in which the door lighting unit is installed on a door according to an embodiment of the present invention.



[0374] Referring to FIG. 29, the door lighting unit **402** may be installed on the door liner **60**.

[0375] The door lighting unit **402** may include a case **441** and a cover **443** covering the case **411**.

[0376] The cover **443** may extend lengthily in a horizontal direction along the door liner **60**. The case **441** defines a space for accommodating a light emitting unit PCB **422** in which a plurality of light emitting units **442a** are installed.

[0377] In the case **441**, a surface facing the light emitting unit PCB **442** may be round, and light irradiated from the light emitting unit **442a** may be reflected through a rounded surface **441a** having a predetermined curvature to travel toward the cover **443**.

[0378] A film for improving reflectance of light may be attached, or a coating layer may be disposed on the rounded surface **441a**.

[0379] The cover **443** may be provided so that the light reflected from the rounded surface **441a** is transmitted. The cover **443** may be transparent or translucent so that light reflected and spread from the round surface **441a** is transmitted. Therefore, the light passing through the cover **433** illuminates the door storage space in an indirect lighting manner and has the same effect as surface light emission.

[0380] The cover **443** may be attached with the film or coated to diffuse the light more effectively.

[0381] A portion of the light passing through the cover **443** may be irradiated to an auxiliary storage space **303**, and the other portion may be irradiated toward the second panel **13**. The light irradiated toward the second panel **13** may pass through the first panel **11** after passing through the second panel **13**.

[0382] When the first panel **11** defines an outer appearance of the refrigerator, the knock sensing device **410** may be in contact with the first panel **11**. As another embodiment, when the third panel **213** defines an outer appearance of the refrigerator, the knock sensing device **410** may be in contact with the third panel **213**.

[0383] The door lighting unit **402** may be disposed to be biased to either side of the door **301**, or a plurality of door lighting units **402** may be disposed to be symmetrical to each other in the door **301**.

[0384] In any case, some of the spacers **165** may be disposed closer to the door lighting unit **402** than other spacers **166** based on the plurality of spacers **16**.

[0385] As illustrated in FIG. 29, an amount of light or an intensity of light reaching to the spacer **165** disposed close to the door lighting unit **402** may be greater than an amount of light or an intensity of light reaching the spacer **166** disposed far from the door lighting unit **402**.

[0386] In views of visibility of the inner space of the home appliance, since it is preferable to minimize that the spacers **165** and **166** are exposed to the outside, a diameter (or size) D5 of one spacers **165** disposed close to the door lighting unit **402** may be less than a diameter (or size) D6 of the other spacer **166** disposed away from the door lighting unit **402**.

[0387] FIG. 30 is a view illustrating another example in which the panel assembly is applied to the refrigerator according to the present invention. FIG. 31 is a cutaway cross-sectional view taken along line E-E of FIG. 30, FIG. 32 is a sectional view taken along line F-F of FIG. 30, and FIG. 33 is an enlarged view of a portion B of FIG. 32.

[0388] FIG. 32 illustrates a positional relationship between a basket **505** and a second door **520** provided in a first door **512**.

[0389] Referring to FIGS. 30 to 33, a refrigerator **500** according to this embodiment may include a cabinet **501** including a storage space and a plurality of doors **510** and **540** for opening and closing the storage space.

[0390] The storage space may include a refrigerating compartment and a freezing compartment, and the plurality of doors **510** and **540** may include a refrigerating compartment door **510** and a freezing compartment door **540**.

[0391] For example, in this embodiment, the refrigerating compartment may be disposed above the freezing compartment.

[0392] The refrigerating compartment may be opened and closed by one or a plurality of refrigerating compartment doors **510**. In FIG. **30**, as an example, two refrigerator compartment doors **510** are opened and closed as the refrigerator compartment door.

[0393] The freezing compartment may be opened and closed by one or more freezing compartment doors **540**.

[0394] The refrigerating compartment door **510** may include a first door **512** that opens and closes the refrigerating compartment and a second door **520** that is rotatable with respect to the first door **512**.

[0395] The first door **512** may include an opening **504** and a door storage space **506**. The door storage space **506** may be an inner space of the basket **505**, a space disposed between a plurality of baskets **505**, or a space defined by a separate case.

