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(54) **METHOD FOR COATING A
CARBON-CARBON COMPOSITE X-RAY
TUBE BEARING CAGE**

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H01J 35/00 (2006.01)

(52) **U.S. Cl.** **378/132; 378/133**

(58) **Field of Classification Search** **378/132-133;**
384/492

See application file for complete search history.

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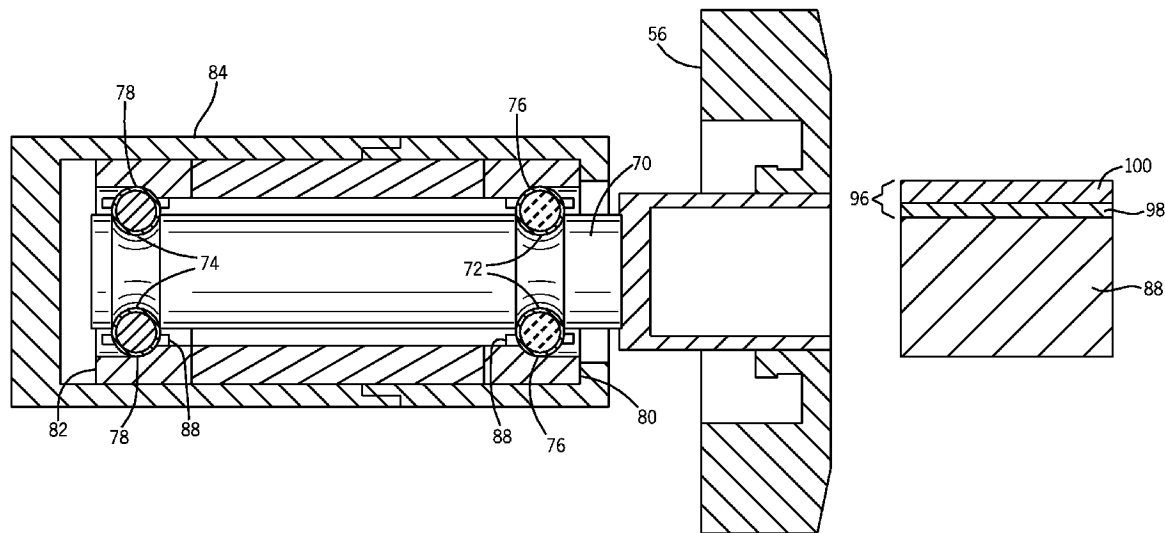
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(57) **ABSTRACT**

A method for manufacturing an x-ray tube bearing cage includes the step of forming a bearing cage from a carbon-carbon composite material. A coating is applied to the carbon-carbon composite bearing cage. The coating includes an outer layer formed of a dry film lubricant. The coated carbon-carbon composite bearing cage is included in a bearing assembly in the x-ray tube and forms a lubricious enclosure for bearing balls positioned therein to minimize wear and heat generation in the bearing assembly.

22 Claims, 6 Drawing Sheets



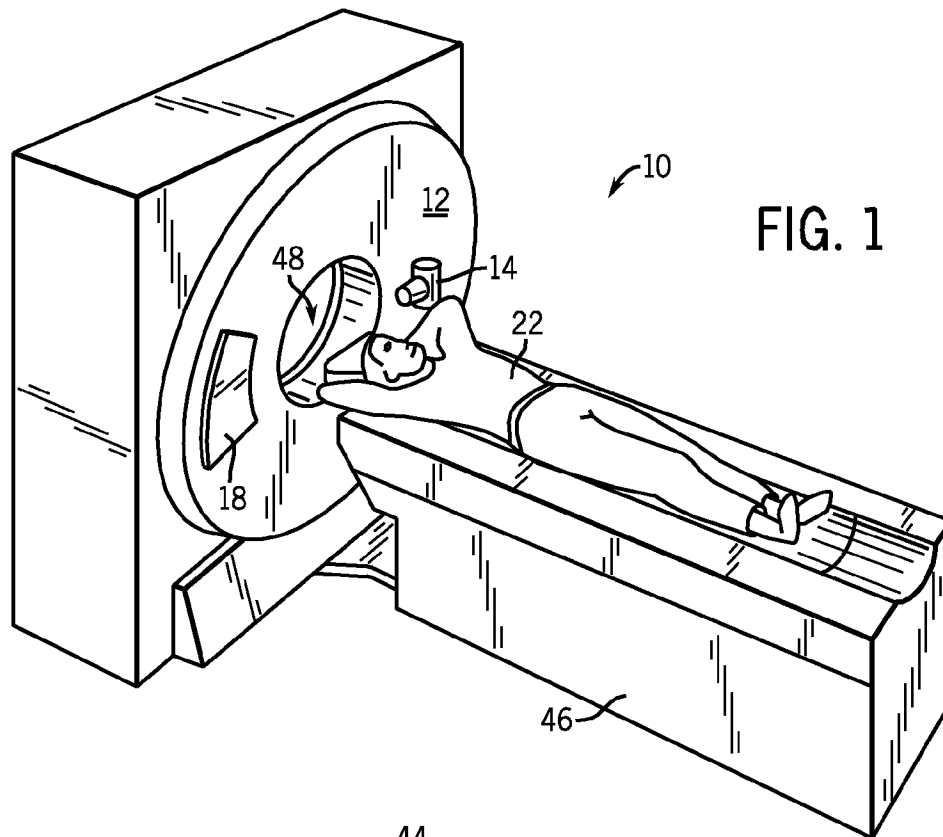
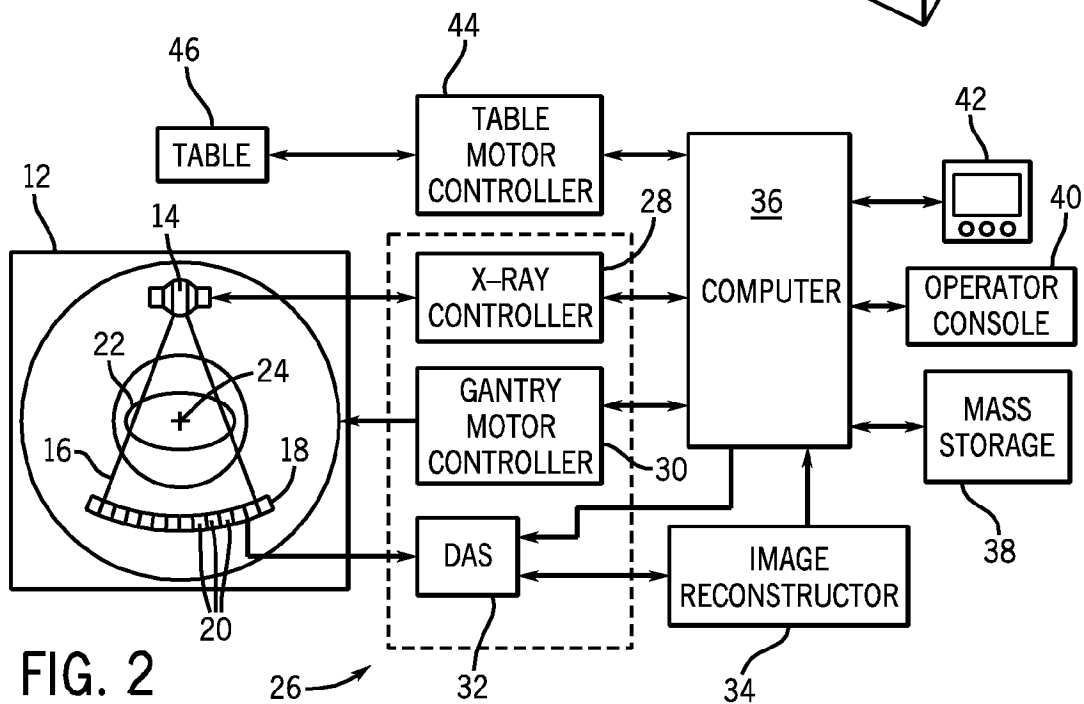


