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(54) Title: SURFACE LAYER FOR FAST DIFFUSION AND METHOD TO PRODUCE THEREOF

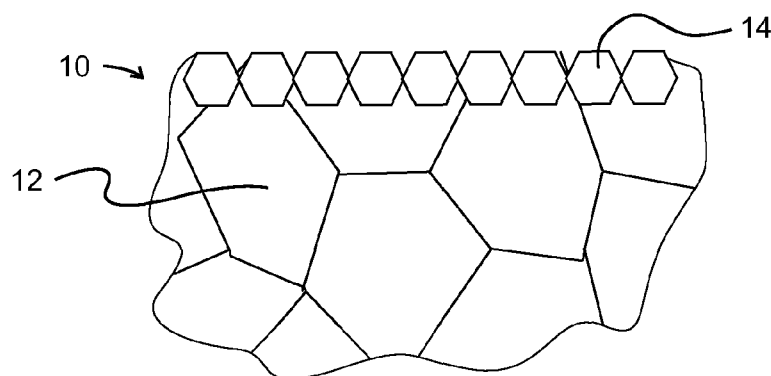


FIG. 2

(57) Abstract: A number of variations may include a method that may include laser shock peening a friction work surface of a work part and applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.

SURFACE LAYER FOR FAST DIFFUSION AND METHOD TO PRODUCE
THEREOF

TECHNICAL FIELD

[0001] The field to which the disclosure generally relates includes ferritic nitrocarburizing processes.

BACKGROUND

[0002] Ferritic nitrocarburizing processes utilize a furnace treatment for a predetermined amount of time in order to diffuse carbon and nitrogen into the surface of a part. Preparing the surface of a part prior to heat treatment may increase or decrease the diffusion rate on the surface of the part.

SUMMARY OF ILLUSTRATIVE VARIATIONS

[0003] A number of variations may include a method that may include laser shock peening a friction work surface of a working part and may include applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0004] A number of variations may include a method that may include machining a friction work surface of a working part; laser shock peening the friction work surface; and applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0005] A number of variations may include a method that may include applying a stress relief treatment to the working part at a temperature ranging from

about 610° C for 3 hours; machining a friction work surface of a working part; laser shock peening the friction work surface utilizing a high power density laser having a power of about 1 GW/cm² including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm; and applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0006] A number of variations may include a method that may include machining a friction work surface of a working part; laser shock peening the friction work surface utilizing a high power density laser having a power greater than or equal to 1 GW/cm² including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm; and applying a ferritic nitrocarburizing process for about 8 to about 12 hours at about 465° C to about 495° C to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0007] A number of variations may include a product that may include a part that may include a friction working surface that has been cast, undergone a stress relief process at about 610° C for about 3 hours, machined, and a laser shock peened amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

[0008] A number of variations may include a product that may include a part that may include a friction working surface that has been cast, machined, laser shock peened, and treated with a ferritic nitrocarburizing process ranging from about 555° C to about 585° C for about 1 to about 3 hours and an amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

[0009] Other illustrative variations within the scope of the invention will become apparent from the detailed description provided hereinafter. It should be understood that the detailed description and enumerated variations, while disclosing optional variations, are intended for purposes of illustration only and are not intended to limit the scope of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0010] Select examples of variations within the scope of the invention will become more fully understood from the detailed description and the accompanying drawings, wherein:

[0011] Figure 1 depicts one variation of a cast iron brake rotor; and

[0012] Figure 2 depicts one variation of a part that may include a friction working surface.

DETAILED DESCRIPTION OF ILLUSTRATIVE VARIATIONS

[0013] The following description of the variations is merely illustrative in nature and is in no way intended to limit the scope of the invention, its application, or uses. The following description of variants is only illustrative of components, elements, acts, methods, and methods considered to be within the scope of the invention and are not in any way intended to limit such scope by what is specifically disclosed or not expressly set forth. The components, elements, acts, methods, and methods as described herein may be combined and rearranged other than as expressly described herein and still are considered to be within the scope of the invention.

[0014] A working part, such as a brake disc or drum brake, may have a friction working surface. The working part may include cast iron. The friction

working surface may undergo a ferritic nitrocarburizing process involving a heat treatment step for a predetermined amount of time. Prior to undergoing the ferritic nitrocarburizing process, the friction working surface may undergo a surface treatment such as machining, shot peening, or cold working. Alternatively, the friction working surface may undergo a laser shock peening or laser shock peening process to form a nanocrystalline layer or amorphous layer on the surface of the working part. A nanocrystalline layer may have grain sizes ranging from about 5nm to about 1000nm. An amorphous layer may have an amorphous structure. The nanocrystalline layer or amorphous layer may range from about 5 to about 500 microns in depth.

