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(54) Title: DEVICE AND METHOD FOR FORMING A METAL MATRIX COMPOSITE VEHICLE COMPONENT

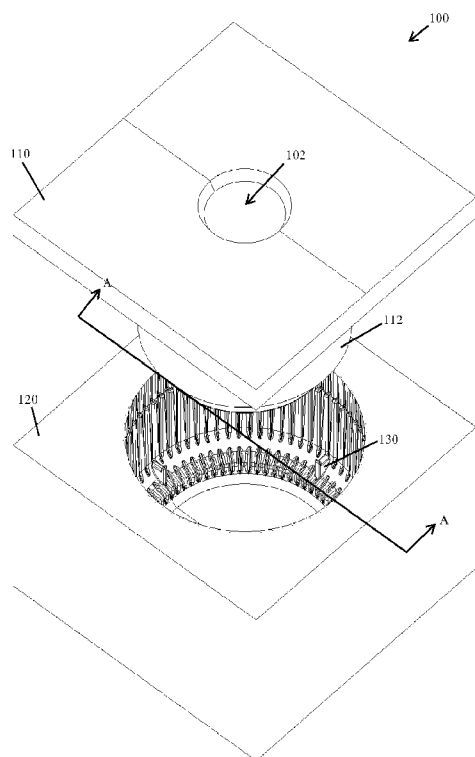


FIG. 1

(57) Abstract: An exemplary method for making a metal matrix composite vehicle component includes: using a mold including male and female die portions having mold surfaces and a plurality of spacers; heating the mold to a casting temperature; placing a ceramic preform on the plurality of spacers, the ceramic preform being spaced apart from at least one of the mold surfaces by the spacers; closing the mold to form a mold cavity between the mold surfaces of the male and female die portions, the ceramic preform being disposed within the mold cavity; providing molten metal into the mold cavity; and pressurizing the molten metal to a casting pressure for a casting duration to infiltrate the ceramic preform thereby forming the metal matrix composite vehicle component.



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TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU,
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**DEVICE AND METHOD FOR FORMING A METAL MATRIX
COMPOSITE VEHICLE COMPONENT**

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] The present application claims the benefit of U.S. Provisional Application Serial No. 62/291,200, filed on February 4, 2016, entitled DEVICE AND METHOD FOR FORMING AND SQUEEZE-CASTING A COMPOSITE BRAKE DRUM and U.S. Provisional Application Serial No. 62/398,042, filed on September 22, 2016, and entitled DEVICE AND METHOD FOR FORMING AND SQUEEZE-CASTING (ISOSTATIC INFILTRATION) A COMPOSITE BRAKE DRUM, ROTOR, OR VEHICLE COMPONENT, the disclosures of which are incorporated herein by reference in their entirety.

TECHNICAL FIELD

[0002] The present application relates generally to metal matrix composite components, and more specifically to metal matrix composite vehicle components, such as brake drums and brake rotors, and devices and methods for making the same.

BACKGROUND OF THE INVENTION

[0003] A metal matrix composite (MMC) is generally made by incorporating a reinforcing material into a metal matrix. For example, a MMC may comprise a ceramic preform that is infiltrated with a metal. A MMC generally has properties and physical characteristics different from metal that may be desirable depending on the application. For example, relative to the metal surrounding an MMC, the MMC may have higher specific strength, a higher Young's modulus, higher temperature resistance, higher transverse stiffness and strength, higher resistance to moisture absorption, higher electrical and thermal conductivity, lower density, and higher wear resistance. The particular physical properties of MMCs are often dependent on

the final application and may be modified by changes in both the matrix and metal alloy used.

[0004] Vehicles may include drum brakes and/or disc brakes. A drum brake generally comprises a rotating drum-shaped part called a brake drum. Shoes or pads of the drum brake press against the interior surface of the brake drum to cause friction and reduce the rotation of the brake drum. A disc brake generally comprises a rotating brake disc or rotor. Calipers having brake pads that squeeze the exterior and interior of the brake disc to cause friction and reduce the rotation of the brake disc. During the vehicle braking process there is often a high energy transfer to the frictional surface of the brake drum or brake disc which can lead to a rise in temperature.

SUMMARY

[0005] Exemplary embodiments of metal matrix composite components and devices and methods for making metal matrix composite components are disclosed herein.

[0006] An exemplary method for making a metal matrix composite vehicle component includes: using a mold including male and female die portions having mold surfaces and a plurality of spacers; heating the mold to a casting temperature; placing a ceramic preform on the plurality of spacers, the ceramic preform being spaced apart from at least one of the mold surfaces by the spacers; closing the mold to form a mold cavity between the mold surfaces of the male and female die portions, the ceramic preform being disposed within the mold cavity; providing molten metal into the mold cavity; and pressurizing the molten metal to a casting pressure for a casting duration to infiltrate the ceramic preform thereby forming the metal matrix composite vehicle component.

[0007] An exemplary mold for making a metal matrix composite vehicle component includes: male and female die portions having mold surfaces; a mold cavity formed by the mold surfaces when the mold is in a closed condition; a plurality of spacers extending from at least one of the mold surfaces; and a plurality of spacers extending from at least one of the mold surfaces. The spacers are configured to support a preform spaced apart from at least one of the mold surfaces, and the mold is configured to receive molten metal for casting the metal matrix composite vehicle component.

[0008] For example, metal matrix composite vehicle components of the present application may be produced by using any of the methods or molds disclosed herein. For example, a metal matrix composite vehicle component may include: a metal matrix composite portion; a metal portion that is substantially free from metal matrix composite material; and an indentation extending from an outer surface of the metal portion to the metal matrix composite portion.

BRIEF DESCRIPTION OF THE DRAWINGS

[0009] These and other features and advantages of the present invention will become better understood with regard to the following description and accompanying drawings in which:

[0010] Figure 1 is a perspective view of an exemplary casting device for a metal matrix composite break drum with the casting device in an open condition;

[0011] Figure 2 is a cross-section view of the casting device of Figure 1 along the line A–A with the casting device in an open condition and a preform positioned within the female die;

[0012] Figure 3 is a cross-section view of the casting device of Figure 1 along the line A–A with the casting device in a closed condition and a preform positioned within the female die;

- [0013] Figure 4 is a cross-section view of the casting device of Figure 1 along the line A–A with the casting device in a closed condition and molten metal filling the die cavity;
- [0014] Figure 5 is a cross-section view an exemplary brake drum removed from the casting device of Figure 4 that is shown cross-sectioned along the line A–A;
- [0015] Figure 6 is a perspective view of an exemplary casting device for a metal matrix composite brake rotor with the casting device in an open condition;
- [0016] Figure 7 is a cross-section view of the casting device of Figure 6 along the line B–B with the casting device in an open condition and a preform positioned within the female die;
- [0017] Figure 8 is a cross-section view of the casting device of Figure 6 along the line B–B with the casting device in a closed condition and a preform positioned within the female die;
- [0018] Figure 9 is a cross-section view of the casting device of Figure 6 along the line B–B with the casting device in a closed condition and molten metal filling the die cavity;
- [0019] Figure 10 is a cross-section view an exemplary brake rotor removed from the casting device of Figure 9 that is shown cross-sectioned along the line B–B; and
- [0020] Figure 11 is a flow chart describing an exemplary method of making metal matrix composite vehicle components.

DETAILED DESCRIPTION

- [0021] As described herein, when one or more components are described as being connected, joined, affixed, coupled, attached, or otherwise interconnected, such interconnection may be direct as between the components or may be indirect such as through the use of one

or more intermediary components. Also as described herein, reference to a "member," "component," or "portion" shall not be limited to a single structural member, component, or element but can include an assembly of components, members, or elements. Also as described herein, the terms "substantially" and "about" are defined as at least close to (and includes) a given value or state (preferably within 10% of, more preferably within 1% of, and most preferably within 0.1% of). Also as described herein, the term "casting device" is defined as any device suitable for forming a metal component, such as, for example, a die or mold for shaping molten metal into a metal component.

[0022] Metal matrix composites embedded with a light weight metal, such as an aluminum alloy, are useful in many industries, such as, for example, aerospace, automotive, heavy trucks, rail, defense, and others. Components made from light weight metal alloys that include localized MMC portions may be used in any portion of a vehicle to reduce the weight of the component while maintaining or improving other characteristics of the material, such as, for example, wear resistance, durability, strength, thermal conductivity, or the like. Many different vehicle components that include localized MMC portions (i.e., the MMC portion is restricted to a certain area of the component) may be formed using the methods described in the present application. While forming rotating and rotationally symmetric components having localized MMC portions—in particular, brake drums and rotors—are discussed in detail below, other non-rotating and non-rotationally symmetric vehicle components, such as portions of a vehicle body, vehicle frame, or vehicle suspension can also be made using the methods described below.

