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(54) **TENSION-BASED NON-PNEUMATIC TIRE**

Mar. 26, 2008, now Pat. No. 8,109,308, which is a continuation-in-part of application No. 11/691,968, filed on Mar. 27, 2007, now Pat. No. 8,104,524.

(71) Applicant: **Bridgestone Americas Tire Operations, LLC, Nashville, TN (US)**

(72) Inventors: **Ali Manesh, Chicago, IL (US); Mike Tercha, Weston, WI (US); Brian Anderson, Wausau, WI (US); Karen Schlei, Wausau, WI (US); Brian Meliska, Weston, WI (US); Louis Stark, Kronenwetter, WI (US); Benjamin Knospe, Merrill, WI (US); Fidelis Ceranski, Marathon, WI (US); Glenn Howland, Kronenwetter, WI (US)**

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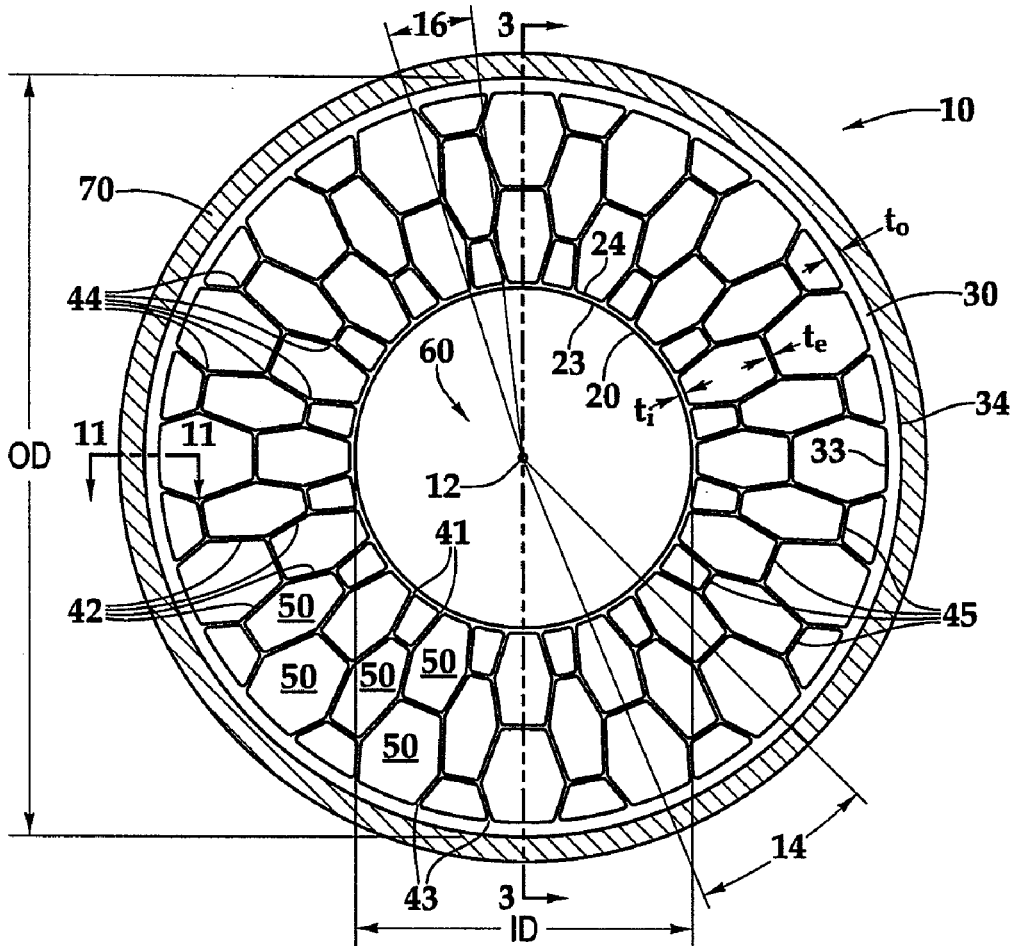
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(57) **ABSTRACT**

Related U.S. Application Data

(60) Division of application No. 16/119,664, filed on Aug. 31, 2018, now Pat. No. 11,014,407, which is a continuation-in-part of application No. 13/333,721, filed on Dec. 21, 2011, now Pat. No. 10,086,654, which is a continuation of application No. 12/055,675, filed on

A non-pneumatic tire and hub assembly includes an inner ring having an axis of rotation, a deformable outer ring, and a flexible web extending between the inner ring and the deformable outer ring. The assembly further includes a hollow, metal cylinder coupled to the inner ring. The hollow, metal cylinder has a flanged portion extending towards an interior portion of the hollow, metal cylinder.



