Additive Manufacturing

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ICEAA 2016 Atlanta

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Introduction

- Additive Manufacturing (aka 3D Printing)
  - Set of manufacturing processes that generally create an item by laying down many successive thin layers of a material.
  - Performed with little worker interaction
  - Based off of 3D CAD file
- Many different processes
  - Material Extrusion- Heated nozzle melts material as it comes out, allowing for layering in multiple directions by CAM software and hardening immediately after extrusion.
  - Stereolithography – Ultraviolet laser traces cross sections in a resin vat and builds layer upon layer, joining them together.
  - Powder Bed Fusion- High power laser fuse small particles of powder into desired mass based on 3D model. Done in a layered fashion similar to stereolithography.
- Need guidance in our hardware model to estimate the cost of additively manufactured parts

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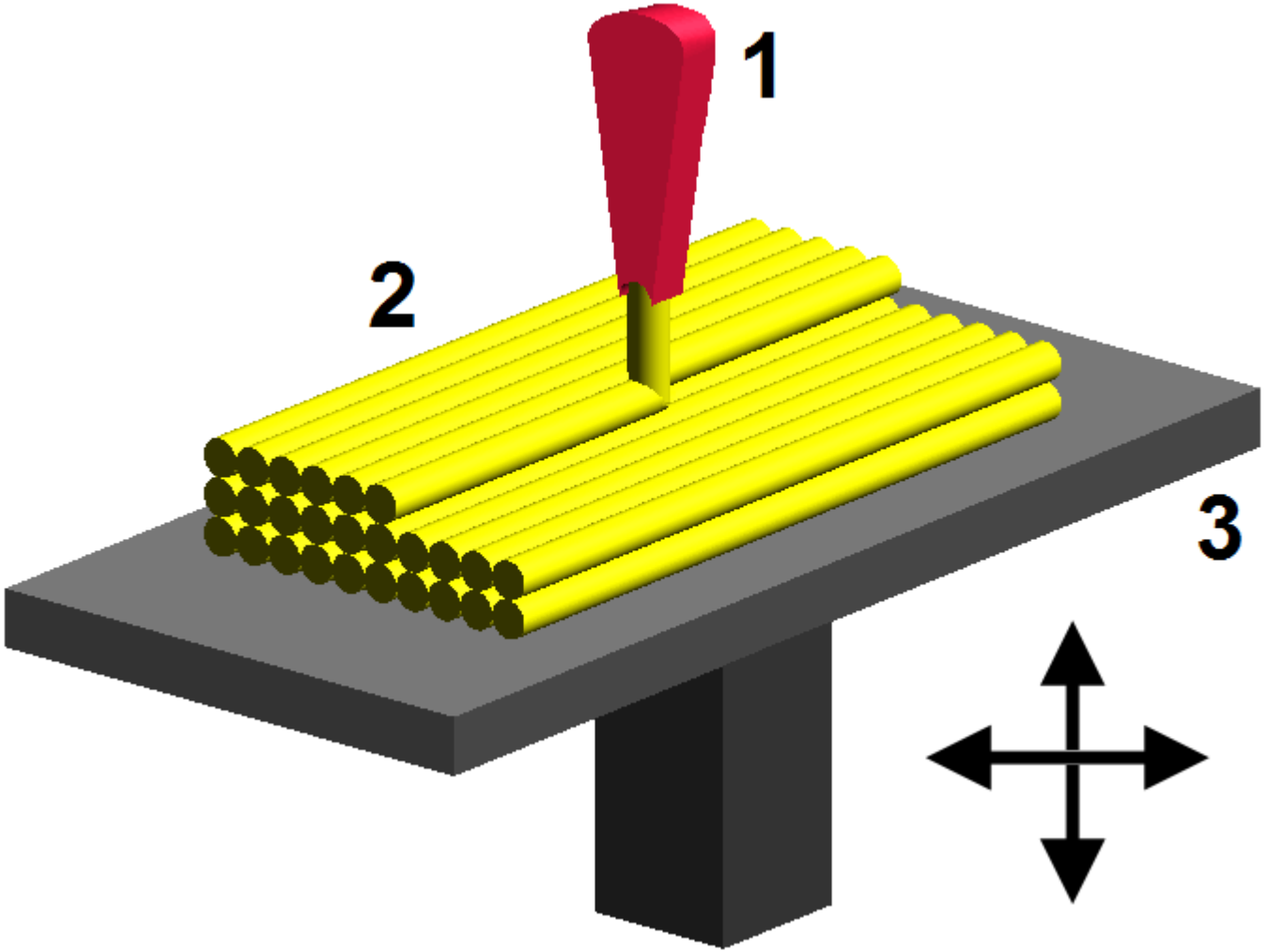
Material Extrusion