FIG. 1



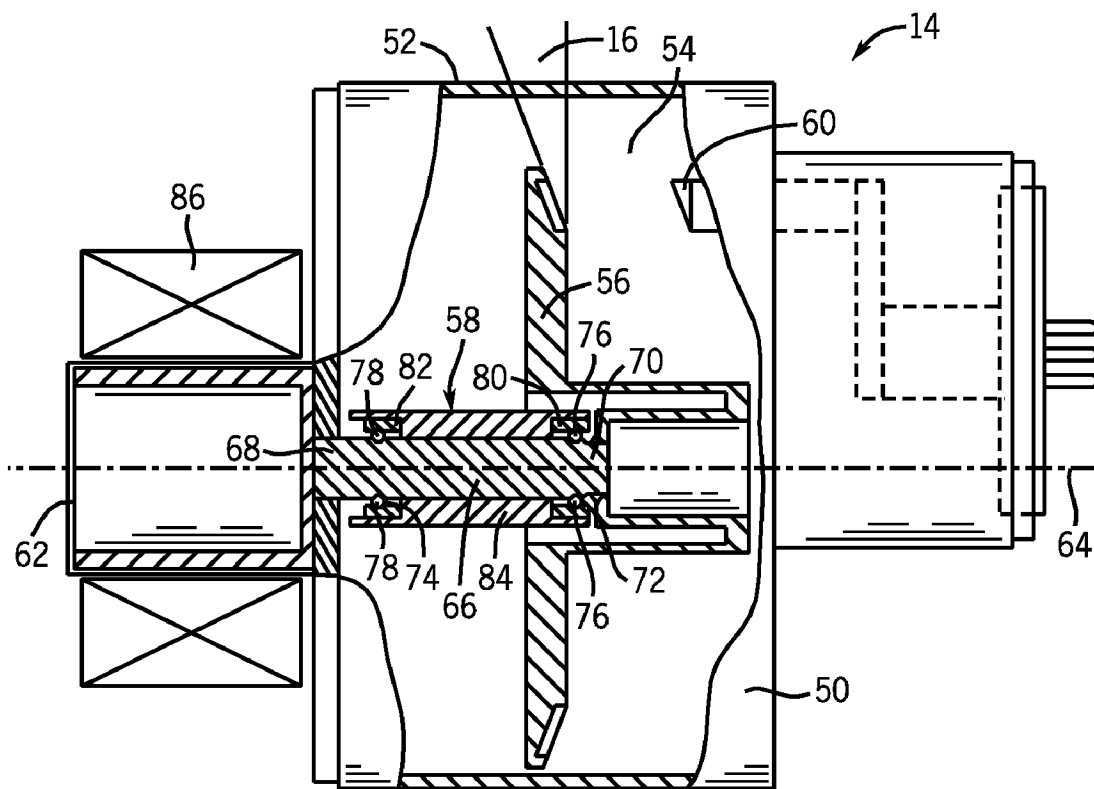


FIG. 3

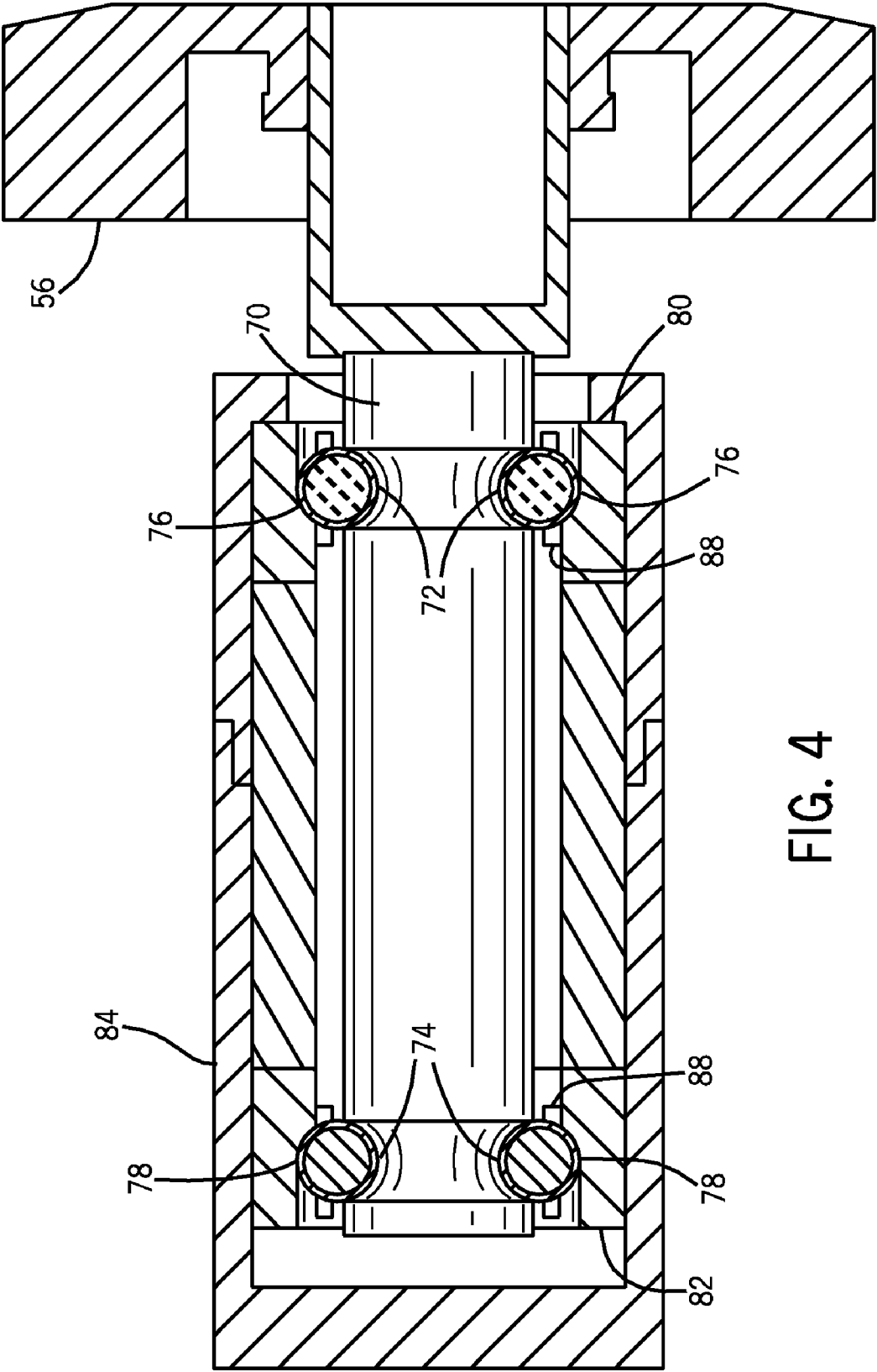


FIG. 4

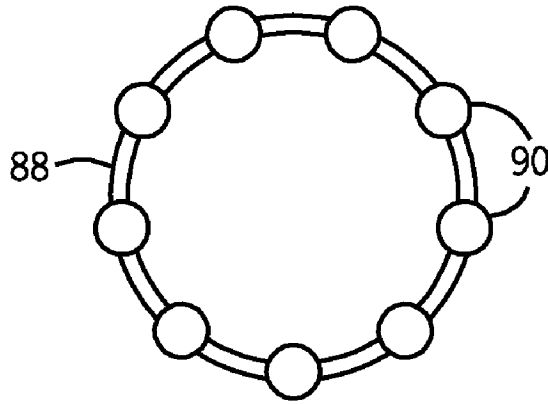


FIG. 5

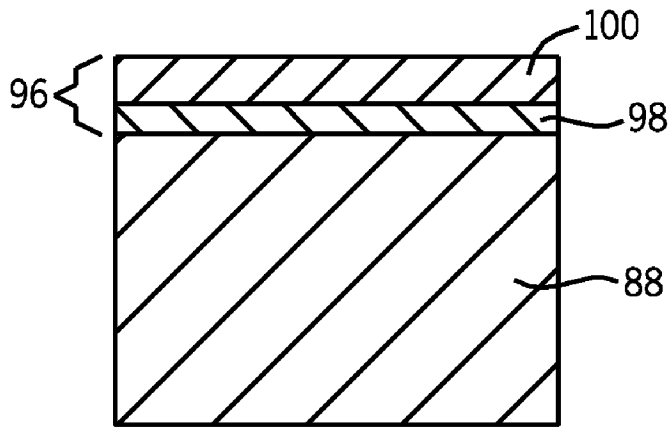


FIG. 6

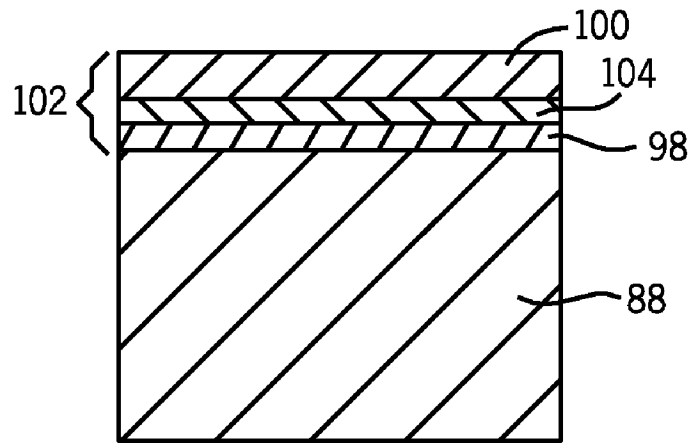


FIG. 7

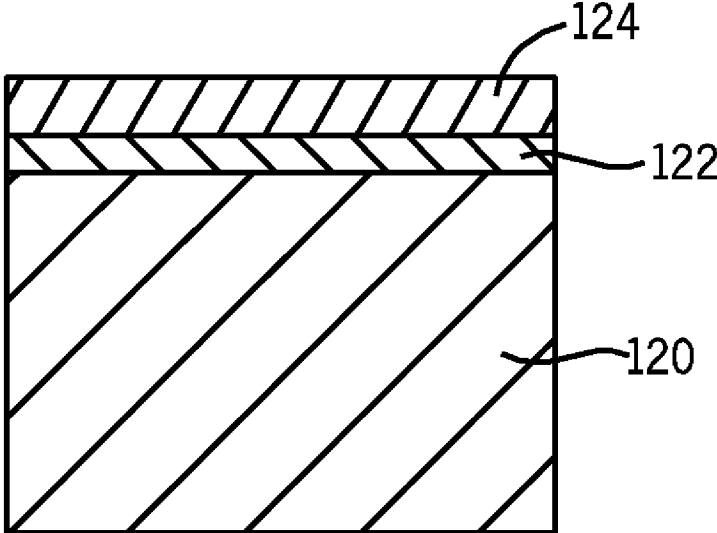


FIG. 8

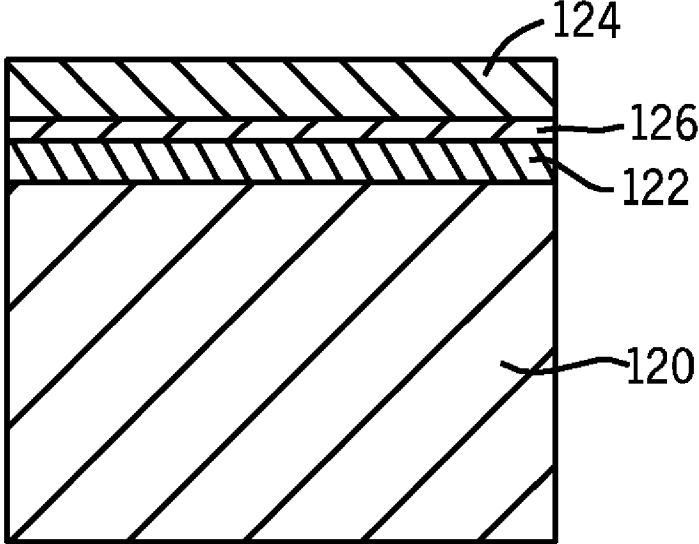


FIG. 9

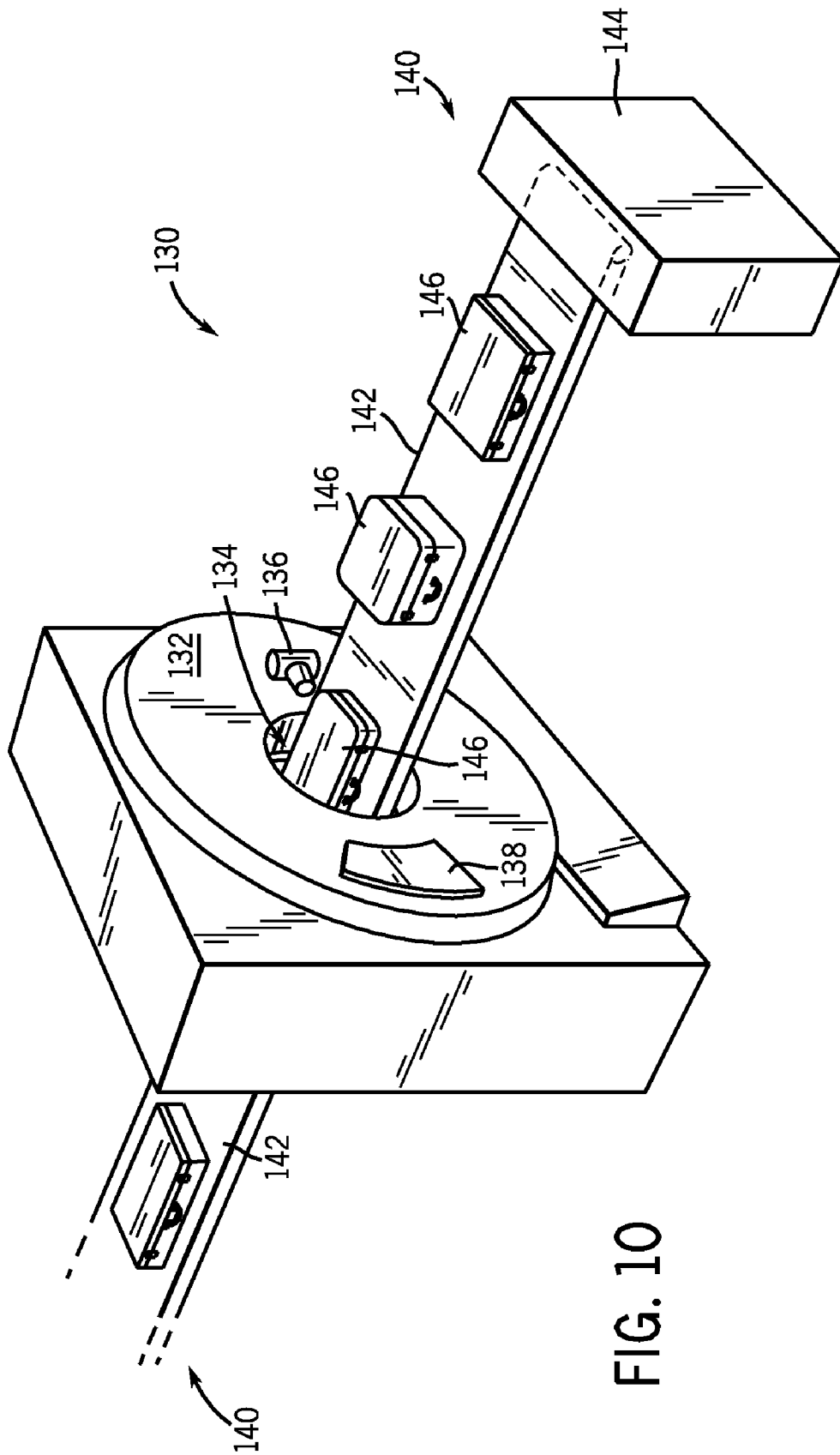


FIG. 10

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METHOD FOR COATING A CARBON-CARBON COMPOSITE X-RAY TUBE BEARING CAGE

BACKGROUND OF THE INVENTION

The present invention relates generally to x-ray tubes and, more particularly, to a method of manufacturing an x-ray tube bearing assembly having a coated bearing cage therein.

X-ray systems typically include an x-ray tube, a detector, and a bearing assembly to support the x-ray tube and the detector. In operation, an imaging table, on which an object is positioned, is located between the x-ray tube and the detector. The x-ray tube typically emits radiation, such as x-rays, toward the object. The radiation typically passes through the object on the imaging table and impinges on the detector. As radiation passes through the object, internal structures of the object cause spatial variances in the radiation received at the detector. The detector then emits data received, and the system translates the radiation variances into an image, which may be used to evaluate the internal structure of the object. One skilled in the art will recognize that the object may include, but is not limited to, a patient in a medical imaging procedure and an inanimate object as in, for instance, a package in a computed tomography (CT) package scanner.