[0396] The second door **520** may open and close the opening **504**. The second door **520** may include a panel assembly **10**. The panel assembly **10** may cover at least a portion of the opening **504**.

[0397] FIGS. **30** to **32** illustrate that the second door **520** includes the panel assembly **10** according to the first embodiment, but it should be noted that the panel assemblies of the second to fourth embodiments described above may be applied to the second door **520** in the same manner.

[0398] The second door **520** may include a door frame **40a** supporting the panel assembly **10a** and a door liner **60a** connected to the door frame **40a**. Also, the second door **520** may further include a bracket **50a**.

[0399] Fundamental functions of the door frame **40a**, the door liner **60a**, and the bracket **50a** may be the same as or similar to those mentioned in the first embodiment.

[0400] The door frame **40a** may include a first opening **41a**, and the door liner **60a** may include a second opening **61a**. The panel assembly **10** may cover the first opening **41a** and the second opening **61a**.

[0401] The door liner **60a** may include a bent portion **62a** that is bent from the second opening **61a** toward the door frame **40a**. Alternatively, the door liner **60a** may include a bent portion **62a** extending toward the first opening **41a**, and the bent portion **62a** may define the second opening **61a**.

[0402] The door frame **40a** may be provided as a thin plate and may include a bent portion **42a** that is bent inward from the second opening **41a**. An inner region of the bent portion **42a** substantially becomes the second opening **41a**.

[0403] The panel assembly **10** may be disposed at the second opening **41a** to cover the second opening **41a** or may cover the second opening **41a** from the outside of the second opening **41a**.

[0404] A side surface of the panel assembly **10** may be in contact with the bent portion **42a**. For example, the side surface of the first panel **11** may be in contact with the bent portion **42a**.

[0405] The first panel **11** may define a portion of the front appearance of the second door **520**. A front surface (first surface) of the first panel **11** may define the same surface as a front surface of the door frame **40a**, or a line passing through the front surface of the first panel **11** may pass through the front surface of the door frame **40a**. Alternatively, the front surface of the first panel **11** and the front surface of the door frame **40a** may be stepped. However, in this case, in order to prevent the first panel **11** from being damaged, the front surface of the first panel **11** may be disposed behind the front surface of the door frame **40a**.

[0406] The bracket **50a** may include a first portion **51a** disposed to face the first panel **11**, a second portion **52a** disposed to face the door frame **40a**, and a third portion **53a** connecting the first portion **51a** to the second portion **52a**.

[0407] The first portion **51a** of the bracket **50a** may face a rear surface (second surface) of the first panel **11**, and the second portion **52a** of the bracket **50a** may face a rear surface of the door frame **40a**.

[0408] For example, the first portion **51a** of the bracket **50a** may be disposed to correspond to the

second area of the first panel **11**. That is, the first portion **51a** of the bracket **50a** may be disposed to face the second area of the first panel **11**.

[0409] Thus, even if the panel assembly **10** is installed on the second door **520**, the bracket **50a** may be prevented from being exposed to the outside.

[0410] The first portion **51a** of the bracket **50a** may be provided with a coupling protrusion **54a**, and the bent portion **42a** may be provided with a protrusion slot (not shown) into which the coupling protrusion **54a** is inserted.

[0411] A heater accommodation groove **502a** may be defined in the first portion **51a** of the bracket **50a**. A heater **58** may be accommodated in the heater accommodation groove **502a**.

[0412] In the case of this embodiment, since the panel assembly **10** has a vacuum insulation space, a thickness of the panel assembly may be reduced compared to a structure in which a gas is filled between two panels.

[0413] When the panel assembly **10** according to this embodiment is applied to the structure of the existing second door **520**, a gap between the panel assembly **10** and the bent portion **62a** of the door liner **60a** may occur by a reduced thickness of the panel assembly **10**.

[0414] If, without changing the structure of the existing door liner **60a**, the panel assembly **10** according to this embodiment is used, the second door **520** may further include an intermediate member **63a** disposed in a spaced portion between the door liner **60a** and the panel assembly **10**.

[0415] One side of the intermediate member **63a** may be coupled to the door liner **60a**, and the other side may be in contact with the panel assembly **10**. For example, the intermediate member **63a** may be in contact with the rear surface (second surface) of the second panel **13**.