Fused deposition modelling (FDM), a method of rapid prototyping: 1 – nozzle ejecting molten material (plastic), 2 – deposited material (modelled part), 3 – controlled movable table.

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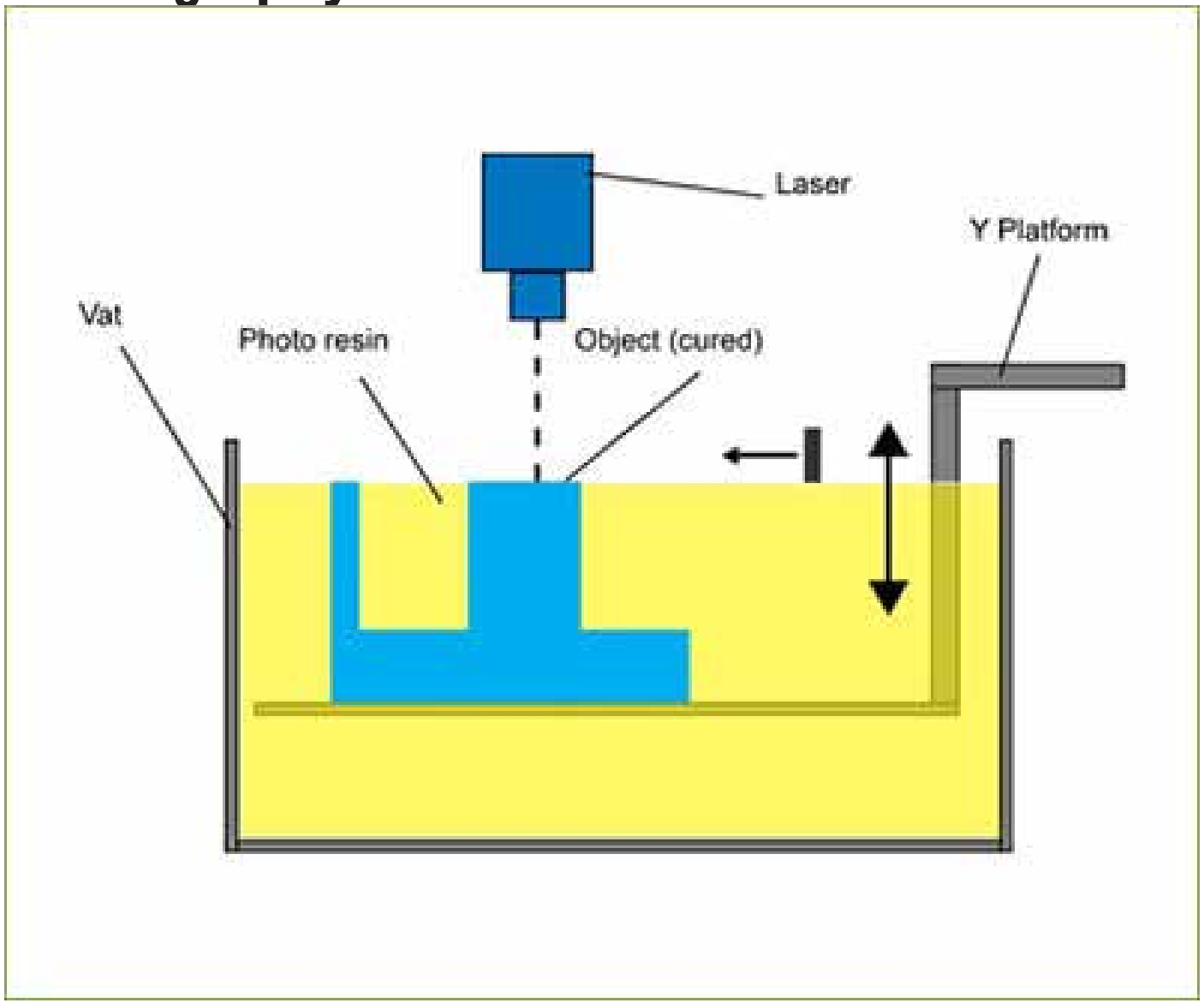
Stereolithography