X-ray tubes include a rotating anode structure for the purpose of distributing the heat generated at a focal spot. The anode is typically rotated by an induction motor having a cylindrical rotor built into a cantilevered axle that supports a disc-shaped anode target and an iron stator structure with copper windings that surrounds an elongated neck of the x-ray tube. The rotor of the rotating anode assembly is driven by the stator. An x-ray tube cathode provides a focused electron beam that is accelerated across an anode-to-cathode vacuum gap and produces x-rays upon impact with the anode. Because of the high temperatures generated when the electron beam strikes the target, it is necessary to rotate the anode assembly at high rotational speed. This places stringent demands on the bearing assembly, which includes tool steel ball bearings and tool steel raceways.

Bearings used in x-ray tubes are required to operate in a vacuum, which precludes lubricating with conventional wet bearing lubricants such as grease or oil. X-ray tube bearing rolling elements (i.e., bearing balls) are typically coated with a solid layer, or tribological system, of a metal with lubricating properties, such as silver, lead, or lead-tin. The lubricating metal that coats the bearing balls helps to reduce friction between adjacent balls and between the balls and the raceway. Despite the lubricating metal coating, however, a large amount of friction and heating is present at contact points between the balls and the raceway. The operating conditions in the x-ray tube environment, where temperatures in the vacuum environment range from 300-500 degrees Celsius and stress levels on the bearing balls can exceed 2.5 GPa, creates yet additional challenges for the bearing

