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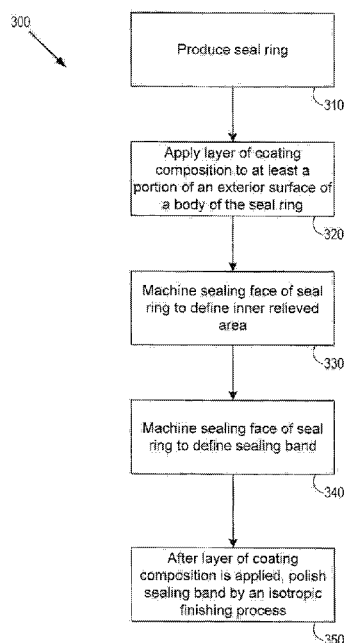
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FOR SEAL ASSEMBLY OF MACHINE

FIG. 8

(57) Abstract: A seal ring (111, 112) for a seal assembly (30, 36) includes a body (240) and a seal flange (137). The body (240) is generally cylindrical and extends along a longitudinal axis between a load end (131) and a seal end (132). The seal flange (137) is disposed adjacent the seal (132) end of the body (240). The seal flange (137) projects radially in circumscribing manner from the body (240) to an outer perimeter (138) thereof. The seal flange (137) includes a sealing face (136) having a sealing band (140), disposed adjacent the outer perimeter (138) of the seal flange (137), and an inner relieved area (245), disposed between the sealing band (140) and an inner perimeter (248) of the seal flange (137). The sealing band (140) is polished by an isotropic finishing process after a layer (142) of coating composition is applied to at least the body (240). The layer (142) of coating composition is formulated to withstand the isotropic finishing process and to help increase the corrosion resistance of the seal ring (111, 112).



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DescriptionISOTROPICALLY FINISHED SEAL RING, SEAL RING ASSEMBLY, AND
METHOD OF MAKING SEAL RING FOR SEAL ASSEMBLY OF MACHINE

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Technical Field

This patent disclosure relates generally to a seal ring of a seal assembly for machinery and equipment and, more particularly, to a seal ring of a seal assembly having a rotary face-to-face contacting relationship via a pair of seal rings.

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Background

The seal environment in a machine, such as, an off-highway truck, for example, can include high pressure, high speed, and high deflection between relatively movable components. A seal assembly of the kind employed for retaining lubricant within a sealed cavity and excluding foreign matter from the bearing surfaces between relatively moving parts disposed within the sealed cavity can comprise a face-type seal wherein sealing is accomplished by mating surfaces of relatively rotating seal parts of hard material. In seals which employ two rings relatively rotating in face-to-face contact, the economical production of sealing surfaces which will endure and maintain a seal throughout many hours of severe service is highly desired.

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Commonly-owned U.S. Patent No. 8,313,823 is entitled, "Method for Coating a Metallic Substrate with a Powder Coating Composition and an Autodepositable Coating Composition." The '823 patent is directed to a method for coating a metallic substrate that includes applying a powder coating composition to a majority of a surface of the metallic substrate, and applying an autodepositable coating composition to less than the majority of the surface of the metallic substrate. According to a preferred embodiment, the powder coating composition is applied to at least one continuous surface of the metallic substrate,

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while the autodepositable coating composition is applied to at least one discontinuous surface, such as an edge, of the metallic substrate.

It will be appreciated that this background description has been created by the inventors to aid the reader, and is not to be taken as an indication
5 that any of the indicated problems were themselves appreciated in the art. While the described principles can, in some aspects and embodiments, alleviate the problems inherent in other systems, it will be appreciated that the scope of the protected innovation is defined by the attached claims, and not by the ability of any disclosed feature to solve any specific problem noted herein.

10 Summary

In embodiments, the present disclosure describes a seal ring for a seal assembly that includes a body and a seal flange. The body is generally cylindrical and extends along a longitudinal axis between a load end and a seal end. The seal flange is disposed adjacent the seal end of the body. The seal
15 flange circumscribes the body and projects radially from the body to an outer perimeter of the seal flange. The seal flange includes a sealing face. The sealing face has a sealing band disposed adjacent the outer perimeter of the seal flange and an inner relieved area disposed between the sealing band and an inner perimeter of the seal flange. The sealing band is isotropically finished.

20 In other embodiments, a seal assembly is described that is adapted for use in sealing a joint having a first member pivotable about a rotational axis relative to a second member thereof. The seal assembly includes first and second annular seal rings and first and second annular load rings.

Each of the first and second annular seal rings has a loading
25 surface, which extends axially, and a sealing face, which extends radially to an outer perimeter. Each sealing face has a sealing band disposed adjacent the outer perimeter. The first and second annular seal rings abut one another such that the sealing bands of the first and second annular seal rings are in contacting relationship with each other. The first annular load ring engages the loading

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surface of the first annular seal ring, and the second annular load ring engages the loading surface of the second annular seal ring. The sealing bands of the first annular seal ring and the second annular seal ring are isotropically finished.

In other embodiments, a method of making a seal ring for a seal assembly includes producing a seal ring. A layer of coating composition is applied to at least a portion of an exterior surface of a body of the seal ring. A sealing face of the seal ring is machined to define an inner relieved area. The sealing face extends radially outward from the body of the seal ring. The sealing face of the seal ring is machined to define a sealing band. The sealing band is disposed radially outward of the inner relieved area along the sealing face. After the layer of coating composition is applied, the sealing band is polished by subjecting the sealing band to an isotropic finishing process.

Further and alternative aspects and features of the disclosed principles will be appreciated from the following detailed description and the accompanying drawings. As will be appreciated, seal rings for a seal assembly, seal assemblies, and methods of preparing a seal ring for a seal assembly disclosed herein are capable of being carried out in other and different embodiments, and capable of being modified in various respects. Accordingly, it is to be understood that both the foregoing general description and the following detailed description are exemplary and explanatory only and do not restrict the scope of the appended claims.

Brief Description of the Drawings

FIG. 1 is a partially-sectioned, diagrammatic side view of an embodiment of a machine having an embodiment of a seal assembly constructed in accordance with principles of the present disclosure.

FIG. 2 is an enlarged, sectioned diagrammatic view of the seal assembly, corresponding to the location encompassed by circle II in FIG. 1.

FIG. 3 is an axial end view of a load ring of the seal assembly of FIG. 2 in an unloaded condition.

FIG. 4 is an enlarged, cross-sectional view taken along line IV—IV in FIG. 3.

FIG. 5 is an axial end view of a seal ring of the seal assembly of FIG. 2.

5 FIG. 6 is an enlarged, fragmentary view of the seal ring of FIG. 5 corresponding to the location encompassed by oval VI in FIG. 5.

FIG. 7 is an enlarged, cross-sectional view taken along line VII—VII in FIG. 5.

10 FIG. 8 is a flow chart illustrating steps of an embodiment of a method of preparing a seal ring for a seal assembly following principles of the present disclosure.

Detailed Description

Embodiments of a seal assembly, a seal ring for a seal assembly, and a method of preparing a seal ring for a seal assembly are described herein. In
15 embodiments, a seal ring for a seal assembly can include a sealing face having a sealing band disposed adjacent an outer perimeter thereof. The sealing band can be annular and substantially flat in cross-section between an inner radial edge and the outer perimeter. In embodiments, the sealing face can include an inner relieved area which is located between the sealing band and an inner perimeter of
20 the seal ring. The sealing band can be isotropically finished.

In embodiments, the sealing face can be polished using any suitable isotropic finishing technique. In embodiments, the sealing band can be isotropically finished such that the sealing band has a consistent surface finish with a surface roughness average of about 0.2 micrometers Ra or less. In
25 embodiments, the sealing face of the seal ring can be prepared without the use of any polishing steps in addition to the isotropic finishing process, such as one using sandpaper or the like.

In embodiments, a layer of coating composition is applied to at least a portion of an exterior surface of a body of the seal ring to help increase the

corrosion resistance of the seal ring. In embodiments, the sealing band is polished by subjecting the sealing band to an isotropic finishing process after the layer of coating composition is applied. In embodiments, the layer of coating composition is formulated to withstand the isotropic finishing process. In
5 embodiments, the layer of coating composition is applied to the exterior surface of the body of the seal ring to help protect the surface metrology of the exterior surface underlying the layer of coating composition from the isotropic finishing process.