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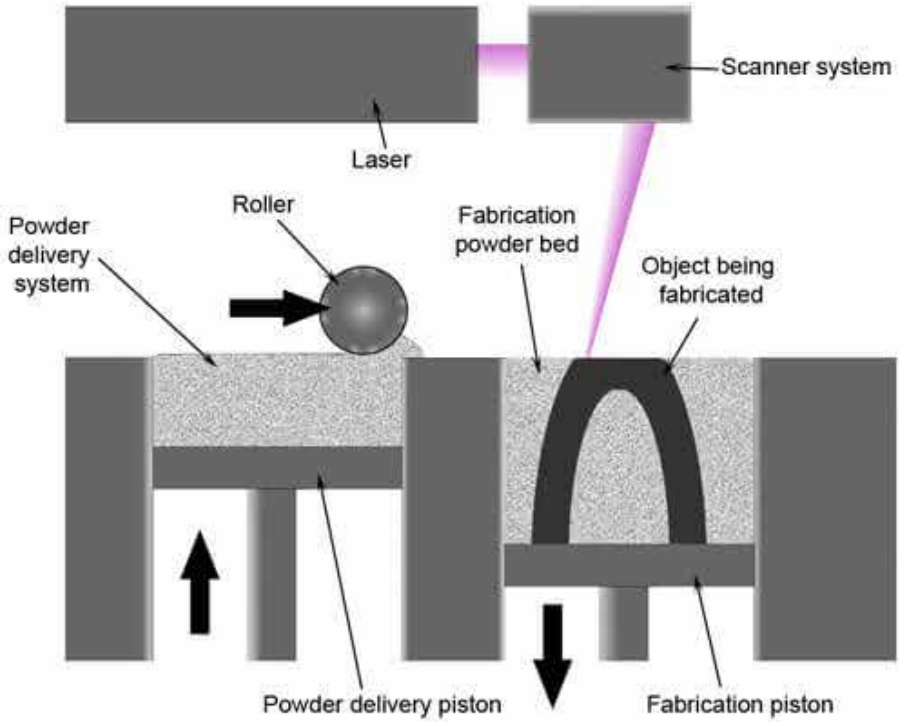
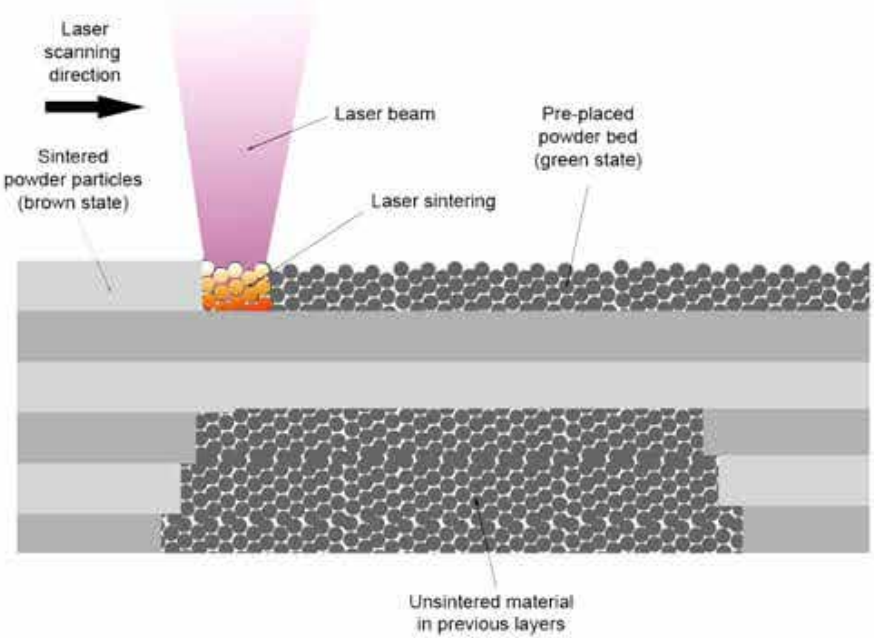
Powder Bed Fusion