Failure of a bearing in an x-ray tube is typically by wear of the plated silver and loss of the silver from a contact region between adjacent bearing balls and between the bearing balls and the raceway. Wear of the plated silver can occur because the balls in the bearing are not evenly spaced around the raceway and the ball-to-ball space positions are changed when the bearing is running. When a bearing ball is transitioned from a load zone to a non-load zone in the bearing, the ball rapidly moves out of the load zone and hits an adjacent ball due to load release. This load release results in a large impact load between adjacent bearing balls. The impact load damages a ball surface by causing indentations on the surface

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at the ball-to-ball contact point. Additionally, the rotation of adjacent bearing balls are opposite to one another. The rotational velocity of the ball surfaces, in inverse directions, creates high skidding torque and heat build-up when the adjacent balls contact one another. The high skidding velocities and internal heat created by ball-to-ball contact causes tremendous wear and lubrication damage so as to reduce bearing life. Thus, impact indentations, skidding wear, and heat build-up all serve to affect bearing performance and durability.

Therefore, it would be desirable to have a method and apparatus to eliminate the problems of skidding wear and dynamic impact load between adjacent balls in a bearing assembly. It would also be desirable to reduce skidding wear and heat build-up between such an apparatus and the bearing balls that may lead to premature failure of the x-ray tube.