[0416] The intermediate member **63a** may further include a contact portion **64a** to increase in contact area between the intermediate member **63a** and the second panel **13**.

[0417] As another example, the door liner **60a** may be configured to include the same configuration as the intermediate member **63a** by changing the structure of the door liner **60a**. In this case, the door liner **60a** may include a contact portion **64a** for contacting the second panel **13**.

[0418] In either case, the door frame **40**, the door liner **60**, the bracket **50**, and the panel assembly **10** may define an insulation space in which an insulation material **80** is filled.

[0419] The contact portion **64a** of the door liner **60a** may be in contact with a position spaced a predetermined distance from an edge end of the second panel **13**.

[0420] The insulating material **80** may be in contact with the door frame **40a**, the door liner **60a**, and the bracket **50a**. Also, the insulation material **80** may be in contact with a rear surface (second surface) of the second panel **13**. A portion of the insulating material **80** may be in contact with the contact portion **64a** to press the contact portion **64a** toward the second panel **13**. Thus, the insulation material may be prevented from leaking between the contact portion **64a** and the second panel **13**.

[0421] Since the panel assembly **10a** itself includes the vacuum insulation space, thermal insulation performance may be maintained by the vacuum insulation space, but an outer surface of the panel assembly **10a**, in particular, the sealing member **222** may be capable of the heat conduction, and thus, there is a need to prevent the thermal insulation performance by the heat conduction.

[0422] In order to prevent deterioration in thermal insulation performance due to the heat conduction of the panel assembly **10**, the insulation material **80** may be in contact with the rear surface (second surface) of the second panel **13**. Also, the insulation material **80** may be in contact with a side surface of the second panel **13** and a portion of the sealing member **15**.

[0423] The insulation material **80** may be disposed to overlap the second panel **13** in a front and rear direction (which may be defined as an arranged direction of the panels). In order to secure the thermal insulation performance, an overlapping length **D4** of the insulation material **80** and the second panel **13** in a front and rear direction may be set within a range of 20 mm to 50 mm. The technical meaning of the overlapping length **D4** of the insulation material **80** and the second panel **13** in the front and rear direction is the same as described in the first embodiment.

[0424] Also, it is noted that the configuration and functions for transmitting light through the panel assembly by turning on the lighting unit by sensing the knock input described above may be applied to this refrigerator in the same manner.

[0425] As described above, if a thickness of the panel assembly **10** decreases, a size of the basket **505** may increase. When the size of the basket **505** increases, a volume of the door storage space defined by the basket **505** may increase.

[0426] For example, a portion of the basket **505** may pass through the opening **504** to protrude forward from a front surface of the first door **512**. As described above, even if the front surface of the basket **505** protrudes from the first door **512**, the basket **505** may not interfere with the panel assembly **10**.

[0427] Referring to FIG. **32**, a portion of the basket **505** may be disposed on an area defined by the door liner **60a**. That is, a front surface **505a** of the basket **505** may be disposed adjacent to a rear surface of the panel assembly **10** (for example, the second panel **13**).

[0428] Thus, the front surface **505a** of the basket **505** may be disposed closer to the second panel **13** than one point of the door liner **60a**.

[0429] The front surface **505a** of the basket **505** may be spaced apart from the second panel **13** to prevent the front surface **505a** of the basket **505** and the second panel **13** from being in contact with each other. A spaced distance **D7** between the front surface **505a** of the basket **505** and the second panel **13** may be greater than a thickness of the second panel **13**.

[0430] The spaced space between the front surface **505a** of the basket **505** and the second panel **13** may provide a path for light irradiated from the door lighting unit **402**.

[0431] The front surface **505a** of the basket **505** may be disposed in a space defined by an insulation material **80** provided in the insulation space **P**.

[0432] To prevent the basket **505** and the door liner **60a** from interfering with each other during the rotation of the second door **520**, both side surfaces **505b** of the basket **505** may be spaced apart from the intermediate member **63a** of the door liner **60a**. The intermediate member **63a** may define a space in which the basket **505** is disposed. When the intermediate member **63a** is integrated with the door liner **60a**, the intermediate member **63a** is referred to as an inner member defining a space in the door liner **60a** in which the basket **505** is disposed (or it may also be referred to as the bent portion described above).