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Why 3D Printing?

- Additive Manufacturing use has been growing:
  - Used in medical, aerospace, and automotive industries
  - Multi-billion dollar worldwide industry (expected $21 billion by 2020)
- Additive has benefits over subtractive methods:
  - Rapid Prototyping
  - Rapid Manufacturing
  - Reduced Waste Material
  - Can produce complicated geometry that can't be achieved through traditional
    - *Spiral channels*
    - *Internal Vias*
    - *Internal Supporting Features (honeycomb/lattice structures) – Reduces weight while maintaining strength*
  - Can reduce logistical footprint, as spares can be created on-demand.
  - Reduced part counts

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Research Approach

- Partnered with Lehigh University's Enterprise Systems Center

LEHIGH UNIVERSITY

ESC Enterprise Systems Center

- Worked closely with vendors in the industry

ProtoCAM Excellence in Additive Manufacturing

Picatinny Arsenal The Joint Center of Excellence for Armaments and Munitions

IMPERIAL 3D SOLUTIONS

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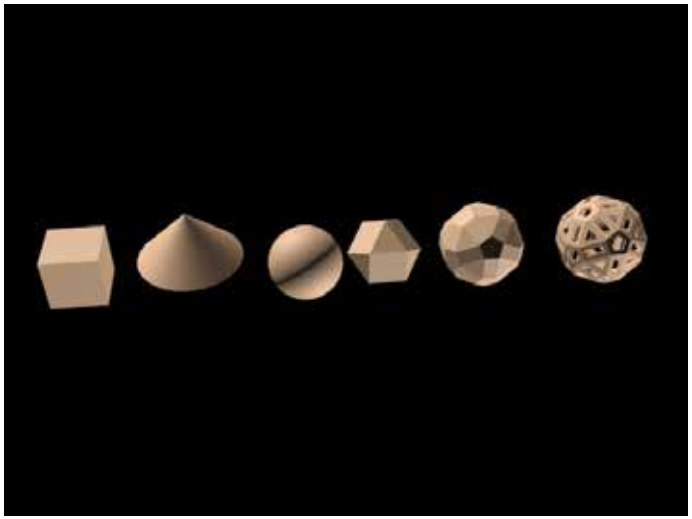
Results - Intricacy Experiment

- Tested hypotheses regarding how shape/intricacy of item affects build time
- Shape/intricacy not found to be a significant driver