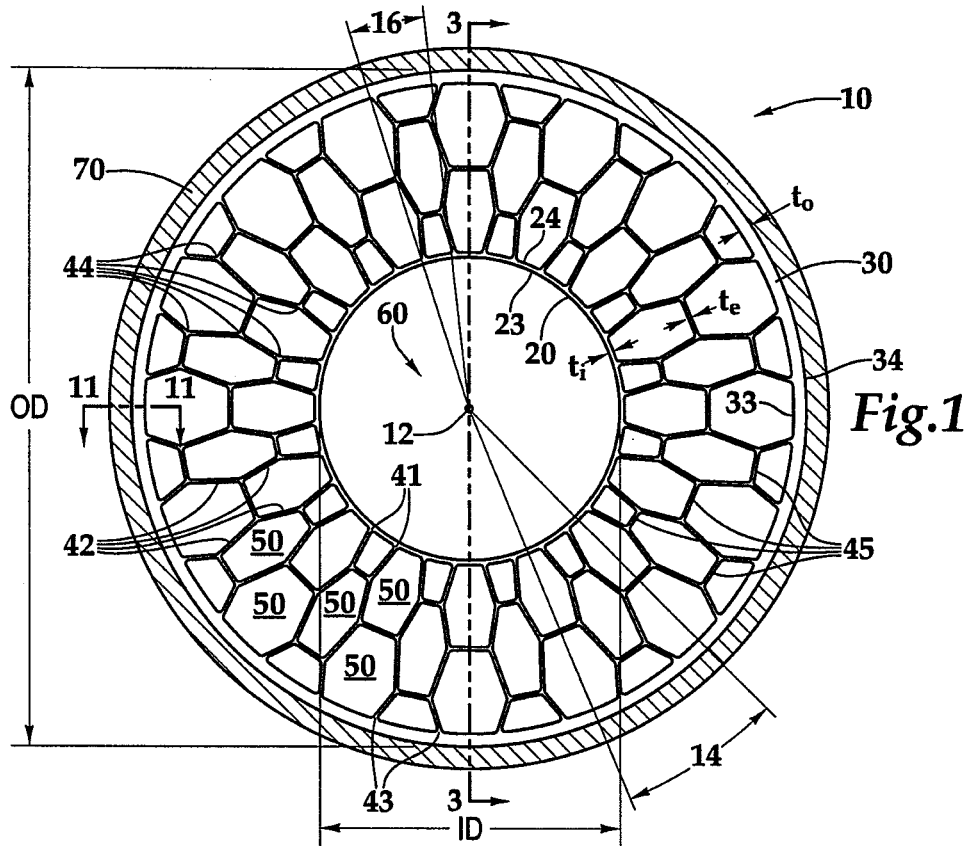


Fig.1

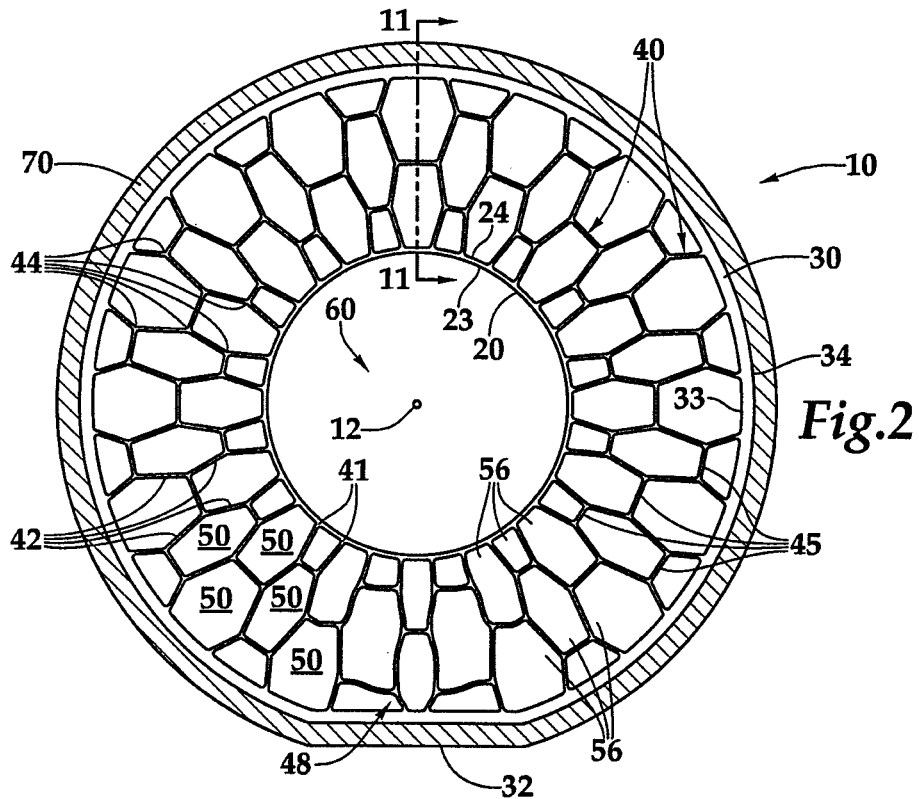


Fig.2

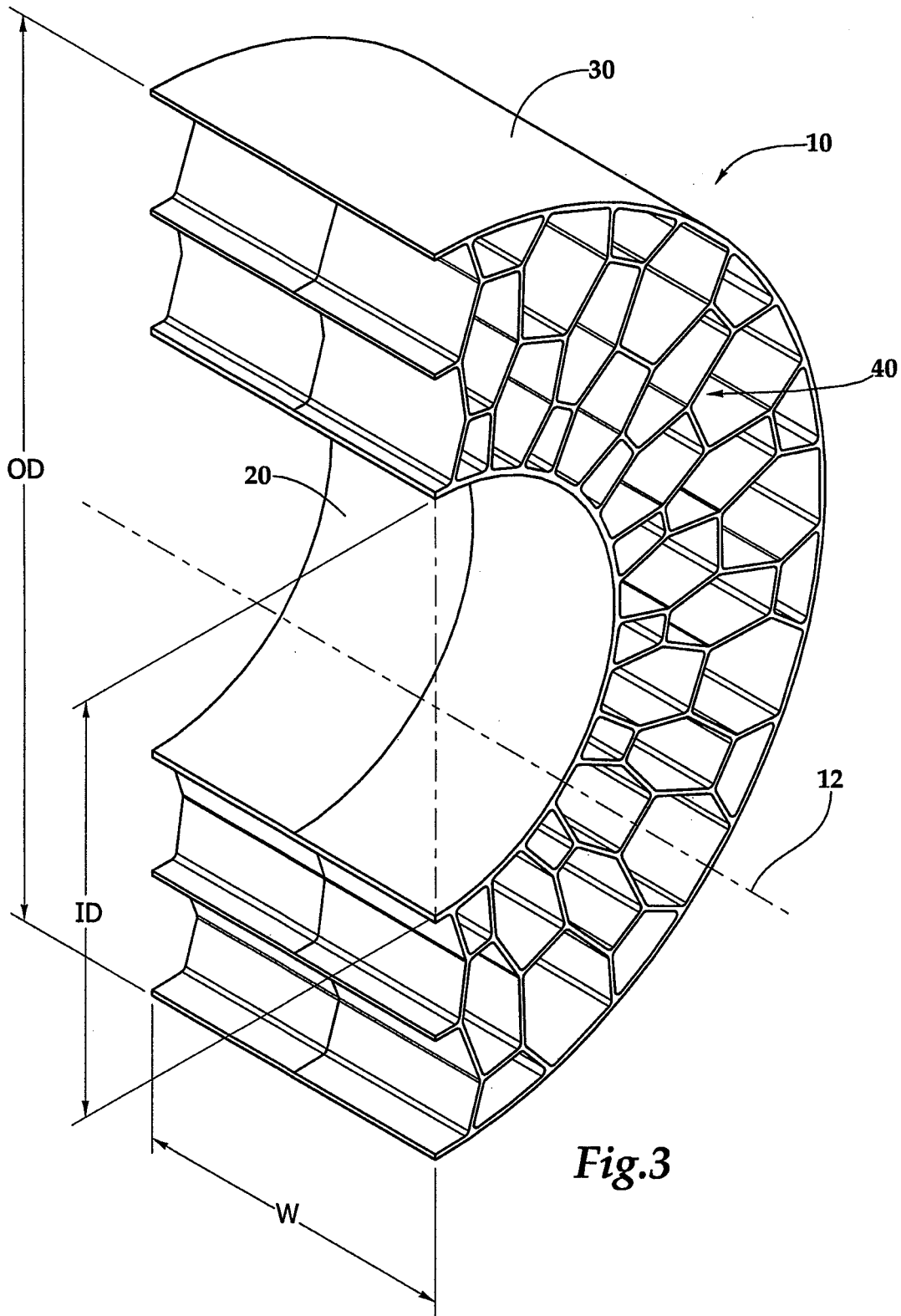
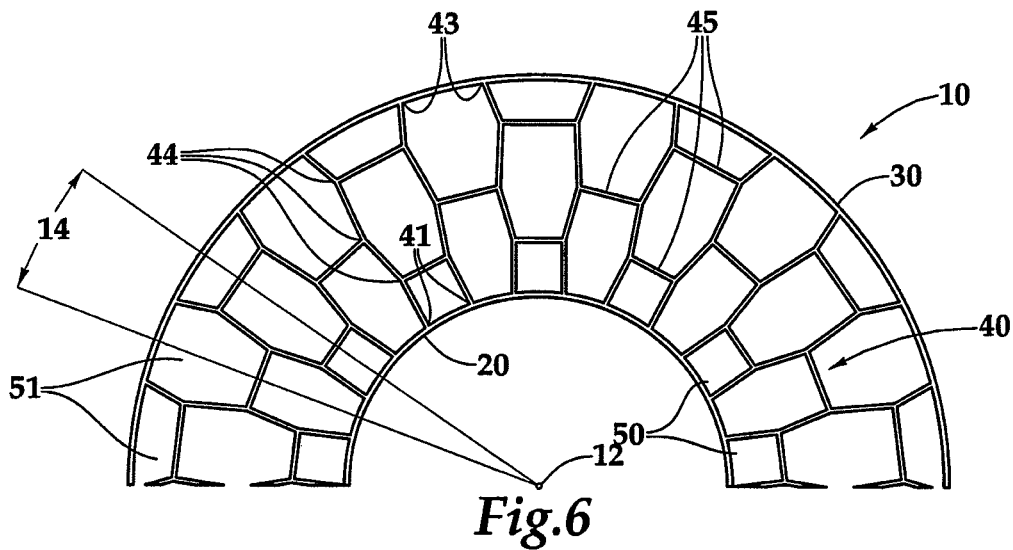
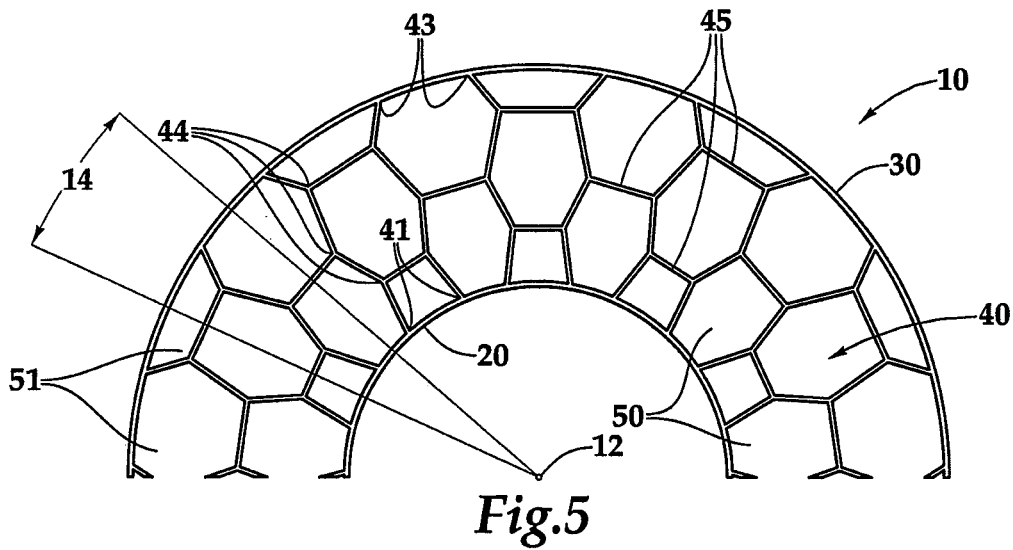
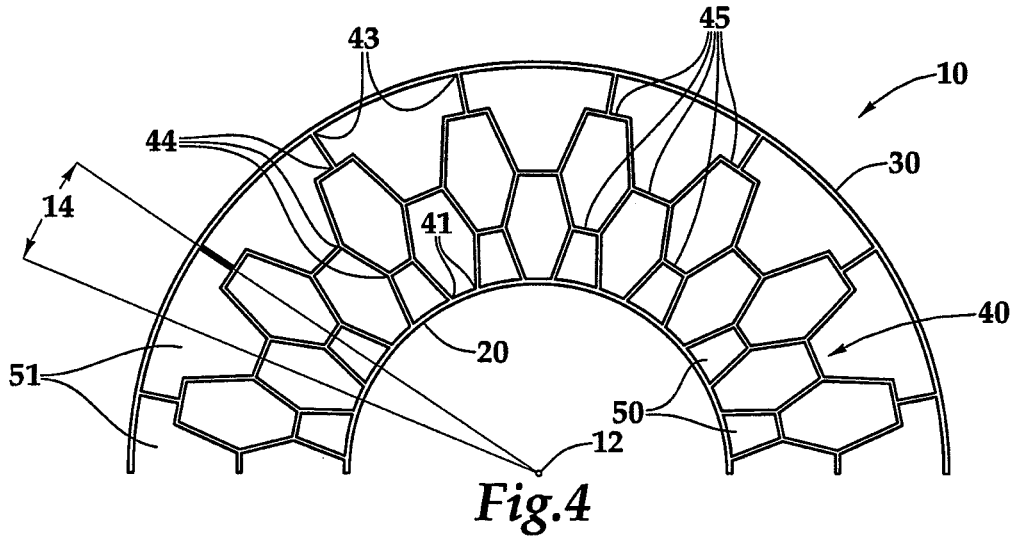
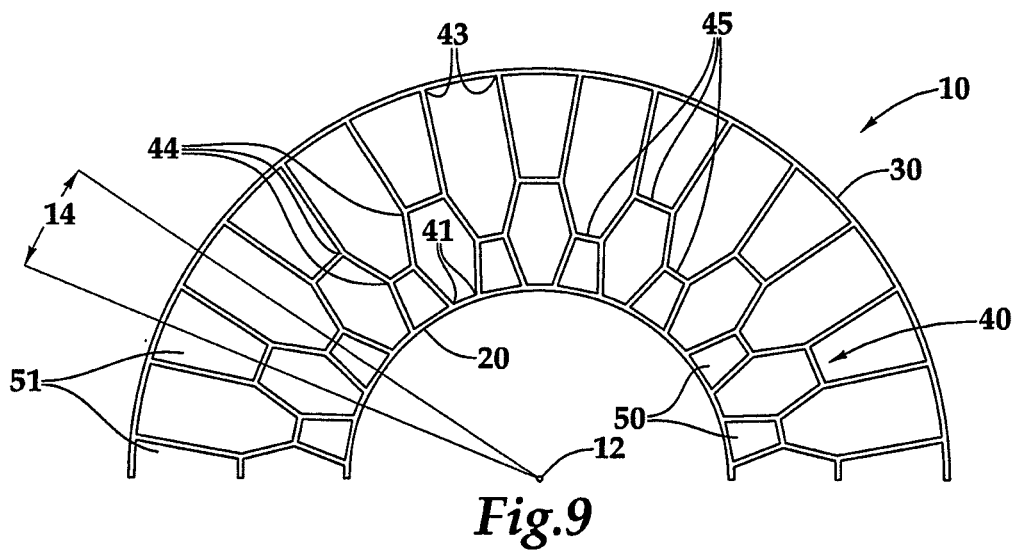
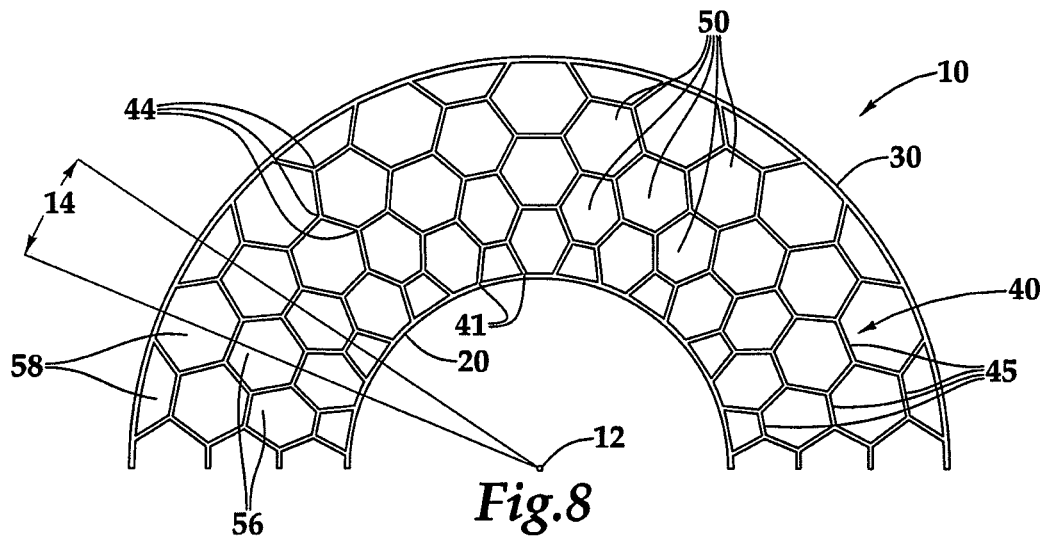
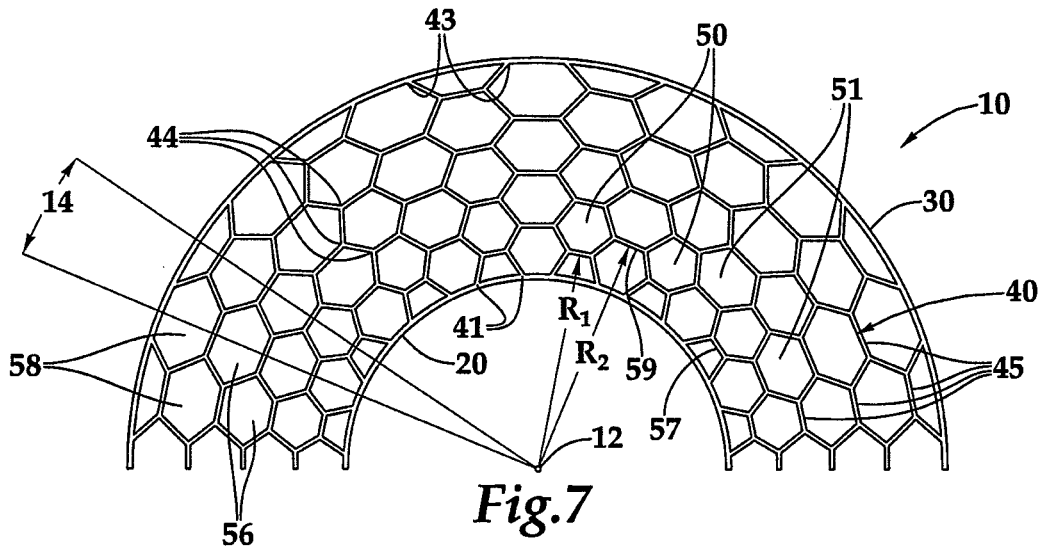


