Table of Contents

Cover
<u>Title Page</u>
<u>Copyright Page</u>
<u>Dedication Page</u>
<u>Preface</u>
Abbreviations
<u>Nomenclature</u>
Greek Symbols
1 Additive Manufacturing Process Classification, Applications, Trends, Opportunities, and Challenges
1.1 Additive Manufacturing: A Long-Term Game Changer
1.2 AM Standard Definition and Classification
1.3 Why Metal Additive Manufacturing?
1.4 Market Size: Current and Future Estimation
1.5 Applications of Metal AM
1.6 Economic/Environmental Benefits and Societal
<u>Impact</u> 1.7 AM Trends, Challenges, and Opportunities
1.8 Looking Ahead
References
2 Basics of Metal Additive Manufacturing
2.1 Introduction
2.2 Main Metal Additive Manufacturing Processes
2.3 Main Process Parameters for Metal DED, PBF, and BI

2.4 Materials
References
3 Main Sub-Systems for Metal AM Machines
3.1 Introduction
3.2 System Setup of AM Machines
3.3 Laser Basics: Important Parameters Needed to
be Known for AM
3.4 Electron Beam Basics
3.5 Powder Feeders and Delivery Nozzles Technology
3.6 CAD File Formats
3.7 Summary
References
4 Directed Energy Deposition (DED)
4.1 Introduction
4.2 Laser Material Interaction and the Associated Significant Parameters to Laser AM
4.3 E-beam Material Interaction
4.4 Power Density and Interaction Time for Various
Heat Source-based Material Processing
4.5 Physical Phenomena and Governing Equations During DED ¹
4.6 Modeling of DED
4.7 Case Studies on Common Modeling Platforms
for DED
4.8 Summary
<u>References</u>
5 Powder Bed Fusion Processes
5.1 Introduction and Notes to Readers

5.2 Physics of Laser Powder bed Fusion (LPBF)
5.3 Physics and Modeling of Electron Beam
Additive Manufacturing
References
6 Binder Jetting and Material Jetting
6.1 Introduction
6.2 Physics and Governing Equations
6.3 Numerical Modeling
6.4 Summary
<u>References</u>
7 Material Extrusion
7.1 Introduction
7.2 Analytical Modeling of ME
7.3 Numerical Modeling of ME
7.4 Summary
References
8 Material Design and Considerations for Metal
Additive Manufacturing
8.1 Historical Background on Materials
<u>8.2 Materials Science: Structure-Property</u> <u>Relationship</u>
8.3 Manufacturing of Metallic Materials
8.4 Solidification of Metals: Equilibrium
8.5 Solidification in Additive Manufacturing: Non-
<u>Equilibrium</u>
8.6 Equilibrium Solidification: Theory and Mechanism
8.7 Non-Equilibrium Solidification: Theory and Mechanism
8.8 Solute Redistribution and Microsegregation

8.9 Constitutional Supercooling	
8.10 Nucleation and Growth Kinetics	
8.11 Solidification Microstructure in Pure Metals	
and Alloys	
8.12 Directional Solidification in AM	
8.13 Factors Affecting Solidification in AM	
8.14 Solidification Defects	
8.15 Post Solidification Phase Transformation	
8.16 Phases after Post-Process Heat Treatment	
8.17 Mechanical Properties	
8.18 Summary	
References	
9 Additive Manufacturing of Metal Matrix Composites	3
9.1 Introduction	
9.2 Conventional Manufacturing Techniques for Metal Matrix Composites (MMCs)	
9.3 Additive Manufacturing of Metal Matrix	
Composites (MMCs)	
9.4 AM Challenges and Opportunities	
9.5 Preparation of Composite Materials:	
<u>Mechanical Mixing</u>	
9.6 Different Categories of MMCs	
9.7 Additive Manufacturing of Ferrous Matrix	
<u>Composites</u>	
9.8 Additive Manufacturing of Titanium-Matrix Composites (TMCs)	
9.9 Additive Manufacturing of Aluminum Matrix Composites	
9.10 Additive Manufacturing of Nickel Matrix	