[0433] A horizontal distance from a rotation center of the second door **520** to one surface of both side surfaces **505b** of the basket **505** may be greater than a maximum horizontal distance from the rotation center of the second door to the intermediate member (or the inner member) of the door liner **60a** to prevent the basket **505** and the door liner **60a** from interfering with each other during the rotation of the second door **520**.

[0434] A spaced distance **D8** between each of both side surfaces **505b** of the basket **505** and the intermediate member **63a** is greater than a spaced distance **D7** between the front surface **505a** of the basket **505** and the second panel **13**. The spaced distance **D8** between each of both side surfaces **505b** of the basket **505** and the intermediate member **63a** may be determined based on a rotation trajectory of the second door **520** and the spaced distance **D7** between the front surface **505a** of the basket **505** and the second panel **13**.

[0435] The spaced space between both side surfaces **505b** of the basket **505** and the intermediate member **63a** may provide a path for light irradiated from the door lighting unit **402**.

[0436] In FIGS. **30** to **32**, the relationship between the panel assembly **10** and the door lighting unit **402** in the second door **520** has been described, but the related information may be applied equally even when the refrigerator includes one door. For example, the door lighting unit **402** may be disposed in the frame assembly **90** of the refrigerating compartment door or the freezing compartment door, and a size of each of the spacers may be determined according to the arrangement relationship between the door lighting unit **420** and the spacers.

[0437] A storage space lighting unit **401** may be provided in the cabinet **501**. The position of the

storage space lighting unit **401** is not limited. For example, the storage space lighting unit **401** may be disposed at a front end (a position adjacent to the door) of the cabinet **501** or on a rear wall defining the storage space.

[0438] In this case, even when the door lighting unit **402** does not exist, if the storage space lighting unit **401** is turned on, the inside of the storage space may be visualized by the light of the storage space lighting unit **401**.

[0439] The storage space lighting unit **402** may be disposed on an upper wall of the cabinet **501**, a lower wall, or at least one of both sidewalls.

[0440] When the storage space lighting unit **402** is disposed on the wall defining the storage space, an amount of light or intensity of light reaching the other spacers disposed at the center of the panel assembly **10** may be greater than an amount or intensity of light reaching the spacer disposed at the outer side of the panel assembly **10**.

[0441] In this case, among the plurality of spacers, a diameter (or size) of the spacer disposed at the center of the panel assembly **10** may be less than a diameter (or size) of the spacer disposed on the outer side of the panel assembly.

[0442] FIG. **34** is a view illustrating another example in which the panel assembly is applied to the refrigerator according to the present invention.

[0443] FIG. **34** illustrates a side-by-side type refrigerator as an example.

[0444] Referring to FIG. **34**, in the refrigerator **600** of this embodiment, a freezing compartment **603** and a refrigerating compartment **602** may be disposed at left and right sides. The freezing compartment **603** may be opened and closed by a freezing compartment door **620**, and the refrigerating compartment **602** may be opened and closed by a refrigerating compartment door **610**.

[0445] The refrigerating compartment door **610** may include the panel assembly **10** described above, and a structure of the refrigerating compartment door **610** may be the same as or similar to the structure of the door **30** described in FIGS. **9** to **11**.

[0446] FIG. **34** illustrates that the refrigerating compartment door **610** includes the panel assembly **10** according to the first embodiment, but it should be noted that the panel assemblies of the second to fourth embodiments described above may be applied to the refrigerating compartment door **610** in the same manner.

[0447] Also, it is noted that the configuration and functions for transmitting light through the panel assembly by turning on the lighting unit by sensing the knock input described above may be applied to this refrigerator in the same manner.

[0448] FIG. **35** is a view illustrating a state in which the panel assembly is applied to a cloth processor that is an example of a home appliance.

[0449] Referring to FIG. **35**, in the case of a cloth processor, an inner space **702** for processing such as sterilization and storage of clothes is provided, and the inner space **702** may be opened and closed by a door **710**. The door **710** may include the panel assembly **10** described above.

[0450] A structure of the door **710** according to this embodiment may be the same as or similar to the structure of the door described above. For example, the door of the home appliance may include a frame including an opening, and a panel assembly connected to the frame to cover the opening. An insulation material may be or may not be provided inside the frame.