[0023] A MMC is generally made by incorporating a reinforcing material into a metal matrix, thereby enhancing the structure of the composite material. The MMC generally comprises two portions: a

primarily inorganic metal portion and a porous structure made from other inorganic components, such as fused silicon carbide. The non-metallic portion of the MMC may be incorporated into the metallic portion through additive and preform techniques.

- [0024] Forming a MMC through an additive process, such as stir casing, involves incorporating the non-metallic material directly into molten metal. In particular, stir casting involves adding a nonmetallic reinforcing substance directly to molten metal while stirring the molten metal, where the surface energy of the additive is higher than the surface tension of the molten metal. These additive methods have been used to produce automotive braking components such as Alcan and Lanxide components.
- [0025] These additive manufacturing techniques, however, have issues that have made mass production of MMC components prohibitively expensive. A brake rotor produced using the Duralcan technique (a stir casting technique used to combine silicon carbide with aluminum) illustrates these issues. For example, with this technique, the silicon carbide is not uniformly distributed within the aluminum alloy resulting in some particles of silicon carbide protruding from the surface of the rotor, in addition to other inconsistencies. Also, the silicon carbide particles are distributed throughout the entire brake rotor. Consequently, machining the cast part requires special tools as silicon carbide was interspersed throughout the aluminum. Various shortcomings of the Duralcan process are described in U.S. Patent No. 6,547,850. The stir casting apparatus designed by Alcan Aluminum Company is described in U.S. Patent No. 5,531,425.
- [0026] Forming a MMC through a preform process involves forming a non-metallic preform of reinforcing material that is infiltrated with a metal alloy, such as aluminum. Applicant has developed

various MMCs and methods of making MMCs, including aluminum MMCs. Examples of such MMCs and their related methods are described in U.S. Patent No. 9,429,202 (herein “the ‘202 patent”) and U.S. Published Patent Application No. 2016/0108980 (i.e., U.S. Application Serial No. 14/536,311; herein “the ‘311 application”), both of which are incorporated herein by reference in their entirety. To the extent the material incorporated by reference contradicts or is inconsistent with the present specification, the present specification will supersede any such material. The citation of any references herein is not an admission that such references are prior art to the present invention.

[0027] Rather than mixing MMC materials throughout a vehicle component, applicant has shown—e.g., in the ‘202 patent and ‘311 application—that certain vehicle brake components can be formed with localized MMC portions. These MMC components are created by providing an MMC preform in the desired location before casting the part. The molten metal used to cast the part infiltrates the ceramic preform to form a localized MMC portion of the final cast part. For example, a MMC portion can be formed on the wear surfaces of a brake rotor, as shown in Figure 6A of the ‘311 application.

[0028] When forming a component—such as a vehicle component—including a MMC portion, a ceramic preform is generally made first. The ceramic compound used to form the ceramic preform may include a variety of components, such as, for example, ceramic particles, reinforcing fibers, starch, organic porous creating materials, low temperature binders, high temperature binders (e.g., colloidal silica), and/or water. These materials may be incorporated through wet and dry methods. The ceramic preform may have a porosity ranging from about 50 percent to about 80 percent, or a porosity of about 60 percent.

[0029] The ceramic compound and preform may be made by a variety of methods that produce a preform capable of being cast by the methods described herein. For example, one method of preparing a ceramic compound is disclosed below. First, the reinforcing fibers undergo in a detangling process. The dry materials (e.g., ceramic particles, reinforcing fibers, starch, and organic porous creating materials) are then added stepwise into a one-pot system and aggravated. The wet materials (e.g., low and high temperature binders and water) may then be added slowly into the same one-pot mixture, agitated, and then mixed under reduced pressure. This homogeneous one-pot mixture generally lacks voids and has randomly oriented fibers and a malleable consistency. The mixture is then loaded into a press and is compressed by male and female molds. This compression molding technique provides uniform structure to the preform. Once the preform is molded, it is removed from the press and is dried in a humid environment, supported by an absorptive liner. Once water is removed from preform, the preform and the absorbing liner are heated to extreme temperatures to remove organic materials and to fuse inorganic ceramic particles. Upon cooling, the ceramic preform is machined to proper dimensions, the outer layer of skin is removed, and the pores of preform are exposed. As noted above, a preform can be prepared using a dry pressing technique where water is not included in the mixture.

[0030] Next, the preform is generally infiltrated with a metal that is determined based on the desired properties of the MMC component. This is done through placing the heated preform in a die, pressurizing aluminum into the mold cavity with sufficient pressure to impregnate the preform and to reach the desired casting pressure. The cast part may then undergo heat treating and machining to the desired characteristics and dimensions of the vehicle component. For example, the component may undergo a T7 heat treatment process.

[0031] During the casting process, molten metal may be pressurized indirectly or directly. Direct pressurization refers to pressurization of the molten metal through the closing of the dies of the mold. Indirect pressurization refers to pressurization of the molten metal with a piston or other mechanism that pressurizes the metal inside of a mold that is already closed.

[0032] In some production methods for MMC vehicle components, for example, through horizontal die casting, the preform is loaded on the male portion of the die or cope to align the preform within the component. Loading the preform onto the cope can sometimes lead to broken preforms from misalignment with the cope or from thermal shock. To insert the preform on the cope of the die without breaking the preform typically requires tight manufacturing tolerances, for example, as little as 0.003" clearance around the preform. After being inserted onto the cope of the die, the mold is closed and molten metal is injected into the mold at high pressure (pressurized indirectly in a shot sleeve or cavity), such as, for example, about 7,000 to about 12,000 pounds per square inch. The high pressure molten metal may also impinge on the preform unevenly, which may also break the preform or push it out of alignment.

[0033] Similar issues may arise through direct squeeze casting. In direct squeeze casting, the preform is loaded into the female portion of the die and molten metal is added before the die is closed. The male portion of the die is then closed to pressurize the molten metal and squeeze it into the preform. During the squeezing process the molten metal flows around the preform and may break the preform or push it out of alignment.

[0034] To aid the alignment of the preform during casting, the cope of the mold used in these casting techniques is typically tapered between about 0.75° and about 1.5°. The taper also facilitates

removal of the cast part from the mold. After casting, the MMC material is machined to remove the draft angle to produce a desired shape. Machining the aluminum MMC is significantly more difficult than machining pure aluminum because of the highly abrasive silicon carbide in the MMC. As noted above, this also leads to increased cost due to the use of sharp and expensive diamond-based tools. The aluminum alloy containing silicon carbide from the MMC removed from the drum during machining is generally scrap material and cannot be recycled.

[0035] According to the embodiments of the present application, MMC vehicle components are formed through an isostatic infiltration process. Exemplary casting methods and devices of the present application reduce the stress experienced by the preform during setup and casting and decrease the amount of scrap produced during the casting process. As described herein, the term “isostatic infiltration” describes infiltrating the preform with molten metal such that the pressure exerted by the metal on the mold and the preform is uniform or evenly distributed across the entirety of the molten metal. Thus, the preform is not disturbed by the molten metal and maintains its position during casting. Isostatic infiltration may be performed through an indirect squeeze casting technique involving placing a preform into the female portion of the mold, closing the mold, filling the mold with molten metal, and then pressurizing the molten metal to cause it to infiltrate the preform.

[0036] The devices and methods of the present application allow the position of the ceramic preform to be maintained during casting, thereby increasing the precision of the positioning of the MMC portion within the cast component and reducing waste and non-recyclable scrap material. Because the preform can be selectively positioned within the MMC vehicle component, the component includes a MMC portion and a metal portion that is substantially

free from MMC material. Selective positioning of the preform within the MMC vehicle component while maintaining the preform in a spaced apart relationship with the mold surfaces also allows a smaller preform to be used without the preform being cracked during loading into the mold. Using a smaller preform reduces the overall cost of the MMC vehicle component as the materials used to form the preform are typically more expensive than the metal alloy.