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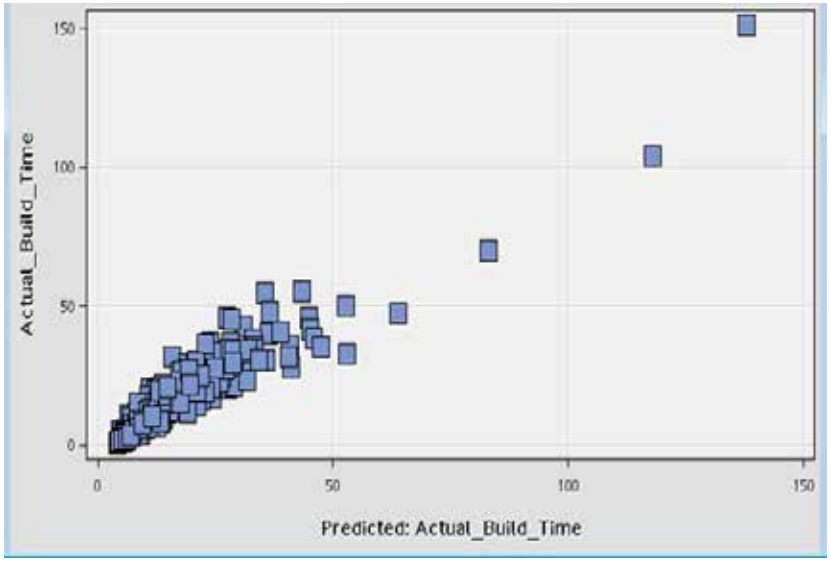
Results

§ Build Time Estimate

- Build Time = f(Height, Volume, Surface Area)
- Based on 691 data points from ProtoCAM
  - *4 different printers, all Stereolithography. Printer was not a significant driver.*
- Conversion for Metal (DMLS) build time estimate based on 11 data points from Picatinny Arsenal.
- Metal Equation validated by Imperial 3D SMEs.

§ Gathered data on

- Common industrial 3D printers, total ownership costs
- Common 3D printed materials (plastic and metal)
- Printer-to-Material Compatibility



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Results

- Additive Manufacturing direct costs composed of:
  - Amortized Machine Cost
  - Material Cost
  - Postprocessing Cost

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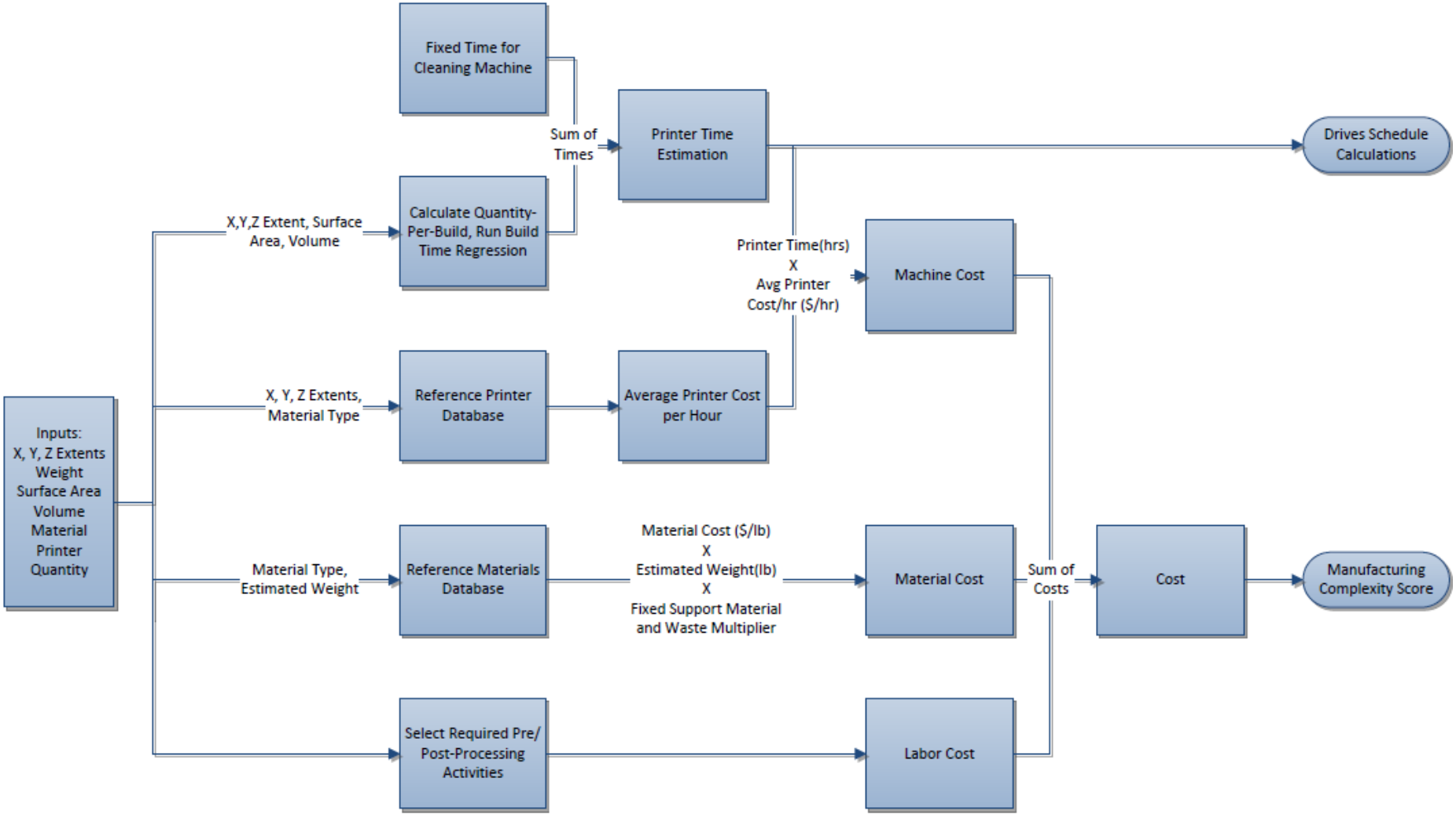
Results