Composites

9.11 Factors Affecting Composite Property
9.12 Summary
References
10 Design for Metal Additive Manufacturing
10.1 Design Frameworks for Additive
<u>Manufacturing</u>
10.2 Design Rules and Guidelines
10.3 Topology Optimization for Additive Manufacturing
10.4 Lattice Structure Design
10.5 Design for Support Structures
10.6 Design Case Studies
10.7 Summary
References
11 Monitoring and Quality Assurance for Metal
Additive Manufacturing
11.1 Why are Closed-Loop and Quality Assurance
<u>Platforms Essential?[1]</u> ¹
11.2 In-Situ Sensing Devices and Setups
11.3 Commercially Available Sensors
11.4 Signal/Data Conditioning, Methodologies, and
Classic Controllers for Monitoring, Control, and
Quality Assurance in Metal AM Processes
11.5 Machine Learning for Data Analytics and Quality Assurance in Metal AM
11.6 Case Study
-
11.7 <u>Summary</u> <u>References</u>
12 1 Introduction
12.1 Introduction

- 12.2 Overview of Hazards
- 12.3 AM Process Hazards
- 12.4 Laser Safety in Additive Manufacturing¹
- 12.5 Electron Beam Safety
- 12.6 Powder Hazards
- 12.7 Human Health Hazards
- 12.8 Comprehensive Steps to AM Safety

Management

12.9 Summary

References

<u>Index</u>

End User License Agreement

List of Tables

Chapter 2

<u>Table 2.1 Configurations of major commercially available PBF systems.</u>

<u>Table 2.2 The market cost of wire and AM grade</u> <u>powder per pound for some of ...</u>

<u>Table 2.3 Configurations of commercially available DED systems.</u>

<u>Table 2.4 Configurations of commercially available BJ systems.</u>

<u>Table 2.5 Influence of increasing process</u> <u>parameters on dimensions of a sing...</u>

Chapter 3

<u>Table 3.1 Comparison between AM processes</u> <u>adapted from [16] with several cha...</u>

<u>Table 3.2 Comparisons of some representative AM processes.</u>

Chapter 4

<u>Table 4.1 Optical properties and Brewster angle of several materials for 106...</u>

<u>Table 4.2 Reflectivity of different surface roughness</u> for a 10.6-µm waveleng...

Chapter 5

Table 5.1 Material input parameters for LPBF [2, 3].

<u>Table 5.2 Equations used for powder particles</u> shape characterization [18].

<u>Table 5.3 Parameters for the single-layer multiple-track scanning.</u>

<u>Table 5.4 Melt pool depths in the multi-track scanning.</u>

Chapter 8

<u>Table 8.1 Phase formation during solidification of different types of AM ste...</u>

<u>Table 8.2 Phase formation during solidification of different types of AM Al ...</u>

<u>Table 8.3 Chemical composition of different superalloys.</u>

Table 8.4 Post solidification phases of In625.

Table 8.5 Post solidification phases of IN718.

Table 8.6 Different types of Stellite.

Table 8.7 Post solidification phases of Stellite.

Table 8.8 Post solidification phases of Ti alloys.

<u>Table 8.9 The estimated cooling rates necessary to obtain various morphologi...</u>

Chapter 9

<u>Table 9.1 Summary of microstructures formed in TMCs.</u>

<u>Table 9.2 Mechanical and wear property of CP-Ti and different kinds of TMCs ...</u>

Chapter 10

<u>Table 10.1 Metal additive technologies compared</u> with key design consideratio...

<u>Table 10.2 Topology optimization of point loaded structures.</u>

<u>Table 10.3 Objectives and constraints for topology</u> <u>optimization of arbor pre...</u>

<u>Table 10.4 Arbor press components and mass composition.</u>

Table 10.5 Design space and optimized result of arbor press components.

Table 10.6 Design iterations for framework.

Chapter 11

Table 11.1 Co-axial mounted based sensors used in LPBF and LDED.

Table 11.2 Off-axial mounted based sensors used in LPBF and LDED.

Table 11.3 Some commercial sensors mounted on the LPBF machines.

<u>Table 11.4 Some commercial sensors mounted on LDED machines.</u>

<u>Table 11.5 Calibration of RGB values with temperature.</u> For colorful spectrum...

Table 11.6 Machine learning methods used in LPBF and LDED.