[0037] An exemplary squeeze casting apparatus of the present application includes a male die portion—known as the “cope”—and a female die portion—known as the “drag,” each having a mold surface. A mold cavity is formed between the mold surfaces of the male and female dies when the mold is in a closed condition. At least one of the dies further include pegs or spacers that support the preform in a spaced apart relationship with at least one of the mold surfaces of the male and female die portions during the casting process. That is, these spacers or pegs allow the preform to be positioned within the die such that the some or all of the surfaces of the preform do not touch the mold surfaces. These spacers allow the preform to be precisely positioned within the mold cavity without the need to locate the preform on the cope of the male die, as described above, thereby reducing the likelihood that the preform is damaged during loading into the mold. The spacers also reduce the contact between the mold and the preform so that less heat is lost from the preform as the mold is closed and before molten metal is introduced into the mold cavity. As the mold cavity is filled, the spacers provide room between the preform and the mold surfaces so that the molten metal can flow freely and present equal pressure on all sides of the preform so that the preform is not broken or displaced by the flowing molten metal. These spacers may be machined into the female die, or may be separate from the die. The spacers may be tapered—with a larger base at the mold and a smaller portion at

the preform—and have any shape, such as, for example, a cone, a cylinder, a ridge, a dome, a pyramid, or the like. In some embodiments, the spacers are formed of a material that is infiltrated or consumed during casting (e.g., the material of the preform), thereby becoming a portion of the cast part. The spacers may also be extended portions of the preform—e.g., “stilts”—that support the preform above the surface of the female die and locate the preform within the mold cavity.

[0038] As a further benefit, the exemplary casting techniques described in the present application can be used to cast vehicle components with metal alloys that are typically considered difficult to cast and infiltrate in MMC components, such as metal alloys with low magnesium content. For example, alloys 319, 355, 356, and 357 Aluminum, may be used in exemplary casting processes disclosed herein.

[0039] As yet another benefit, the exemplary casting techniques in the present application allow the cast parts to be heat treated using a T7 heat treatment process. The T7 heat treatment process involves heating the part up to the solution phase, quenching, and then aging the cast part. Parts cast using high pressure die casting techniques are difficult to treat using the T7 process because the porous internal structure of the die cast part results in gas inclusions that blister in the solution phase. Parts made using the casting techniques disclosed herein do not suffer from this issue.

[0040] Referring now to Figure 1, an exemplary mold 100 for isostatic casting of a metal matrix composite brake drum according to an embodiment of the present application is shown. The mold 100 includes a male die portion 110 having a mold surface 112 and a female die portion 120 having a mold surface 122. The female die 120 includes spacers 130 extending above the mold surface 122.

The male die portion 110 includes a pressurization chamber 102 for pressurizing molten metal during casting. In some embodiments, the positions of the male and female die portions may be reversed.

[0041] Spacers 130 may be included in both of the male and female dies 110, 120 and may be located anywhere within a mold cavity 140 (see Figures 2–3) and may support a ceramic preform 150 (see Figures 2–3) from below, above, the sides, and/or any combination of the same. The spacers 130 maintain the preform 150 in a spaced apart relationship with at least one of the mold surfaces 112, 122. Though four spacers 130 are shown in the illustrated embodiment, any number of spacers 130 may be included in the mold 100. The spacers 130 can be formed of the same material as the preform 150 or another temperature resistant material, such as a ceramic or a metal alloy (e.g., tool steel or cast iron). As described above, the spacers 130 are tapered—i.e., the spacers have a draft—to enable removal after infiltration and casting of the component. The reduced contact area at the top of the spacers 130 reduces heat transfer away from the spacer 130 and into the mold 100. As described above, spacers can be included on any surface of the mold to contact any portion of the preform. For example, spacers can be included on the top and bottom of the preform to space it apart from both the top and bottom mold surfaces. The preform may also be held in place on spacers by gravity.

[0042] The spacers 130 can be permanently formed in one or both of the dies 110, 120. Spacers 130 that are integrally formed with the dies 110, 120 have a draft or taper towards the preform 150 to provide relief when removing the cast part from the mold 100. The integrally formed spacers 130 are generally formed of the same material of the mold 100, such as, for example, tool steel. As needed, removable spacers may be used in conjunction with

integrally formed spacers. Removable spacers permit the same mold to be used to product a part with or without a localized MMC portion. Spacers may also include tapered portions to aid in the alignment of the preform during loading of the preform into the casting device. Spacers may extend from the mold surface any distance necessary to locate the preform in the desired location, depending on the shape of the mold cavity and the particular application. In certain embodiments, the spacers extend from the mold surface about 0.05 inches to about 0.2 inches, or at least about 0.1 inches, or at least about 0.05 inches.

[0043] Referring now to Figure 2, a cross-section of the mold of Figure 1 along the line A–A is shown. The mold 100 is shown in an open condition with the male and female dies 110, 120 spaced apart. The ceramic preform 150 is positioned on the spacers 130 in the female die 120 and is spaced apart from the mold surface 122. Draft angles may be provided in either or both of the male and female die portions 110, 120 to enable removal of the component after casting.

[0044] Referring now to Figure 3, the mold 100 is shown in a closed condition. The mold surfaces 112, 122 of the male and female die portions 110, 120 form the mold cavity 140 surrounding the preform 150. The male and female dies 110, 120 are moved into contact with each other and locked together so that they are not separated during pressurization of the mold cavity 140.

[0045] Referring now to Figure 4, the mold 100 is shown in a closed condition and filled with molten metal 160. A pressurization piston 106 presses down through the pressurization chamber 102 in the direction of arrow 104 to pressurize the molten metal 160 to cause it to fill the mold cavity 140 and infiltrate the preform 150.

[0046] Referring now to Figure 5, exemplary brake drum 162 is shown removed from the mold 100 and in a final, machined condition.

The brake drum 162 includes a MMC portion 164 and a metal portion 166 that is substantially free of MMC material.

Indentations 168 extending from an outer surface of the metal portion 166 to the MMC portion 164 are formed in the metal portion 166 by the spacers 130, as described above. The MMC portion 164 can have a thickness ranging from about 0.05 inches to the entire thickness of the component. In certain embodiments, the MMC portion has a thickness ranging from about 0.2 inches to about 0.5 inches, or from about 0.25 inches to about 0.45 inches.

[0047] Excess aluminum removed after casting of the brake drum 162 can substantially cover the inner and outer diameters of the preform 150. Because the mold surfaces 112, 122 are not used to position the preform 150 in the mold cavity 140, the gap between the preform 150 and the mold surfaces 112, 122 is filled with metal that is substantially free from MMC materials. To remove this excess material, a two-part machining process can be used. A first machining step involves removing the metal portion using traditional machining tools without the need for special tools used to machine MMC materials. A second machining step involves using special tools to form the finished surface of the MMC portion. Material removed during the first machining step is substantially free from MMC materials and can be recycled, reducing waste produced during the production of the MMC vehicle component.

[0048] Referring now to Figure 6, an exemplary mold 200 for isostatic casting of a metal matrix composite brake disc is shown. The mold 200 includes a male die portion 210 having a mold surface 212 and a female die portion 220 having a mold surface 222. The female die 220 includes spacers 230 extending above the mold surface 222. The male die portion 210 includes a pressurization chamber 202 for pressurizing molten metal during casting. In

some embodiments, the positions of the male and female die portions may be reversed.

[0049] Spacers 230 may be included in both of the male and female dies 210, 220 and may be located anywhere within a mold cavity 240 (see Figures 2–3) and may support a ceramic preform 250 (see Figures 2–3) from below, above, the sides, and/or any combination of the same. The spacers 230 maintain the preform 250 in a spaced apart relationship with at least one of the mold surfaces 212, 222. Though four spacers 230 are shown in the illustrated embodiment, any number of spacers 230 may be included in the mold 200. The spacers 230 can be formed of the same material as the preform 250 or another temperature resistant material, such as a ceramic or a metal alloy (e.g., tool steel or cast iron). As described above, the spacers 230 are tapered—i.e., the spacers have a draft—to enable removal after infiltration and casting of the component. The reduced contact area at the top of the spacers 230 reduces heat transfer away from the spacer 230 and into the mold 200.

[0050] The spacers 230 can be permanently formed in one or both of the dies 210, 220. Spacers 230 that are integrally formed with the dies 210, 220 have a draft or taper towards the preform 250 to provide relief when removing the cast part from the mold 200. The integrally formed spacers 230 are formed of the same material of the mold 200, such as, for example, tool steel. As needed, removable spacers may be used in conjunction with integrally formed spacers. Removable spacers permit the same mold to be used to product a part with or without a localized MMC portion. Spacers may also include tapered portions to aid in the alignment of the preform during loading of the preform into the casting device. Spacers may extend from the mold surface any distance necessary to locate the preform in the desired location, depending on the shape of the mold cavity and the particular

application. In certain embodiments, the spacers extend from the mold surface about 0.05 inches to about 0.2 inches, or at least about 0.1 inches, or at least about 0.05 inches.

