

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	Terms and definitions	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