Fig.3





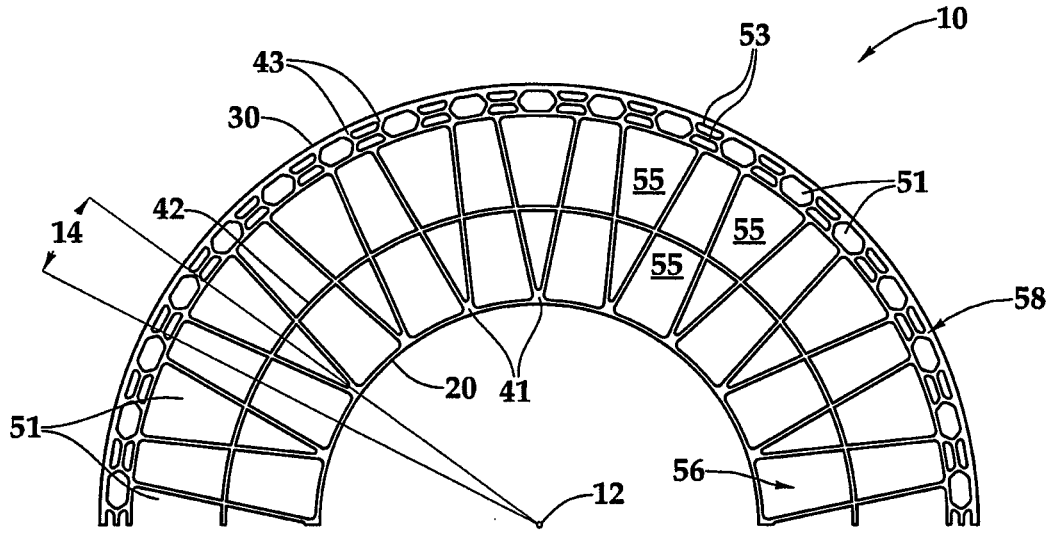


Fig.10

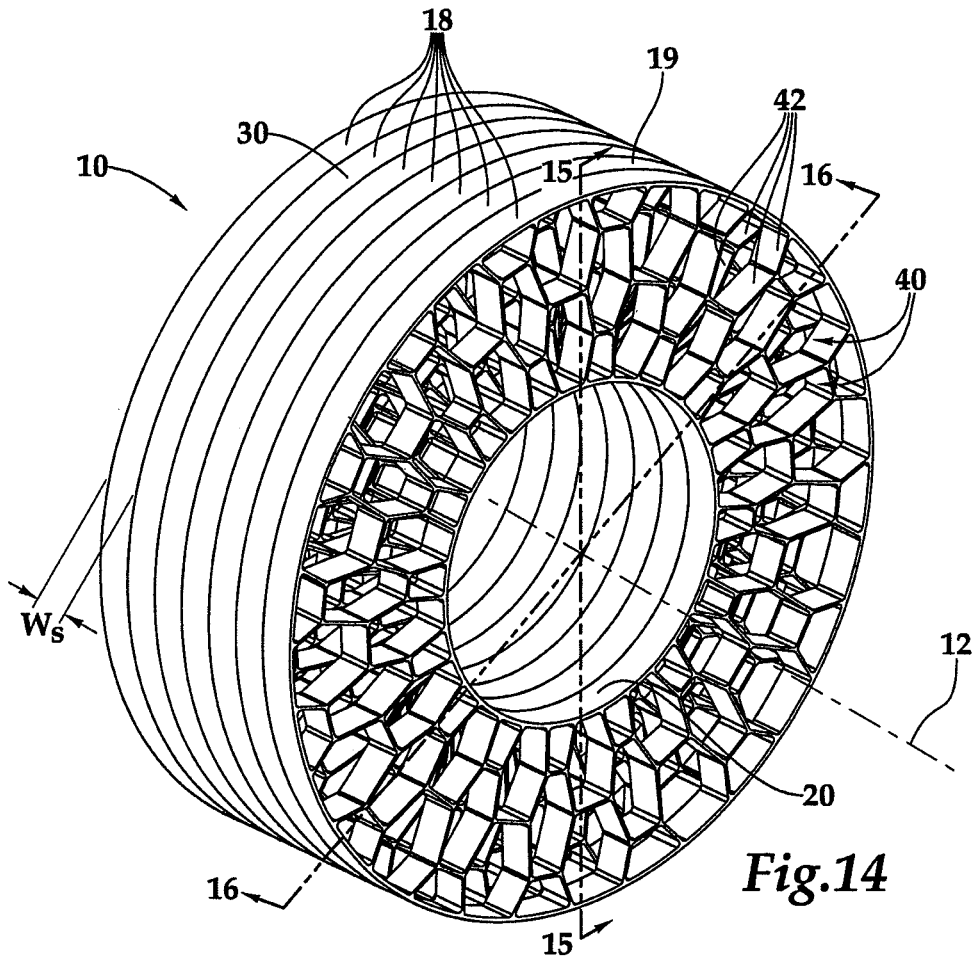


Fig.14

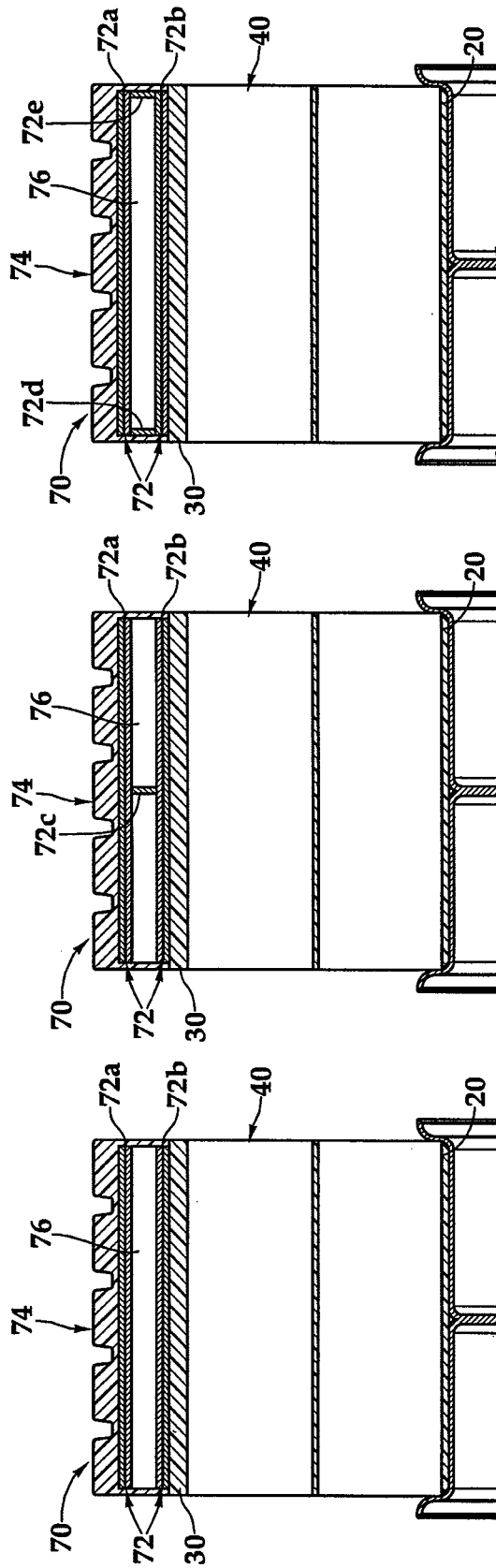


Fig.13

Fig.12

Fig.11

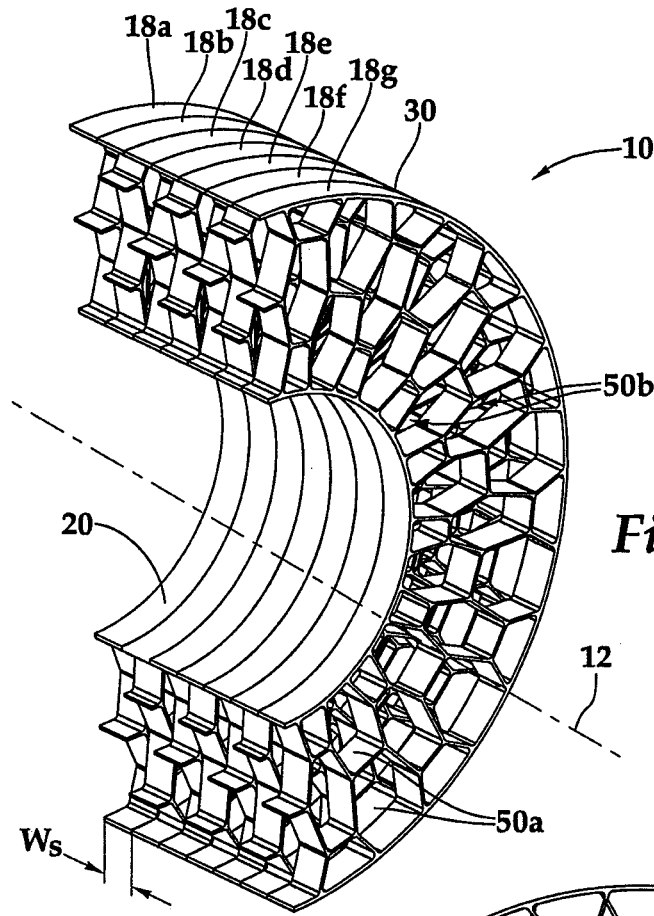


Fig.15

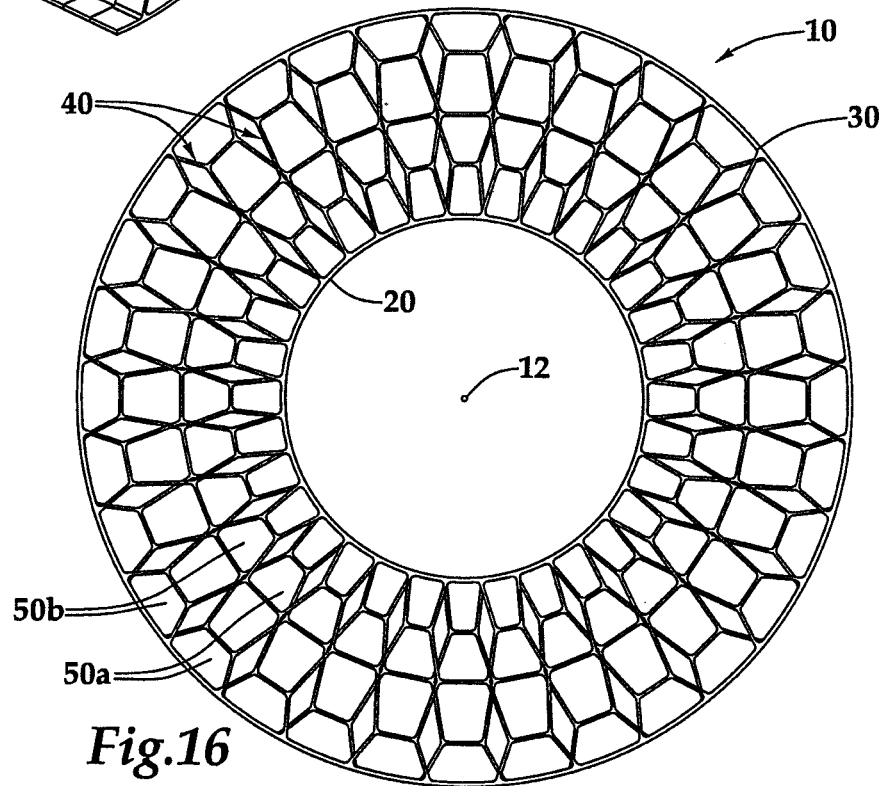
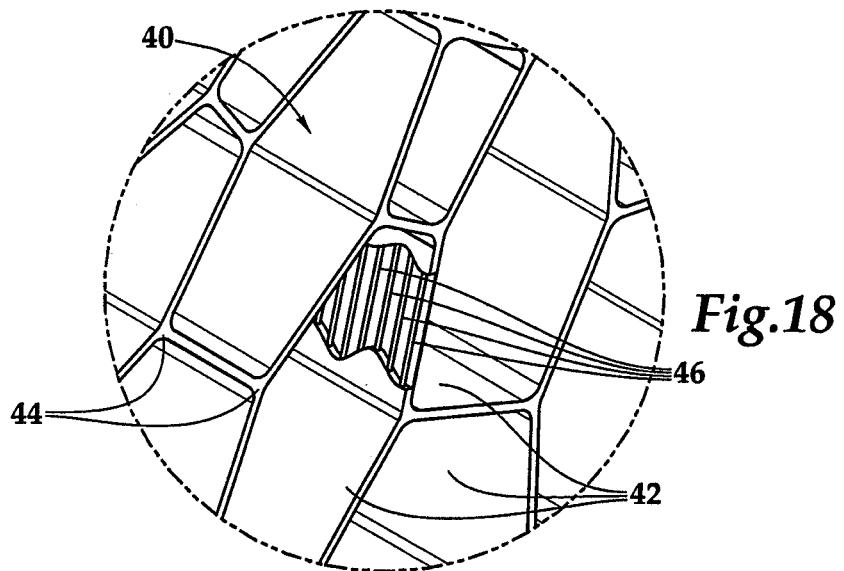
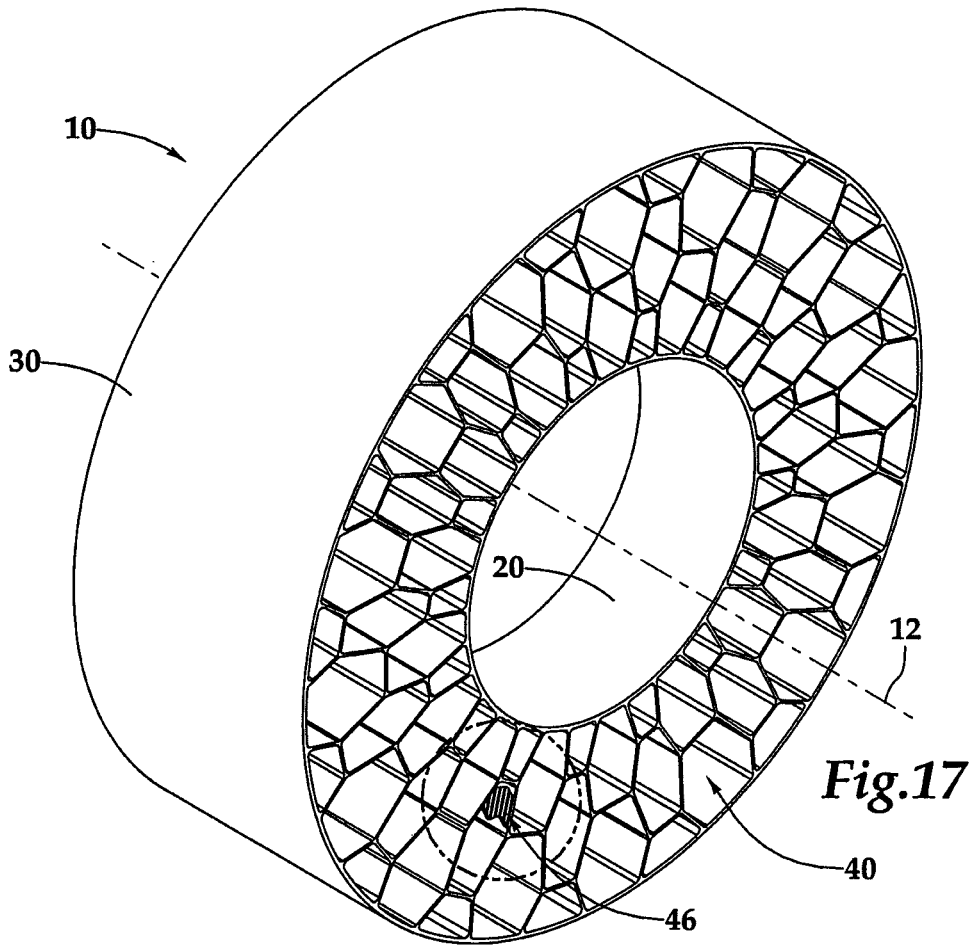