<u>Table 11.7 Performance of different SOM</u> dimensions based on the SOEDNN.

<u>Table 11.8 Types and print parameters in print 1.</u>

Table 11.9 Types and print parameters in print 2.

<u>Table 11.10 Applying the detection algorithms on the five consecutive layers...</u>

<u>Table 11.11 The range of *p*-value from ANOVA single-factor analysis of the var...</u>

Table 11.12 The percentage of identification for each size of the defect and...

Table 11.13 Confusion matrix to compare the prediction of the algorithm (AL)...

Table 11.14 Evaluation metrics of AL algorithm based on the CT scan result f...

Table 11.15 Evaluation metrics of AL algorithm based on the CT scan result f...

Chapter 12

<u>Table 12.1 Related potential hazards by metal AM process category [3].</u>

Table 12.2 Different $K_{\underline{st}}$ values for different materials and their severity.

<u>Table 12.3 National Fire Protection Association</u> (NFPA) standards [13].

List of Illustrations

Chapter 1

<u>Figure 1.1 Global public interest trends for "3D Printing".</u>

<u>Figure 1.2 AM chain, enabling physical parts from digital design.</u>

<u>Figure 1.3 Complex parts made by AM. The</u> <u>spherical nest has three spheres in...</u>

Figure 1.4 Lightweight structure made by AM. In this typical bracket, the we...

<u>Figure 1.5 Consolidation of around 300 parts to one part printed by AM.</u>

<u>Figure 1.6 Functionally graded materials (FGMs);</u>
(a) Laser DED with multiple...

Figure 1.7 A fiber optic embedded in a metallic cutting part using a combine...

Figure 1.8 A mold insert with (a) conformal cooling channels, (b) conformal ...

Figure 1.9 LDED used to rebuild turbine blades.

Figure 1.10 Total AM market size by segment that includes all technologies (...

<u>Figure 1.11 Metal AM market size in AMPower Report.</u>

<u>Figure 1.12 Timeline for adopted, emerging, and future applications of AM.</u>

Figure 1.13 Most important metal AM processes versus part size, complexity, ...

<u>Figure 1.14 (a) Dental crowns printed by LPBF(b)</u> joint implants printed ...

<u>Figure 1.15 LPBF-made combustion chamber (left)</u> and the engine in finished c...

<u>Figure 1.16 Small-size, lightweight, one-piece, AM-made antenna.</u>

<u>Figure 1.17 Hydraulic parts made for the oil and gas industry.</u>

Figure 1.18 (a) Ford's custom anti-theft wheel lock being printed in EOS PBF...

Figure 1.19 MX3D smart bridge (a) main structure (b) side wall.

Figure 1.20 (a) Three different geometries made of Ti-6Al-4V by different pr...

Chapter 2

Figure 2.1 Schematic of (a) LPBF and (b) EB-PBF.

<u>Figure 2.2 A view of melt pool and ejected spatters in LPBF.</u>

Figure 2.3 Samples of metal parts made via PBF for (a) aerospace, (b) toolin...

<u>Figure 2.4 The CT scan results of (i) cylindrical, (ii) triangular prism, an...</u>

<u>Figure 2.5 Schematics of (a) powder-fed laser DED</u> with lateral nozzle(b)...

<u>Figure 2.6 Applications of DED: (a) Near-net-shape production.(b) Freefo...</u>

<u>Figure 2.7 A sample of repaired rotating part using Optomec® LENS DED system...</u>

Figure 2.8 A schematic of binder jetting technology.

<u>Figure 2.9 ExOne binder jetting technology in Action.</u>

Figure 2.10 HP multi-jet fusion technique steps.

Figure 2.11 Sample part made using BJ technology.

<u>Figure 2.12 Comparison of traditional binder jetting</u> and <u>Desktop Metal's bin...</u>

<u>Figure 2.13 Schematic of material extrusion</u> <u>system.</u>

<u>Figure 2.14 A sample metal filament from Desktop</u> <u>Metal. In contrast to polym...</u>

Figure 2.15 Visual prototypes made using (a) 17-4 PH stainless steel on Mark...

<u>Figure 2.16 Schematic of material jetting technology.</u>

<u>Figure 2.17 XJET's NanoParticle Jetting technique</u> is one of the emerging met...