- [0051] Referring now to Figure 7, a cross-section of the mold of Figure 6 along the line B–B is shown. The mold 200 is shown in an open condition with the male and female dies 210, 220 spaced apart. The ceramic preform 250 is positioned on the spacers 230 in the female die 220 and is spaced apart from the mold surface 222. Draft angles may be provided in either or both of the male and female die portions 210, 220 to enable removal of the component after casting.
- [0052] Referring now to Figure 8, the mold 200 is shown in a closed condition. The mold surfaces 212, 222 of the male and female die portions 210, 220 form the mold cavity 240 around the preform 250. The male and female dies 210, 220 are moved into contact with each other and locked together so that they are not separated during pressurization of the mold cavity 240.
- [0053] Referring now to Figure 9, the mold 200 is shown in a closed condition and filled with molten metal 260. A pressurization piston 206 presses down through the pressurization chamber 202 in the direction of arrow 204 to pressurize the molten metal 260 to cause it to fill the mold cavity 240 and infiltrate the preform 250.
- [0054] Referring now to Figure 10, exemplary brake disc 262 is shown removed from the mold 200 and in a final, machined condition. The brake disc 262 includes a MMC portion 264 and a metal portion 266 that is substantially free of MMC material. Indentations (not shown) extending from an outer surface of the metal portion 266 to the MMC portion 264 are formed in the metal portion 266 by the spacers 230. In the illustrated embodiment, the indentations are not evident in the final, machined condition of the brake disc 262 because the metal

portion 266 is machined away from both sides of the MMC portion 264 after casting. In certain embodiments, indentations are present in the final, machined brake disc 262. The MMC portion 264 can have a thickness ranging from about 0.05 inches to the entire thickness of the component. In certain embodiments, the MMC portion has a thickness ranging from about 0.2 inches to about 0.5 inches, or from about 0.25 inches to about 0.45 inches.

[0055] Excess aluminum removed after casting of the brake disc 262 can substantially cover the top and bottom surfaces of the preform 250. Because the mold surfaces 212, 222 are not used to position the preform 250 in the mold cavity 240, the gap between the preform 250 and the mold surfaces 212, 222 is filled with metal that is substantially free from MMC materials. To remove this excess material, a two-part machining process can be used. A first machining step involves removing the metal portion using traditional machining tools without the need for special tools used to machine MMC materials. A second machining step involves using special tools to form the finished surface of the MMC portion. Material removed during the first machining step is substantially free from MMC materials and can be recycled, reducing waste produced during the production of the MMC vehicle component.

[0056] While various embodiments described and illustrated herein show a single preform used to form an MMC vehicle component, a plurality of preforms may be supported by spacers in a mold for forming a MMC vehicle component having one or more MMC portions. Also, though the molds shown in Figures 1–10 are arranged with a vertical orientation, the casting techniques of the present application may also be applied to horizontal casting devices or any casting device oriented at any angle.

[0057] Referring now to Figure 11, a flow chart of an exemplary method 1100 of forming a metal matrix composite vehicle component is shown. The exemplary method 1100 includes: providing a mold including male and female die portions each having mold surfaces and a plurality of spacers extending from or above at least one of the mold surfaces of the male and female die portions, at 1102; heating the mold to a casting temperature, at 1104; placing a ceramic preform on the plurality of spacers such that the preform is spaced away from the mold surfaces, at 1106; closing the mold to form a mold cavity between the mold surfaces of the male and female die portions, the ceramic preform being disposed within the mold cavity, at 1108; providing molten metal into the mold cavity, at 1110; and pressurizing the molten metal to a casting pressure for a casting duration to infiltrate the ceramic preform thereby forming the metal matrix composite vehicle component, at 1112. Exemplary method 1100 can be implemented with any of the casting devices described above.

[0058] In certain embodiments, the casting temperature can range from about 500° Fahrenheit to about 1,200° Fahrenheit, or can be about 1,000° Fahrenheit or more. The preform may be heated from about 1,000° Fahrenheit to about 1,500° Fahrenheit, or more than about 1,500° Fahrenheit before being placed in the mold. During infiltration, the molten aluminum can range from about 1,000° Fahrenheit to about 1,200° Fahrenheit, depending on the alloy used. The casting pressure can range from about 10,000 pounds per square inch to about 16,000 pounds per square inch, or can be about 15,000 pounds per square inch or more. In certain embodiments, a clamping force required to hold the die portions of the mold together is about 1,000 tons. The casting duration is generally not greater than about three minutes, or is in a range from about 20 seconds to about 40 seconds, or is about 27 seconds. Applicant notes that in certain embodiments, lower temperatures and pressures may be used to cast metal matrix vehicle

components, such as a casting temperature ranging from about 400° Fahrenheit to about 600° Fahrenheit, and a casting pressure ranging from about 8,000 pounds per square inch to about 12,000 pounds per square inch.

[0059] While various inventive aspects, concepts and features of the disclosures may be described and illustrated herein as embodied in combination in the exemplary embodiments, these various aspects, concepts, and features may be used in many alternative embodiments, either individually or in various combinations and sub-combinations thereof. Unless expressly excluded herein all such combinations and sub-combinations are intended to be within the scope of the present application. Still further, while various alternative embodiments as to the various aspects, concepts, and features of the disclosures—such as alternative materials, structures, configurations, methods, devices, and components, alternatives as to form, fit, and function, and so on—may be described herein, such descriptions are not intended to be a complete or exhaustive list of available alternative embodiments, whether presently known or later developed. Those skilled in the art may readily adopt one or more of the inventive aspects, concepts, or features into additional embodiments and uses within the scope of the present application even if such embodiments are not expressly disclosed herein.

[0060] Additionally, even though some features, concepts, or aspects of the disclosures may be described herein as being a preferred arrangement or method, such description is not intended to suggest that such feature is required or necessary unless expressly so stated. Still further, exemplary or representative values and ranges may be included to assist in understanding the present application, however, such values and ranges are not to be construed in a limiting sense and are intended to be critical values or ranges only if so expressly stated.

[0061] Moreover, while various aspects, features and concepts may be expressly identified herein as being inventive or forming part of a disclosure, such identification is not intended to be exclusive, but rather there may be inventive aspects, concepts, and features that are fully described herein without being expressly identified as such or as part of a specific disclosure, the disclosures instead being set forth in the appended claims. Descriptions of exemplary methods or processes are not limited to inclusion of all steps as being required in all cases, nor is the order that the steps are presented to be construed as required or necessary unless expressly so stated. The words used in the claims have their full ordinary meanings and are not limited in any way by the description of the embodiments in the specification.

CLAIMS

What is claimed is:

1. A method of making a metal matrix composite vehicle component, the method comprising:

using a mold comprising:

a male die portion having a mold surface;

a female die portion having a mold surface; and

a plurality of spacers;

heating the mold to a casting temperature;

placing a ceramic preform on the plurality of spacers, wherein the ceramic preform is spaced apart from at least one of the mold surfaces by the spacers;

closing the mold to form a mold cavity between the mold surfaces of the male and female die portions, the ceramic preform being disposed within the mold cavity;

providing molten metal into the mold cavity; and

pressurizing the molten metal to a casting pressure for a casting duration to infiltrate the ceramic preform thereby forming the metal matrix composite vehicle component.

2. The method of claim 1, wherein pressurizing the molten metal comprises isostatic pressurization of the mold cavity wherein the molten metal exerts substantially equal pressure on sides of the ceramic preform exposed to the molten metal.
3. The method of claim 1, wherein:

the ceramic preform comprises ceramic particles, reinforcing fibers, and a high temperature binder; and

the ceramic preform has a porosity ranging from about 50 percent to about 80 percent.

4. The method of claim 3, wherein the ceramic preform has a porosity of about 60 percent.

5. The method of claim 1, wherein the molten metal comprises aluminum.

6. The method of claim 1, wherein:

the casting temperature ranges from about 500° Fahrenheit to about 1,200° Fahrenheit;

the casting pressure ranges from about 10,000 pounds per square inch to about 16,000 pounds per square inch; and

the casting duration is not greater than about three minutes.

7. The method of claim 1, wherein the casting pressure ranges from about 8,000 pounds per square inch to about 12,000 pounds per square inch.

8. The method of claim 1, wherein the casting temperature ranges from about 400° Fahrenheit to about 600° Fahrenheit.

9. The method of claim 1, wherein the casting duration is about 27 seconds.

10. The method of claim 1, further comprising:

heat treating the metal matrix composite vehicle component with a T7 heat treatment process.