Fig.16



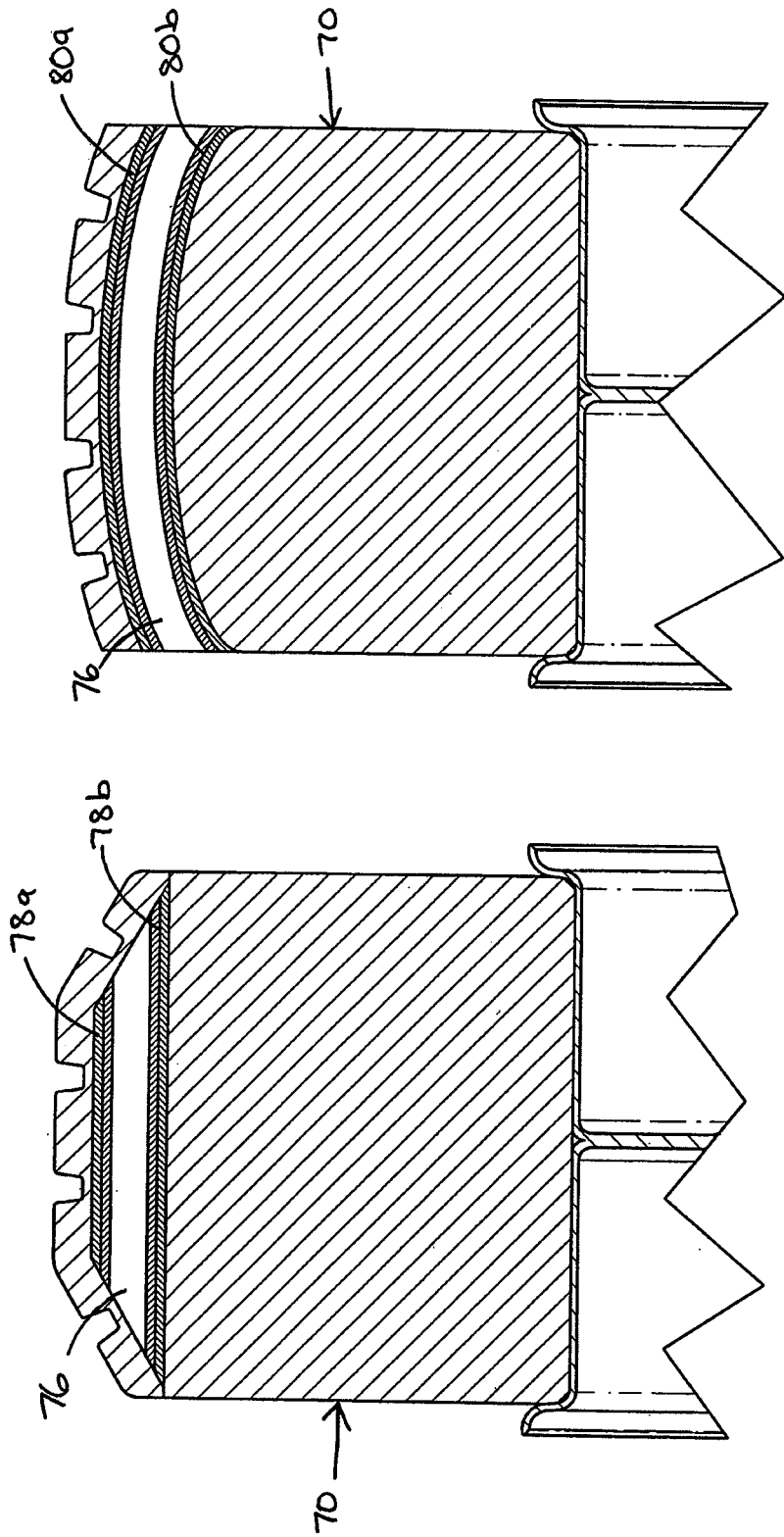


FIG. 20

FIG. 19

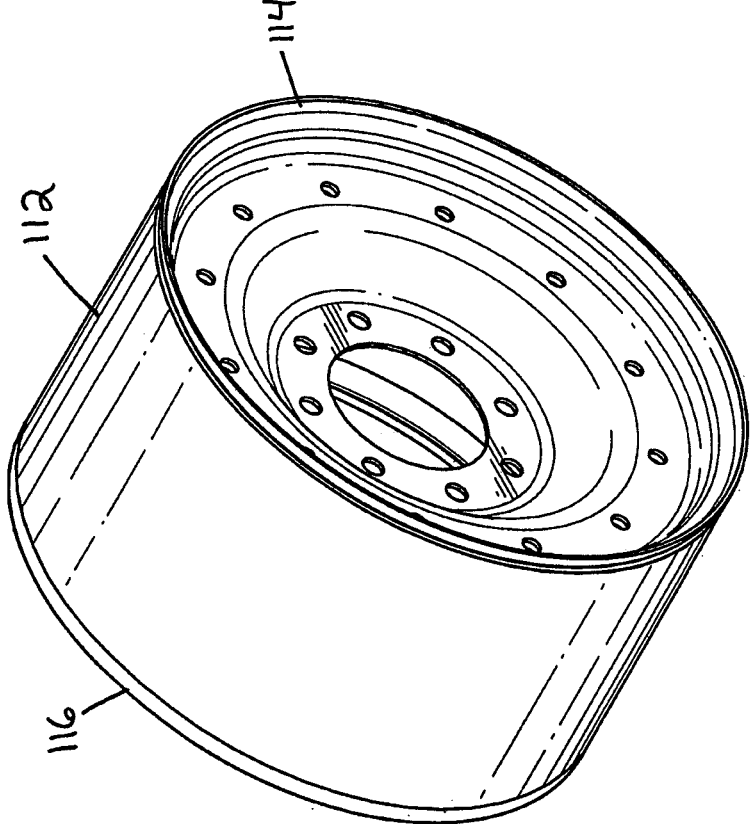


FIG. 21

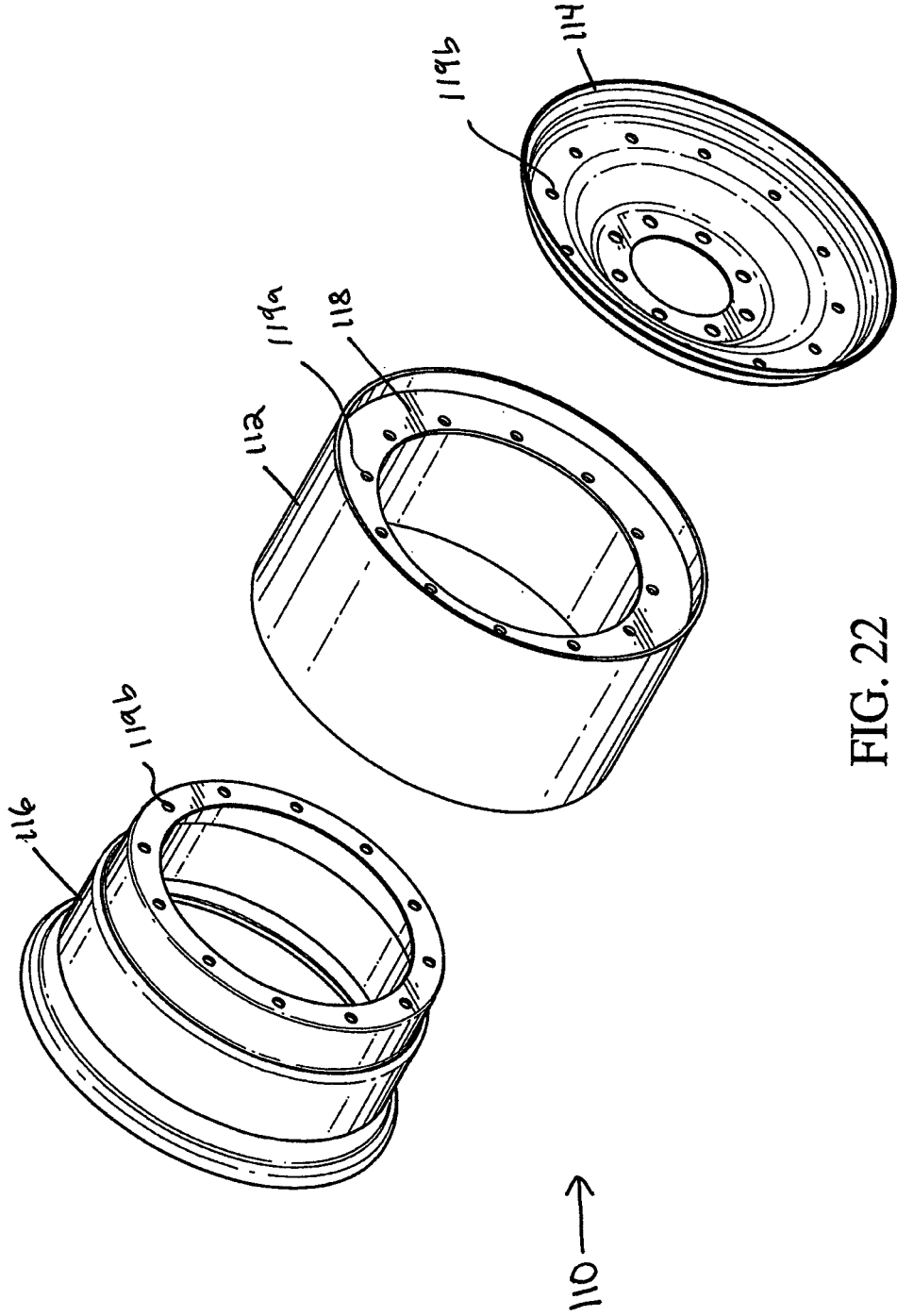


FIG. 22

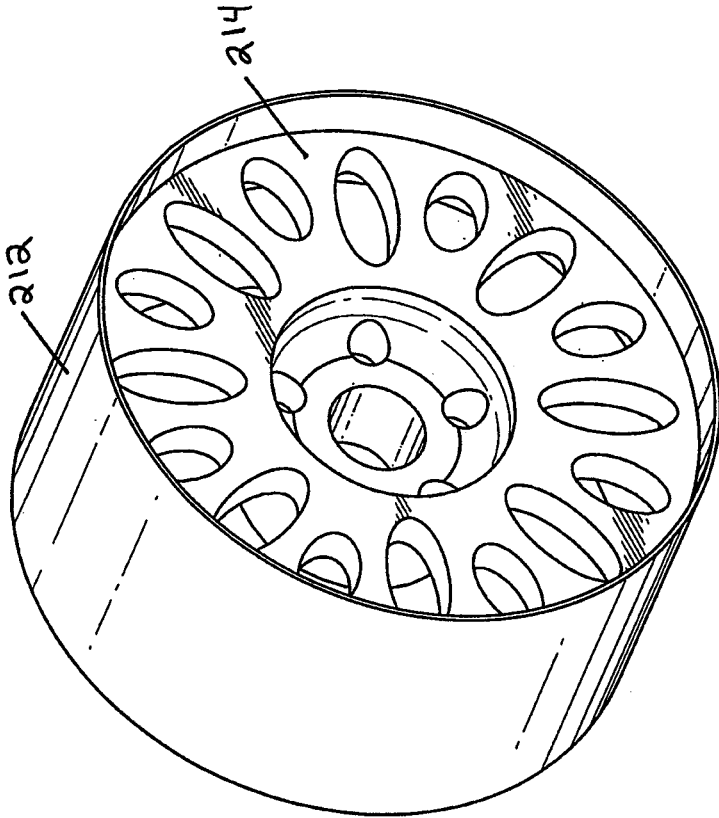


FIG. 23

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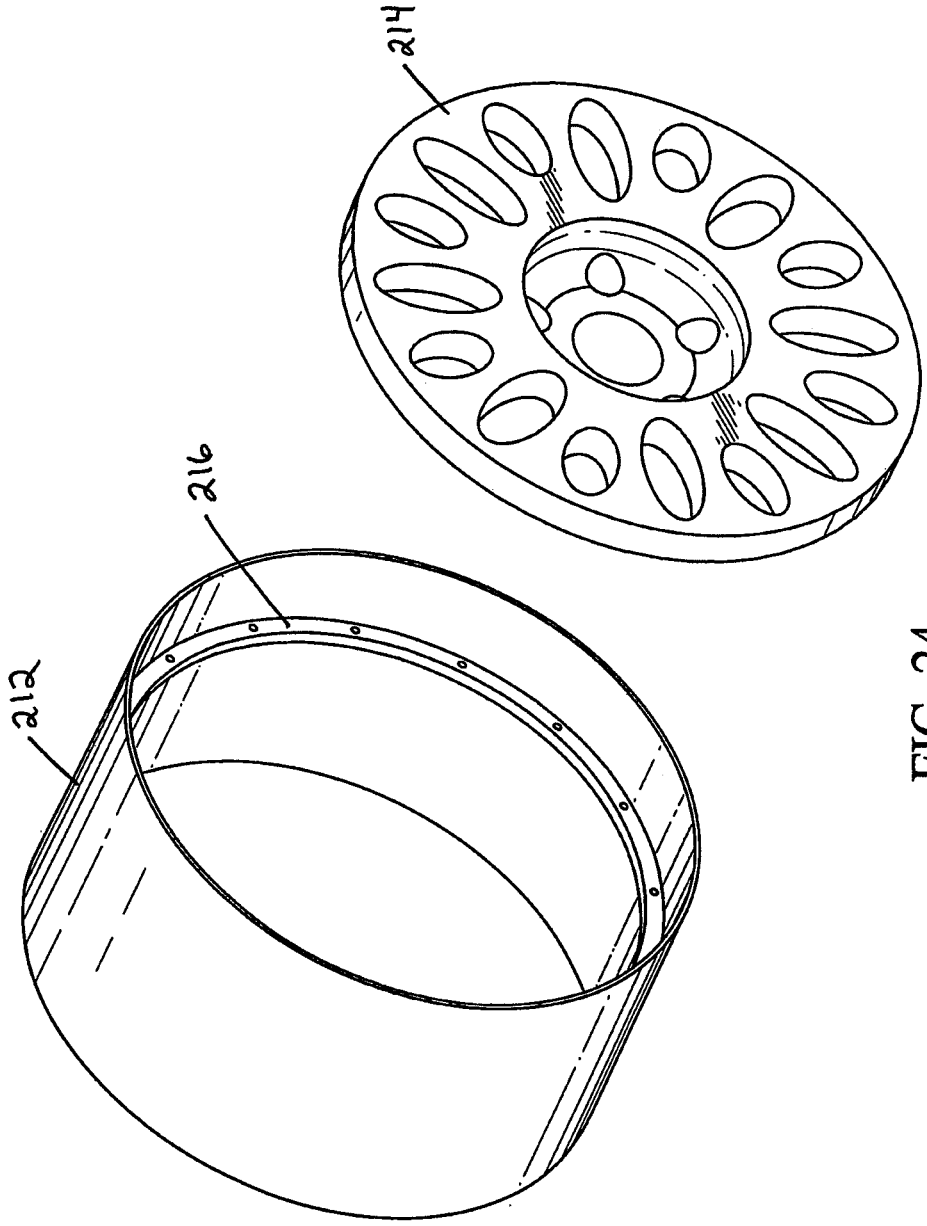