 In embodiments, the layer of coating composition is applied to the
10 seal ring prior to the seal ring being subjected to the isotropic finishing process. In embodiments, the layer of coating composition is applied to the seal ring using any suitable technique, such as an autodeposition process, an electro-deposition process, or a plating process (e.g., an electroplating process or an electroless plating process). In embodiments, the layer of coating composition is applied
15 using an autodeposition process, and the layer of coating composition comprises an epoxy-acrylic resin.

 Referring now to the drawings and in particular to FIG. 1, an embodiment of a machine 10 is shown schematically. The machine 10 include a housing or frame 12 having a wheel assembly 14 coupled therewith. The wheel
20 assembly 14 includes a hub 16, a spindle 18 journaled with the hub 16 via bearings 20, and a wheel 22. The machine 10 includes a brake system 24 which is arranged with the wheel assembly 14 and configured to selectively stop the rotation of the wheel 22.

 A seal assembly 30 constructed according to principles of the
25 present disclosure can provide a running seal between a first member 32 which is mounted to the hub 16 of the wheel assembly 14 and a second member 34 which is in the form of a brake housing of the brake system 24. The brake housing 34 is arranged such that the brake housing 34 is rotatable with respect to the first member 32 about a rotational axis which is aligned with a longitudinal axis "LA"

defined by the spindle 18. The seal assembly 30 is disposed between the first member 32 and the second member 34.

A second seal assembly 36 constructed according to principles of the present disclosure is provided to form a second running seal between a
5 different pair of first and second members 38, 34 of the machine 10 which are rotatable with respect to each other about a longitudinal axis "LA." In embodiments, the first and second seal assemblies 30, 36 can be substantially the same. In yet other embodiments, the second seal assembly 36 can be different from the first seal assembly 30.

10 The first seal assembly 30, which is in the form of a metal-to-metal face seal assembly, is disposed in a first seal cavity 40 axially extending between the first member 32 and the second member 34. The second member 34 in the form of the brake housing is rotatable about the longitudinal axis "LA" relative to the first member 32 with the first seal assembly 30 providing a running
15 seal therebetween. The second seal assembly 36 is similarly disposed in a second seal cavity 42. In embodiments, the first and second seal assemblies 30, 36 can be used to retain brake cooling fluid and/or a lubricant. In other embodiments, a seal assembly constructed according to principles of the present disclosure can be used in other applications, as will be recognized by one skilled in the art.

20 In embodiments, the machine 10 can be any suitable machine, such as a wheel loader, a backhoe, an excavator, a material handler and the like. In embodiments, the machine 10 comprises other types of equipment that include pivotal linkage arrangements which utilize a seal ring, a seal assembly, and a joint having a seal assembly constructed in accordance with principles of the
25 present disclosure. Examples of other such machines include machines used for compaction, mining, construction, farming, transportation, etc. While the present disclosure may be implemented in the context of a wheel assembly, it is not thereby limited. A wide variety of other applications are contemplated, including various components of track-type tractors such as track seals, track roller and

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carrier roller seals, pin joint assemblies and cartridges, final drive arrangements, auger drive/support arrangements, and other suitable machine systems wherein rotatable seal assemblies are utilized.

The first and second members 32, 34 can be rotatable relative to one another about the longitudinal axis "LA" with the seal assembly 30 providing a means for fluidly sealing the first member 32 and the second member 34 with a running seal therebetween. In embodiments, the first member 32 can comprise a component mounted to the frame 12 or otherwise stationary with respect to the frame 12, and the second member 34 can comprise a component which is rotatably movable with respect to the first member 32 about the longitudinal axis "LA." In other embodiments, the second member 34 can be stationary and the first member 32 is rotatable with respect to the frame 12. It should be understood, however, that the use of the terms "first," "second," and the like herein is for convenient reference only and is not limiting in any way.

The illustrated first and second seal assemblies 30, 36 are substantially identical to each other. It should be understood, therefore, that the description of one seal assembly is applicable to the other seal assembly, as well.

Referring to FIG. 2, the first seal assembly 30 is shown. The first member 32 is rotatable about the longitudinal axis "LA" with respect to the second member 34. The first member 32 and the second member 34 are disposed in spaced relationship to each other such that they are separated by a seal gap distance "SG" along the longitudinal axis "LA." During use, the first member 32 and the second member 34 can move axially with respect to each other along the longitudinal axis "LA," thereby varying the seal gap distance "SG."

The first seal assembly 30 includes first and second seal rings 111, 112 and first and second load rings 121, 122, which are all annular. The first and second seal rings 111, 112 and the first and second load rings 121, 122 are disposed in the first seal cavity 40 between the first member 32 and the second member 34. The first and second seal rings 111, 112 of the first seal assembly 30

are disposed in abutting relationship with each other. The first and second load rings 121, 122 are respectively mounted to the first and second seal rings 111, 112. The first and second seal rings 111, 112 can be made from any suitable material, such as a suitable metal, including a ferrous alloy, for example. The
5 first and second load rings 121, 122 are preferably made from a suitable elastomeric material (e.g., nitrile, low temperature nitrile, hydrogenated nitrile (HNBR), silicone, or viton).

In the first seal assembly 30, the first load ring 121 acts as a gasket and sealingly engages the first member 32 and the first seal ring 111 to provide a
10 fluid-tight seal therebetween. The second load ring 122 acts as a gasket and sealingly engages the second member 34 and the second seal ring 112 to provide a fluid-tight seal therebetween.

An outboard end portion 124 of the first member 32 is in proximal relation to an inboard end portion 126 of the second member 34. The outboard
15 end portion 124 of the first member 32 and the inboard end portion 126 of the second member 34 each includes a load ring engagement surface 130. The load ring engagement surfaces 130 of the first member 32 and the second member 34 define, at least in part, the first seal cavity 40, which extends axially and is interposed between the first member 32 and the second member 34. It will be
20 understood that the members 32, 34 cooperate in a similar manner to define, at least in part, the second seal cavity 42.

The load ring engagement surfaces 130 are generally annular and are coaxial with the longitudinal axis "LA." In the illustrated embodiment, the load ring engagement surfaces 130 maintain the cross-sectional shape shown in
25 FIG. 2 substantially continuously around the entire circumference circumscribed around the longitudinal axis "LA" by the first and second members 32, 34.

The first and second seal rings 111, 112 are substantially identical to each other. The first and second seal rings 111, 112 are each in the form of an annulus. The first and second seal rings 111, 112 are rotationally movable with

respect to each other about the longitudinal axis "LA." In this arrangement, the first seal ring 111 can be considered a stationary seal ring as it is rotatively coupled with the first member 32. The second seal ring 112 can be considered a rotational seal ring as it is coupled with the second member 34 which can rotate
5 relative to the first member 32 about the longitudinal axis "LA."

The first and second seal rings 111, 112 each has a load end 131 and a seal end 132 in spaced relationship to each other along the longitudinal axis "LA," a ramped or inclined loading surface 134, which is axially extending, and a sealing face 136, which is disposed at the seal end 132 and extends radially with
10 respect to the longitudinal axis "LA." The first seal ring 111 and the second seal ring 112 abut one another such that the sealing faces 136 of the first seal ring 111 and the second seal ring 112 are in contacting relationship with each other.

The sealing face 136 is defined by a seal flange 137, which is radially-extending. The sealing faces 136 of the first and second seal rings 111,
15 112 form a radially-extending annulus and are in sealing relationship with each other.

Each sealing face 136 extends radially to an outer perimeter 138. Each sealing face 136 has a sealing band 140 disposed adjacent the outer perimeter 138. The first and second seal rings 111, 112 abut one another such
20 that the sealing bands 140 of the first and second seal rings 111, 112 are in contacting relationship with each other.

The first and second load rings 121, 122 are respectively mounted to the first and second seal rings 111, 112. The first and second load rings 121, 122 resiliently support the first and second seal rings 111, 112, respectively. The
25 first annular load ring 121 engages the loading surface 134 of the first annular seal ring 111, and the second annular load ring 122 engages the loading surface 134 of the second annular seal ring 112.

The first seal assembly 30 employs dual cones in the form of the first and second seal rings 111, 112. Axial loading of the first and second seal

rings 111, 112 along the longitudinal axis "LA" is accomplished by means of the first and second load rings 121, 122. The tapered conical or inclined loading surfaces 134 are formed along the outside surface of the first and second seal rings 111, 112 to receive the first and second load rings 121, 122, respectively.

5 The load ring engagement surfaces 130 of the first and second members 32, 34 are positioned in corresponding, confronting inclined relation with the inclined loading surfaces 134 of the first and second seal rings 111, 112 so as to contain the first and second load rings 121, 122, respectively, therebetween. Axial loading of the first and second seal rings 111, 112 is thus accomplished through

10 the axial loading of the first and second load rings 121, 122, respectively.