[0451] FIG. **35** illustrates that the door **710** includes the panel assembly **10** according to the first embodiment, but it should be noted that the panel assemblies of the second to fourth embodiments described above may be applied to the door **710** in the same manner.

[0452] Also, it is noted that the configuration and functions for transmitting light through the panel assembly by turning on the lighting unit by sensing the knock input described above may be applied to this cloth processor in the same manner.

[0453] Also, although not presented in the this specification, if the home appliance includes the inner space and a door including the inner space and a door that opens and closes the inner space, the panel assembly of the present invention may be provided on the door, the configuration and

functions for transmitting light through the panel assembly by turning on the lighting unit due to the sensing of a knock input may be applied in the same manner.

## Claims

1. A refrigerator comprising: a cabinet having an inner space; and a door configured to open and close at least a portion of the inner space, the door comprising (i) a frame assembly having an opening, (ii) a panel assembly that covers the opening, and (iii) an insulation material provided in an insulation space that is defined by the frame assembly and the panel assembly, wherein the panel assembly comprises: a first panel made of a glass material, the first panel defining a front surface of the door, a second panel spaced apart from the first panel and made of a glass material, wherein a size of the first panel is greater than a size of the second panel, and a seal disposed between the first panel and the second panel and configured to block a space between the first panel and the second panel, wherein the insulation material overlaps with the second panel, and wherein an overlapping length between the insulation material and the second panel is greater than a thickness of the panel assembly.
2. The refrigerator of claim 1, wherein the frame assembly comprises: a door frame that defines the opening; a door liner connected to the door frame; and a connection member that connects the door frame to the door liner.
3. The refrigerator of claim 2, wherein the door frame comprises a bent portion that is bent at the opening and that faces a side surface of the first panel.
4. The refrigerator of claim 2, wherein the connection member defines a plurality of injection holes.
5. The refrigerator of claim 2, wherein the door liner comprises a contact portion that is in contact with the second panel and that is disposed between a portion of the insulation material and the second panel.
6. The refrigerator of claim 5, wherein a length of the contact portion along the second panel is greater than a thickness of at least one of the first panel or the second panel.
7. The refrigerator of claim 5, wherein a length of the contact portion along the second panel is greater than a thickness of the contact portion.
8. The refrigerator of claim 2, wherein the frame assembly further comprises an intermediate member that connects the door liner to the second panel, the intermediate member comprising a contact portion that is in contact with the second panel.
9. The refrigerator of claim 8, wherein the contact portion is disposed between a portion of the insulation material and the second panel.
10. The refrigerator of claim 8, wherein a length of the contact portion along the second panel is greater than a thickness of at least one of the first panel or the second panel.
11. The refrigerator of claim 8, wherein a length of the contact portion along the second panel is greater than a thickness of the contact portion.
12. The refrigerator of claim 1, wherein the first panel and the second panel are arranged in a first direction, and wherein the first panel comprises a printed layer that overlaps with a portion of the insulation material in the first direction.
13. The refrigerator of claim 12, wherein the insulation material is in contact with the printed layer.
14. The refrigerator of claim 1, wherein the first panel and the second panel are arranged in a first direction, and wherein the insulation material overlaps with the space between the first panel and the second panel in the first direction.
15. The refrigerator of claim 1, wherein the door further comprises: a heater that faces the first panel; and a bracket that supports the heater.
16. The refrigerator of claim 15, wherein the insulation material is in contact with the bracket.
17. The refrigerator of claim 15, wherein the bracket comprises (i) a first portion that faces the first panel and (ii) a second portion that faces a front surface of the frame assembly.

- 18.** The refrigerator of claim 17, wherein the first portion of the bracket is disposed between a portion of the insulation material and the first panel, and wherein the second portion of the bracket is disposed between another portion of the insulation material and the frame assembly.
- 19.** The refrigerator of claim 1, wherein the second panel defines an exhaust hole configured to discharge air from the space between the first panel and the second panel, and wherein the panel assembly further comprises a cover configured to cover the exhaust hole.
- 20.** The refrigerator of claim 19, wherein the insulation material is in contact with the cover.
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