FIG. 24

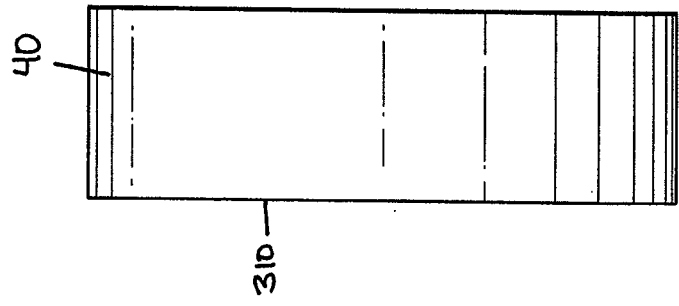


FIG. 26

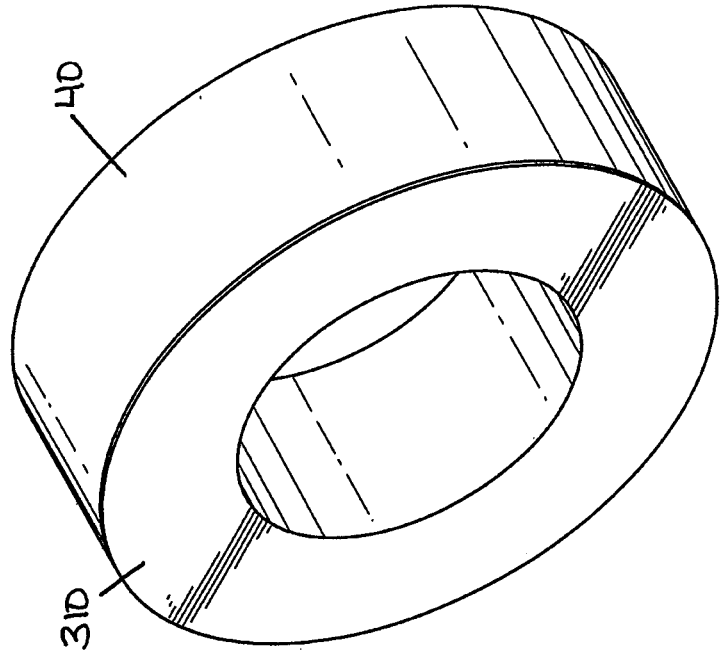


FIG. 25

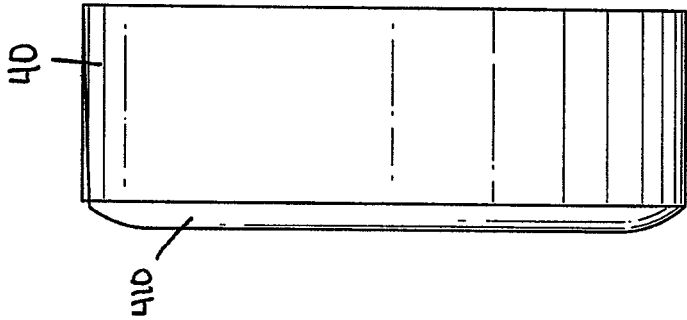


FIG. 28

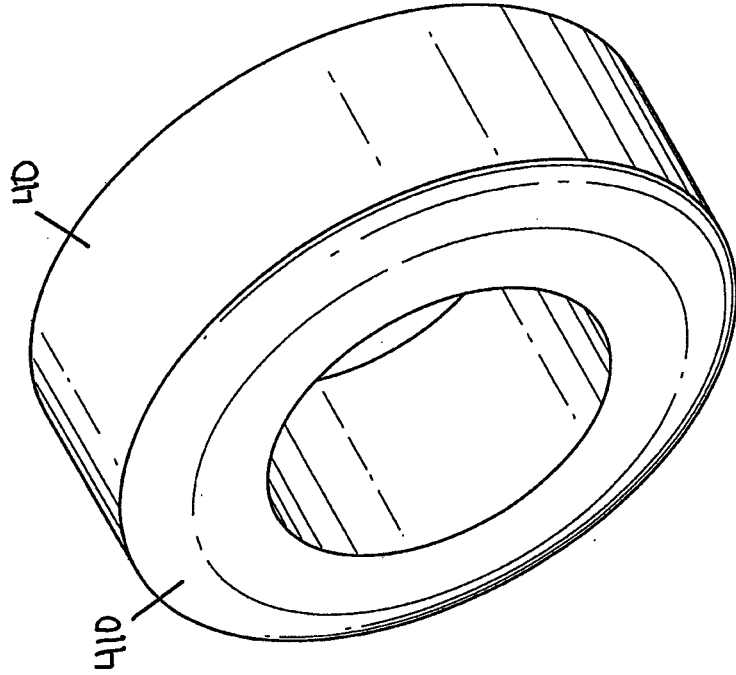


FIG. 27

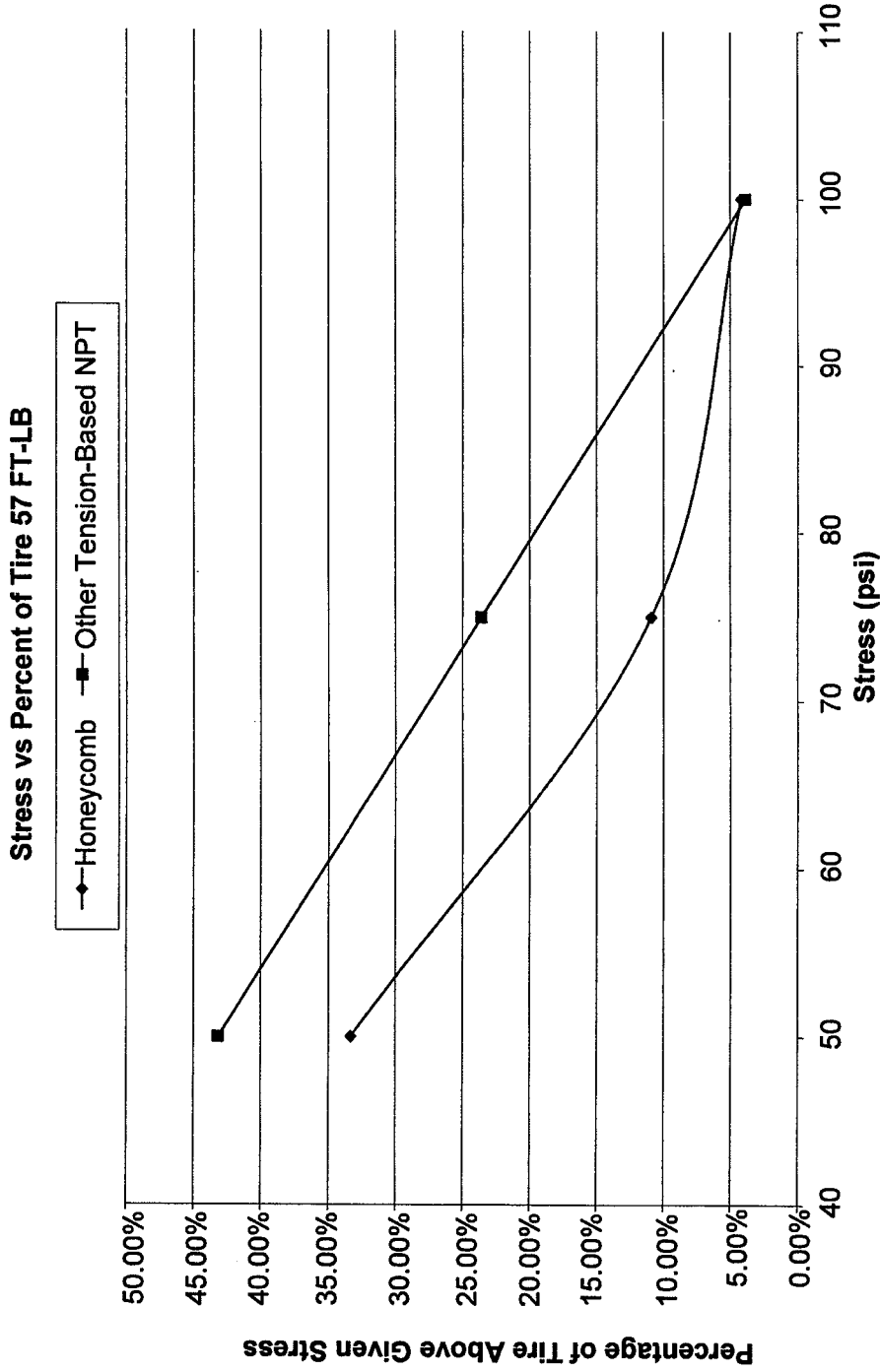


Fig. 29

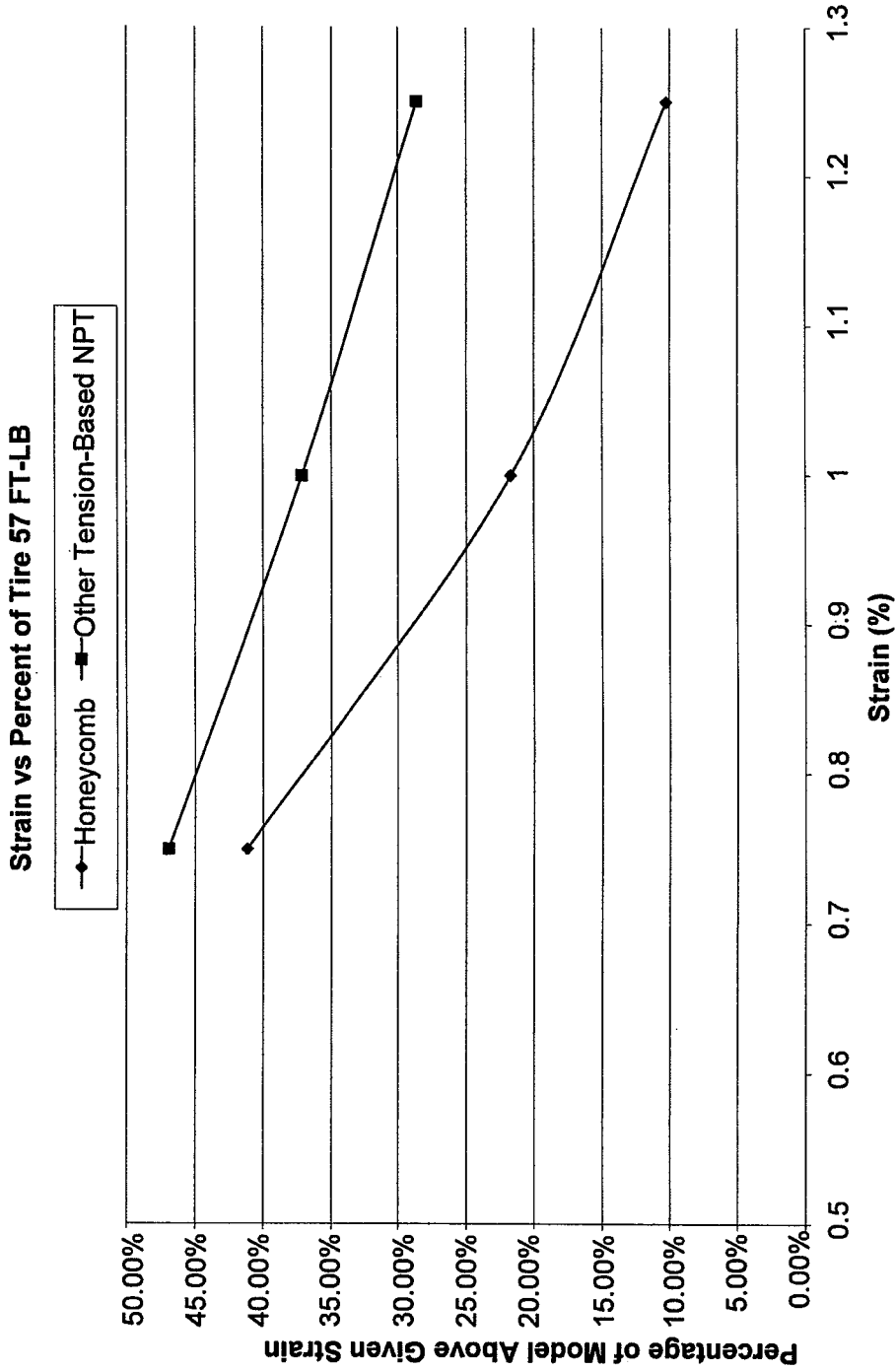


Fig. 30

TENSION-BASED NON-PNEUMATIC TIRE

CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] The present application is a divisional of U.S. patent application Ser. No. 16/119,664, filed Aug. 31, 2018 and presently pending, which is a continuation-in-part of U.S. patent application Ser. No. 13/333,721, filed Dec. 21, 2011 and now U.S. Pat. No. 10,086,654, which is a continuation of U.S. patent application Ser. No. 12/055,675, filed Mar. 26, 2008 and now U.S. Pat. No. 8,109,308, which is a continuation-in-part of U.S. patent application Ser. No. 11/691,968, filed Mar. 27, 2007 and now U.S. Pat. No. 8,104,524. The entire contents of these disclosures are hereby expressly incorporated by reference in their entirety.

[0002] This invention was made, in part, with United States government support awarded by the United States Army Research Laboratory under contract numbers W911NF-06-2-0021 and W911QX-08-C-0034. Accordingly, the United States may have certain rights in this invention.

BACKGROUND OF THE INVENTION

Field of the Invention

[0003] The present application is directed to a tire, and more particularly, to a non-pneumatic tire.

Description of the Related Art

[0004] Non-pneumatic, or airless, tires (NPT) have historically been comprised largely of an entirely solid substance. These solid tires made the ride rather uncomfortable for passengers and caused greater damage to the suspension of a vehicle, which had to compensate for the lack of "give" in a solid tire. Eventually, it was found that putting pressurized air in tires created a more comfortable ride. However, along with their advantages, pneumatic tires still possess some drawbacks.

[0005] The material that encloses standard pneumatic tires is susceptible to leaking the pressurized air it tries to withhold. This occurs both via leakage around the wheel rim, and on a smaller scale, when the rubber of the tire absorbs the oxygen. As a result, loss of pressure causes the tire to flatten in the area where the load is applied, subjecting a larger portion of the tire to the load with every revolution, and leading to quicker degradation of the tire. Furthermore, a tire reliant upon pressurized air is susceptible to being punctured leading to rapid release of the pressurized air.

[0006] Focusing on fuel efficiency, safety and ride comfort, several attempts have been made to address the problems associated with pneumatic tires while retaining their advantages over solid non-pneumatic tires. By way of example, U.S. Published Application 2006/0113016 by Cron, et al., and assigned to Michelin, discloses a non-pneumatic tire that it commercially refers to as the Tweel™. In the Tweel™, the tire combines with the wheel. It is made up of four parts that are eventually bonded together: the wheel, a spoke section, a reinforced annular band that surrounds the spoke section, and a rubber tread portion that contacts the ground.

[0007] Other alternatives to standard pneumatic tires have been attempted, including making solid tires out of polyurethane instead of rubber and suspending reinforcement

materials within the polyurethane during molding. Another alternative is to use internal ribs made of a thermoplastic that are subsequently reinforced with glass fibers. A third alternative is to use an electroactive polymer that is capable of changing shape when an electrical current is applied. This allows the tire to change shape or size based upon road conditions by using the automobile's electrical system.

SUMMARY OF THE INVENTION

[0008] In one embodiment, a non-pneumatic tire and hub assembly includes an inner ring having an axis of rotation, a deformable outer ring, and a flexible web extending between the inner ring and the deformable outer ring. The assembly further includes a hollow, metal cylinder coupled to the inner ring. The hollow, metal cylinder has a flanged portion extending towards an interior portion of the hollow, metal cylinder.

[0009] In another embodiment, a method of making a tire and hub assembly includes providing a hollow cylinder, placing the hollow cylinder in a mold, and connecting an inner ring of a non-pneumatic tire to the hollow cylinder.

[0010] In yet another embodiment, a method of making a non-pneumatic tire and hub assembly includes providing a hollow cylinder, and providing a non-pneumatic tire having an inner ring, an outer ring, and a web connecting the inner ring to the outer ring. The method further includes applying an adhesive to at least one of an outer surface of the hollow cylinder and an inner surface of the inner ring of the non-pneumatic tire. The method also includes connecting the inner surface of the inner ring of the non-pneumatic tire to the outer surface of the hollow cylinder.

BRIEF DESCRIPTION OF THE DRAWINGS

[0011] These and other features of the present embodiments will become more apparent upon reading the following detailed description and with reference to the accompanying drawings of the embodiments, in which:

[0012] FIG. 1 is a front view of an undeformed non-pneumatic tire.

[0013] FIG. 2 is a front view of the non-pneumatic tire of FIG. 1 being deformed when subjected to a load.

[0014] FIG. 3 is a sectional perspective view of the undeformed non-pneumatic tire taken along line 3-3 in FIG. 1.

[0015] FIG. 4 is a front view of another embodiment of an undeformed non-pneumatic tire.

[0016] FIG. 5 is a front view of still another embodiment of an undeformed non-pneumatic tire.

[0017] FIG. 6 is a front view of a further embodiment of an undeformed non-pneumatic tire.

[0018] FIG. 7 is a front view of yet another embodiment of an undeformed non-pneumatic tire.

[0019] FIG. 8 is a front view of another embodiment of an undeformed non-pneumatic tire.

[0020] FIG. 9 is a front view of still another embodiment of an undeformed non-pneumatic tire.

[0021] FIG. 10 is a front view of a further embodiment of an undeformed non-pneumatic tire.

[0022] FIG. 11 is a sectional view of a prior art tread carrying portion attached to a non-pneumatic tire taken along line 11-11 in FIG. 2.

[0023] FIG. 12 is a sectional view of another tread carrying portion attached to a non-pneumatic tire taken along line 11-11 in FIG. 2.

[0024] FIG. 13 is a sectional view of still another tread carrying portion attached to a non-pneumatic tire taken along line 11-11 in FIG. 2.

[0025] FIG. 14 is a perspective view of an embodiment of an undeformed non-pneumatic tire with circumferentially offset segments.

[0026] FIG. 15 is a sectional perspective view of the undeformed non-pneumatic tire taken along line 15-15 in FIG. 14.

[0027] FIG. 16 is a front view of the undeformed non-pneumatic tire as viewed from the line 16-16 in FIG. 14.

[0028] FIG. 17 is a perspective view of the non-pneumatic tire of FIG. 1.

[0029] FIG. 18 is an enlarged, cutaway view of the interconnected web of the non-pneumatic tire of FIG. 17.

[0030] FIG. 19 is a cross sectional view of an embodiment of the shear layer of a non-pneumatic tire.

[0031] FIG. 20 is a cross sectional view of an embodiment of the shear layer of a non-pneumatic tire.

[0032] FIG. 21 is a perspective view of an embodiment of a non-pneumatic tire incorporating a cylinder and two wheel components.

[0033] FIG. 22 is an exploded view of the embodiment of FIG. 21.

[0034] FIG. 23 is a perspective view of an embodiment of a non-pneumatic tire incorporating a cylinder and wheel plate.

[0035] FIG. 24 is an exploded view of the embodiment of FIG. 23.

[0036] FIG. 25 is a perspective view of an embodiment of a non-pneumatic tire, including a sidewall integrated with the interconnected web.

[0037] FIG. 26 is a left side view of the sidewall in FIG. 25.

[0038] FIG. 27 is a perspective view of an embodiment of a non-pneumatic tire, including a sidewall integrated with the interconnected web.

[0039] FIG. 28 is a left side view of the sidewall in FIG. 27.

[0040] FIG. 29 is a graphical comparison of the relative stresses in the tension-based non-pneumatic tire vs. the percentage of the tire experiencing that stress compared to another tension-based non-pneumatic tire.

[0041] FIG. 30 is a graphical comparison of the relative strains in the tension-based non-pneumatic tire vs. the percentage of the tire experiencing that strain compared to another tension-based non-pneumatic tire.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0042] FIGS. 1, 2 and 3 illustrate an embodiment of a non-pneumatic tire 10 having certain features and advantages according to an embodiment of the present invention. In the illustrated embodiment, the non-pneumatic tire 10 comprises a generally annular inner ring 20 that engages a wheel 60 to which tire 10 is mounted. The wheel 60 has an axis of rotation 12 about which tire 10 spins. The generally annular inner ring 20 comprises an internal surface 23 and an external surface 24 and can be made of cross-linked or uncross-linked polymers. In one embodiment, the generally annular inner ring 20 can be made of a thermoplastic

material such as a thermoplastic elastomer, a thermoplastic urethane or a thermoplastic vulcanizate. In another embodiment, the generally annular inner ring 20 can be made of rubber, polyurethane, and/or other suitable material. In this application, the term “polymer” means cross-linked or uncross-linked polymers.

[0043] For smaller applied loads, L, the generally annular inner ring 20 can be adhesively engaged with wheel 60 or can undergo some chemical structure change allowing it to bond to the wheel 60. For larger applied loads, L, the generally annular inner ring 20 can be engaged to the wheel 60 via some form of a mechanical connection such as a mating fit, although a mechanical connection can be used for supporting smaller loads as well. The mechanical engagement can provide both the wheel 60 and the generally annular inner ring 20 with extra strength to support the larger applied load, L. In addition, a mechanical connection has the added benefit of ease of interchangeability. For example, if the non-pneumatic tire 10 needs to be replaced, generally annular inner ring 20 can be detached from wheel 60 and replaced. The wheel 60 can then be remounted to the axle of the vehicle, allowing the wheel 60 to be reusable. In another embodiment, the inner ring 20 can be connected to the wheel 60 by a combination of a mechanical and adhesive connection.