The first load ring 121 is compressed such that it engages the load ring engagement surface 130 of the first member 32 and the inclined loading surface 134 of the first seal ring 111. The second load ring 122 is compressed such that it engages the load ring engagement surface 130 of the second member

15 34 and the inclined loading surface 134 of the second seal ring 112. The first and second load rings 121, 122 are positioned such that they resiliently support the first and second seal rings 111, 112 and drive the sealing faces 136 of the first and second seal rings 111, 112 together to define a band 141 of contact between the sealing bands 140. The first and second load rings 121, 122 act in the manner

20 of a spring to apply an axial load respectively against the first and second seal rings 111, 112 in opposing directions along the longitudinal axis "LA" to bring the sealing faces 136 of the first and second seal rings 111, 112 into face-to-face sealing contact under pressure along the band 141 of contact such that a running, fluid-tight seal is formed.

25 In embodiments, the sealing band 140 of both of the first annular seal ring 111 and the second annular seal ring 112 is isotropically finished. An isotropic finish is one in which defects are generally non-directional, or invariant in all directions, in contrast to directional defects, such as, machine marks, for example. In embodiments, the sealing bands 140 of the first and second seal

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rings 111, 112 can be isotropically finished such that each sealing band 140 has a non-periodic or randomized surface texture as will be appreciated by one skilled in the art. In embodiments, the sealing band 140 of both of the first annular seal ring 111 and the second annular seal ring 112 is isotropically finished such that the sealing band 140 has a surface roughness average of about 0.2 micrometers Ra or less, and has a surface roughness average of about 0.15 micrometers Ra or less in still other embodiments. In embodiments, at least substantially the entire sealing face 136 of both of the first annular seal ring 111 and the second annular seal ring 112 is isotropically finished. In embodiments, any suitable technique can be used to isotropically finish the sealing bands 140 of the first and second annular seal rings 111, 112 to achieve a desired degree of polished surface smoothness.

In embodiments, the first annular seal ring and the second annular seal ring both include a layer 142 of coating composition applied to at least a portion of the loading surface 134. In the illustrated embodiment, the layer 142 of coating composition of each of the first and second annular seal rings 111, 112 substantially covers an outer exterior surface 143 of both the first and second annular seal rings 111, 112. In embodiments, the layer 142 of coating composition can be applied to at least a portion of an internal cylindrical surface 144 of each of the first and second annular seal rings 111, 112. The layers 142 of coating composition illustrated in FIG. 2 are not necessarily depicted to scale but rather for explanatory purposes only.

Any suitable technique can be used to apply the layer 142 of coating composition. For example, in embodiments, the layer 142 of coating composition is applied using at least one of an autodeposition process, an electro-deposition process, and a plating process (e.g., an electroplating process or an electroless plating process).

In embodiments, the layer 142 of coating composition of both of the first annular seal ring 111 and the second annular seal ring 112 is applied

before the sealing bands 140 are isotropically finished, and the coating composition is formulated to withstand the isotropic finishing process used to polish the sealing bands 140. In embodiments, the coating composition can be made from a material that has an enhanced property or characteristic relative to the material from which the seal ring is made. For example, in embodiments, each of the first and second seal rings 111, 112 is made from a seal ring material, and the respective layers 142 of coating composition are more corrosion resistant than the seal ring material. In embodiments, the coating composition includes a material possessing a rust preventative characteristic.

10 In embodiments, the layer 142 of coating composition is applied using an autodeposition process, and the layer 142 of coating composition comprises an epoxy. In embodiments, the layer 142 of coating composition comprises an epoxy-acrylic resin.

15 In embodiments, the layer 142 of coating composition comprises a suitable autodepositable coating composition, including, for example, a coating composition marketed under the brand name Autophoretic® or Autophoretic Coating Chemicals® by Henkel Surface Technologies. In embodiments, the autodepositable coating composition comprises an Autophoretic® coating composition including an epoxy-acrylic based resin. In embodiments, the autodepositable coating composition comprises a coating composition marketed by Henkel Surface Technologies as Bonderite Metal Pre-treatment Paint Process (BONDERITE M-PP) 930. In yet other embodiments, the layer 142 of coating composition can comprise other suitable autodepositable coating compositions.

20 The load ring engagement surfaces 130 of the first member 32 and the second member 34 are mirror images. The loading surfaces 134 of the first and second seal rings 111, 112 are substantially identical to each other. Accordingly, it should be understood that the description below of the load ring engagement surface 130 of the first member 32 and the loading surface 134 of the first seal ring 111 is applicable respectively to the load ring engagement surface

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130 of the second member 34 and the loading surface 134 of the second seal ring 112, as well. Also, it should be understood that the foregoing description of the loading surface 134 contemplates that the layer 142 of coating composition can be applied thereto and can be considered to be a part of the loading surface 134.

5 Furthermore, the description of the relationships between the first member 32, the first load ring 121, and the first seal ring 111 are also applicable to the relationships between the second member 34, the second load ring 122, and the second seal ring 112, as well.

The load ring engagement surface 130 of the first member 32 and

10 the inclined loading surface 134 of the first seal ring 111 are in confronting, spaced apart relationship such that they define an annular load ring cavity 146 within which the first load ring 121 is disposed. The load ring engagement surface 130 of the first member 32 and the inclined loading surface 134 of the first seal ring 111 cooperate together to define a seal end restriction 148 adjacent

15 the sealing face 136 of the first seal ring 111. The seal end restriction 148 is configured to help prevent the first load ring 121 from sliding axially off of the first seal ring 111 in a direction toward the second seal ring 112 and to help prevent the first load ring 121 from extending into a pinch point therein. The load end 131 of the first seal ring 111 cooperates with the first member 32 to

20 define a load end restriction 149.

Referring to FIGS. 3 and 4, the first load ring 121 is shown. The first and second load rings 121, 122 are substantially identical to each other. It should be understood, therefore, that the description of the first load ring 121 is applicable to the second load ring 122. The first load ring 121 is in the shape of

25 an annulus. When the first load ring 121 is in an unloaded or uncompressed condition, it has a substantially circular cross-sectional shape 235, as shown in FIG. 4. The cross-sectional shape 235 has a predetermined cross-sectional radius “R” when in an unloaded condition (*see* FIG. 4).

Referring to FIGS. 5-7, the first seal ring 111 is shown. The first seal ring 111 is an example of an embodiment of a seal ring constructed according to principles of the present disclosure. The second seal ring 112 is substantially identical to the first seal ring 111. It should be understood, therefore, that the description of the first seal ring 111 is applicable to the second seal ring 112, as well.

Referring to FIGS. 5 and 6, the first seal ring 111 is in the shape of an annulus. The seal flange 137 includes the sealing face 136. The sealing face 136 includes the sealing band 140 disposed adjacent the outer perimeter 138 of the seal flange 137 and an inner relieved area 245 disposed between the sealing band 140 (with its isotropic finish being shown as a hatched area in FIGS. 5 and 6 for illustrative purposes) and an inner perimeter 248 of the first seal ring 111. The inner relieved area 245 can be tapered between the sealing band 140 and the inner perimeter 248 such that the inner perimeter 248 is axially displaced from the sealing band 140 (*see* FIG. 2).

In embodiments, the sealing band 140 of the first seal ring 111 is isotropically finished such that the sealing band 140 has a surface roughness average of about 0.2 micrometers Ra or less. In other embodiments, the sealing band 140 is isotropically finished such that the sealing band 140 has a surface roughness average of about 0.15 micrometers Ra or less, and a surface roughness average of about 0.1 micrometers Ra or less in still other embodiments. In embodiments, the sealing band 140 of the first seal ring 111 is isotropically finished such that the sealing band 140 has a surface roughness average of about 0.2 micrometers Ra or less. In embodiments, at least the inner relieved area 245 of the sealing face 136 is isotropically finished. In embodiments, substantially the entire sealing face 136 of the first seal ring 111 is isotropically finished.

The surface roughness average can be computed using any suitable technique known to those skilled in the art. For example, in one arrangement, the surface roughness average (Ra) of the sealing band 140 can be

determined using a profilometer set up with a 0.25 mm cutoff and evaluated for five cutoff lengths. The first seal ring 111 can be checked in at least three locations at predetermined locations and/or about 120° circumferentially apart from each other. The traverse direction of the measurement surface traces can be perpendicular to the direction of any initial machine or directional wear marks.