Figure 2.18 Sample parts made using XJET system.

Figure 2.19 Ultrasonic consolidation mechanism.

<u>Figure 2.20 FGM parts made using Fabrisonic's ultrasonic consolidation syste...</u>

<u>Figure 2.21 Process design parameters for LDED, LPBF, and BJ techniques.</u>

<u>Figure 2.22 Melt pool and clad/track bead</u> <u>geometrical parameters.</u>

<u>Figure 2.23 Relative density vs. energy for various ferrous alloys (a) relat...</u>

<u>Figure 2.24 Normalized density vs. specific energy techniques.</u>

Figure 2.25 Common scanning strategies.

Figure 2.26 (a) Keyhole porosity and its formation mechanism.(b) Lack of...

Figure 2.27 The combined effect of scanning velocity and beam power on the d...

Figure 2.28 The relationship between melt-pool geometry and hatching distanc...

<u>Figure 2.29 Porosity of LPBF-made parts from AlSi10Mg as a function of hatch...</u>

<u>Figure 2.30 Classification of powder particle properties.</u>

<u>Figure 2.31 The relationship between particle and flow properties and flowab...</u>

Figure 2.32 Different wire-feeding orientations.

<u>Figure 2.33 Illustration of the staircase effect.</u>

<u>Figure 2.34 The maximum layer thickness as a measure of the overlap height o...</u>

Figure 2.35 Cross section of a part as the print layer: contour/skin and cor...

<u>Figure 2.36 (a, b) Illustration of up-skin vs down-skin in PBF process.(...</u>

<u>Figure 2.37 The concept of supports structures,</u> three different support shap...

<u>Figure 2.38 Printability of the fluids based on dimensionless Reynolds and W...</u>

<u>Figure 2.39 The effects of (a) undersaturation and (b) oversaturation on BJ-...</u>

<u>Figure 2.40 H13 tool steel powder agglomeration</u> as a result of oversaturatio...

Chapter 3

<u>Figure 3.1 Laser powder bed fusion system (LPBF).</u> Figure 3.2 Laser Powder-Fed (LPF) system. <u>Figure 3.3 Schematic of a binder jetting system setup.</u>

Figure 3.4 Illustration of the absorption, spontaneous emission, and stimula...

Figure 3.5 Two-level system scheme.

<u>Figure 3.6 A three-level system scheme.</u>

<u>Figure 3.7 Scheme of a four-level system.</u>

<u>Figure 3.8 The main components of a laser are shown. The active medium or ga...</u>

<u>Figure 3.9 Solid-state Laser scheme.</u>

<u>Figure 3.10 Energy-level diagram for Nd3+ doped</u> in YAG.

Figure 3.11 (a) Longitudinally excited and (b) transversely excited CO₂ lase...

Figure 3.12 Laser transitions between vibrational levels in CO_2 .

Figure 3.13 Liquid dye laser schematic.

Figure 3.14 Diode laser scheme.

Figure 3.15 Scheme of a typical fiber laser.

<u>Figure 3.16 Schematic of fiber lasers that include</u> <u>FBGs and beam coupler</u>

<u>Figure 3.17 Energy-level diagram of the erbium-doped fiber.</u>

<u>Figure 3.18 Laser employed in laser-based AM processes (i.e. laser powder be...</u>

Figure 3.19 Mode patterns for different TEMs.

<u>Figure 3.20 Laser beam profile.</u>

Figure 3.21 Schematic of a typical EBM apparatus.

Figure 3.22 Electron beam formation schematic.

<u>Figure 3.23 Gun electrode types: (a) Tungsten (W) filament, (b) Lanthanum He...</u>

Figure 3.24 Electromagnetic Lens.

<u>Figure 3.25 Scheme of a mechanical wheel powder feeder.</u>

<u>Figure 3.26 Schematic of gravity-based powder</u> <u>feeders with a rotating wheel ...</u>

<u>Figure 3.27 Schematic of gravity-based powder</u> <u>feeders with a metering wheel....</u>

<u>Figure 3.28 Schematic of gravity-based powder</u> <u>feeders with a lobe gear.</u>

<u>Figure 3.29 Schematic of a fluidized bed powder feeder.</u>

<u>Figure 3.30 Schematic of a vibratory-based powder feeder.</u>

Figure 3.31 Schematic of a typical lateral nozzle.