[0044] With continued reference to FIGS. 1, 2 and 3, the non-pneumatic tire 10 further comprises a generally annular outer ring 30 surrounding an interconnected web 40 (discussed below). The outer ring 30 can be configured to deform in an area around and including a footprint region 32 (see FIG. 2), which decreases vibration and increases ride comfort. However, since in some embodiments the non-pneumatic tire 10 does not have a sidewall, the generally annular outer ring 30, combined with the interconnected web 40, can also add lateral stiffness to the tire 10 so that the tire 10 does not unacceptably deform in portions away from the footprint region 32.

[0045] In one embodiment, the generally annular inner ring 20 and a generally annular outer ring 30 are made of the same material as interconnected web 40. The generally annular inner ring 20 and the generally annular outer ring 30 and the interconnected web 40 can be made by injection or compression molding, castable polymer, or any other method generally known in the art and can be formed at the same time so that their attachment is formed by the material comprising the inner ring 20, the outer ring 30 and the interconnected web 40 cooling and setting.

[0046] As shown in FIGS. 1, 2 and 3, the interconnected web 40 of non-pneumatic tire 10 connects the generally annular inner ring 20 to the generally annular outer ring 30. In the illustrated embodiment, the interconnected web 40 comprises at least two radially adjacent layers 56, 58 of web elements 42 that define a plurality of generally polygonal openings 50. In other words, with at least two adjacent layers 56, 58, a slice through any radial portion of the non-pneumatic tire 10 extending from the axis of the rotation 12 to the generally annular outer ring 30 passes through or traverses at least two generally polygonal openings 50. The polygonal openings 50 can form various shapes, some of which are shown in FIGS. 4-10. In many embodiments, a majority of generally polygonal openings 50 can be generally hexagonal shape with six sides. However, it is possible that each one of the plurality of generally polygonal openings 50 has at least three sides. In one embodiment, the

plurality of generally polygonal openings **50** are either generally hexagonal in shape or hexagonal in shape circumferentially separated by openings that are generally trapezoidal in shape, as can be seen in FIG. 1, giving interconnected web **40** a shape that can resemble a honeycomb.

[0047] A preferred range of angles between any two interconnected web elements (moving radially from the tread portion of the tire to the wheel) can be between 80 and 180 degrees (see, for example, the web elements of FIG. 1). Other ranges are also possible.

[0048] With continued reference to the illustrated embodiment of FIGS. 1-3, the interconnected web **40** can be arranged such that one web element **42** connects to the generally annular inner ring **20** at any given point or line along the generally annular inner ring **20** such that there are a first set of connections **41** along the generally annular inner ring **20**. Likewise, one web element **42** can connect to the generally annular outer ring **30** at any given point or line along an internal surface **33** of the generally annular outer ring **30** such that there are a second set of connections **43** along the generally annular outer ring **30**. However, more than one web element **42** can connect to either the generally annular inner ring **20** or to the generally annular outer ring **30** at any given point or line.

[0049] As shown in FIGS. 4-10, the interconnected web **40** can further comprise intersections **44** between web elements **42** in order to distribute applied load, *L*, throughout the interconnected web **40**. In these illustrated embodiments, each intersection **44** joins at least three web elements **42**. However, in other embodiments, the intersections **44** can join more than three web elements **42**, which can assist in further distributing the stresses and strains experienced by web elements **42**.

[0050] With continued reference to FIGS. 4-10, the web elements **42** can be angled relative to a radial plane **16** containing the axis of rotation **12** that also passes through web element **42**. By angling the web elements **42**, applied load, *L*, which is generally applied perpendicular to the axis of rotation **12**, can be eccentrically applied to the web elements **42**. This can create a rotational or bending component of an applied load on each web element **42**, facilitating buckling of those web elements **42** subjected to a compressive load. Similarly situated web elements **42** can all be angled by about the same amount and in the same direction relative to radial planes **16**. Preferably, however, the circumferentially consecutive web elements **42**, excluding tangential web elements **45**, of a layer of plurality of generally polygonal openings **50** are angled by about the same magnitude but measured in opposite directions about radial planes such that web elements **42** are generally mirror images about radial plane **16** of one another.

[0051] Each of the openings within the plurality of generally polygonal tubular openings **50** can, but is not required, to be similar in shape. FIG. 7, for example shows a first plurality of generally polygonal openings **50** that is different in shape from a second plurality of generally polygonal openings **51**. In this embodiment, at least one opening of the first plurality of general polygonal openings **50** can be smaller than at least one opening of the second plurality of generally polygonal openings **51**. FIG. 7 also shows that each generally polygonal opening in the first plurality of generally polygonal openings **50** has an inner boundary **57** spaced a radial distance, R_1 , from axis of rotation **12** and each generally polygonal opening in the second plurality of

generally polygonal openings **51**, has a second inner boundary **59** spaced a radial distance, R_2 , which can be greater than R_1 , from axis of rotation **12**.

[0052] The number of openings **50** within the interconnected web **40** can vary. For example, the interconnected web **40** can have five differently sized openings patterned 16 times for a total of 80 cells, such as in FIG. 1. In yet other embodiments, other numbers of openings **50** can be used other than 16. For example, in preferred embodiments the interconnected web **40** could include between 12-64 patterns of cells. Other numbers outside of this range are also possible.

[0053] As shown in FIGS. 7 and 8, openings in a radially inner layer **56** can be similarly shaped as compared to those in a radially outer layer **58** but can be sized differently from those openings such that the generally polygonal openings **50** increase in size when moving from opening to opening in a radially outward direction. However, turning to FIG. 10, a second plurality of generally polygonal openings **51** in a radially outer layer **58** can also be smaller than those in a first plurality of generally polygonal openings **50** in a radially inner layer **56**. In addition, the second plurality of generally polygonal openings can be either circumferentially separated from each other by a third plurality of generally polygonal openings **53** or can be greater in number than the first plurality of generally polygonal openings **50**, or it can be both.

[0054] As noted above, FIGS. 1-9 show several variations of a plurality of generally polygonal openings **50** that are generally hexagonally shaped. As shown, these openings can be symmetrical in one direction or in two directions, or, in another embodiment, they are not symmetrical. For example, in FIG. 1, radial symmetry planes **14** bisect several of the plurality of generally polygonal openings **50**. Those openings are generally symmetrical about radial symmetry planes **14**. However, interconnected web **40** of tire **10** can also be generally symmetrical as a whole about radial symmetry planes. In comparison, a second plurality of generally polygonal openings **51** can be generally symmetrical about similar radial symmetry planes **14**. In addition, as shown in FIGS. 7-8, a second plurality of generally polygonal openings can be generally symmetrical about lines tangent to a cylinder commonly centered with axis of rotation **12**, providing a second degree of symmetry.

[0055] The web elements **42** can have significantly varying lengths from one embodiment to another or within the same embodiment. For example, the interconnected web **40** in FIG. 7 comprises web elements **42** that are generally shorter than web elements of the interconnected web shown in FIG. 6. As a result, interconnected web **42** can appear denser in FIG. 7, with more web elements **42** and more generally polygonal openings **50** in a given arc of tire **10**. In comparison, FIGS. 9 and 10 both show interconnected webs **40** which web elements **42** substantially vary in length within the same interconnected web. In FIG. 9, radially inward web elements **42** are generally shorter than web elements **42** located comparatively radially outward. However, FIG. 10 shows radially inward web elements **42** that are substantially longer than its radially outward web elements **42**. As a result, interconnected web **40** of FIG. 9 appears more inwardly dense than interconnected web **42** of FIG. 10.

[0056] Remaining with FIG. 10, an interconnected web **40** is shown such that web elements **42** define a radially inner

layer 56 of generally polygonal openings 50 that is significantly larger than a radially outer layer 58 of generally polygonal openings 50. Radially inner layer 56 can comprise alternating wedge-shaped openings 55 that may or may not be similarly shaped. As shown, second plurality of generally polygonal openings 51 can be separated from first plurality of generally polygonal openings 50 by a generally continuous web element 42 of interconnected web 40 spaced at a generally constant radial distance from axis of rotation 12. The generally continuous, generally constant web element 42 can assist in providing further stiffness to non-pneumatic tire 10 in regions that are resistant to deformation.

[0057] With reference back to FIG. 2, the combination of the geometry of interconnected web 40 and the material chosen in interconnected web 40 can enable an applied load, L , to be distributed throughout the web elements 42. Because the web elements 42 are preferably relatively thin and can be made of a material that is relatively weak in compression, those elements 42 that are subjected to compressive forces may have a tendency to buckle. These elements are generally between the applied load, L , that generally passes through axis of rotation 12 and footprint region 32 and are represented as buckled section 48 in FIG. 2.

[0058] In one embodiment, some or all of the web elements 42 can be provided with weakened (e.g., previously bent) or thinned sections such that the web elements 42 preferentially bend and/or are biased to bend in a certain direction. For example, in one embodiment, the web elements are biased such that they bend generally in an outwardly direction. In this manner, web elements do not contact or rub against each as they buckle. In addition, the position of the weakened or thinned portion can be used to control the location of the bending or buckling to avoid such contact.

[0059] When buckling occurs, the remaining web elements 42 may experience a tensile force. It is these web elements 42 that support the applied load L . Although relatively thin, because web elements 42 can have a high tensile modulus, E , they can have a smaller tendency to deform but instead can help maintain the shape of the tread carrying layer 70. In this manner, the tread carrying layer 70 can support the applied load L on the tire 10 as the applied load L is transmitted by tension through the web elements 42. The tread carrying layer 70, in turn, acts as an arch and provides support. Accordingly, the tread carrying layer 70 is preferably sufficiently stiff to support the web elements 42 that are in tension and supporting the load L . Preferably a substantial amount of said applied load L is supported by the plurality of said web elements working in tension. For example, in one embodiment, at least 75% of the load is supported in tension, in another embodiment at least 85% of the load is supported in tension and in another embodiment at least 95% of the load is supported in tension. In other embodiments, less than 75% of the load can be supported in tension.

[0060] Although the generally annular inner ring 20, the generally annular outer ring 30, and the interconnected web 40 can be comprised of the same material; they can all have different thicknesses. That is, the generally annular inner ring can have a first thickness, t_i , the generally annular outer ring can have a second thickness t_o , and the interconnected web can have a third thickness, t_e . As shown in FIG. 1, in one embodiment, the first thickness t_i can be less than the second

thickness t_o . However, the third thickness, t_e , can be less than either first thickness, t_i , or the second thickness, t_o . This illustrated arrangement is presently preferred as a thinner web element 42 buckles more easily when subjected to a compressive force whereas a relatively thicker generally annular inner ring 20 and the generally annular outer ring 30 can advantageously help maintain lateral stiffness of non-pneumatic tire 10 in an unbuckled region by better resisting deformation.

[0061] The thickness, t_e , of web elements 42 can vary, depending on predetermined load capability requirements. For example, as the applied load, L , increases, the web elements 42 can increase in thickness, t_e , to provide increased tensile strength, reducing the size of the openings in the plurality of generally polygonal openings 50. However, the thickness, t_e , should not increase too much so as to inhibit buckling of those web elements 42 subject to a compressive load. As with choice of material, the thickness, t_e , can increase significantly with increases in the applied load L . For example, in certain non-limiting embodiments, each web element 42 of interconnected web 40 can have a thickness, to between about 0.04 inch and 0.1 inch thick for tire loads of about 0-1000 lbs, between about 0.1 and 0.25 inch thick for loads of about 500-5000 lbs, and between 0.25 and 0.5 inch thick for loads of about 2000 lbs or greater. Those of skill in the art will recognize that these thicknesses can be decreased or increased in modified embodiments.

[0062] In addition to the web elements 42 that are generally angled relative to radial planes 16 passing through axis of rotation 12, the interconnected web 40 can also include tangential web elements 45, as shown in FIGS. 1-9. The tangential web elements 45 can be oriented such that they are generally aligned with tangents to cylinders or circles centered at axis of rotation 12. The tangential web elements 45 are preferred because they assist in distributing applied load L . For example, when the applied load L , is applied, the web elements 42 in a region above axis of rotation 12 are subjected to a tensile force. Without the tangential web elements 45, interconnected web 40 may try to deform by having the other web elements 42 straighten out, orienting themselves in a generally radial direction, resulting in stress concentrations in localized areas. However, by being oriented in a generally tangential direction, the tangential web elements 45 distribute the applied load, L throughout the rest of interconnected web 40, thereby minimizing stress concentrations.

[0063] Staying with FIGS. 1-9 the plurality of generally polygonal openings 50 are shown wherein each one of said plurality of generally polygonal openings 50 is radially oriented. As noted above, the generally polygonal openings 50 can be oriented such that they are symmetrical about radial symmetry planes 14 that pass through axis of rotation 12. This arrangement can facilitate installation by allowing tire 10 to still function properly even if it is installed backwards because it should behave in the same manner regardless of its installed orientation.

[0064] As shown in FIG. 1, the generally annular outer ring 30 can have a radially external surface 34 to which a tread carrying layer 70 is attached. Attachment can be done adhesively or using other methods commonly available in the art. In addition, as seen in FIG. 11-13, the tread carrying layer 70 can comprise embedded reinforcing belts 72 to add increased overall stiffness to the non-pneumatic tire 10 wherein the embedding of the reinforcing belts 72 is accom-

plished according to methods commonly available in the art. Reinforcing belts **72** can be made of steel or other strengthening materials.

[0065] FIGS. 11-13 show several possible examples of the arrangement of the reinforcing belts **72** in tread carrying layer **70**. FIG. 11 is a version showing a tread **74** at a radial outermost portion of the tire **10**. Moving radially inwardly are a plurality of reinforcing belts **72a**, a layer of support material **76**, which forms a shear layer, and a second plurality of reinforcing belts **72b**. In this embodiment, the reinforcing belts **72a**, **72b** are arranged so that each belt is a generally constant radial distance from axis of rotation **12**.

[0066] Turning to the embodiment of FIG. 12, a tread carrying layer **70** similar to that of FIG. 11 is shown. However, the embodiment of FIG. 12 shows the layer of support material **76** being approximately bisected in a generally radial direction by at least one transverse reinforcing belt **72c**. Support material **76** can be a rubber, polyurethane or similar compound. As a footprint is formed by the tire, the support material **76** between the reinforcing belts **72** is subjected to a shear force. Thus, the support layer **76** provides the tread carrying layer **70** with increased stiffness.

[0067] The tread carrying layer **70** of FIG. 13 resembles that of FIG. 11 but comprises two additional groupings of reinforcing belts **72**. In addition to the generally radially constant plurality of reinforcing belts **72a**, **72b**, the tread carrying layer **70** in FIG. 13 includes transverse reinforcing belts **72d**, **72e**. The transverse reinforcing belts **72d**, **72e** include at least one reinforcing belt **72d** proximate a longitudinally inner surface and at least one reinforcing belt **72e** proximate a longitudinally outer surface, such that reinforcing belts **72a**, **72b**, **72d**, **72e** generally enclose layer of support material **76** in a generally rectangular box shape.