11. The method of claim 1, wherein the mold comprises four spacers.

12. The method of claim 11, wherein the four spacers are arranged in two pairs, wherein the spacers in each pair of spacers are arranged on opposite sides of the mold cavity.
13. The method of claim 1, wherein the ceramic preform is centered in the mold cavity and supported substantially equally by each of the spacers.
14. The method of claim 1, wherein:
 - the female die portion is a bottom die portion having a bottom mold surface; and
 - the spacers extend above the bottom die portion and are configured to space the preform apart from the bottom mold surface.
15. The method of claim 1, wherein the metal matrix composite vehicle component comprises:
 - a metal matrix composite portion; and
 - a metal portion that is substantially free from metal matrix composite material.
16. The method of claim 15, wherein at least a portion the metal matrix composite portion is disposed at an exterior surface of the metal matrix composite vehicle component.
17. A metal matrix composite vehicle component comprising:
 - a metal matrix composite portion;
 - a metal portion that is substantially free from metal matrix composite material; and
 - an indentation extending from an outer surface of the metal portion to the metal matrix composite portion.

18. The metal matrix composite vehicle component of claim 17, wherein the vehicle component is a braking component.
19. The metal matrix composite vehicle component of claim 18, wherein the vehicle component is a brake drum.
20. The metal matrix composite vehicle component of claim 18, wherein the vehicle component is a brake disc.
21. The metal matrix composite vehicle component of claim 17, wherein the vehicle component is a structural component.
22. A metal matrix composite vehicle component made according to the method of claim 1.
23. A mold for making a metal matrix composite vehicle component comprises:
 - a male die portion having a mold surface;
 - a female die portion having a mold surface; and
 - a mold cavity formed by the mold surfaces of the male and female die portions when the mold is in a closed condition; and
 - a plurality of spacers extending from at least one of the mold surfaces of the male and female die portions;
 - wherein the spacers are configured to support a preform spaced apart from at least one of the mold surfaces; and
 - wherein the mold is configured to receive molten metal for casting the metal matrix composite vehicle component.
24. The mold for making a metal matrix composite vehicle component of claim 23, further comprising:

at least one heating element for heating the mold to a casting temperature ranging from about 400° Fahrenheit to about 1,200° Fahrenheit; and

25. The mold for making a metal matrix composite vehicle component of claim 23, further comprising:

a pressurization piston for pressurizing molten metal in the mold cavity to a casting pressure ranging from about 8,000 pounds per square inch to about 16,000 pounds per square inch.