Referring to FIG. 7, the first seal ring 111 includes a body 240 and the seal flange 137. The body 240 is generally cylindrical and extends along the longitudinal axis "LA" between the load end 131 and the seal end 132, which is in opposing relationship to the load end 131. The cylindrical body 240 can extend radially between the inner perimeter 248 and the internal cylindrical surface 144, which is substantially cylindrical, and the majority of the inclined loading surface 134, which is in outer, radial spaced relationship to the inner perimeter 248.

In embodiments, the layer 142 of coating composition is applied to at least a portion of the exterior surface 143 of the body 240. In the illustrated embodiment, the layer 142 of coating composition is applied to substantially the entirety of the exterior surface 143 of the body 240.

The seal flange 137 is disposed adjacent the seal end 132. The seal flange 137 circumscribes the body 240 and projects radially from the cylindrical body 240 to the outer perimeter 138 thereof. The sealing face 136 is disposed on the seal flange 137 and extends radially with respect to the longitudinal axis "LA." The sealing band 140 can be substantially flat in cross-section between an inner radial edge 257 and the outer perimeter 138 (*see* FIG. 6 also). In embodiments, the sealing band 140 can include an outer relieved area disposed adjacent the outer perimeter 138 that is chamfered or tapered.

It should be understood that in other embodiments, a seal ring constructed according to principles of the present disclosure can have a different configuration from that of the seal rings 111, 112 illustrated in FIGS. 2 and 5-7, such as, heavy duty dual face metal face seals using Belleville washers; other

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types of duo-cone seal rings with different loading surfaces and/or sealing faces and/or used in conjunction with different shaped load rings or torics; and other seals for other seal assemblies, as will be appreciated by one skilled in the art.

A seal ring constructed according to principles of the present disclosure can be made using any suitable technique known to those skilled in the art. For example, a seal ring blank or “button” can be made by any suitable technique, such as by being stamped and formed, or cast, for example. The seal ring button can be machined by any suitable technique, such as by using a lathe for lathe-turning and/or grinder for grinding operations, for example, to achieve the desired configuration for the seal ring. The seal ring can be machined such that the thickness of the seal flange is within a predetermined tolerance, the seal ramp angle is within a predetermined tolerance, and other dimensional tolerances are met, for example. It should be understood that dimensional details relating to the seal ring, and other components of a seal assembly, constructed according to principles of the present disclosure as described herein are nominal values. It is contemplated that suitable tolerance variations are also included within the described nominal values, as will be appreciated by one skilled in the art.

Referring to FIG. 8, steps of an embodiment of a method 300 of preparing a seal ring for a seal assembly in accordance with principles of the present disclosure are shown. The seal ring is produced (step 310). In embodiments, the seal ring can be produced in step 310 using any suitable technique, such as by being stamped and formed or by being cast, for example. For example, in embodiments, the seal ring is produced by stamping a seal ring blank or button to form the seal ring. In embodiments, the seal ring can be produced using any suitable casting technique, such as by a static cast process, for example. In embodiments, the seal ring can be heat treated as part of its being produced.

In embodiments, the seal ring can be machined to at least one predetermined tolerance. The seal ring can be machined such that the thickness

of the seal flange is within a predetermined tolerance, the seal ramp angle is within a predetermined tolerance, and other dimensional tolerances are met, for example. The seal ring can be machined by any suitable technique, such as by using a lathe for lathe-turning and/or grinder for grinding operations, for
5 example.

A layer of coating composition is applied to at least a portion of an exterior surface of a body of the seal ring (step 320). Any suitable technique can be used to apply the layer of coating composition. For example, in embodiments, the layer of coating composition is applied using at least one of an autodeposition
10 process, an electro-deposition process, and a plating process (e.g., an electroplating process or an electroless plating process). In embodiments, any suitable autodeposition process, electro-deposition process, or plating process known to one skilled in the art can be used to apply the layer of coating composition.

15 In embodiments, before the layer of coating composition is applied to the seal ring, the seal ring can be cleaned to remove any foreign substances deposited on the exterior surface of the metallic substrate of the seal ring to which the layer of coating composition is to be applied. Such foreign substances, may include, for example, grease, dirt, dust, oils, or any other
20 substances that may interfere with a coating process. The seal ring can be cleaned, and/or degreased, using any known physical or chemical means. For example, a cleaning agent, such as any commercially-available alkaline or acidic cleaning agents, may be used. In addition, the seal ring can be subjected to grit blasting using a suitable abrasive media to enhance the adhesion of the layer of
25 coating composition to the exterior surface of the seal ring.

In embodiments, the coating composition can be made from any suitable material. For example, in embodiments, the coating composition is formulated to withstand the isotropic finishing process used to polish the sealing bands. In embodiments, the coating composition can be made from a material

that has an enhanced property or characteristic relative to the material from which the seal ring is made. For example, in embodiments, the seal ring is made from a seal ring material (e.g., a ferrous alloy), and the layer of coating composition is more corrosion resistant than the seal ring material. In embodiments, the coating
5 composition includes a material possessing a rust preventative characteristic.

In embodiments, the layer of coating composition is applied using an autodeposition process, and the layer of coating composition comprises an epoxy. In embodiments, the layer of coating composition comprises an epoxy-acrylic resin. In embodiments, the layer of coating composition comprises a
10 suitable autodepositable coating composition, including, for example, a coating composition marketed under the brand name Autophoretic® or Autophoretic Coating Chemicals® by Henkel Surface Technologies. In embodiments, the autodepositable coating composition comprises an Autophoretic® coating composition including an epoxy-acrylic based resin. In embodiments, the
15 autodepositable coating composition comprises a coating composition marketed by Henkel Surface Technologies as Bonderite Metal Pre-treatment Paint Process (BONDERITE M-PP) 930. In yet other embodiments, the layer 142 of coating composition can comprise other suitable autodepositable coating compositions.

In embodiments, the layer of coating composition is applied using
20 any suitable autodeposition process in which a waterborne coating composition is applied to the seal ring by means of a chemical reaction. Specifically, the seal ring can be dipped, or immersed, into a chemical bath, where pigment and resin particles may be deposited onto the exterior surface thereof (or at least a portion thereof).

25 As is known in the art, the seal ring can undergo one or more rinse stages, after application of the autodepositable coating composition. For example, the seal ring can undergo a first rinse to remove any coating composition material that has not adhered to the exterior surface of the seal ring. In addition, a reaction rinse may be provided to allow new properties, such as, for

example, increased corrosion resistance, to be introduced to the autodepositable coating composition before curing. After the rinse stages, the seal ring can be heated, using any suitable technique known to one skilled in the art, to a temperature sufficient to cure the autodepositable coating composition.

- 5 Specifically, the seal ring can be heated to a target temperature for a predetermined time to sufficiently cure the autodepositable coating composition.

In addition, it should be understood that in embodiments, the layer of coating composition can be applied to more than the intended application area of the seal ring in the application process. In embodiments, one or more portions
10 of the seal ring which have the layer of coating material application can be treated, such as by machining processes to remove the applied layer of coating composition therefrom. For example, the layer of coating composition can be applied to the exterior surface of the seal ring by dipping the entire seal ring into the chemical bath. In embodiments, the layer of coating composition can be
15 applied to the sealing face and/or the internal cylindrical surface of the seal ring. In embodiments, the layer of coating composition applied to the sealing face and/or the internal cylindrical surface of the seal ring can be removed using machining techniques known to those skilled in the art. In other embodiments, masking techniques can be used to protect one or more portions of the exterior
20 surface of seal ring such that the coating composition is inhibited from adhering thereto.

In step 330, the sealing face of the seal ring is machined to define an inner relieved area. The sealing face extends radially outward from the body of the seal ring. In step 330, the sealing face can be machined using any suitable
25 technique, such as by lapping with a spherical lap, for example, to define the inner relieved area.

The sealing face of the seal ring is machined to define a sealing band (step 340). The sealing band is disposed radially outward of the inner relieved area along the sealing face. In step 340, the sealing face can be

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machined using any suitable technique, such as by lapping with a flat lap, for example, to define the sealing band.

After the layer of coating composition is applied, the sealing band is polished by subjecting the sealing band to an isotropic finishing process (step 5 350). In embodiments, the sealing band is polished by subjecting the sealing band to isotropic finishing such that the sealing band has a surface roughness average of about 0.2 micrometers Ra or less; about 0.15 micrometers Ra or less in still other embodiments; and about 0.1 micrometers Ra or less in yet other embodiments.