BRIEF DESCRIPTION OF THE INVENTION

The present invention provides a method for manufacturing a bearing cage in an x-ray tube bearing assembly that overcomes the aforementioned drawbacks. A coating is applied to a carbon-carbon composite bearing cage to lubricate the bearing cage and prevent wear and particle generation therefrom.

According to one aspect of the present invention, a method of manufacturing an x-ray tube bearing cage includes the steps of forming a bearing cage from a carbon-carbon composite material and applying a coating to the carbon-carbon composite material, wherein the coating includes an outer layer formed of a dry film lubricant.

According to another aspect of the present invention, a method of manufacturing an x-ray tube bearing assembly includes the steps of assembling a bearing race having an inner race and an outer race, forming at least one carbon-carbon composite bearing cage, and coating the at least one carbon-carbon composite bearing cage with a dry film lubricant. The method further includes the steps of placing the at least one coated carbon-carbon composite bearing cage between the inner race and the outer race and positioning a plurality of bearing balls within the at least one carbon-carbon composite bearing cage.

According to yet another aspect of the present invention, a method for manufacturing an x-ray tube includes the steps of forming a casing having a vacuum therein, positioning an anode and a cathode within the casing, mounting the anode on a rotatable shaft, and supporting the rotatable shaft with a bearing assembly. The bearing assembly is constructed by assembling a bearing race having an inner race and an outer race, positioning a carbon-carbon composite retainer within the bearing race, applying a dry film lubricant to the carbon-carbon composite retainer, and positioning a plurality of bearing balls within the retainer.

Various other features and advantages of the present invention will be made apparent from the following detailed description and the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

The drawings illustrate one preferred embodiment presently contemplated for carrying out the invention.

In the Drawings:

FIG. 1 is a pictorial view of a CT imaging system that can benefit from incorporation of an embodiment of the present invention.

FIG. 2 is a block schematic diagram of the system illustrated in FIG. 1.

FIG. 3 is a cross-sectional view of an x-ray tube useable with the system illustrated in FIG. 1.

FIG. 4 is a cross-sectional view of a bearing assembly according to one embodiment of the present invention.

FIG. 5 is a cross-sectional view of a bearing cage according to one embodiment of the present invention

FIG. 6 is a partial cross-sectional view of a bearing cage having a combination coating according to an embodiment of the present invention.

FIG. 7 is a partial cross-sectional view of a bearing cage having a gradient coating according to an embodiment of the present invention.

FIG. 8 is a partial cross-sectional view of a base material having a combination coating according to an embodiment of the present invention.

FIG. 9 is a partial cross-sectional view of a base material having a combination coating according to another embodiment of the present invention.

FIG. 10 is a pictorial view of a CT system for use with a non-invasive package inspection system.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

The operating environment of the present invention is described with respect to the use of an x-ray tube as used in a computed tomography (CT) system. However, it will be appreciated by those skilled in the art that the present invention is equally applicable for use in other systems that require the use of an x-ray tube. Such uses include, but are not limited to, x-ray imaging systems (for medical and non-medical use), mammography imaging systems, and RAD systems.

Moreover, the present invention will be described with respect to use in an x-ray tube. However, one skilled in the art will further appreciate that the present invention is equally applicable for other systems that require operation of a bearing in a high vacuum, high temperature, and high contact stress environment, wherein a solid lubricant, such as silver, is plated on the rolling contact components. The present invention will be described with respect to a "third generation" CT medical imaging scanner, but is equally applicable with other CT systems, such as a baggage scanner.

Referring to FIGS. 1 and 2, a computed tomography (CT) imaging system 10 is shown as including a gantry 12 representative of a "third generation" CT scanner. Gantry 12 has an x-ray tube 14 that projects a beam of x-rays 16 toward a detector array 18 on the opposite side of the gantry 12. Detector array 18 is formed by a plurality of detectors 20 which together sense the projected x-rays that pass through a medical patient 22. Each detector 20 produces an electrical signal that represents the intensity of an impinging x-ray beam and hence the attenuated beam as it passes through the patient 22. During a scan to acquire x-ray projection data, gantry 12 and the components mounted thereon rotate about a center of rotation 24.

Rotation of gantry 12 and the operation of x-ray tube 14 are governed by a control mechanism 26 of CT system 10. Control mechanism 26 includes an x-ray controller 28 that provides power and timing signals to an x-ray tube 14 and a gantry motor controller 30 that controls the rotational speed and position of gantry 12. A data acquisition system (DAS) 32 in control mechanism 26 samples analog data from detectors 20 and converts the data to digital signals for subsequent processing. An image reconstructor 34 receives sampled and digitized x-ray data from DAS 32 and performs high speed

reconstruction. The reconstructed image is applied as an input to a computer 36 which stores the image in a mass storage device 38.

Computer 36 also receives commands and scanning parameters from an operator via console 40 that has a keyboard. An associated cathode ray tube display 42 allows the operator to observe the reconstructed image and other data from computer 36. The operator supplied commands and parameters are used by computer 36 to provide control signals and information to DAS 32, x-ray controller 28 and gantry motor controller 30. In addition, computer 36 operates a table motor controller 44 which controls a motorized table 46 to position patient 22 and gantry 12. Particularly, table 46 moves portions of patient 22 through a gantry opening 48.

FIG. 3 illustrates a cross-sectional view of an x-ray tube 14 that can benefit from incorporation of an embodiment of the present invention. The x-ray tube 14 includes a casing 50 having a radiation emission passage 52 formed therein. The casing 50 encloses a vacuum 54 and houses an anode 56, a bearing assembly 58, a cathode 60, and a rotor 62. X-rays 16 are produced when high-speed electrons are suddenly decelerated when directed from the cathode 60 to the anode 56 via a potential difference therebetween of, for example, 60 thousand volts or more in the case of CT applications. The x-rays 16 are emitted through the radiation emission passage 52 toward a detector array, such as detector array 18 of FIG. 2. To avoid overheating the anode 56 from the electrons, an anode 56 is rotated at a high rate of speed about a centerline 64 at, for example, 90-250 Hz.

The bearing assembly 58 includes a center shaft 66 attached to the rotor 62 at first end 68 and attached to the anode 56 at second end 70. A front inner race 72 and a rear inner race 74 of center shaft 66 rollingly engage a plurality of front balls 76 and a plurality of rear balls 78 (i.e., bearing balls), respectively, that function as rolling elements. Bearing assembly 58 also includes a front outer race 80 and a rear outer race 82 configured to rollingly engage and position, respectively, the plurality of front balls 76 and the plurality of rear balls 78. Bearing assembly 58 includes a stem 84 which is supported by the x-ray tube 14. Stator 86 drives rotor 62, which rotationally drives anode 56.