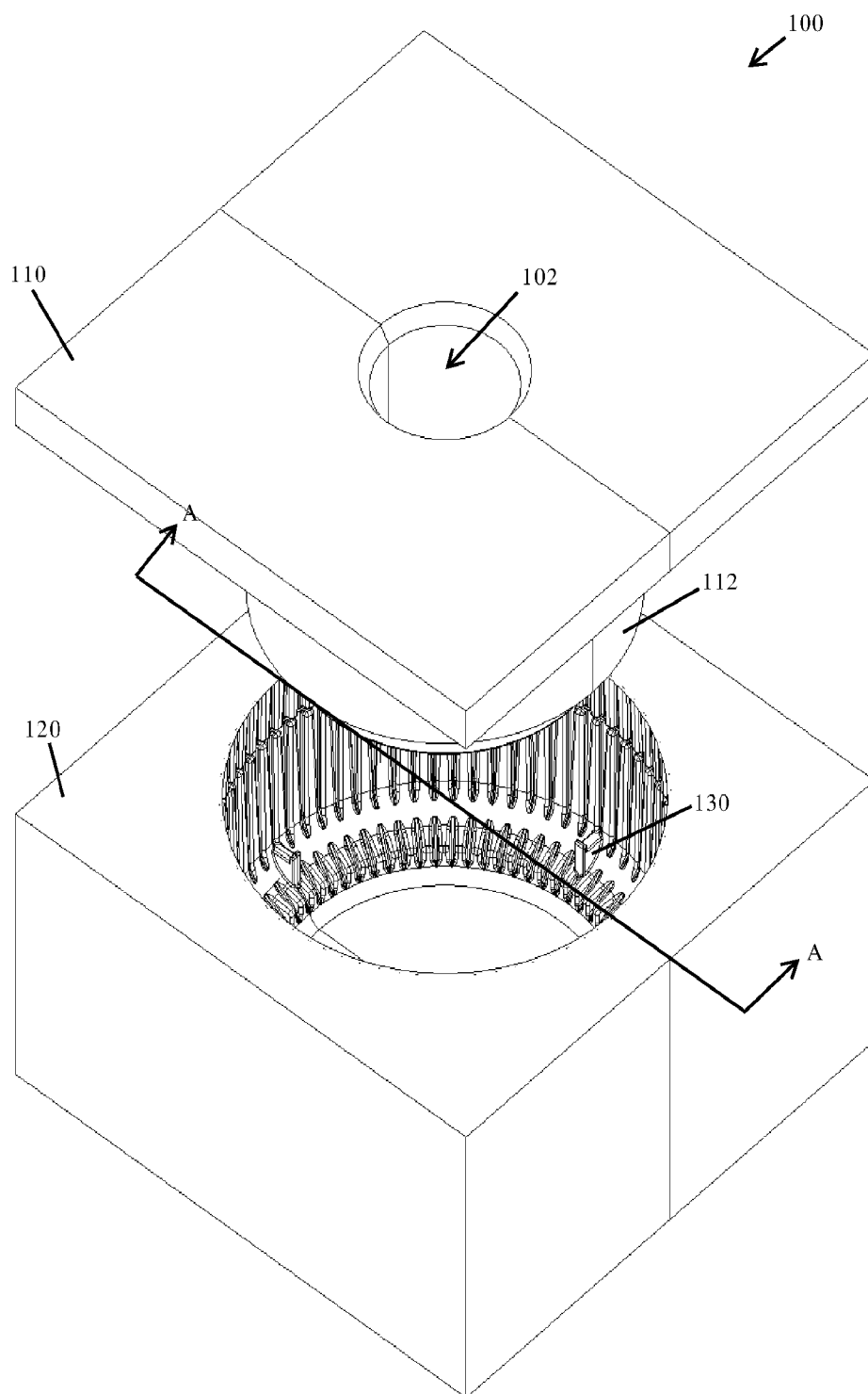


FIG. 1

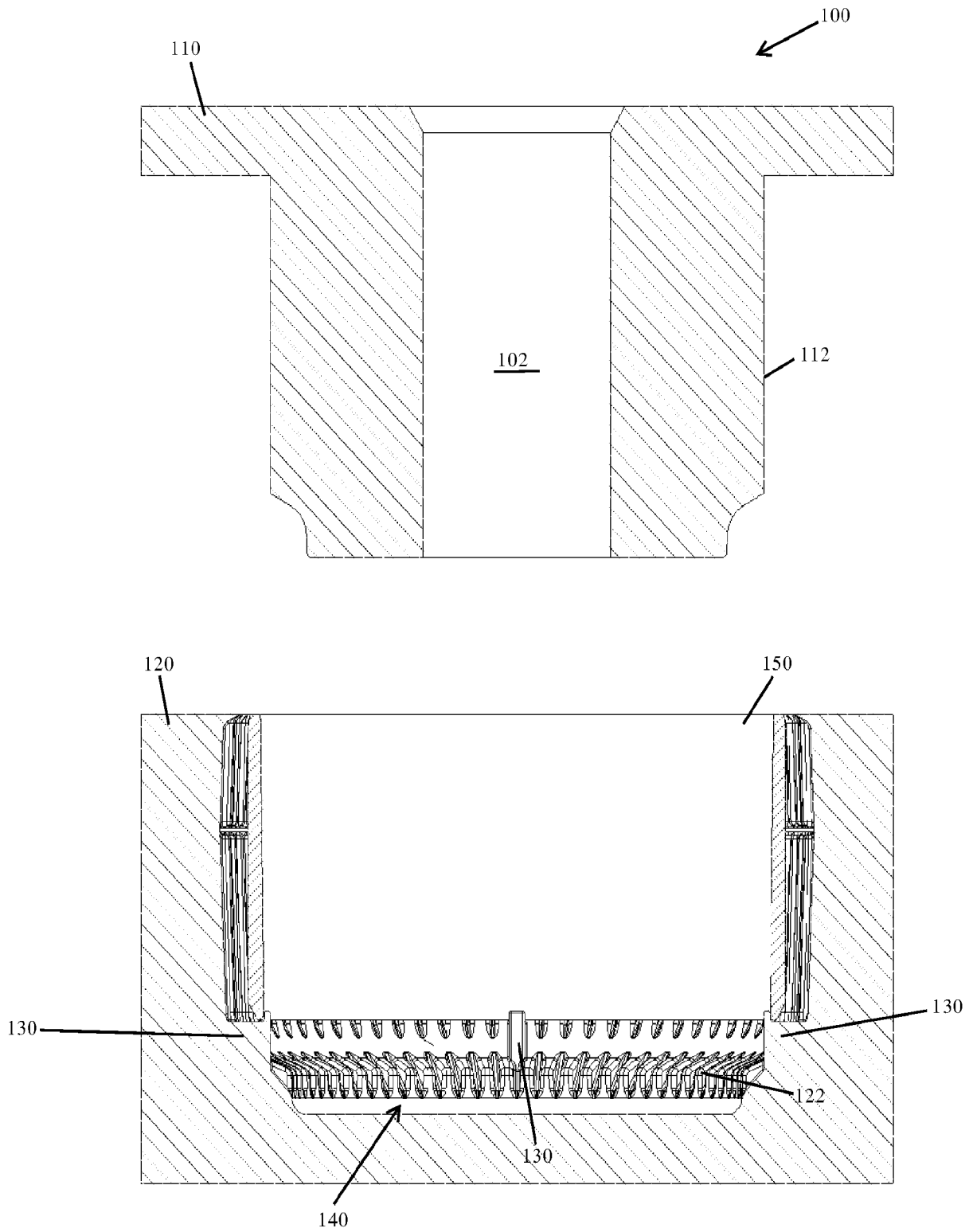


FIG. 2

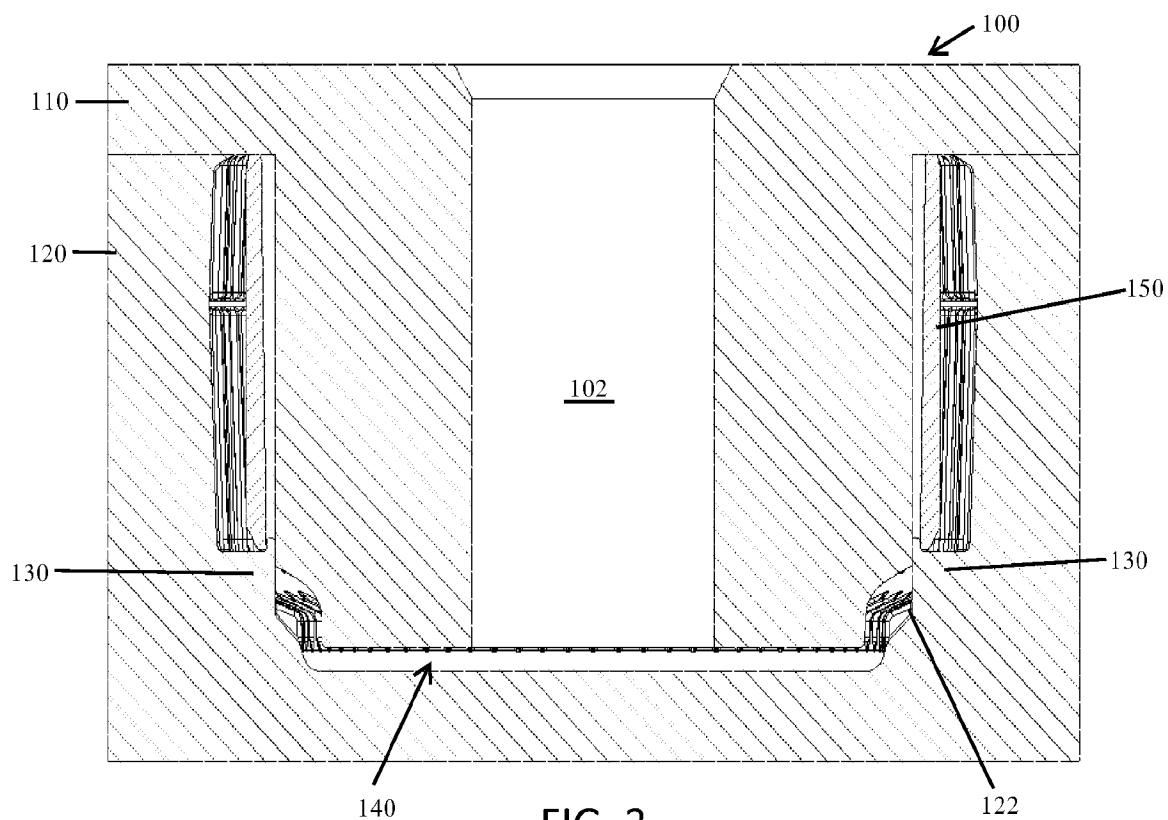


FIG. 3

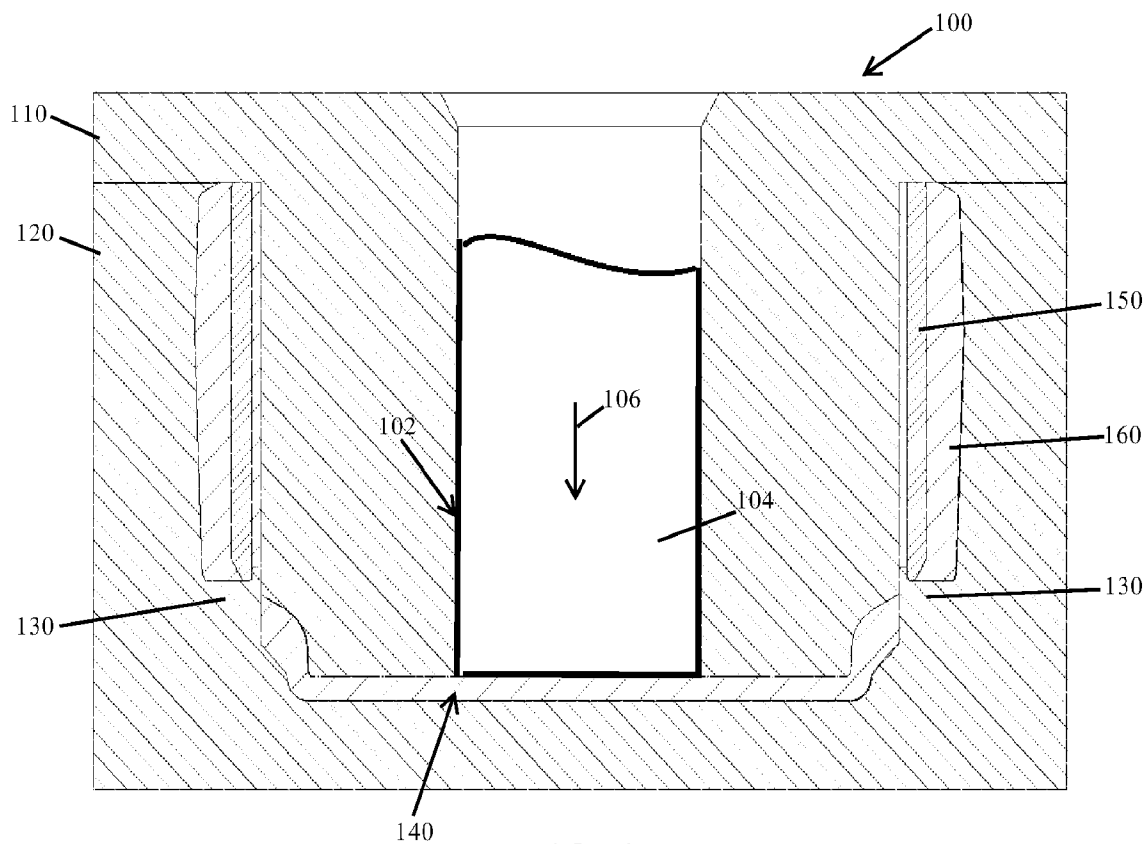


FIG. 4

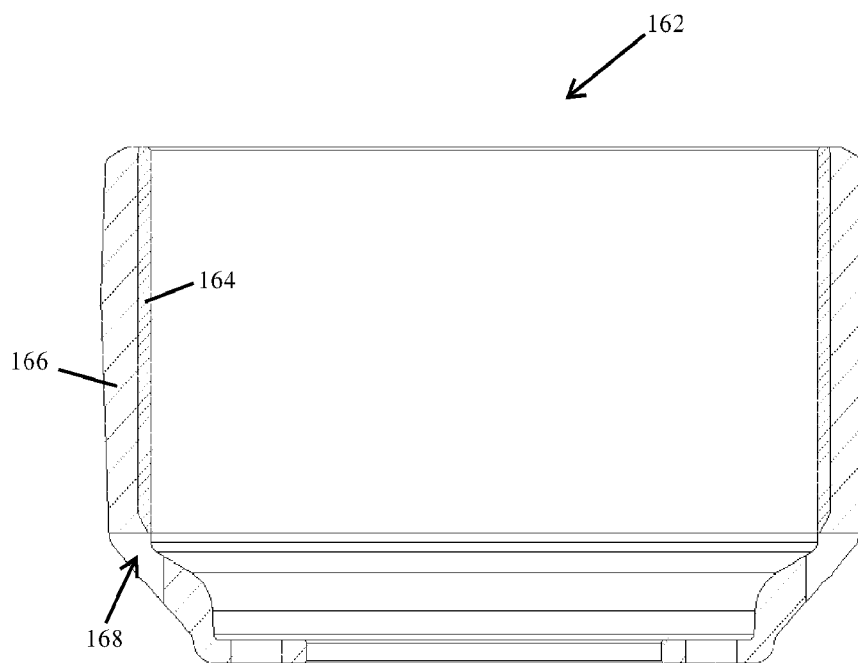


FIG. 5

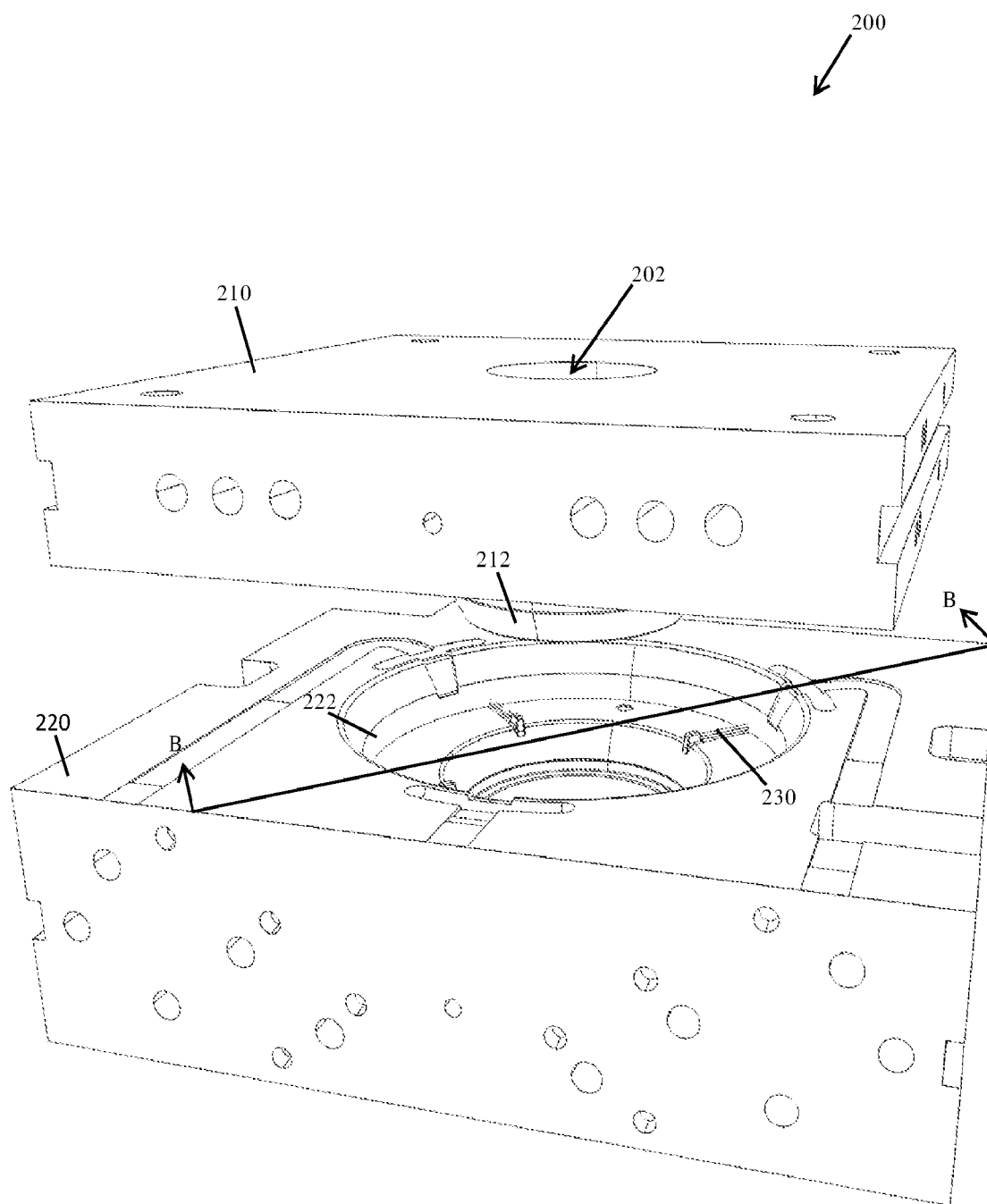


FIG. 6

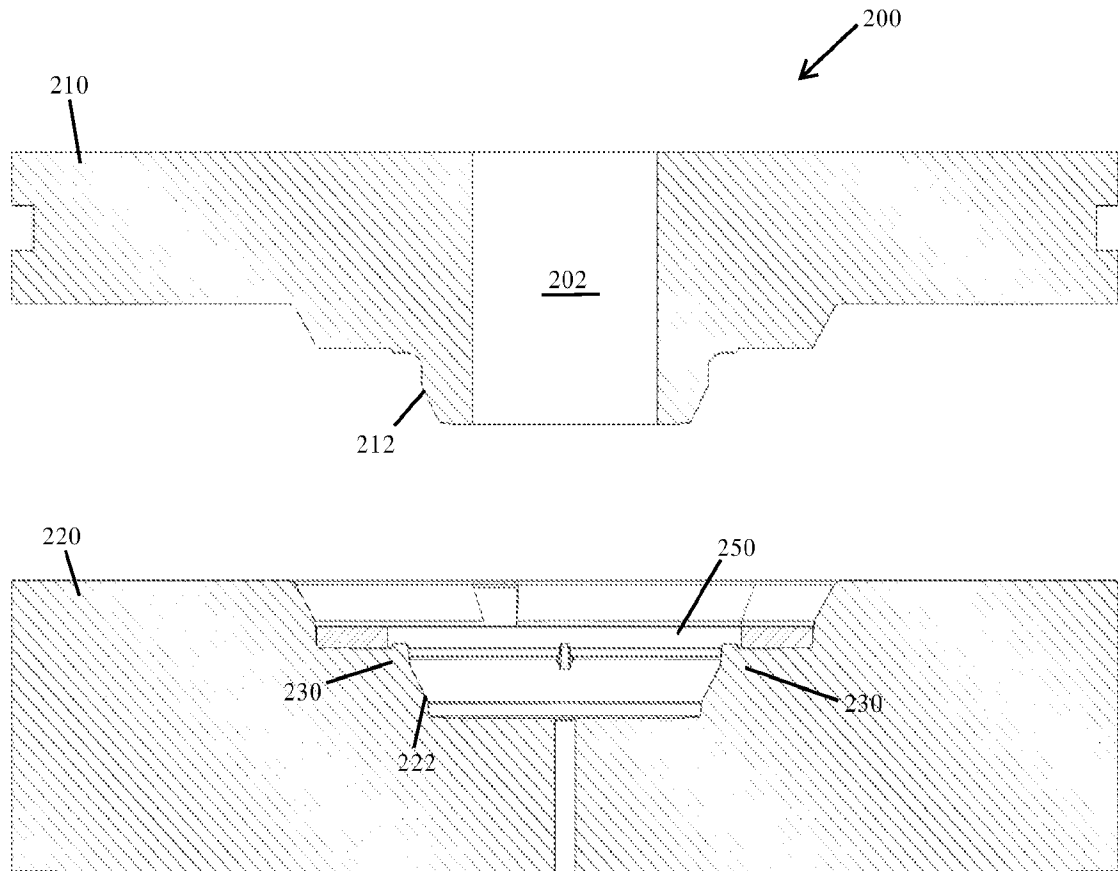


FIG. 7

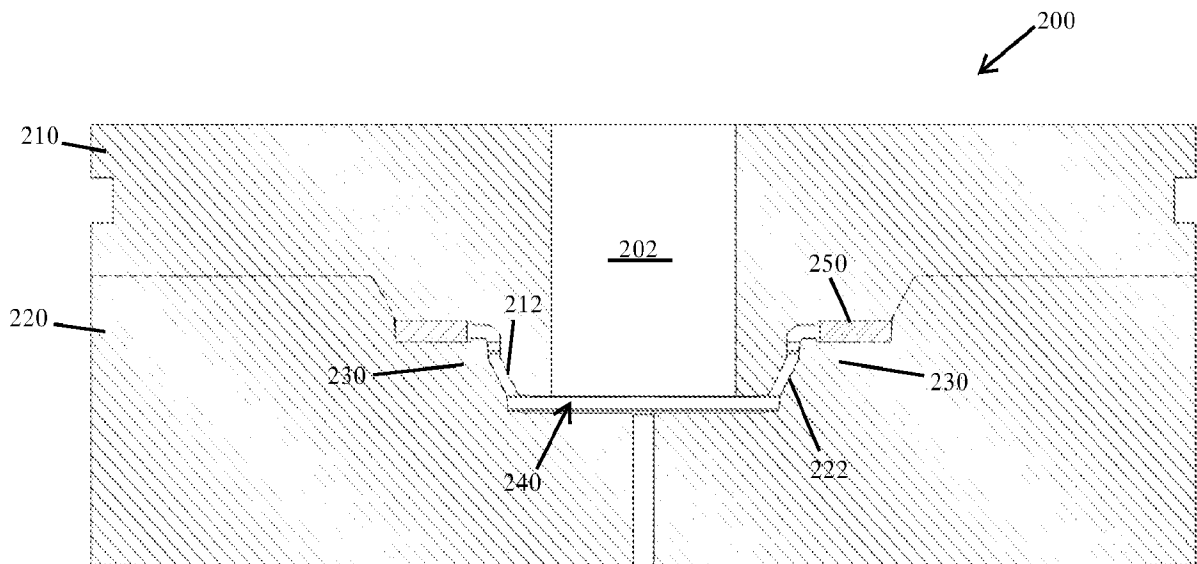
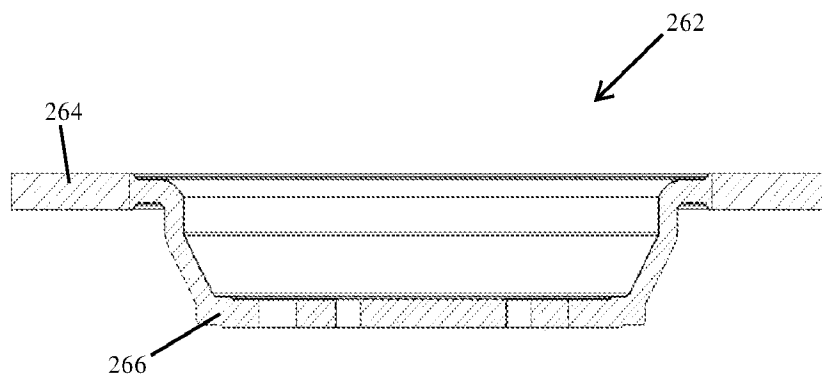
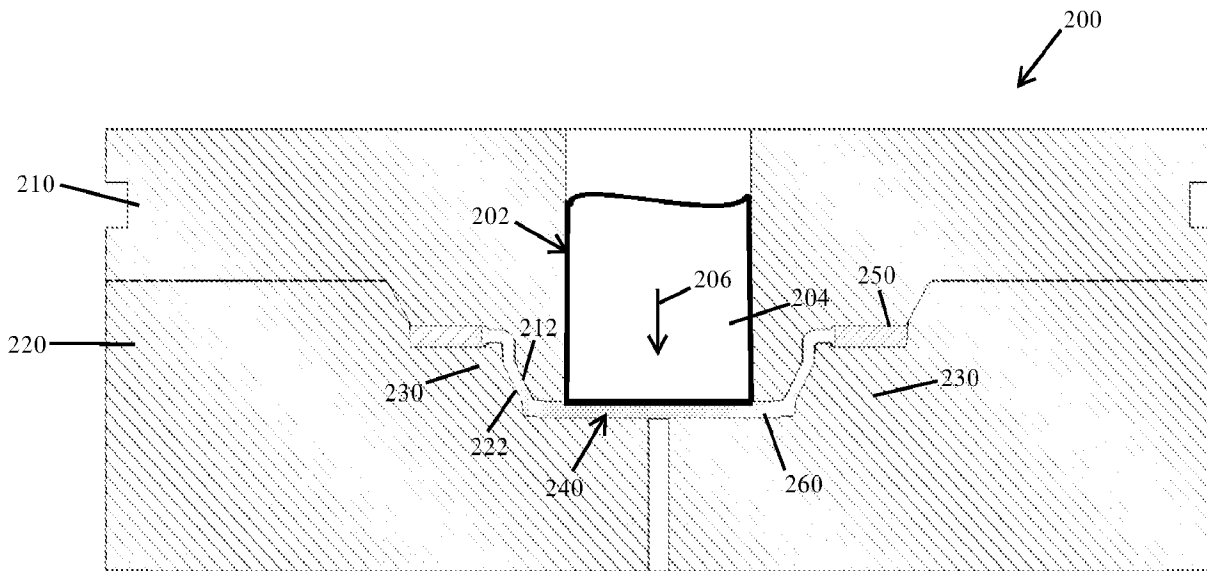


FIG. 8



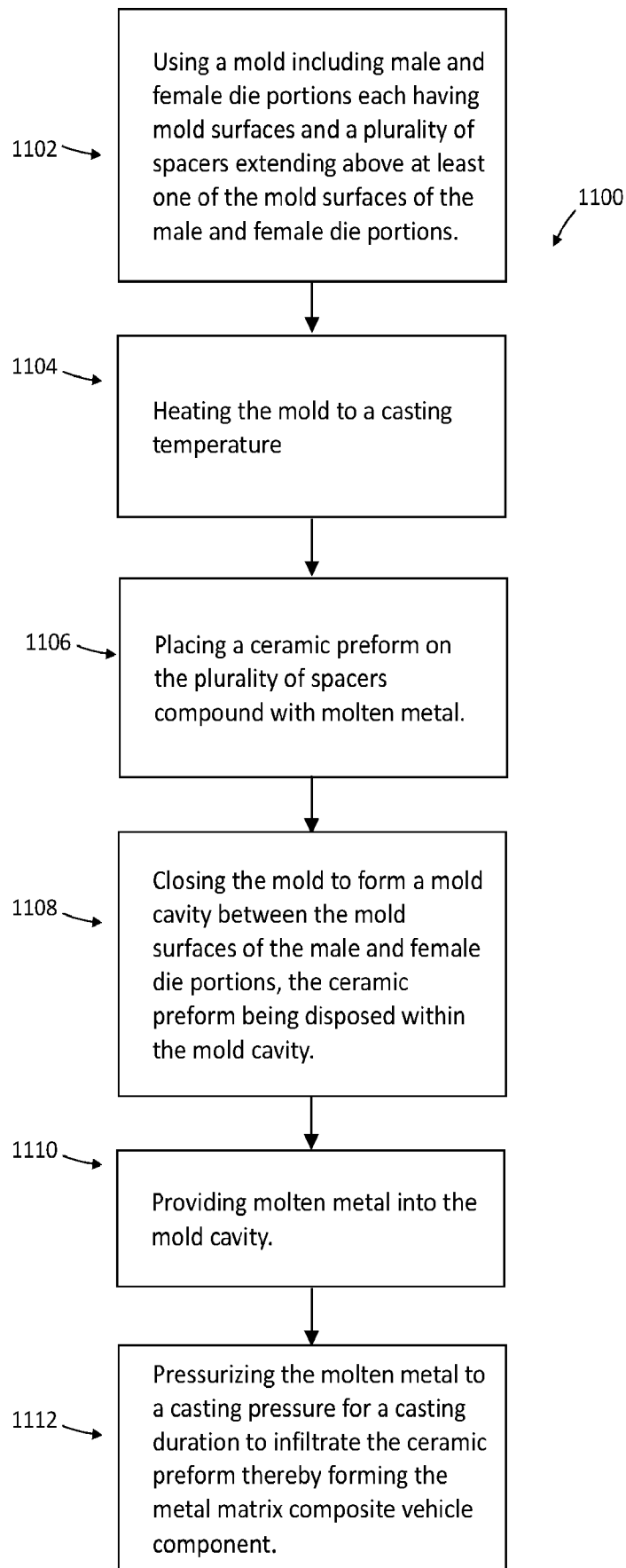


FIG. 11

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2017/016670

A. CLASSIFICATION OF SUBJECT MATTER
INV. B22D19/08
ADD.

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)
B22D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

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

EPO-Internal, WPI Data

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Y	figs. 2, 6 with c. 1, l. 1-17, 58ff; c. 2, l. 60ff; c. 4, l. 48-58; c. 5, l. 14-40, 65ff; c. 6, l. 42ff;	10
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Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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

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Date of the actual completion of the international search

30 March 2017

Date of mailing of the international search report

10/04/2017

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Authorized officer

Radeck, Stephanie

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2017/016670

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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