10 In embodiments, once the sealing band is polished in step 350, the inner relieved area and the sealing band of the sealing face substantially do not have the layer of coating composition applied thereto. In other words, to the extent that the layer of coating composition is applied to the sealing face, it can be removed therefrom during the machining steps 330, 340 and/or through other 15 machining operations so that the sealing band can be isotropically finished.

In embodiments, any suitable isotropic finishing process can be used to polish the sealing band. In embodiments, the processing procedure for isotropic finishing can involve two cycles, namely a cut cycle and a burnish cycle. The cycle time can vary depending upon the initial surface finish and part 20 geometry tolerance. In embodiments, the cycle times can be determined such that seal ring part geometry, e.g., corners, roundness, slopes, openings, etc., remain within tolerance.

In embodiments, subjecting the sealing band to isotropic finishing comprises applying a cutting fluid to the surface of the component to yield an 25 isotropic surface finish. In embodiments, the cutting fluid has a pH of about five to about six. For example, in embodiments, the acid used in the cut cycle is one of phosphoric acid and oxalic acid with a pH value between about five and about six.

For example, in embodiments, the seal ring is subjected to acid resurfacing wherein the seal ring is submerged in a cutting fluid mixture of an

appropriate acid such as phosphoric or oxalic acid, with a pH value between about five and about six as described above. The acid resurfacing may be executed in a processing tank. The cutting fluid can be introduced into the processing tank from a cutting fluid reservoir via an electronically-controlled cutting fluid valve operated by a refinishing processor. The refinishing processor can comprise a digital microcomputer or microprocessor associated with a non-transitory, computer-readable digital memory containing computer-executable code for controlling the operation of the refinishing processor. An agitator or other flow enhancement means can also be used to speed the processing of the seal ring in the processing tank.

The cutting process can proceed by removing the asperities, i.e., high points, in the surface of the sealing band of the seal ring, while elements in the solution protect the low points. In this way, asperities become broadened and lowered to an extent that the irregularities eventually become sufficiently minor and isotropic.

In embodiments, subjecting the sealing band to isotropic finishing further comprises applying a burnishing solution to the surface of the component. In embodiments, the burnishing solution has a pH of about seven to about nine. For example, in embodiments, the solution used in the burnish cycle is a slip agent at a pH of about seven to about nine. In embodiments, the cut or burnish fluid need not be removed prior to adding fluid for the burnish cycle or prior to adding fluid to maintain the pH of the fluid. After burnishing, the processed seal rings can be completely rinsed to prevent further etching or erosion.

For example, in embodiments, once the surface cutting stage is complete, the sealing band is burnished in an embodiment. A burnishing solution, e.g., a slip agent having a pH of about seven to about nine, is flowed over the sealing band of the seal ring. In embodiments, the cutting fluid is drained prior to introduction of the burnishing solution. In other embodiments, the burnishing solution itself is used to displace the cutting fluid. An

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electronically-controlled cutting fluid valve from the cutting fluid reservoir can be closed, while an electronically-controlled evacuation valve is opened to drain the processing tank. Contemporaneously, an electronically-controlled burnishing solution valve arranged with a burnishing solution tank can be opened to admit
5 the burnishing solution into the processing tank.

The burnishing solution can act to further smooth the sealing band of the seal ring and also to neutralize the cutting fluid to avoid continued cutting. After the burnishing cycle, the seal ring can be rinsed to cease the isotropic finishing cycles. In embodiments, the layer of coating composition is formulated
10 to withstand the isotropic finishing process used to polish the sealing band such that the layer of coating composition remains generally intact as it was prior to being subjected to the isotropic finishing cycles.

Industrial Applicability

The industrial applicability of the embodiments of an alloy for a
15 seal ring, a seal ring for a seal assembly, and a method of making a seal ring described herein will be readily appreciated from the foregoing discussion. The described principles are applicable to machines and equipment including a wheel assembly such that one member is rotatably movable with respect to the other member. A wheel assembly can include at least one seal assembly constructed in
20 accordance with the present principles. In other embodiments, a seal ring constructed according to principles of the present disclosure can be used in a seal assembly used in a different application, such as a slurry pump auger or a pin joint assembly for a linkage assembly, for example.

During use, the first and second seal rings 111, 112 can help
25 prevent a fluid, such as, a lubricant (not shown), e.g., from leaking out of an internal cavity. The first and second seal rings 111, 112 provide a running seal therebetween. Specifically, the first and second seal rings 111, 112 rotate relatively against one another in sealing engagement. The first and second load rings 121, 122 act in the manner of a spring to apply an axial load respectively

against the first and second seal rings 111, 112 in opposing directions along the longitudinal axis "LA" to bring the sealing bands 140 of the first and second seal rings 111, 112 into face-to-face sealing contact under pressure such that a running fluid-tight seal is formed. The structure of the seal cavity 40 can help maintain
5 the first and second load rings 121, 122 in proximal relationship to the first and second seal rings 111, 112, respectively, to promote the opposing axial forces exerted by the first and second seal rings 111, 112 against each other. Accordingly, fluid can be restrained from escaping from the seal cavity 40 under difficult loading conditions.

10 Construction of the sealing bands 140 is such that an effective fluid tight seal can be produced readily upon installation of the first and second seal rings 111, 112 in a joint. The sealing bands 140 can have a consistent surface finish produced using an isotropic finishing process. Isotropic finishing can modify the surface finish and/or texture of the sealing band to improve its
15 performance through reduced galling or wear when relative sliding occurs. Subjecting the sealing band to isotropic finishing can help decrease pitting fatigue and extending the useful life of the seal ring.

Furthermore, before the isotropic finishing process takes place, a layer of coating composition can be applied to the exterior surface of the seal ring
20 to enhance its corrosion and/or rust resistance, for example. The layer of coating composition can be formulated to withstand the isotropic finishing process.

It will be appreciated that the foregoing description provides examples of the disclosed system and technique. However, it is contemplated that other implementations of the disclosure may differ in detail from the
25 foregoing examples. All references to the disclosure or examples thereof are intended to reference the particular example being discussed at that point and are not intended to imply any limitation as to the scope of the disclosure more generally. All language of distinction and disparagement with respect to certain features is intended to indicate a lack of preference for the features of interest, but

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not to exclude such from the scope of the disclosure entirely unless otherwise specifically indicated.

Recitation of ranges of values herein are merely intended to serve as a shorthand method of referring individually to each separate value falling
5 within the range, unless otherwise indicated herein, and each separate value is incorporated into the specification as if it were individually recited herein. All methods described herein can be performed in any suitable order unless otherwise indicated herein or otherwise clearly contradicted by context.

Claims

1. A method of preparing a seal ring (111, 112) for a seal assembly (30, 36), the method of preparing comprising:
5 producing the seal ring (111, 112);
applying a layer (142) of coating composition to at least a portion of an exterior surface (143) of a body (240) of the seal ring (111, 112);
machining a sealing face (136) of the seal ring (111, 112) to define an inner relieved area (245), the sealing face (136) extending radially outward
10 from the body (240) of the seal ring (111, 112);
machining the sealing face (136) of the seal ring (111, 112) to define a sealing band (140), the sealing band (140) disposed radially outward of the inner relieved area (245) along the sealing face (136); and
after the layer (142) of coating composition is applied, polishing
15 the sealing band (140) by subjecting the sealing band (140) to an isotropic finishing process.
2. The method of preparing according to claim 1, wherein the sealing band (140) is polished by subjecting the sealing band (140) to isotropic
20 finishing such that the sealing band (140) has a surface roughness average of about 0.2 micrometers Ra or less.
3. The method of preparing according to claim 1 or claim 2, wherein once the sealing band (140) is polished, the inner relieved area (245) and
25 the sealing band (140) of the sealing face (136) substantially do not have the layer (142) of coating composition applied thereto.