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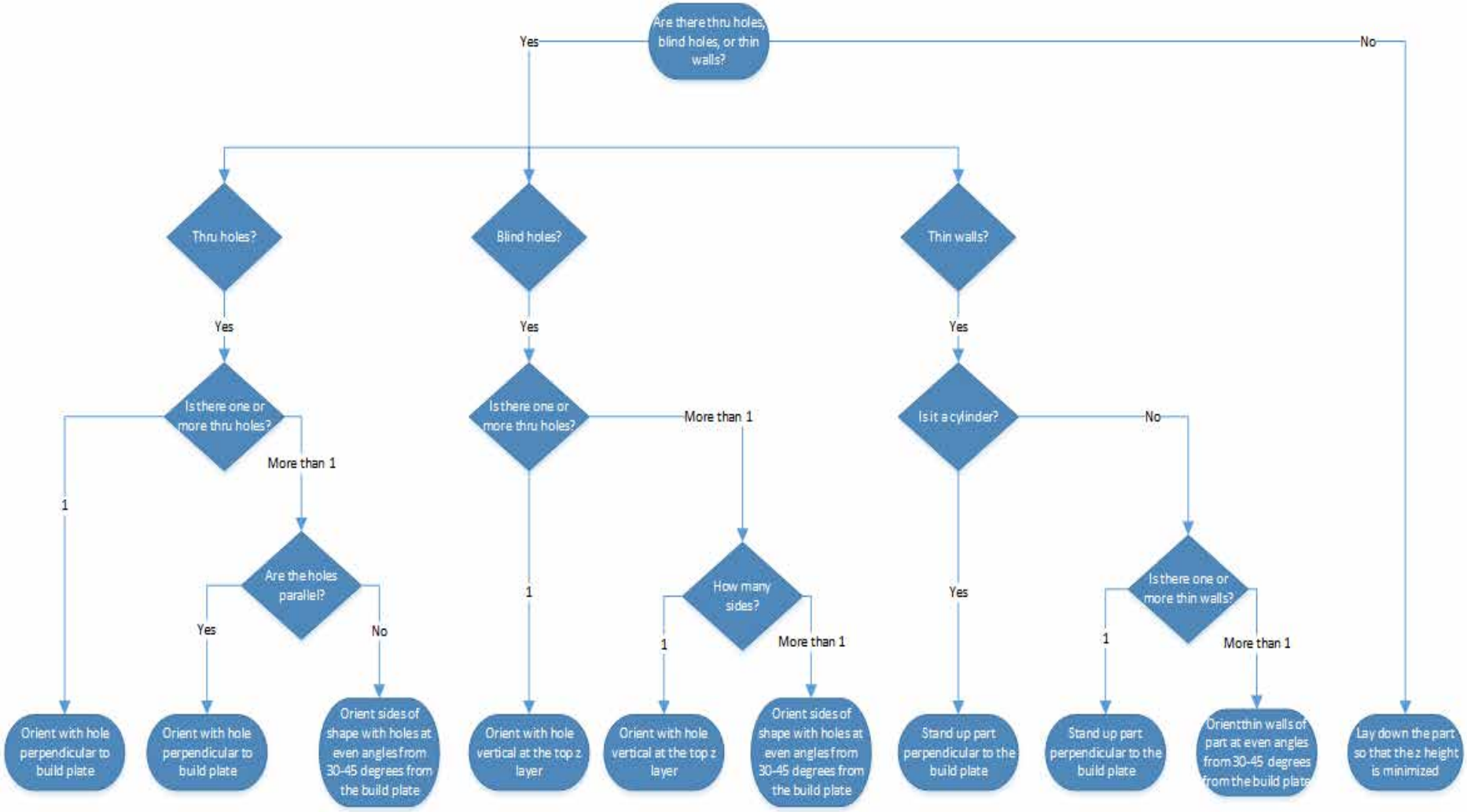
Results