In addition to rotation of the anode 56 within x-ray tube 14, the x-ray tube 14 as a whole is caused to rotate about gantry 12 at rates of, typically, 1 Hz or faster. The rotational effects of both the x-ray tube 14 about the gantry 12 and the anode 56 within the x-ray tube 14 cause the anode 56 weight to be compounded significantly, hence leading to operating contact stresses in the races 72, 74, 80, 82 (i.e., a raceway) and bearing balls 76, 78 of up to 2.5 GPa. Additionally, heat generated from operation of the cathode 60, the resulting deceleration of electrons in anode 56, and heat generated from frictional self-heating of the races 72, 74, 80, 82 and bearing balls 76, 78 to operate typically above 400 degrees Celsius.

To reduce the heat and wear generated by friction between adjacent bearing balls 76, 78, a bearing cage or retainer is included in bearing assembly 58. As shown in FIG. 4, bearing assembly 58 includes bearing cages 88 to house the plurality of front bearing balls 76 and rear bearing balls 78, although it is also envisioned that only a single bearing cage 88 be included in the bearing assembly 58 to house either front bearing balls 76 or rear bearing balls 78. Bearing cages 88 are included at both the first and second ends 68, 70 of the bearing assembly 58 and are positioned between the front inner and outer races 72, 80 and the rear inner and outer races 74, 82, respectively. Bearing cages 88 are positioned about the bearing balls 76, 78 and are configured to prevent contact between adjacent balls. As shown in the detailed view of bearing cage

88 in FIG. 5, the bearing cage **88** is configured to evenly space the individual bearing balls **90** within apertures formed in the bearing cage **88**. As such, bearing cage **88** prevents impact load damage, skidding wear, and heat buildup that would occur were the bearing balls **90** allowed to make contact with one another. The alignment of the bearing balls **90** provided by bearing cage **88** also evenly distributes loads between the balls **90** associated with bearing rotation. Referring back to FIG. 4, the bearing cage **88** also accurately guides the balls in the races **72**, **74**, **80**, **82** during rotation of the bearing assembly **58**.

The bearing cages **88** are formed of a material that possesses a high specific strength and is capable of operating in an extreme high temperature environment, such as the environment present during operation of an x-ray tube. In a preferred embodiment, bearing cages **88** are formed of a carbon-carbon composite material that can withstand operation in an x-ray tube environment. It is envisioned, however, that the bearing cages **88** can also be formed from other suitable materials, such as AISI 4340 steel, that contain desired strength and temperature characteristics. Carbon-carbon composites, in particular, display a number of physical properties that make it a suitable material for construction of the bearing cages **88** for use in an x-ray tube. First, carbon-carbon composites have a high specific strength at high temperature (up to 1000° C. in vacuum), which is suitable for the high temperature environment of the x-ray tube bearing assembly. Also, carbon-carbon composites have a low coefficient of thermal expansion, which is desirable to lower strain associated with the large temperature differentials experienced in x-ray tube operation. Additionally, carbon-carbon composite materials have a low density, which serves to reduce the centrifugal force caused by the bearing cages **88** and lessen wear between the bearing cage **88** and the raceways **72**, **74**, **80**, **82**, shown in FIG. 4, as compared to denser materials. Finally, carbon-carbon composites have excellent heat transfer properties that help to reduce heat buildup in the bearing cages **88**.

Because of the high temperatures and high rotational speeds imposed on the bearing assembly by operation of the x-ray tube, according to another embodiment of the present invention, a coating may be applied to the carbon-carbon composite bearing cage **88** to allow it to operate more effectively by reducing part-wear and increasing lubricative properties. That is, a dry film or self-lubricating coating can be applied to bearing cage **88** for purposes of lubrication. Referring now to FIG. 6, a partial cross-sectional view of a bearing cage **88** is shown. As shown therein, a combination coating **96** is applied to the base material (i.e., carbon-carbon composite) that forms the bearing cage **88**. The combination coating **96** includes a bonding layer **98** (i.e., interlayer) and a lubricant layer **100**. The bonding layer **98** is formed from a bonding material (i.e., an adhesion promoter) such as platinum, tungsten, molybdenum, chromium, nickel, silicon, copper, or titanium, although it is also envisioned that other suitable materials could also be used. The bonding layer **98** promotes adhesion between lubricant layer **100** and bearing cage **88** through a finite mutual solubility with the lubricant layer material and the base material of bearing cage **88**. Ti and W metals, for example, provide both mechanical adhesion provided through a deposition process and chemical adhesion between bearing cage **88** and lubricant layer **100**. In one embodiment, the bonding layer **98** is deposited on bearing cage **88** with a thickness from 10-100 nanometers so as to coat the bearing cage **88**. It is also envisioned that bonding layer can have a greater thickness, such as 5-20 microns for example, or alternatively, that an intermediate layer of 5-20

microns be applied to the thin 10-100 nm base bonding layer. Where bearing cage **88** is formed of a carbon-carbon composite, a thickness in the range of 5-20 microns for either bonding layer **98** or an intermediate layer can serve to, at least in part, fill-in irregularities that may be present on the carbon-carbon composite surface and present a smooth surface to which lubricant layer **100** can be applied. A smoother lubricant layer **100** will thus be formed, which may decrease wear in the bearing cage, extend bearing assembly life, and decrease subsequent machining costs. While specified thickness ranges for bonding layer **98** (and possibly an intermediate layer) have been set forth above, a thickness that is greater or lesser than these ranges can also be applied to bearing cage **88**.

Lubricant layer **100** is deposited on top of bonding layer **98** in order to reduce friction between bearing cage **88** and the bearing balls **90** shown in FIG. 5. Lubricant layer **100** can be composed of any known dry film lubricant material suitable for use with bearings in an x-ray tube environment. Silver is typically used as a lubricant when operating temperatures in the x-ray tube environment exceed 400 degrees Celsius and serves to minimize formation of adhesive junctions between bearing cage **88**, bearing balls **76**, **78**, and races **72**, **74**, **80**, and **82**. (shown in FIG. 4) Being a relatively soft coating, silver is able to transfer from bearing cage **88** to either of the bearing balls and the races and maintain low friction therebetween. While silver has been described as a preferred lubricant layer **100**, it is also envisioned that other metallic lubricants can also be used such as gold, lead, or lead-tin. Furthermore, other solid lubricants may be added to form a "combination material" composed of, for example, silver and another lubricant, such as tungsten disulfides (WS₂), molybdenum disulfide (MoS₂), calcium fluoride (CaF₂), CaF₂BaF₂ eutectics, and the like. Other advanced, high temperature, self-lubricating coatings can also be used for the bearings, such as a nano-alloyed carbon coating.

While lubricant layer **100** is shown deposited on top of bonding layer **98** in FIG. 6, it is also envisioned that lubricant layer **100** could be directly applied to the carbon-carbon composite of bearing cage **88** without any bonding layer **98** therebetween.