[0015] The laser shock peening process may utilize a laser having a pulse energy of 3 Joules and a pulse duration of 20 nanoseconds. The diameter of the laser beam may be about 3 millimeters. The scan frequency of the laser shock peening process may be about 2 Hz.

[0016] After the laser shock peening process, the working part may undergo a ferritic nitrocarburizing process at a temperature ranging from about 570° C to about 580° C for about 1 to about 3 hours or from about 465° C to about 495° C for about 2-10 hours to achieve a compound layer about 10 microns in depth..

[0017] One process may include casting an iron brake drum or disk, stress relieving the brake at 610°C for 3 or more hours, machining the friction working surface of the brake, laser shock peening the friction working surface, and nitrocarburizing the brake at 570° C for about 1 hour or at a temperature ranging from about 555° C to about 585° C for about 2-5 hours.

[0018] One process may include casting an iron brake drum or disk, machining the friction working surface of the brake, laser shock peening the friction

working surface and nitro-carburizing the brake at 480°C for about 8 to about 10hours.

[0019] Referring to Figures 1 & 2, a number of variations may include a product that may include a part 10 that may include a friction working surface 12 that has been cast, undergone a stress relief process at about 610° C for about 3 hours, machined, and a laser shock peened amorphous layer 14 disposed on the friction working surface 12 wherein the amorphous layer 14 ranges from about 5 microns to about 500 microns in depth.

[0020] According to variation 1, a method may include laser shock peening a friction work surface of a working part and may include applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.

[0021] Variation 2 may include a method as set forth in variation 1 wherein the laser shock peening process may refine the microstructure of the friction work surface such that a nanocrystalline layer of about 5 to about 500 μm in depth is formed.

[0022] Variation 3 may include a method as set forth in variation 1 or 2 wherein the laser shock peening process refines the microstructure of the friction work surface such that an amorphous layer of less than or equal to about 500 μm in depth is formed.

[0023] Variation 4 may include a method as set forth in any of variations 1 through 3 wherein the laser shock peening process utilizes a high power density laser having a power ranging from about 0.5 GW/cm^2 to about 5 GW/cm^2 .

[0024] Variation 5 may include a method as set forth in any of variations 1 through 4 wherein the ferritic nitrocarburizing process may include a furnace treatment for about 2-6 hours at about 555° C to about 585° C.

[0025] Variation 6 may include a method as set forth in any of variations 1 through 5 wherein the ferritic nitrocarburizing process may include a furnace treatment for about 2-4 hours at about 570° C - 580° C.

[0026] Variation 7 may include a method as set forth in any of variations 1 through 6 wherein the laser shock peening process includes a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm.

[0027] Variation 8 may include a method as set forth in any of variations 1 through 7 and may further include, prior to laser shock peening the friction work surface, applying a stress relief treatment to the working part at about 610° C for about 2-4 hours.

[0028] Variation 9 may include a method as set forth in any of variations 1 through 8 further may include, prior to laser shock peening the friction work surface, machining the friction work surface.

[0029] According to variation 10, a method may include machining a friction work surface of a working part; laser shock peening the friction work surface; and applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0030] Variation 11 may include a method as set forth in variation 10 wherein the ferritic nitrocarburizing process may include a furnace treatment for about 8 to about 12 hours at about 455° C to about 495° C.

[0031] Variation 12 may include a method as set forth in any of variations 10 through 11 wherein the laser shock peening process refines the microstructure of the friction work surface such that a nanocrystalline layer of about 5 to about 500 μm in depth is formed.

[0032] Variation 13 may include a method as set forth in any of variations 10 through 12 wherein the laser shock peening process refines the microstructure of the friction work surface such that an amorphous layer is formed.

[0033] Variation 14 may include a method as set forth in any of variations 10 through 13 wherein the laser shock peening process utilizes a high power density laser having a power ranging from about 0.5 GW/cm^2 to about 5 GW/cm^2 .

[0034] Variation 15 may include a method as set forth in any of variations 10 through 14 wherein the laser shock peening process includes a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm.

[0035] Variation 16 may include a method as set forth in any of variations 10 through 15 may further include, prior to laser shock peening the friction work surface, applying a stress relief treatment to the working part at about 610° C for greater than or equal to about 3 hours.