§ Build tray orientation guidance



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Results

- Post-processing costs research with Imperial 3D SMEs
  - Post-processing activity checklist
  - Cost baselines per activity

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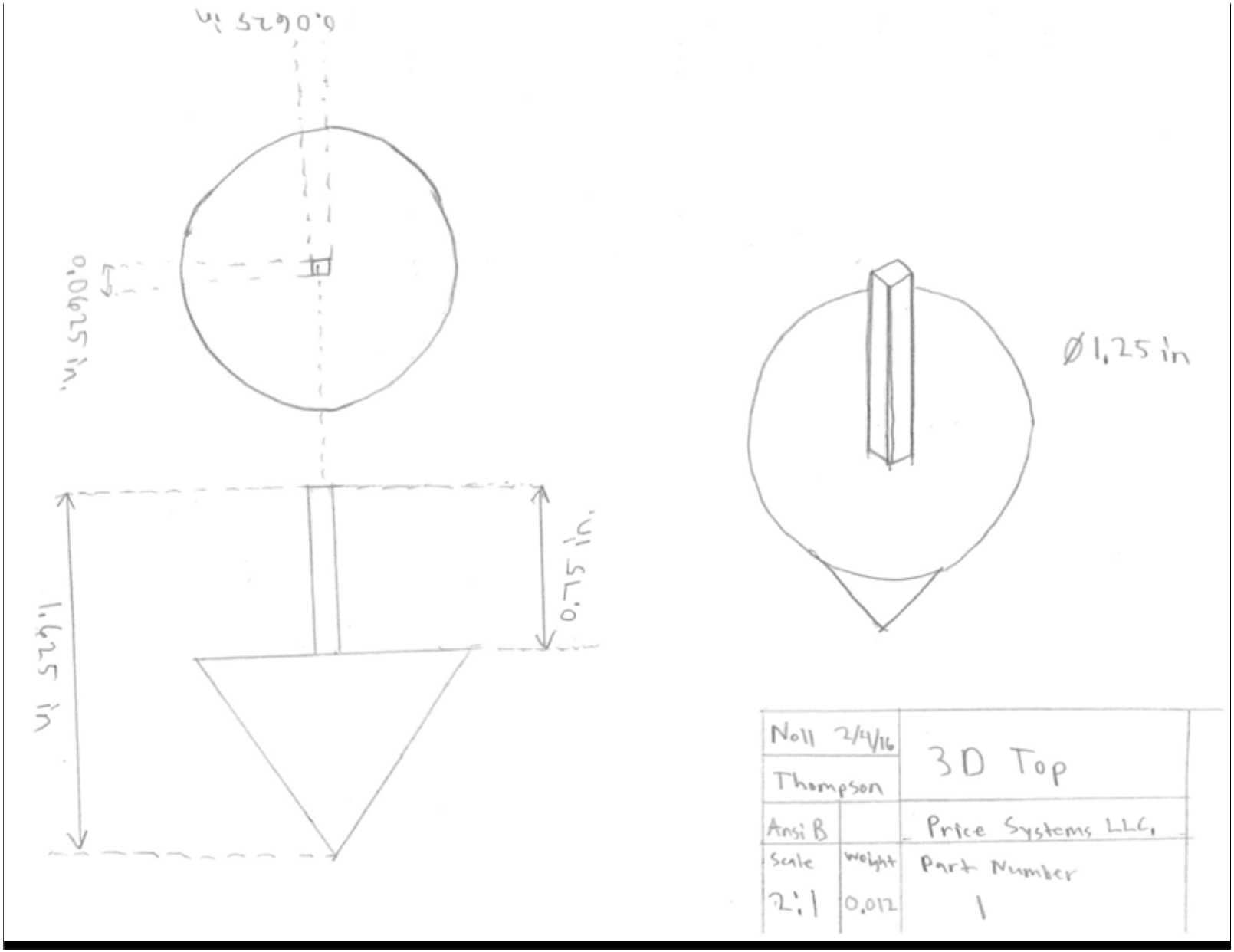
Demo