It is also envisioned that, rather than bonding layer **98** and lubricant layer **100** being two distinct layers, a gradient type coating can be applied to bearing cage **88**. Referring now to FIG. 7, a gradient coating **102** is shown deposited on the carbon-carbon composite of bearing cage **88** that is comprised of a bonding layer **98**, a transition layer **104**, and a lubricant layer **100**. The gradient coating **102** contains a gradual change in materials, such as from nickel to silver, that forms chemical bonds between adjoining layers and minimizes a coefficient of thermal expansion mismatch between adjacent coating layers, thus enhancing overall adhesion. For example, bonding layer **98** can be formed from 100% nickel to adhere to bearing cage **88**. Transition layer **104** is positioned above bonding layer **98** and contains a percentage of bonding material therein (e.g., 50% nickel) and a percentage of a lubricant material used to form lubricant layer **100** (e.g., 50% silver). The transition layer **104** is shown as a single layer in FIG. 7, however, it is envisioned that transition layer **104** could be comprised of several layers, with each layer containing different percentages of bonding material and lubricant material so as to slowly transition from the bonding layer **98** to lubricant layer **100**.

The combination coating **96** of FIG. 6 and gradient coating **102** of FIG. 7 described above can be applied to bearing cage **88** in a variety of methods. That is, bonding layer **98**, lubricant layer **100**, and transition layer **104** can be applied via a num-

ber of suitable techniques. In one embodiment, chemical vapor deposition (CVD), including thermal CVD, metal-organic CVD, and plasma-enhanced CVD, is used to deposit a layer **98**, **100**, **104** onto the carbon-carbon composite material of bearing cage **88**. CVD uses a gas-phase precursor (e.g., silver halide or hydride) that is heated and flowed over the bearing cage **88** in a heated state to deposit bonding material and/or lubricant material to the bearing cage.

In another application method, a physical vapor deposition (PVD) technique is used to deposit a coating layer **98**, **100**, **104** onto the carbon-carbon composite material of bearing cage **88**. In PVD, the bonding and/or lubricant material to be deposited on bearing cage **88** is placed in an energetic, entropic environment, so that particles of material escape its surface. For example, in an ion-plating operation, bearing cage **88** is placed in an inert gas (e.g., argon), together with the bonding/lubricant material. A heating temperature and a low-voltage arc is applied to evaporate the metallic component of the coating material (e.g., silver), and then the ionized particles are accelerated to a high energy to coat bearing cage **88** via a bombardment of these accelerated particles.

In another technique, electroplating may be used to put on a layer, layers, or gradients of layers onto the carbon-carbon material of bearing cage **88**. Bearing cage **88** and the bonding/lubricant material are immersed in a solution containing one or more metal salts as well as other ions that permit the flow of electricity. A rectifier supplies a direct current to the bearing cage, causing the metal ions in solution to lose their charge and plate out the bearing cage **88**. As the electrical current flows, the bonding/lubricant material slowly dissolves and replenishes the ions in the solution.

In yet another PVD application technique, a sputtering technique is employed to deposit a layer **98**, **100**, **104** onto the carbon-carbon composite material of bearing cage **88**. In a sputtering coating technique, a thin film of bonding/lubricant material is deposited on bearing cage **88** by the ejection of atoms in a gas phase from a block of bonding/lubricant material called a target. The bonding/lubricant material atoms are ejected into the gas phase due to bombardment of the target material by energetic ions (e.g., argon plasma) and deposit on bearing cage **88** when positioned in a vacuum chamber.

It is also envisioned that various organic or inorganic based metallic pastes could be used to put on a layer, layers, or gradients of layers onto the carbon-carbon material of bearing cage **88**. For example, a platinum paste with ethyl cellulose and alpha terpineol could be applied to bearing cage **88**. The paste could also contain oxides such as nickel oxide or titanium oxide, which could be subsequently be reduced to the base metal to form bonding layer **98** and/or lubricant layer **100**. A thermal spray or "cold spray" process may also be utilized to place a layer on the carbon-carbon bearing cage **88**. This material may be a metal or an oxide based material, such as NiO or TiO, that would be subsequently reduced.

In addition to the techniques set forth above, other various suitable coating techniques can also be implemented for applying a bonding layer **98** and lubricant layer **100** to the carbon-carbon composite bearing cage **88**.

Alternatively, or in addition to, the combination coatings **96**, **102** applied to bearing cage **88** as shown in FIGS. **6** and **7**, it is also envisioned that a lubricant can also be applied to races **72**, **74**, **80**, **82** and bearing balls **76**, **78** shown in the bearing assembly **58** of FIG. **4**, in order to reduce friction therebetween. Races **72**, **74**, **80**, **82** and bearing balls **76**, **78** may be comprised of tool steels typically used for bearing materials, such as Rex® 20, T5, T15 tool steels, and the like. Rex is a registered trademark of Crucible Materials Corporation, Solvay, N.Y. Bearing balls **76**, **78** may also be formed

from a ceramic material. Referring now to FIG. **8**, a partial cross-sectional view of a base material **120** is shown from which the race and bearing balls are comprised. An adhesion layer **122** is deposited on base material **120**, and a lubricant layer **124** is deposited on the adhesion layer **122**. Lubricant layer **124** can be composed of silver, for example, or can further include a lubrication material other than silver such as WS₂, MoS₂, CaF₂, CaF₂BaF₂ eutectics, nano-alloyed carbon, and the like. In this manner, the lubricant layer **124**, together with the adhesion layer **122**, enhances the lubrication performance and life of the base material **120** that forms the race and/or bearing balls.

As shown in FIG. **9**, a hardening layer **126** can also be included between adhesion layer **122** and lubricant layer **124**. The hardening layer **126** is formed of a material having a hardness greater than a base material **120** of the bearing race and the bearing balls. The hard material **126** can be formed of a hard particulate comprising one of TiC, TiN, TiAlN, diamond, silicon nitride, and silicon carbide. Alternatively, the hard material **126** can be formed of a hard coating comprising one of a monolithic nitride, a nano-multilayered nitride, a nickel-diamond coating, a ceramic, and a carbon and oxide coating with lubricating phase. For example, a nanocomposite TiC—C coating consists of nanocrystalline TiC grains embedded in an amorphous carbon matrix (nc-TiC/a-C), and offers low friction, high toughness, and thus excellent tribological properties. An improved wear resistance to the base material **120** is achieved by applying a hard material **126** layer on the base material **120** and applying lubricant **124** thereto.

FIG. **10** is a pictorial view of a CT system for use with a non-invasive package inspection system that can incorporate the x-ray tube **14** and bearing assembly **58** shown in FIG. **3**. Package/baggage inspection system **130** includes a rotatable gantry **132** having an opening **134** therein through which packages or pieces of baggage may pass. The rotatable gantry **132** houses a high frequency electromagnetic energy source **136** as well as a detector assembly **138** having scintillator arrays comprised of scintillator cells. A conveyor system **140** is also provided and includes a conveyor belt **142** supported by structure **144** to automatically and continuously pass packages or baggage pieces **146** through opening **134** to be scanned. Objects **146** are fed through opening **134** by conveyor belt **142**, imaging data is then acquired, and the conveyor belt **142** removes the packages **146** from opening **134** in a controlled and continuous manner. As a result, postal inspectors, baggage handlers, and other security personnel may non-invasively inspect the contents of packages **146** for explosives, knives, guns, contraband, etc.