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4. The method of preparing according to claim 1 or claim 2, wherein the layer (142) of coating composition is applied using at least one of an autodeposition process, an electro-deposition process, and a plating process.
5. The method of preparing according to claim 4, wherein the layer (142) of coating composition is formulated to withstand the isotropic finishing process.
6. The method of preparing according to claim 5, wherein the seal ring (111, 112) is made from a seal ring material, and the layer (142) of coating composition is more corrosion resistant than the seal ring material.
7. The method of preparing according to claim 1 or claim 2, wherein the layer (142) of coating composition is applied using an autodeposition process, and the layer (142) of coating composition comprises an epoxy.
8. The method of preparing according to claim 7, wherein the layer (142) of coating composition comprises an epoxy-acrylic resin.
9. A seal ring (111, 112) for a seal assembly (30, 36), the seal ring (111, 112) being made according to any one of claims 1 to 8.
10. A seal assembly (30, 36) adapted for use in sealing a joint having a first member (32, 38) pivotable about a rotational axis relative to a second member (34, 34) thereof, the seal assembly (30, 36) comprising:
a first annular seal ring (111) and a second annular seal ring (112), the first annular seal ring (111) and the second annular seal ring (112) being respectively made according to any one of claims 1 to 8, the first annular seal ring (111) and the second annular seal ring (112) each having a loading surface

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(134) extending axially and a sealing face (136) extending radially to an outer perimeter (138), the sealing face (136) of both of the first annular seal ring (111) and the second annular seal ring (112) having a sealing band (140) disposed adjacent the outer perimeter (138), the first annular seal ring (111) and the second
5 annular seal ring (112) abutting one another such that the sealing band (140) of the first annular seal ring (111) is in contacting relationship with the sealing band (140) of the second annular seal ring (112); and

a first annular load ring (121) and a second annular load ring (122), the first annular load ring (121) engaging the loading surface (134) of the
10 first annular seal ring (111), the second annular load ring (122) engaging the loading surface (134) of the second annular seal ring (112);

wherein the sealing band (140) of both of the first annular seal ring (111) and the second annular seal ring (112) is isotropically finished.

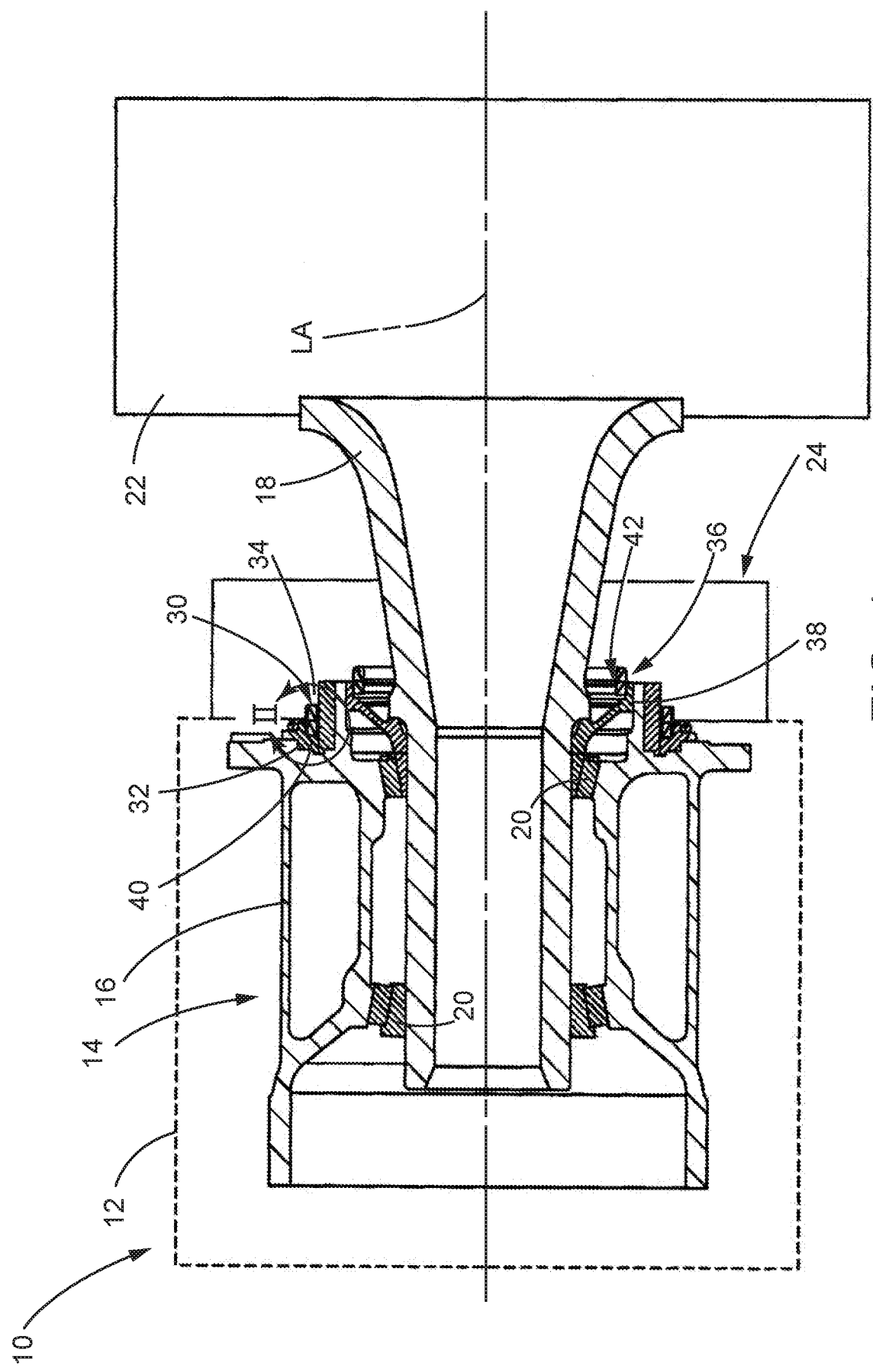
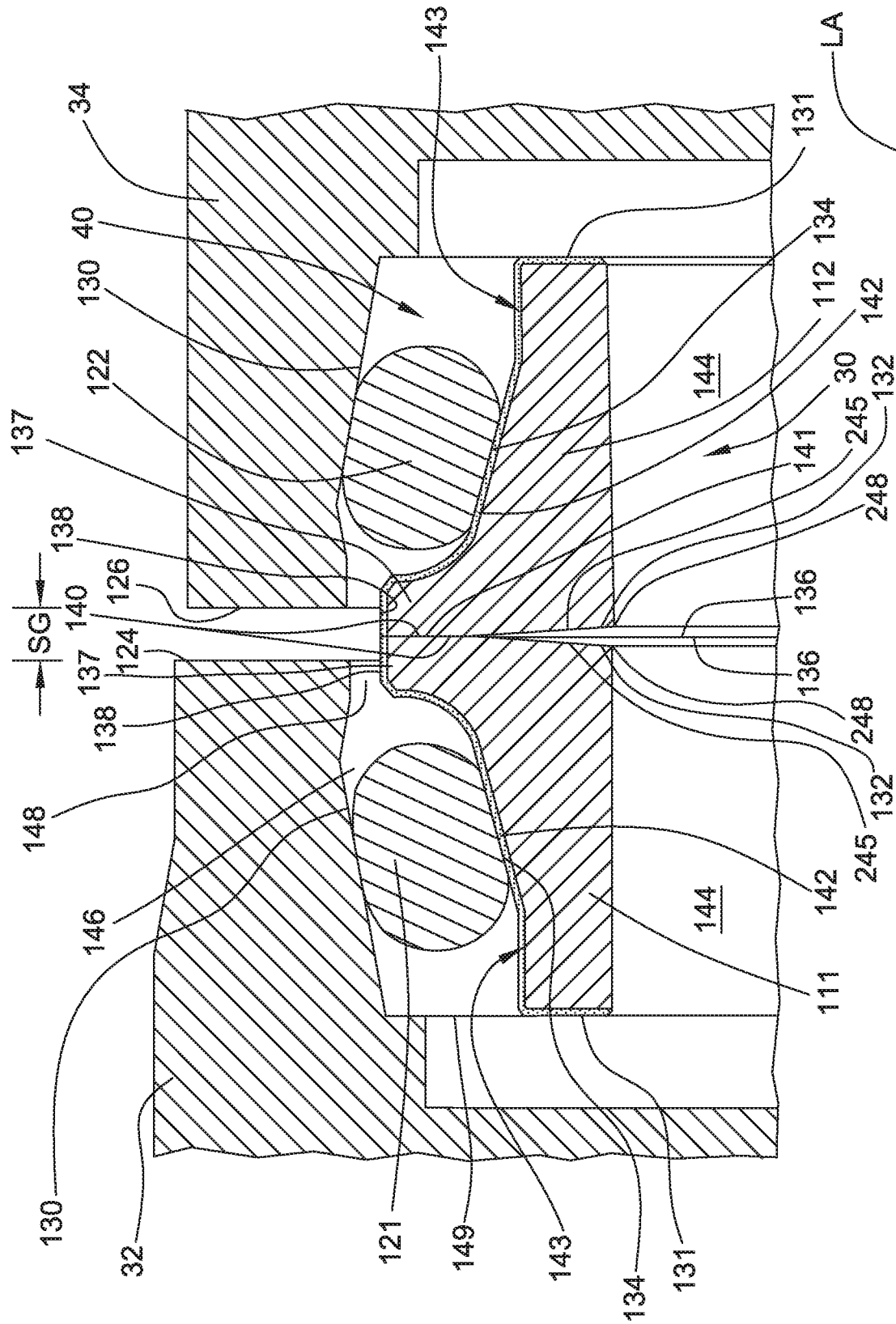