[0036] According to variation 17, a method may include applying a stress relief treatment to the working part at about 610° C for 3 hours; machining a friction work surface of a working part; laser shock peening the friction work surface utilizing a high power density laser having a power of about 1 GW/cm^2 including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm; and applying a ferritic nitrocarburizing process to the friction

work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0037] Variation 18 may include a method as set forth in variation 17 wherein the ferritic nitrocarburizing process may include a furnace treatment ranging from about 1 to about 3 hours at about 555° C to about 585° C.

[0038] Variation 19 may include a method as set forth in any of variations 17 through 18 wherein the ferritic nitrocarburizing process may include a furnace treatment ranging from about 8 to about 12 hours at about 465° C to about 495° C.

[0039] According to variation 20, a method may include laser shock peening a friction work surface of a working part utilizing a high power density laser having a power greater than or equal to 1 GW/cm² including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm; and applying a ferritic nitrocarburizing process for about 8 to about 12 hours at about 465° C to about 495° C to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface may be accelerated.

[0040] According to variation 21, a product may include a part that may include a friction working surface that has been cast, undergone a stress relief process at about 610° C for about 3 hours, machined, and a laser shock peened and an amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

[0041] Variation 22 may include a product as set forth in variation 21 wherein the part is a cast iron brake rotor.

[0042] According to variation 23, a product may include a part may include a friction working surface that has been cast, machined, laser shock peened, and treated with a ferritic nitrocarburizing process at about 450° C for about 2 to about 4 hours

and an amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

[0043] Variation 24 may include a product as set forth in variation 23 wherein the part is a cast iron brake rotor.

[0044] The above description of variations of the invention is merely demonstrative in nature and, thus, variations thereof are not to be regarded as a departure from the spirit and scope of the inventions disclosed within this document.

CLAIMS

What is claimed is:

1. A method comprising:
laser shock peening a friction work surface of a working part; and
applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.
2. The method according to claim 1 wherein the laser shock peening process refines the microstructure of the friction work surface such that a nanocrystalline layer of about 5 to about 500 μm in depth is formed.
3. The method according to claim 1 wherein the laser shock peening process refines the microstructure of the friction work surface such that an amorphous layer of less than or equal to about 500 μm in depth is formed.
4. The method according to claim 1 wherein the laser shock peening process utilizes a high power density laser having a power ranging from about 0.5 GW/cm^2 to about 5 GW/cm^2 .
5. The method according to claim 1 wherein the ferritic nitrocarburizing process comprises a furnace treatment for about 2-6 hours at about 555°C to about 585°C .

6. The method according to claim 1 wherein the ferritic nitrocarburizing process comprises a furnace treatment for about 2-4 hours at about 570° C - 580° C.

7. The method according to claim 1 wherein the laser shock peening process includes a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm.

8. The method according to claim 1, further comprising, prior to laser shock peening the friction work surface, applying a stress relief treatment to the working part at about 610° C for about 2-4 hours.

9. The method according to claim 1, further comprising, prior to laser shock peening the friction work surface, machining the friction work surface.

10. A method comprising:

machining a friction work surface of a working part;

laser shock peening the friction work surface; and

applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.

11. The method according to claim 10, wherein the ferritic nitrocarburizing process comprises a furnace treatment for about 8 to about 12 hours at about 455° C to about 495° C.

12. The method according to claim 1 wherein the laser shock peening process refines the microstructure of the friction work surface such that a nanocrystalline layer of about 5 to about 500 μm in depth is formed.

13. The method according to claim 1 wherein the laser shock peening process refines the microstructure of the friction work surface such that an amorphous layer is formed.

14. The method according to claim 1 wherein the laser shock peening process utilizes a high power density laser having a power ranging from about 0.5 GW/cm^2 to about 5 GW/cm^2 .

15. The method according to claim 1 wherein the laser shock peening process includes a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm.

16. The method according to claim 1, further comprising, prior to laser shock peening the friction work surface, applying a stress relief treatment to the working part at about 610°C for greater than or equal to about 3 hours.

17. A method comprising:

applying a stress relief treatment to the working part at about 610°C for 3 hours;

machining a friction work surface of a working part;

laser shock peening the friction work surface utilizing a high power density laser having a power of about 1 GW/cm² including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm.; and

applying a ferritic nitrocarburizing process to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.

18. The method according to claim 17 wherein the ferritic nitrocarburizing process comprises a furnace treatment ranging from about 1 to about 3 hours at about 555° C to about 585° C.