<u>Figure 3.32 Powder feed profile characteristics.</u>

Figure 3.33 Schematic of a typical coaxial nozzle.

<u>Figure 3.34 Powder stream at the nozzle exit to a co-axial nozzle.</u>

<u>Figure 3.35 Illustration of a LPBF process system setup.</u>

Figure 3.36 Schematic of a lateral wire-feed system equipped with EBM.

Figure 3.37 Schematic of a coaxial wire-feed system.

Figure 3.38 Schematic of a galvo scanner.

<u>Figure 3.39 Schematics of (a) piezo and (b) thermal inkjet print heads.</u>

Figure 3.40 Typical STL file.

Chapter 4

<u>Figure 4.1 Interaction of a moving heat source and a substrate and the assoc...</u>

<u>Figure 4.2 Schematic of phases formed in a mild steel substrate while being ...</u>

<u>Figure 4.3 Sinusoidal electromagnetic laser beam:</u> <u>emitted beam, reflected be...</u>

<u>Figure 4.4 Graphical concept of the thermal time</u> constant.

<u>Figure 4.5 Laser pulse shaping, including pulse</u> width *W*, pulse energy *E*, and...

<u>Figure 4.6 A typical modulated/pulsed laser beam</u> with rising time, falling t...

Figure 4.7 Dependencies of reflectivity to wavelengths, (a) from 200 to 1000...

<u>Figure 4.8 Temperature dependencies of reflectivity</u> <u>for Al, Cu, and steel at...</u>

<u>Figure 4.9 Dependencies of reflectivity to the angle of incidence for *s*-ray ...</u>

<u>Figure 4.10 E-beam interaction with a substrate</u> and the associated signals g...

<u>Figure 4.11 Penetration depth versus absorption</u> coefficient for accelerated ...

<u>Figure 4.12 Power density and interaction time for various heat source-based...</u>

Figure 4.13 Schematic of physical domains of DED.

<u>Figure 4.14 Track cross section created by DED, (a)</u> <u>high dilution, well wett...</u>

<u>Figure 4.15 Dynamic and equilibrium wetting angles.</u>

Figure 4.16 A schematic of the process zone during LDED powder-fed. Melting ...

Figure 4.17 Geometry and boundary conditions for a typical coaxial nozzle ex...

Figure 4.18 Schematic of 3D heat flow during DED used for the development of...

Figure 4.19 Balance of energy in PF-LDED.

Figure 4.20 Lumped cross section of single track deposited in LDED.

Figure 4.21 Attenuated laser volume in PF-LDED.

Figure 4.22 Lumped temperature distribution at *y* = 0 for parameters listed i...

<u>Figure 4.23 Schematic diagram for laser powder-fed laser-directed deposition...</u>

<u>Figure 4.24 Inconel 625 powder stream grayscale intensity distribution measu...</u>

Figure 4.25 Schematic diagram for melt pool geometry and deposited track [27...

Figure 4.26 Schematic diagram of the solidification front in the longitudina...

<u>Figure 4.27 Laser beam intensity distribution on the substrate surface: (a) ...</u>

<u>Figure 4.28 Melt pool temperature distribution on</u> Inconel 625 substrate surf...

Figure 4.29 Real-time melt pool top surface peak temperature of SS 316L depo...

<u>Figure 4.30 Melt pool peak temperature map for SS 316L single-track depositi...</u>

<u>Figure 4.31 Real-time local thermal profiles at different clad height locati...</u>

Figure 4.32 Effect of *G* and *R* on the mode and scale of solidification micros...

<u>Figure 4.33 Predicted in situ solidification</u> characteristics at different me...

<u>Figure 4.34 Schematic of the laser beam, powder</u> stream and substrate interac...

Figure 4.35 Sequence of calculation in the proposed numerical model [37]....

Figure 4.36 Maximum temperatures for each layer, when $\dot{m} = 2 \text{ g/min}$, U = 1.5 m...

Figure 4.37 Temperature distribution for the second layer deposition at t = ...