[0068] The reinforcing belts **72** and the support material **76** as described above generally form a shear layer. As a footprint is formed by the tire, the support material **76** between the reinforcing belts is subjected to a shear force. Thus, the support layer **75** provides the tread carrying layer with increased stiffness.

[0069] In one embodiment, the shear layer (support material) **76** has a thickness that is in the range from about 0 inches (i.e., no shear layer) to about 1 inch thick (as measured along a radius extending from the axis of rotation). In other heavy load applications, the shear layer **76** can have a thickness greater than 1 inch.

[0070] The interconnected web **40**, the generally annular inner ring **20** and the generally annular outer ring **30** can be molded all at once to yield a product that has a width or depth of the finished non-pneumatic tire. However, the interconnected web **40**, the generally annular inner ring **20** and the generally annular outer ring **30** can be manufactured in steps and then assembled as seen in the embodiments of FIGS. 14-16. In these figures, each segment **18** has an interconnected web **40** having the same pattern as the non-pneumatic tire **10** of FIG. 1.

[0071] FIG. 14 shows a perspective view of an embodiment where the tire **10** comprises a plurality of segments **18**. Each segment **18** can have a generally uniform width, W_s , but they can also have different widths in modified embodiments. The segments **18** can be made from the same mold so as to yield generally identical interconnected webs **40**, but they can also be made from different molds to yield varying patterns of interconnected webs **40**. In addition, as seen in FIGS. 14, 15 and 16, segments **18** can be circumferentially

offset from one another so that a plurality of generally polygonal openings **50a** of one segment **18** is not generally aligned with a plurality of similarly-shaped generally polygonal openings **50b** of a radially adjacent segment **19**. The segments can alternate so that every other segment **18** is generally aligned. In another embodiment, the segments do not alternate. FIG. 15 shows an embodiment having seven segments **18**, where the first, third, fifth and seventh segments **18a**, **18c**, **18e** and **18g** are generally aligned with each other, the second, fourth and sixth segments **18b**, **18d**, and **18f** are generally aligned with each other, but the two groups of segments are not generally aligned as a whole. In addition, FIG. 15 is a cutaway view showing two radially adjacent segments **18**, **19** that are not generally aligned. This stacking orientation can help with buckling around the footprint region **32**, can decrease vibration and noise, and can provide greater torsional stiffness to non-pneumatic tire **10**.

[0072] The choice of materials used for interconnected web **40** may be an important consideration. In one embodiment, the material that is used will buckle easily in compression, but be capable of supporting the required load in tension. Preferably, the interconnected web **40** is made of a cross-linked or uncross-linked polymer, such as a thermoplastic elastomer, a thermoplastic urethane, or a thermoplastic vulcanizate. More generally, in one embodiment, the interconnected web **40** can preferably be made of a relatively hard material having a Durometer measurement of about 80A-95A, and in one embodiment 92A (40D) with a high tensile modulus, E , of about 21 MPa or about 3050 psi or in other embodiments between about 3000 psi to about 8000 psi. However, tensile modulus can vary significantly for rubber or other elastomeric materials, so this is a very general approximation. In addition, Durometer and tensile modulus requirements can vary greatly with load capability requirements.

[0073] The polymer materials discussed above for the interconnected web **40**, the inner ring **20**, and/or the outer ring **30** can additionally include additives configured to enhance the performance of the tire **10**. For example, in one embodiment, the polymer materials can include one or more of the following: antioxidants, light stabilizers, plasticizers, acid scavengers, lubricants, polymer processing aids, anti-blocking additives, antistatic additives, antimicrobials, chemical blowing agents, peroxides, colorants, optical brighteners, fillers and reinforcements, nucleating agents, and/or additives for recycling purposes.

[0074] Other advantages can be obtained when using a polymer material such as polyurethane to make non-pneumatic tire **10** instead of the rubber of traditional tires. A manufacturer of the illustrated embodiments can only need a fraction of the square footage of work space and capital investment required to make rubber tires. The amount of skilled labor necessary can be significantly less than that of a rubber tire plant. In addition, waste produced by manufacturing components from a polyurethane material can be substantially less than when using rubber. This is also reflected in the comparative cleanliness of polyurethane plants, allowing them to be built in cities without the need for isolation, so shipping costs can be cut down. Furthermore, products made of polyurethane can be more easily recyclable.

[0075] Cross-linked and uncross-linked polymers, including polyurethane and other similar non-rubber elastomeric materials can operate at cooler temperatures, resulting in less

wear and an extended fatigue life of tire **10**. In addition, the choice of materials for interconnected web **40** and outer ring **30** can significantly decrease rolling resistance, leading to about a 10% decrease in fuel consumption. Polyurethane has better abrasion resistance and, therefore, better tread wear than a traditional rubber tire and, unlike rubber, it is inert, making it resistant to oxidization or reaction with other materials that make rubber harden or even crack.

[0076] In another embodiment shown in FIGS. **17** and **18**, the interconnected web **40** comprises web elements **42** that also contain strengthening components **46** such as carbon fibers, KEVLAR®, or some additional strengthening material to provide additional tensile strength to the interconnected web **40**. Properties of the strengthening components **46** for certain embodiments can include high strength in tension, low strength in compression, light weight, good fatigue life and an ability to bond to the material comprising interconnected web **40**.

[0077] With reference back to the tread and shear layers, in the embodiments shown in FIGS. **19** and **20**, a crowned (FIG. **19**) or rounded configuration (FIG. **20**) of the components of the tread layer **70** can be utilized to prevent or reduce excessive drag on the edges of the tread and shear layer **70** during steering or cornering of the vehicle. By giving the tread layer a curved or crowned geometry, such as that shown in FIGS. **19** and **20**, the tread along the outer edges of the tire will not wear down as quickly, and the life of the tire can be extended.

[0078] Thus, for example, and with reference to FIG. **19**, in at least one embodiment the tread carrying layer **70** can comprise inner belt layers **78a** and **78b**. The belt layer **78a** can have a larger width than the belt layer **78b**, giving the tread carrying layer **70** a generally crowned or rounded shape. A layer of support material **76** can be placed between the belt layers **78a** and **78b**.

[0079] With reference to FIG. **20**, in at least another embodiment the tread carrying layer **70** can comprise belt layers **80a** and **80b**. Both belt layers **80a** and **80b** can be curved in order to give the tread carrying layer **70** a generally crowned or rounded shape. Again, a layer of support material **76** can be placed between belt layers **80a** and **80b**.

[0080] The tread carrying layer **70** of FIGS. **11-13**, **19**, and **20** described above can be manufactured similar to pneumatic tires. For example, in one embodiment, each layer of the tread carrying layer can be manufactured separately in rolls. The thicknesses of the rolls can vary. In at least one embodiment, some of the rolls can be rubber, while other rolls can comprise a steel belting that is coated in a rubber compound and configured for a particular belt angle for a particular tire. Each of the rolls can be brought to a tire building machine, and wrapped onto the machine in a particular order. The last layer can generally comprise a thick layer of rubber to be used as the exterior tread for the tire.

[0081] After wrapping each layer, the entire assembly can be brought to a mold. The outer diameter of the mold can have the reverse pattern of the tread engraved in it. The mold can be heated to a temperature that allows the rubber to easily deform and/or flow. The assembly can be set in the mold, and pressure can be applied from the inside to force the tread against the outer wall of the mold, which converts the thick outer layer into a patterned tread. The assembly can sit within the mold under heat and pressure for a specified

period of time, allowing the rubber layers to vulcanize and generally transform from several individual layers into one solidlayer.

[0082] Once a tread carrying layer has been manufactured as described above, the tread carrying layer **70** can be connected to the interconnected web **40**. Various methods can be used. For example, at least one arrangement comprises overmolding the interconnected web **40** directly onto the radially inwardly facing surface of the tread carrying layer **70**. An adhesive can be sprayed onto the inside diameter of the tread carrying layer **70** and outside diameter of the tire's wheel **60**. In one embodiment, a mold can then be filled with liquid urethane. The adhesive on the tread layer **70** and wheel **60** of the tire **10** can form a bond with the urethane. Once the urethane cures and stiffens, the interconnected web **40** will be molded to both the tread carrying layer **74** and tire wheel **60**.

[0083] In another embodiment, the interconnected web **40** can first be made separately in its own mold. The outside diameter of the interconnected web **40**, or the generally annular outer ring **30**, can be formed so that it is slightly larger than the inside diameter of the tread carrying layer **70**. An adhesive can be applied to the outside diameter of the interconnected web **40**. The interconnected web **40** can then be temporarily compressed so that it can be placed into the tread carrying layer **70**. Once the interconnected web is positioned correctly, the compression on the interconnected web **40** can be removed. The interconnected web **40** can then spread out and contact the tread carrying layer **70**. This method can reduce the residual tension (caused by shrinking of the web material as it cures) that might occur by molding the interconnected web **40** and attaching it to the tread carrying layer **70** at the same time as discussed above.

[0084] As mentioned above, the tire **10** can be coupled to the wheel **60** of a vehicle. In at least one embodiment, a generally cylindrical component can fasten to the non-pneumatic tire's wheel **60**. For example, with reference to FIGS. **21** and **22**, an embodiment of a non-pneumatic tire **110** can comprise a hollow metal (or other material) cylinder **112** configured for attachment to an existing High Mobility Multipurpose Wheeled Vehicle ("HMMWV") or other vehicle's wheel components **114**, **116**. The wheel components **114**, **116** may be configured for use with a specific vehicle. The wheel components **114**, **116** may also include a faceplate identified with a specific vehicle or manufacturer. Alternatively, the wheel components **114**, **116** may be configured to receive a faceplate identified with a specific vehicle or manufacturer.

[0085] The cylinder **112** can include a flanged portion **118** extending towards the interior hollow portion of the cylinder **112**. The flange **118** can have holes **119a** which align with holes **119b** in the wheel components **114**, **116**, thereby facilitating attachment of the cylinder **112** and wheel **114**, **116** by bolts or other fasteners (not shown). While the embodiment shown discloses a flange **118** that extends circumferentially around the interior of the cylinder **112**, in other embodiments the flange **118** can extend around only a portion of the interior of the cylinder **112**. In yet other embodiments, there can be a plurality of flanges spaced apart around the interior of the cylinder **112**.

[0086] At least a portion of cylinder **112** can be coupled to the generally annular inner ring **20** as described above. Thus, an interconnected web **40** and a generally annular outer ring **30**, such as any of those shown in FIGS. **1-18**, can be

attached to the exterior, or radially outwardly facing surface, of cylinder **112** via molding, adhesion, or other methods of attachment. In one example of a molding method of attachment, the cylinder **112** is placed inside of an injection mold (not shown). The interconnected web **40** is then built on the cylinder **112** during an injection molding process. Alternatively, a green interconnected web may be built on a cylinder **112**, and then the web and cylinder assembly are placed in a vulcanization mold. The interconnected web **40** may bond to the cylinder **112** during a curing process.

[0087] In yet another embodiment, the parts are formed of cured thermoset urethane. The urethane parts may be produced by an open mold casting, spin casting, or liquid injection molding (LIM) process. In an open mold casting process, a mold with an open top is used and the mixed urethane, still in its liquid state, is either pumped into the open cavity through ports in the base of the mold (bottom-fill) or poured in from the top (top-fill or gravity-fill). In a spin casting process, a closed mold is rotated while the mixed, liquid urethane is pumped into the mold. The rotation of the mold forces the liquid outward from the center of rotation, allowing for more unique geometries to be molded when compared to the open mold method. In an LIM process, a liquid mixing and pumping mechanism is used. The mixed, liquid urethane is then pumped or injected into the mold.

[0088] In one embodiment, an intermediate material is disposed about the cylinder **112** to facilitate bonding between the cylinder **112** and the interconnected web **40**. Exemplary intermediate materials include sheets of fabric or polymeric material, and an adhesive or cement. In an alternative embodiment, the interconnected web is built directly onto the cylinder **112**. The cylinder **112**, the interconnected web **40**, the inner ring **20**, and the generally annular outer ring **30** can then be attached to the wheel **114**, **116**.

[0089] The tire configuration of FIGS. **21** and **22** provides an advantage in tire servicing and replacement. For example, the cylinder **112** and wheel components **114**, **116** can easily be removed from one another by removing the bolts or other fasteners. Once the bolts are removed, the tire **10** can quickly be serviced, and/or parts of the tire **10** can quickly and easily be replaced.

[0090] With reference to FIGS. **23** and **24**, another embodiment of a non-pneumatic tire **210** can comprise a metal (or other material) cylinder **212**. Cylinder **212**, much like cylinder **112** of the preceding embodiment, can include a flange **216** with holes configured for attaching cylinder **212** with wheel plate **214**. Just as with cylinder **112**, the inner ring **20**, the interconnected web **40** and the generally annular outer ring **30**, such as any of those shown in FIGS. **1-18**, can be attached to the radially outwardly facing surface of cylinder **212** via molding, adhesion, or other methods of attachment. In one example of a molding method of attachment, the cylinder **212** is placed inside of an injection mold (not shown). The interconnected web **40** is then built on the cylinder **212** during an injection molding process. Alternatively, a green interconnected web may be built on a cylinder **212**, and then the web and cylinder assembly are placed in a vulcanization mold. The interconnected web **40** may bond to the cylinder **212** during a curing process.

[0091] In one embodiment, an intermediate material is disposed about the cylinder **212** to facilitate bonding between the cylinder **212** and the interconnected web **40**. Exemplary intermediate materials include sheets of fabric or

polymeric material, and an adhesive or cement. In an alternative embodiment, the interconnected web is built directly onto the cylinder **212**. The single metal wheel plate **214** can quickly and easily be removed from the rest of the tire in order to service the tire or replace parts.

[0092] In yet another embodiment, the interconnected web and the generally annular outer ring, such as any of those shown in FIGS. **1-18**, can be directly attached to an existing wheel rim (not shown) without use of a cylinder such as cylinder **112** or **212**. Thus, instead of removing any bolts and replacing or servicing different parts of the tire, the tire can simply be discarded when it has worn down.

[0093] Additionally, in yet another embodiment, an interconnected web can be directly engaged by a wheel, tread carrying layer, or both. For example, a wheel and tread carrying layer can either or both comprise dovetail joints. The wheel and tread carrying layer can then be inserted into a mold with the material comprising the interconnected web filling the joints. In this case, the generally radially outwardly facing surfaces of the wheel comprise the generally annular inner surface of the tire, and the generally radially inwardly facing internal surface of the tread carrying layer comprises the generally annular outer ring. Therefore, when the interconnected web sets, the interconnected web is directly engaged, obviating the need to bond or otherwise affix the interconnected web to the generally annular outer ring.

[0094] Non-pneumatic tires, including those that use an interconnected web as discussed above, can also incorporate the use of a sidewall or some other structure capable of covering and protecting the interconnected web **40** and tire **10**. Use of a sidewall helps to ensure that debris, water, or other material does not enter the tire, including the interconnected web area, and interfere with the tire's functionality and performance. The sidewall can also help prevent damage to the web from projectiles or other debris.

[0095] With reference to FIGS. **25** and **26**, a sidewall **310** can be attached to or integrated with an interconnected web **40**. In at least one embodiment, the sidewall **310** can be adhered directly to at least one side of the interconnected web **40**. The sidewall **310** can be entirely flat when viewed from its side, as illustrated in FIG. **26**, such that it can be bonded directly to the edges of each or some of the interconnected web element **42** exposed along the outside of the tire **10**. The sidewall **310** can be manufactured separately as one piece and then adhered to the interconnected web **40**, or the sidewall can be integrated directly into the interconnected web's molding during production of the web **40**.