19. The method according to claim 17 wherein the ferritic nitrocarburizing process comprises a furnace treatment ranging from about 8 to about 12 hours at about 465° C to about 495° C.

20. A method comprising:

machining a friction work surface of a working part;

laser shock peening the friction work surface utilizing a high power density laser having a power greater than or equal to 1 GW/cm² including a pulse energy of about 3 Joules, pulse duration of about 20 nanoseconds, and a laser beam diameter of about 3mm; and

applying a ferritic nitrocarburizing process for about 8 to about 12 hours at about 465° C to about 495° C to the friction work surface such that diffusion of carbon and nitrogen atoms into the friction work surface is accelerated.

21. A product comprising:

a part comprising a friction working surface that has been cast, undergone a stress relief process at about 610° C for about 3 hours, machined, and a laser shock peened and an amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

22. The product according to claim 21, wherein the part is a cast iron brake rotor.

23. A product comprising:

a part comprising a friction working surface that has been cast, machined, laser shock peened, and treated with a ferritic nitrocarburizing process at about 450° C for about 2 to about 4 hours and an amorphous layer disposed on the friction working surface wherein the amorphous layer ranges from about 5 microns to about 500 microns in depth.

24. The product according to claim 23, wherein the part is a cast iron brake rotor.

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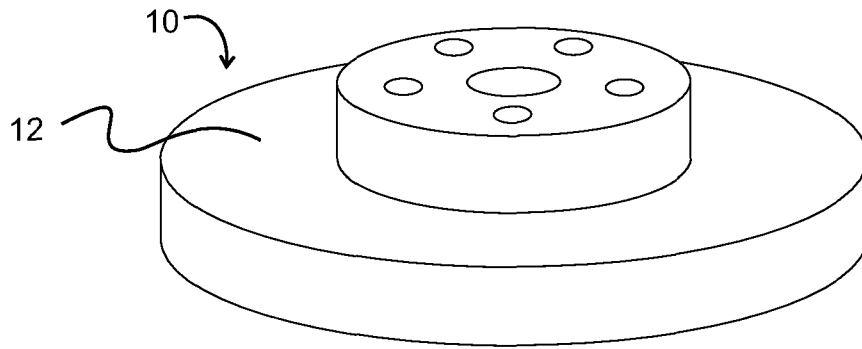


FIG. 1

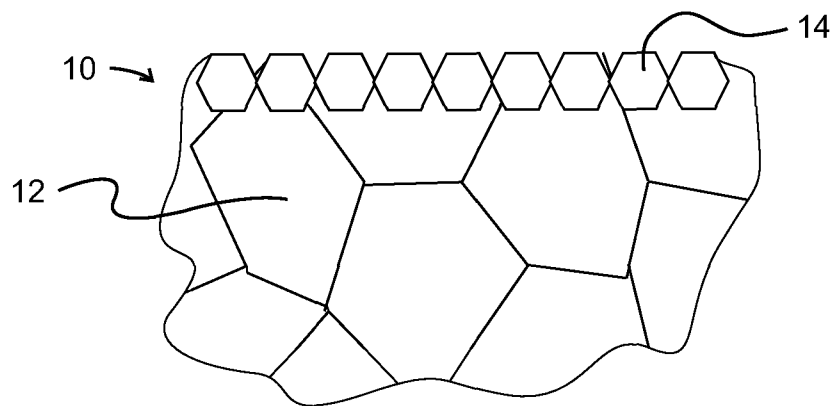


FIG. 2

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US2015/024822

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - C23C 8/02 (2015.01)

CPC - C23C 8/02 (2015.04)

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC(8) - B32B 15/00; C21D 7/06; C23C 8/02, 8/30, 8/80 (2015.01)

CPC - B32B 15/00; C21D 7/06; C23C 8/02, 8/30, 8/32, 8/80 (2015.04) (keyword delimited)

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
USPC - 219/121.6, 121.85; 428/610 (keyword delimited)

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

Orbit, Google Patents, Google Scholar

Search terms used: laser shock peening, lsp, ferritic, nitrocarburizing or carbonitriding or nitriding or carburizing

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	CN 103046058 A (SHANDONG UNIVERSITY) 17 April 2013 (17.04.2013), see machine translation	1-24
Y	US 2011/0220415 A1 (JIN et al) 15 September 2011 (15.09.2011) entire document	1-24
Y	US 6,153,023 A1 (ROKUTANDA et al) 28 November 2000 (28.11.2000) entire document	9-11, 17-24

☐ Further documents are listed in the continuation of Box C.


* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

01 June 2015

Date of mailing of the international search report

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