<u>Figure 4.38 Energy transformations within the deposition area of a substrate...</u>

Figure 4.39 Deposition patterns in wire-fed EBAM.

<u>Figure 4.40 Proposed Hammerstein-Wiener</u> <u>nonlinear structure</u>

Figure 4.41 Experimental data: (a) multistep process speed and (b) clad/depo...

<u>Figure 4.42 Verification of Hammerstein-Wiener</u> <u>dynamic model using unseen da...</u>

Chapter 5

<u>Figure 5.1 Schematic of LPBF, showing physical phenomena surrounding the mel...</u>

<u>Figure 5.2 Heat source models schematics: (a)</u> <u>cylindrical shape; (b) semi-sp...</u>

Figure 5.3 Powder-laser interaction mechanisms.

<u>Figure 5.4 Thermophysical properties of bulk and powder material: (a) therma...</u>

<u>Figure 5.5 Schematic of (a) keyhole mode and (b) conduction mode. Top figure...</u>

<u>Figure 5.6 Temperature gradient mechanism</u> <u>inducing residual stress.</u>

<u>Figure 5.7 The laser scanning path used for the case study.</u>

<u>Figure 5.8 Geometry and mesh used in the finite</u> element simulation of the ca...

Figure 5.9 Ripples of a single track: (a) experimental results and (b) numer...

Figure 5.10 Experimental surface of the multiple-track scanning: (a) microsc...

<u>Figure 5.11 Melt pool cross section of a single track</u> <u>from (a) experiment (b...</u>

Figure 5.12 Multi-track melt pool cross sections: (a) experiment and (b) sim...

<u>Figure 5.13 Schematic of the theoretical model of the LPF process.</u>

<u>Figure 5.14 Electron acceleration between anode and cathode and electric pot...</u>

<u>Figure 5.15 Binary head-on collision of particles in a hexagonal grid model ...</u>

<u>Figure 5.16 Three-dimensional projection of a face-centered hypercubic latti...</u>

<u>Figure 5.17 Phases assigned to different cells in the LB method. The specifi...</u>

Figure 5.18 Exponential (60 kV) and constant (120 kV) absorption profiles....

Figure 5.19 Melt pool evolution during EB-PBF processing using the LB method...

Figure 5.20 (a) Rain model schematic. (b) Generated powder bed. (c) Relative...

Figure 5.21 Gaussian EB model using the constant absorption profile.

<u>Figure 5.22 (a) Micro-scale simulation temperature distribution for a scan l...</u>

Figure 5.23 Strain evolution of a part during the build process.

<u>Figure 5.24 Comparison between the FEM model</u> and produced parts. It uses the...

Chapter 6

<u>Figure 6.1 Schematic of (a) continuous inkjet</u> <u>printing showing the working m...</u>

<u>Figure 6.2 The droplet formation and flight in inkjet printing. The tail of ...</u>

Figure 6.3 (a) The thinning of the jet on the onset of droplet formation in ...

<u>Figure 6.4 The pinch-off of liquid column as time</u> passes for a liquid with r...

<u>Figure 6.5 Schematic of surface wettability for a droplet of water as a func...</u>

Figure 6.6 Droplet impact regimes on dry surfaces.

<u>Figure 6.7 Droplet cross section changes as a function of time from impact t...</u>

<u>Figure 6.8 Infiltration of the droplet into (a) dry and (b) - (c) pre-wetted...</u>

<u>Figure 6.9 The wetted region imaged using micro-CT for one droplet dispensed...</u>

<u>Figure 6.10 The creation of crater geometry: (a)</u> <u>droplet approaching the sur...</u>

<u>Figure 6.11 Schematic of liquid bridge between two identical spherical parti...</u>

<u>Figure 6.12 The penetration of a droplet with the impact velocity of 5 m/s i...</u>

<u>Figure 6.13 Droplet formation modeling using level-</u> <u>set method showing the ef...</u>

<u>Figure 6.14 (a) Sample D2Q9 LBM.(b) Lattice</u> vectors in a D2Q9 cell.

Figure 6.15 Streaming step in LBM.

Figure 6.16 Collision step in LBM.

