ISO/ASTM 52911-1:2019-07 (E)

Additive manufacturing - Design - Part 1: Laser-based powder bed fusion of metals

Contents

Page

Foreword v

Introduction vi

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 1

4 Symbols and abbreviated terms 2
4.1 Symbols 2
4.2 Abbreviated terms 3

5 Characteristics of powder bed fusion (PBF) processes 3
5.1 General 3
5.2 Size of the parts 4
5.3 Benefits to be considered in regard to the PBF process 4
5.4 Limitations to be considered in regard to the PBF process 5
5.5 Economic and time efficiency 5
5.6 Feature constraints (islands, overhang, stair-step effect) 6
5.6.1 General 6
5.6.2 Islands 6
5.6.3 Overhang 6
5.6.4 Stair-step effect 6
5.7 Dimensional, form and positional accuracy 7
5.8 Data quality, resolution, representation 7

6 Design guidelines for laser-based powder bed fusion of metals (PBF-LB/M) 8
6.1 General 8
6.1.1 Selecting PBF-LB/M 8
6.1.2 Design and test cycles 8
6.2 Material and structural characteristics 8
6.3 Support structures 9
6.4 Build orientation, positioning and arrangement 11
6.4.1 General 11
6.4.2 Powder spreading 11
6.4.3 Support structures design 12
6.4.4 Curl effect 13
6.5 Anisotropy of the material characteristics 14
6.6 Surface roughness 14
6.7 Post-production finishing 14
6.7.1 General 14
6.7.2 Surface finishing 15
6.7.3 Removal of powder residue 15
6.7.4 Removal of support structures 15
6.7.5 Adjusting geometric tolerances 15
6.7.6 Heat treatment 15
6.8 Design considerations 16
6.8.1 General 16
6.8.2 Cavities 16
6.8.3 Gaps 16

6.8.4 Wall thicknesses 16
6.8.5 Holes and channels 17
6.8.6 Integrated markings 17
6.9 Example applications 17
6.9.1 General 17
6.9.2 Integral design (provided by CETIM -- Technical Centre for Mechanical Industry) 17

6.9.3 Gear wheel design (provided by Fraunhofer IGCV) 19
6.9.4 Impossible crossing (provided by TNO -- The Netherlands Organisation for applied scientific research) 20

Annex A (informative) Materials for PBF-LB/M 22

Bibliography 23