FIG. 1

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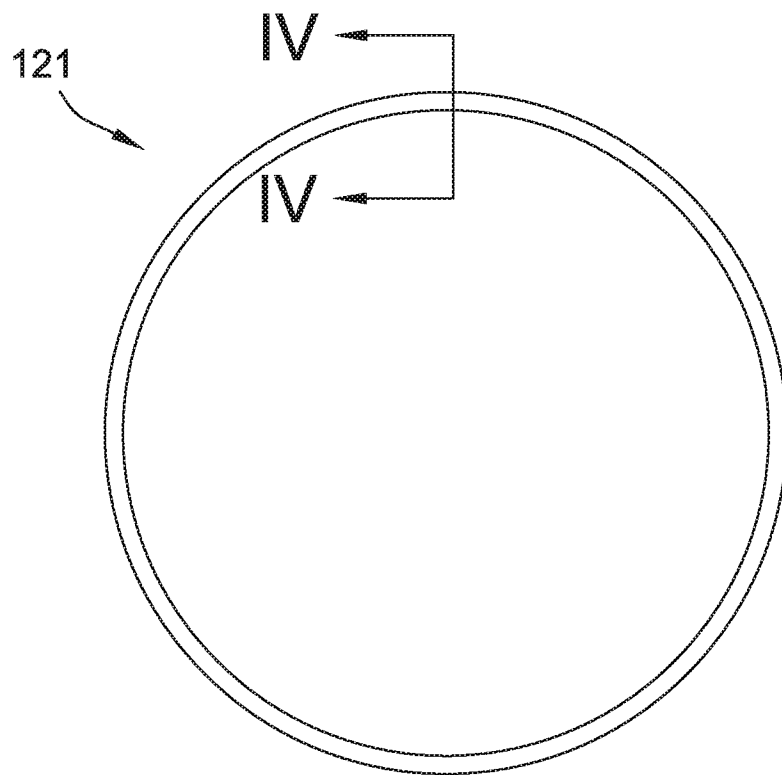