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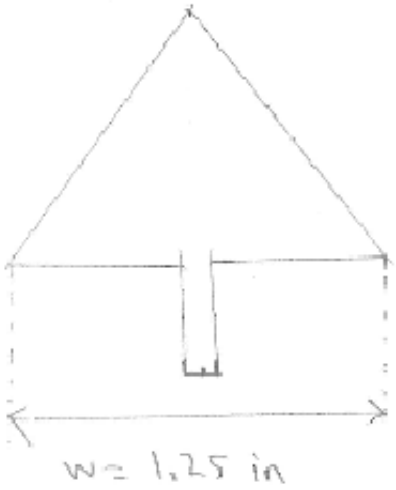

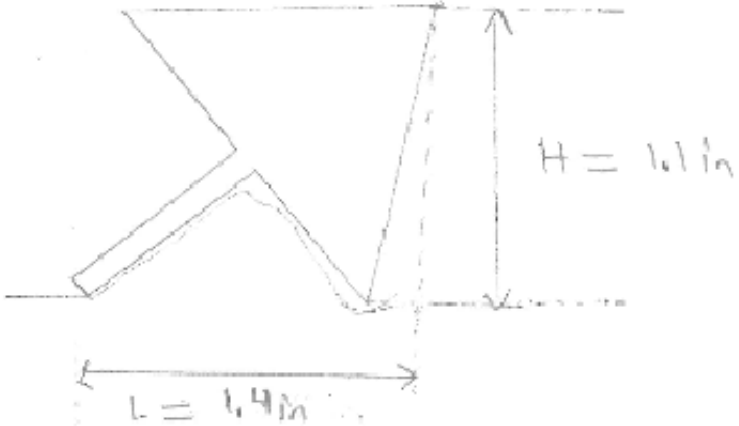

No 91 2/4/16		3D Top
Thompson		
Ansi B		Price Systems LLC,
Scale	Weight	Part Number
2:1	0.092	1

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Future Work

- Collect Build Time data for additional AM machines.
- Research Development Cost/Schedule Impacts
- Review with interested customers
  - Validate the model structure, especially post-processing
  - Validate completeness for A&D market
  - Validate results
- Address more material types
  - Composites
  - Sands
  - Ceramics
  - Chocolate?

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Questions?

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