According to one embodiment of the present invention, a method of manufacturing an x-ray tube bearing cage includes the steps of forming a bearing cage from a carbon-carbon composite material and applying a coating to the carbon-carbon composite material, wherein the coating includes an outer layer formed of a dry film lubricant.

According to another embodiment of the present invention, a method of manufacturing an x-ray tube bearing assembly includes the steps of assembling a bearing race having an inner race and an outer race, forming at least one carbon-carbon composite bearing cage, and coating the at least one carbon-carbon composite bearing cage with a dry film lubricant. The method further includes the steps of placing the at least one coated carbon-carbon composite bearing cage between the inner race and the outer race and positioning a plurality of bearing balls within the at least one carbon-carbon composite bearing cage.

According to yet another embodiment of the present invention, a method for manufacturing an x-ray tube includes the

steps of forming a casing having a vacuum therein, positioning an anode and a cathode within the casing, mounting the anode on a rotatable shaft, and supporting the rotatable shaft with a bearing assembly. The bearing assembly is constructed by assembling a bearing race having an inner race and an outer race, positioning a carbon-carbon composite retainer within the bearing race, applying a dry film lubricant to the carbon-carbon composite retainer, and positioning a plurality of bearing balls within the retainer.

The present invention has been described in terms of the preferred embodiment, and it is recognized that equivalents, alternatives, and modifications, aside from those expressly stated, are possible and within the scope of the appending claims.

The invention claimed is:

1. A method of manufacturing an x-ray tube bearing cage comprising the steps of:

forming a bearing cage from a carbon-carbon composite material;

depositing an adhesion layer onto the carbon-carbon composite material; and

applying a coating to the adhesion layer, the coating comprising a dry film lubricant;

wherein the adhesion layer is configured to provide a mechanical adhesion and a chemical adhesion between the carbon-carbon composite material and the dry film lubricant.

2. The method of claim 1 wherein the dry film lubricant further comprises silver.

3. The method of claim 1 wherein the dry film lubricant further comprises one of WS₂, MoS₂, CaF₂, CaF₂BaF₂ eutectics, and amorphous carbon.

4. The method of claim 1 wherein the step of applying a coating comprises depositing a dry film lubricant by chemical vapor deposition.

5. The method of claim 1 wherein the step of applying a coating comprises depositing a dry film lubricant by physical vapor deposition.

6. The method of claim 5 wherein the step of depositing comprises depositing a dry film lubricant by one of ion-plating and sputtering.

7. The method of claim 1 wherein the step of applying a coating comprises depositing a dry film lubricant by electroplating.

8. The method of claim 1 wherein the step of applying a coating further comprises depositing a dry film lubricant by applying a metallic-based paste.

9. The method of claim 1 wherein the step of applying a coating further comprises depositing a dry film lubricant by one of a thermal spray process and a cold spray process.

10. The method of claim 1 wherein the step of depositing comprises depositing the adhesion layer by one of: chemical vapor deposition, physical vapor deposition, ion-plating, sputtering, electroplating, thermal spraying, and cold spraying.

11. The method of claim 1 wherein the coating is a gradient coating having a plurality of layers therein, each of the plurality of layers having a specified composition of a dry film lubricant and an adhesion material and wherein the specified composition of each of the plurality of layers is different from a composition of an adjacent layer.

12. A method of manufacturing an x-ray tube bearing assembly, the method comprising the steps of:

assembling a bearing race having an inner race and an outer race;

forming at least one carbon-carbon composite bearing cage;

coating the at least one carbon-carbon composite bearing cage with an adhesive interlayer;

coating the at least one carbon-carbon composite bearing cage with a dry film lubricant, the dry film lubricant being coated on the adhesive interlayer;

placing the at least one coated carbon-carbon composite bearing cage between the inner race and the outer race; and

positioning a plurality of bearing balls within the at least one carbon-carbon composite bearing cage

wherein the adhesive interlayer has a finite mutual solubility with the carbon-carbon composite bearing cage and the dry film lubricant.

13. The method of claim 12 wherein the dry film lubricant further comprises one of silver, WS₂, MoS₂, CaF₂, and CaF₂BaF₂ eutectics.

14. The method of claim 12 wherein the step of coating comprises coating the at least one carbon-carbon composite bearing cage with a dry film lubricant by one of: chemical vapor deposition, physical vapor deposition, ion-plating, sputtering, electroplating, applying a metallic-based paste, thermal spraying, and cold spraying.

15. The method of claim 12 wherein the step of coating comprises coating the carbon-carbon composite bearing cage with an adhesive interlayer by one of: chemical vapor deposition, physical vapor deposition, ion-plating, sputtering, electroplating, thermal spraying, and cold spraying.

16. The method of claim 12 wherein the steps of coating the carbon-carbon composite bearing cage with a dry film lubricant and with an adhesive interlayer comprises coating the carbon-carbon composite bearing cage with the dry film lubricant and the adhesive interlayer as gradient layers composed of varying amounts of lubricant material and adhesive material.

17. A method for manufacturing an x-ray tube comprising the steps of:

forming a casing having a vacuum therein;

positioning an anode and a cathode within the casing;

mounting the anode on a rotatable shaft; and

supporting the rotatable shaft with a bearing assembly, the bearing assembly constructed by:

assembling a bearing race having an inner race and an outer race;

positioning a carbon-carbon composite retainer within the bearing race;

applying a bonding layer and a dry film lubricant to the carbon-carbon composite retainer, the bonding layer forming a mechanical adhesion and a chemical adhesion between the carbon-carbon composite retainer and the dry film lubricant; and

positioning a plurality of bearing balls within the retainer.

18. The method of claim 17 wherein the step of applying comprises applying the dry film lubricant to the at least one carbon-carbon composite bearing cage by one of: chemical vapor deposition, physical vapor deposition, ion-plating, sputtering, electroplating, applying a metallic-based paste, thermal spraying, and cold spraying.

19. The method of claim 17 further comprising the step of coating the carbon-carbon composite retainer with an adhesive coating before applying the dry film lubricant.

20. The method of claim 19 wherein the step of coating comprises coating carbon-carbon composite retainer with an adhesive coating by one of: chemical vapor deposition, physical

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cal vapor deposition, ion-plating, sputtering, electroplating, thermal spraying, and cold spraying.

21. The method of claim **17** wherein applying the bonding layer comprises applying a bonding layer having a thickness between 5 and 20 microns to fill in irregularities on a surface of the carbon-carbon composite retainer and form a smooth surface for application of the dry film lubricant.

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22. The method of claim **1** wherein depositing the adhesion layer comprises depositing an adhesion layer having a thickness between 5 and 20 microns to fill in irregularities on a surface of the carbon-carbon composite bearing cage.

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