[0096] With continued reference to FIGS. **25** and **26**, the sidewall **310** can cover all, or only a portion of, the side of the interconnected web **40**. By attaching or integrating a sidewall **310** onto at least a portion of the interconnected web **40**, debris or other material can be prevented from entering the interconnected web area of the tire **10** and interfering with the web elements **42**.

[0097] The sidewall **310** can be made from the same material as that of the interconnected web **40**, or the material can be different, such as rubber. In some embodiments, the material for both the interconnected web **40** and sidewall **310** is cast polyurethane. Additionally, in some embodiments the sidewall **310** can have a lower stiffness than that of the interconnected web elements **42**. By having a lower stiffness, the sidewall **310** as illustrated in FIGS. **25** and **26** will generally not support any of the loads acting on the tire

10. Instead, the sidewall **310** can bend or flex during loading in the areas between the interconnected web elements **42**, allowing the interconnected web elements **42** to continue supporting the loads acting on the tire **10**. In other embodiments, the sidewall **310** can support a load.

[0098] In an additional embodiment, and with continued reference to FIGS. **25** and **26**, the sidewall **310** can be adhered to or integrated with the interconnected web **40** only near the generally annular inner ring **20** and the generally annular outer ring **30**. In such embodiments, the sidewall **310** is not adhered to or integrated with some of the interconnected web elements **42** located between the generally annular inner ring **20** and generally annular outer surface **30**. This allows sidewall **310** the freedom to flex and bend in the region between the generally annular inner **20** and the generally annular outer rings **30**, instead of only in those areas between the interconnected web elements **42**.

[0099] With reference to FIGS. **27** and **28**, an additional embodiment of a sidewall **410** can have a generally “domed” or flexed shape, as opposed to the flat shape of sidewall **410** as shown in FIG. **26**. In this embodiment, the sidewall **410** can be adhered to or integrated with the interconnected web **40** as discussed above near both the generally annular inner ring **20** and the generally annular outer ring **30**. The “domed” shape of the sidewall **410**, as illustrated in FIG. **28**, biases the sidewall **410** to deform in a prescribed direction (i.e., away from the web **40**), as opposed to buckling or deforming in towards the web **40** and interconnected web elements **42**. Just as with the previous embodiments, the sidewall **410** and interconnected web **40** can be made of the same material, or different materials. In some embodiments, the interconnected web material **40** is cast polyurethane, and the sidewall **410** rubber.

[0100] In yet additional embodiments, the sidewalls **310**, **410** described above can be made separate from the interconnected web, and be removable from the tire for servicing and/or replacement. For example, the sidewall **310**, **410** can be held in place adjacent the interconnected web **40** by a flange or flanges encircling the tire **10**. The flanges (not shown) can be made from material having low stiffness so as to prevent the flanges from interfering with the functionality and performance of the interconnected web elements **42**. The flanges can be adhered to or integrated with the interconnected web **40** or other portions of the tire **10**. In at least some embodiments, the sidewall can slide out from the grip of the flanges. In yet other embodiments, the flanges can bend or flex, allowing the sidewall to be inserted or removed. In yet other embodiments, the sidewall can be flexible enough to bend and to be inserted into the stationary flanges.

[0101] In yet additional embodiments, instead of an actual wall along the side(s) of the interconnected web **40**, the interconnected web **40** can be filled partially or wholly with filler, for example, a foam material. In at least one embodiment, the foam can comprise polyurethane foam. By filling the interconnected web **40** with foam or similar material, debris can be prevented from entering the areas between the interconnected web elements **42**, which can substantially interfere with the tire’s functionality and performance. At the same time, the foam can be flexible. Thus, the foam itself generally will not support any loads on the tire, instead allowing the tire’s interconnected web elements to continue supporting the loads. In addition, in other modified embodi-

ments, the filler can be used to support some of the load. As mentioned above, non-foam materials can also be used.

[0102] In yet additional embodiments, non-pneumatic tires can incorporate sidewalls similar to pneumatic tires. The sidewalls can be vulcanized to the tread portion of the generally annular outer ring and additionally mounted to the rim of the wheel after the interconnected web has been formed.

[0103] Sidewall thicknesses can vary, depending on factors including, but not limited to, the expected applied loads the tire will experience during use, as well as material strength and flexibility. For example, in at least one embodiment, a sidewall comprised of rubber can have a thickness of approximately 0.09375 inches. In at least some embodiments, the thickness of the sidewall can also vary across each individual sidewall.

[0104] Advantageously, the embodiments of a non-pneumatic tire described above exhibit many of the same performance characteristics as traditional pneumatic tires. For example, the non-pneumatic tire can demonstrate a general ride quality and traction similar to current pneumatic tires. The non-pneumatic tire **10** can also have costs, weight, load supporting capability and tread life similar to current pneumatic tires.

[0105] However, the non-pneumatic tires of the embodiments described herein demonstrate several advantages over standard pneumatic tires. For example, in addition to virtually eliminating blowouts and flat tires, the ability of the generally annular outer ring **30** and the interconnected web **40** to deform in an area around footprint region **32** as shown in FIG. **2** reduces the stresses placed on wheel **60** when hitting a bump, pothole, or similar obstacle, thereby making non-pneumatic tire **10** and wheel **60** less susceptible to damage. Without relying on air pressure to maintain its functionality, interconnected web **40** of non-pneumatic tire **10** can also be better able to withstand damage caused by projectiles. If a portion of interconnected web **40** is damaged, the applied load **L**, which is generally applied perpendicular to axis of rotation **12**, can be transferred to the remaining elements so that a vehicle relying on non-pneumatic tires **10** is not immediately disabled. In addition, because non-pneumatic tire **10** cannot be over- or under-inflated, footprint region **32** can remain generally constant, improving fuel efficiency as compared to traditional pneumatic tires.

[0106] The generally annular outer ring **30** combined with interconnected web **40** can display higher lateral stiffness compared to standard pneumatic tires, especially in the embodiment in which the tread carrying layer **70** is attached. Therefore, while general ride quality can be similar to standard pneumatic tires, non-pneumatic tire **10** can achieve improved cornering ability. The non-pneumatic tire **10** can also require less maintenance by obviating the need to check and maintain air pressure.

[0107] Additionally, a major advantage of using a non-pneumatic tire compared to a standard tire is eliminating flat tires. If a portion of the web is compromised, the load will be redistributed through other elements of the web by virtue of the fact that the web is interconnected, prolonging the life of the tire. In addition, by not carrying any significant load along a footprint region where the tire contacts a surface, a smoother ride results since the non-pneumatic tire is less susceptible to shock and vibration.

[0108] Besides its benefits over traditional pneumatic tires, non-pneumatic tire **10** can exhibit multiple advantages over other non-pneumatic tires. Most of these other tires have solid rim and a solid tire section and are in production for low-speed applications. In comparison to these tires, the non-pneumatic tire **10** can be significantly lighter. The interconnected web **40** can allow non-pneumatic tire **10** to absorb impacts significantly better, resulting in a more comfortable ride. In addition, other non-pneumatic tires are not usable at high speeds due to the amount of vibration that is generated. Some conventional non-pneumatic tires work by placing the portion of the tire that is between the applied load *L* and the contact surface in compression. This causes that section of the tire and its internal structure to deform under the load. When the body to which the tire is attached is not in motion, this portion of the tire remains deformed under the static load. Over time, this can lead to semi-permanent deformation of the tire causing decreased performance, increased noise vibration and worse fuel efficiency, among other things. In contrast, buckled section **48** carries very little, if any, load so the tire can remain statically deformed for a while and not experience any appreciable semi-permanent deformation.

[0109] In comparison to other tension-based non-pneumatic tires, tire **10** can demonstrate even further benefits. Non-pneumatic tire **10** can experience smaller stresses and strains under loading conditions than other tension-based non-pneumatic tires, as can be seen in FIGS. **29** and **30**. By allowing air to flow through the tire **10** and around web elements **42**, the design of interconnected web **40** can result in less heat generation as well as less fatigue, prolonging the life of tire **10**. The ability of interconnected web **40** to buckle around footprint region **32**, thereby causing less reactive force when passing over an obstacle, can also result in less vibration and a better ride. Despite the ability of interconnected web **40** to buckle, it can also be relatively stiff when compared to the internal structure of other tension-based non-pneumatic tires. This can result in less noise being generated, resulting in a quieter ride. It can also cause non-pneumatic tire **10** to experience better starting and stopping performance.

EXAMPLE

[0110] In one non-limiting example embodiment, a non-pneumatic tire **10** possesses the interconnected web **40** of the configuration shown in FIGS. **1** and **2**. Tire **10** has a radius of about 9.5 inches and wheel **60** has a radius of about 4.375 inches.

[0111] In general, the force required for buckling of a column is governed by the equation: $F_{\text{buckling}} = (KEI\pi^2)/l^2$ where *K*=a constant whose value depends on how the ends of the column are affixed, *E*=tensile modulus, *I*=the area moment of inertia, and *l*=the unsupported length of the column.

[0112] If each web element **42** of interconnected web **40** is modeled as its own thin column, the radially innermost elements will be fixed at one end and free to move laterally at another end. In this example, $K=1/4$.

[0113] In this example, the interconnected web **40** and the generally annular outer ring **30** are made of a similar material having a tensile modulus, *E*, of about 21 MPa or 3050 psi.

[0114] Tire **10** can be about 8 inches wide. As noted above, in preferred embodiments, each web element **42** of inter-

connected web **40** can be between about 0.04 inch and 0.1 inch thick for tire loads of about 0-1000 lbs, between about 0.1 and 0.25 inch thick for loads of about 500-5000 lbs, and between 0.25 and 0.5 inch thick for loads of about 2000 lbs or greater. A thickness of about 0.08 inch will be used for this example. In this case, the area moment of inertia, $I=(w*h^3)/12$ where *w*=the width of each web element **42**, 8 inches and *h*=the thickness, 0.08 inch. Therefore, *I* is about 0.000341 in⁴.

[0115] Using the tire and wheel radii mentioned above, and observing the pattern of interconnected web **40** as seen in FIGS. **1** and **2**, each web element **42** can have an approximate length of about $(9.5 \text{ in.} - 4.375 \text{ in.})/4$, or approximately 1.28 inch.

[0116] Based on these numbers, $F_{\text{buckling}} = (KEI\pi^2)/l^2$ = about 1.59 lbs. In addition, web elements **42** of interconnected web **40** are angled with respect to a radial direction to facilitate buckling, which can further decrease *F_{buckling}*.

[0117] In this application, non-pneumatic tire **10** is subjected to a load, *L*, of about 250 lbs. Load, *L*, is distributed throughout web elements **42** such that the entire load, *L*, is not borne by a single web element, **42**. However, the web elements **42** most directly aligned with the direction of load, *L*, should bear the greatest portion of the load. Since *L* is significantly larger than *F_{buckling}*, elements **42** of interconnected web **40** that are subjected to a compressive force will buckle and not support load, *L*.

[0118] While the foregoing written description of embodiments of the invention enables one of ordinary skill to make and use what is considered presently to be the best mode thereof, those of ordinary skill will understand and appreciate the existence of variations, combinations, and equivalents of the specific exemplary embodiments and methods herein. The invention should therefore not be limited by the above described embodiment and method, but by all embodiments and methods within the scope and spirit of the invention as claimed.

What is claimed is:

1. A method of making a tire and hub assembly comprising:
 - providing a hollow cylinder;
 - placing the hollow cylinder in a mold; and
 - connecting an inner ring of a non-pneumatic tire to the hollow cylinder.
2. The method of claim 1, wherein the mold is an injection mold.
3. The method of claim 2, wherein the connecting of the inner ring of the non-pneumatic tire to the hollow cylinder includes injecting flowable material into the injection mold to form the inner ring of the non-pneumatic tire about the hollow cylinder.
4. The method of claim 3, further comprising injecting additional flowable material into the injection mold to form an interconnected web and an outer ring.
5. The method of claim 1, wherein the mold is a vulcanization mold.
6. The method of claim 5, wherein the connecting of the inner ring of the non-pneumatic tire to the hollow cylinder includes providing a green non-pneumatic tire and placing the green non-pneumatic tire in the mold about the hollow cylinder.
7. The method of claim 6, further comprising placing a material between the hollow cylinder and the green non-

pneumatic tire, wherein the material is selected from the group consisting of a sheet of fabric, a sheet of polymeric material, an adhesive, and a cement.

8. The method of claim 6, further comprising curing the green non-pneumatic tire in the vulcanization mold.

9. The method of claim 1, further comprising connecting a pair of wheel components to the hollow cylinder such that each of the pair of wheel components are substantially coaxial with the hollow cylinder,

wherein the connecting of the pair of wheel components to the hollow cylinder includes attaching a first face of a first wheel component to a first side of a flanged portion of the hollow cylinder, and

wherein the connecting of the pair of wheel components to the hollow cylinder further includes attaching a second face of a second wheel component to a second side of the flanged portion of the hollow cylinder.

10. A method of making a non-pneumatic tire and wheel assembly comprising:

providing a hollow cylinder having an outer surface;
placing the hollow cylinder in an injection mold;
injecting a flowable material into the injection mold, thereby forming an inner ring about the outer surface of the hollow cylinder; and

connecting a pair of wheel components to the hollow cylinder such that each of the pair of wheel components are substantially coaxial with the hollow cylinder,

wherein the connecting of the pair of wheel components to the hollow cylinder includes attaching a first face of a first wheel component to a first side of a flanged portion of the hollow cylinder, and

wherein the connecting of the pair of wheel components to the hollow cylinder further includes attaching a second face of a second wheel component to a second side of the flanged portion of the hollow cylinder.

11. The method of claim 10, wherein at least one of the pair of wheel components is a wheel plate.

12. The method of claim 10, further comprising injecting additional flowable material into the injection mold to form an outer ring and support structure extending between the inner ring and the outer ring.

13. The method of claim 12, wherein the support structure is an interconnected web.

14. The method of claim 12, wherein the support structure is a plurality of spokes.

15. A method of making a non-pneumatic tire and wheel assembly comprising:

providing a hollow cylinder having an outer surface;
providing a green non-pneumatic tire;
placing the hollow cylinder in a vulcanization mold;
placing the green non-pneumatic tire in the vulcanization mold about the hollow cylinder; and

connecting a pair of wheel components to the hollow cylinder such that each of the pair of wheel components are substantially coaxial with the hollow cylinder,

wherein the connecting of the pair of wheel components to the hollow cylinder includes attaching a first face of a first wheel component to a first side of a flanged portion of the hollow cylinder, and

wherein the connecting of the pair of wheel components to the hollow cylinder further includes attaching a second face of a second wheel component to a second side of the flanged portion of the hollow cylinder.

16. The method of claim 15, wherein at least one of the pair of wheel components is a wheel plate.

17. The method of claim 15, further comprising placing a material between the hollow cylinder and the green non-pneumatic tire, wherein the material is selected from the group consisting of a sheet of fabric, a sheet of polymeric material, an adhesive, and a cement.

18. The method of claim 15, further comprising curing the green non-pneumatic tire in the vulcanization mold.

19. The method of claim 15, wherein the green non-pneumatic tire includes an inner ring, an outer ring, and support structure extending between the inner ring and the outer ring.

20. The method of claim 15, further comprising placing a tread layer about the outer ring of the green non-pneumatic tire.

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