FIG. 3

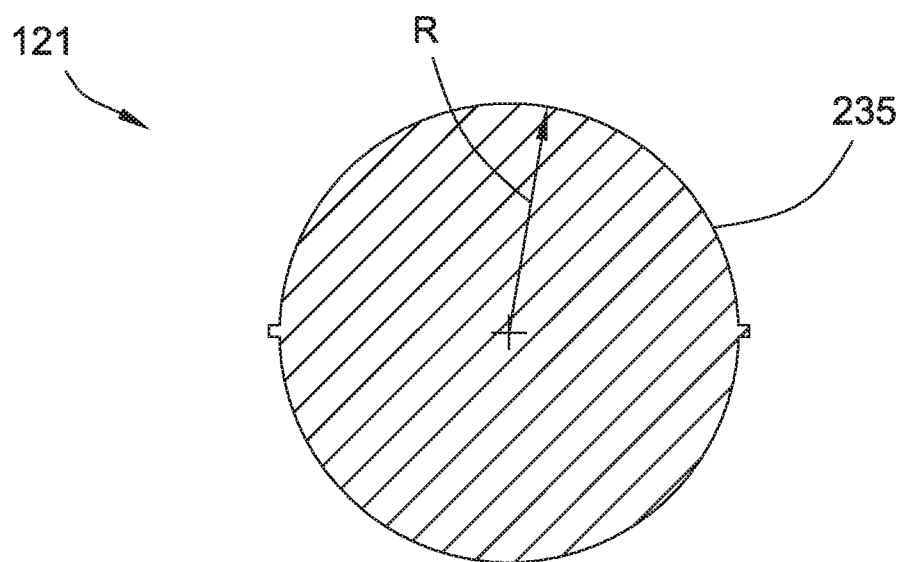


FIG. 4

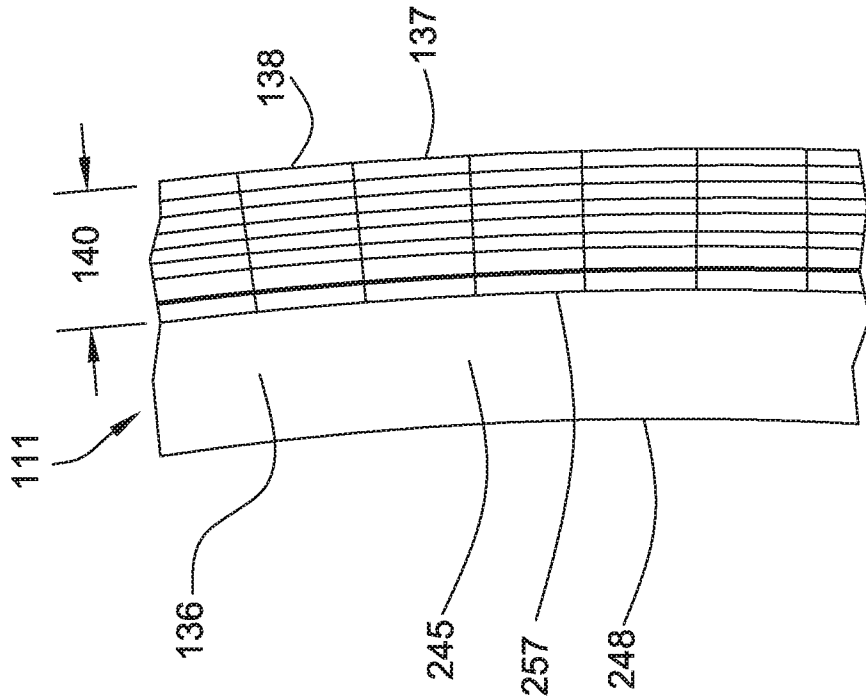


FIG. 5

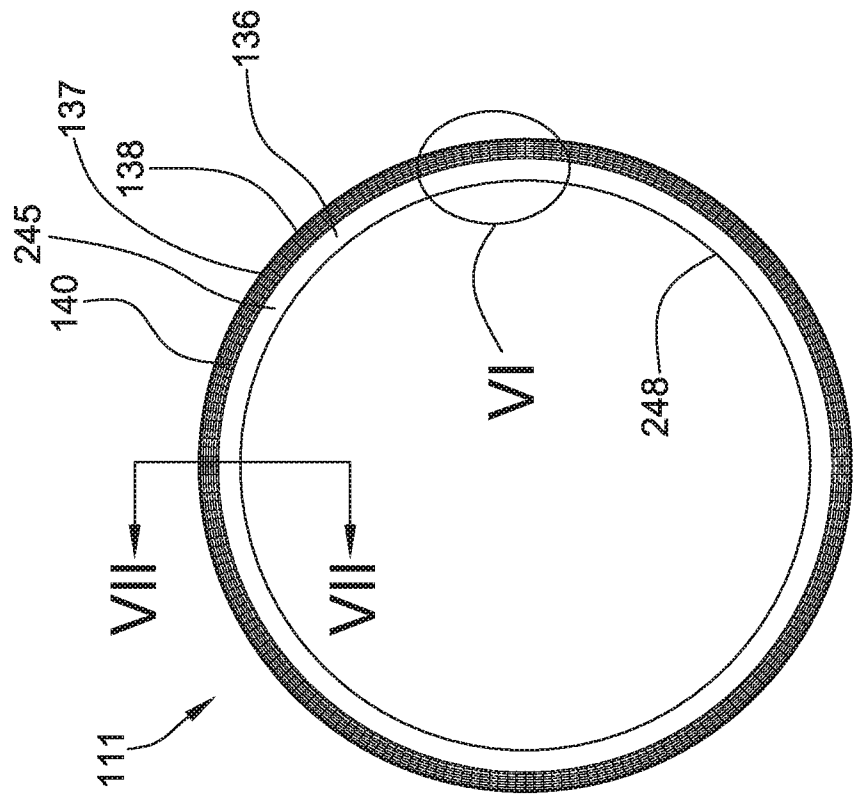


FIG. 6

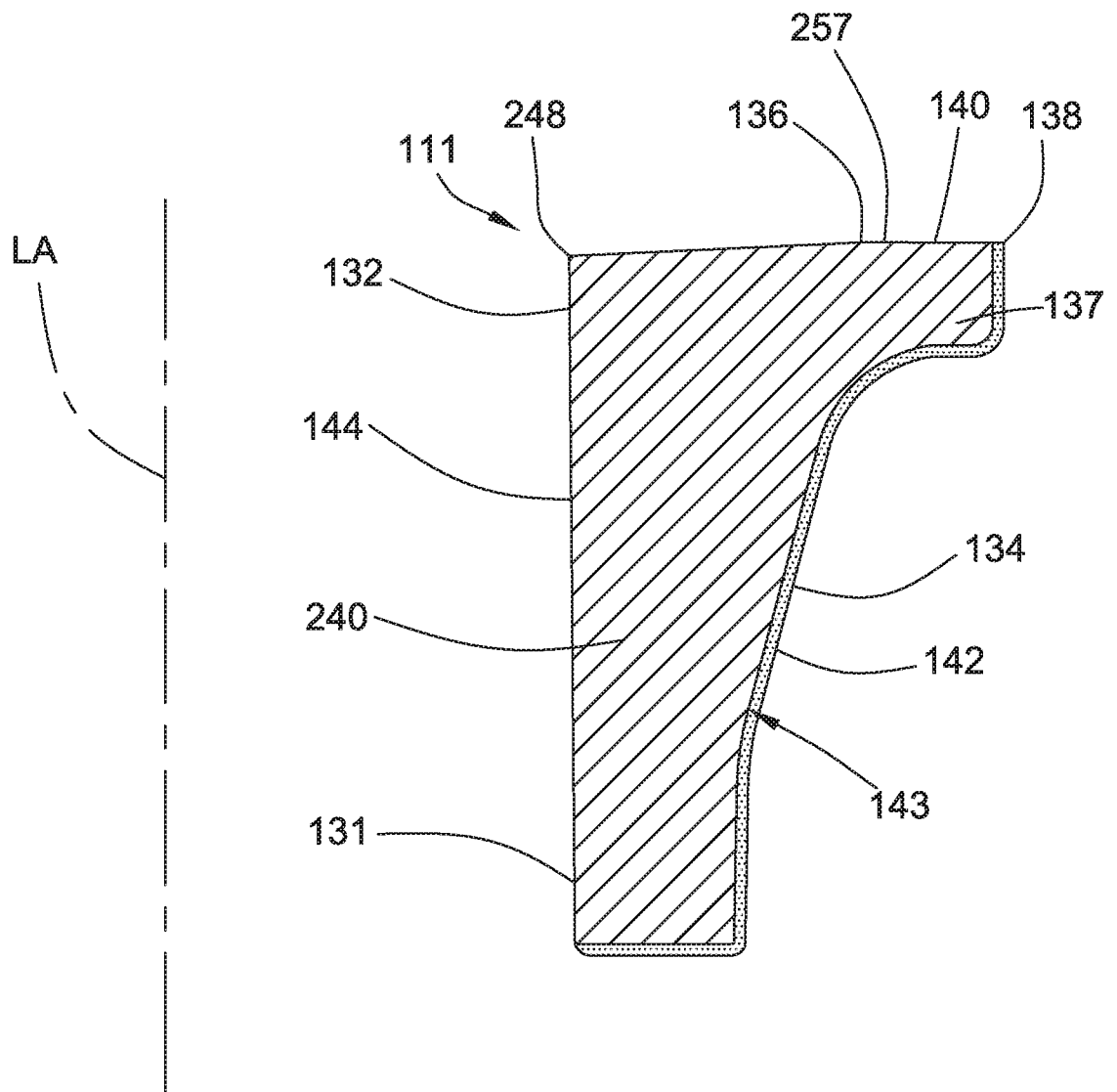


FIG. 7

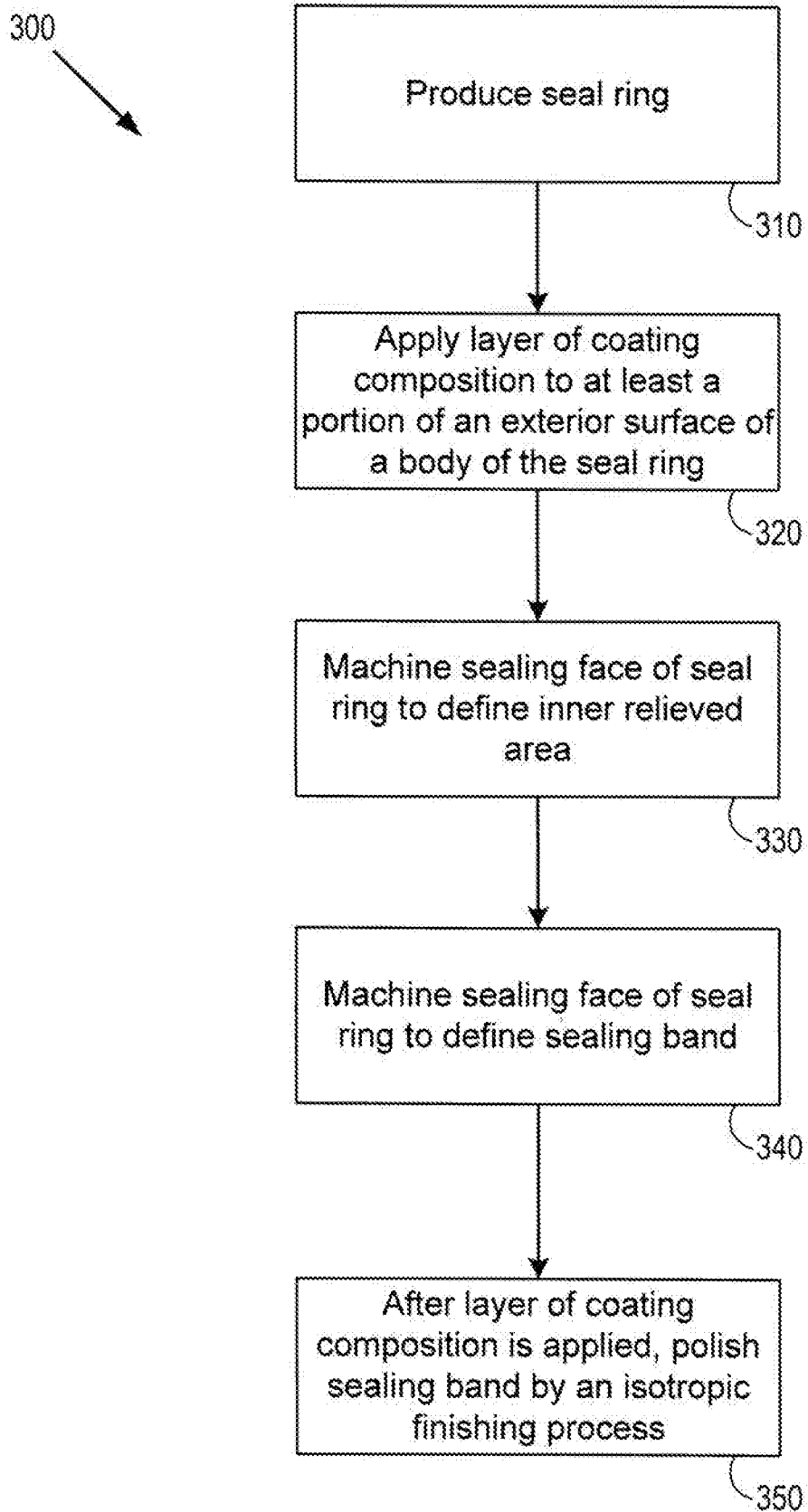


FIG. 8

INTERNATIONAL SEARCH REPORT

International application No
PCT/US2017/029561

A. CLASSIFICATION OF SUBJECT MATTER
INV. F16J15/34
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)
F16J

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

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 2 042 789 A1 (KOMATSU MFG CO LTD [JP]) 1 April 2009 (2009-04-01)	10
A	the whole document	1-9
A	US 2016/076122 A1 (BARNES CHRISTOPHER A [US] ET AL) 17 March 2016 (2016-03-17) paragraph [0090] - paragraph [0095]; figures	1-9



Further documents are listed in the continuation of Box C.



See patent family annex.

* 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

4 July 2017

Date of mailing of the international search report

18/07/2017

Name and mailing address of the ISA/

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Authorized officer

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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2017/029561

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