<u>Figure 6.17 (a) 2D view of droplet spreading on a smooth surface from initia...</u>

Chapter 7

<u>Figure 7.1 Components of a typical printhead in a ME system.</u>

<u>Figure 7.2 HF composite filament at different ME process stages: Metal-polym...</u>

<u>Figure 7.3 The schematic view of liquefier and nozzle in ME.</u>

Figure 7.4 Schematic of heat transfer region in ME.

<u>Figure 7.5 Three pressure drop zones in the nozzle.</u>

<u>Figure 7.6 (a) The gap (B) between the filament and liquefier walls filled w...</u>

Figure 7.7 (a) Nozzle configuration in a conventional ME (FDM) model and (b)...

Figure 7.8 Die swell effect results in an increase in the diameter of the be...

Figure 7.9 Schematics of the liquefier entrance.

Figure 7.10 (a) Geometry and temperature zones of Serdeczny's model and (b) ...

Figure 7.11 (a) Temperature distribution at the liquefier at different times...

Chapter 8

<u>Figure 8.1 The relationship between four major components of materials scien...</u>

<u>Figure 8.2 Conventional manufacturing processes:</u> <u>e.g., casting.</u>

<u>Figure 8.3 AM powder production steps [1].</u>

<u>Figure 8.4 Schematic of cooling curves during</u> <u>solidification, (a) definition...</u>

<u>Figure 8.5 Fe-C phase diagram.</u>

<u>Figure 8.6 Continuous cooling transformation diagram for steel.</u>

<u>Figure 8.7 Time-temperature profile of a single-layer AM-manufactured Ti-6Al...</u>

<u>Figure 8.8 Critical continuous cooling</u> <u>transformation diagram for welded or ...</u>

<u>Figure 8.9 Time-temperature diagram presenting</u> the nucleation onset of two d...

<u>Figure 8.10 A comparative presentation of the theoretical equilibrium (solid...</u>

<u>Figure 8.11 Solidification during inadequate</u> <u>diffusion in liquid and no diff...</u>

Figure 8.12 Solute distribution without diffusion in the solid and dissimila...

Figure 8.13 Schematic presentation of constitutional supercooling: (a) parti...

<u>Figure 8.14 Schematic presentation on the relation</u> between the Gibbs free en...

<u>Figure 8.15 (a) The figure depicting the nucleation of a sphere-shaped parti...</u>

Figure 8.16 (a) Solid nucleus connected with substrate metal and liquid. (b)...

<u>Figure 8.17 Schematic presentation of the Walton and Chalmers model showing ...</u>

<u>Figure 8.18 The graphics showing the growth characteristics and constitution...</u>

<u>Figure 8.19 Epitaxial growth of the solidified metal adjacent the fusion lin...</u>

<u>Figure 8.20 The schematic diagrams illustrate the modes of solidification pa...</u>

<u>Figure 8.21 Occurrence of various solidification</u> <u>structures related to const...</u>

<u>Figure 8.22 Change of the temperature in time, throughout the solidification...</u>

Figure 8.23 Schematic of the dendrite formation/growth.

Figure 8.24 Influence of temperature gradient *G* and growth rate *R* on size an...

Figure 8.25 Formation mechanism of grains in AM: (a) single track, (b) multi...

<u>Figure 8.26 Schematic of (a) Keyhole porosity.(b)</u> <u>Process and gas-induce...</u>

<u>Figure 8.27 Process window for LPBF manufactured Ti-6Al-4V alloy.</u>

Figure 8.28 Schematic of balling incident appeared by coarsened sphere-shape...

<u>Figure 8.29 Representation of balling phenomenon characterized by small shap...</u>

Figure 8.30 The mechanism of liquation cracking in the melt pool area.

<u>Figure 8.31 Schematic presentation of the microstructural development and ph...</u>

<u>Figure 8.32 Transformation-time-temperature plot</u> for IN718 alloy [79].

<u>Figure 8.33 Microstructure of Stellite 12</u> <u>manufactured through laser-based A...</u>

Figure 8.34 Effect of (a) α -stabilizing, (b) β -isomorphous, and (c...

<u>Figure 8.35 The graphical presentation of ternary titanium alloys having bot...</u>

<u>Figure 8.36 The graphical illustration of thermal profiles.</u>

<u>Figure 8.37 Continuous cooling transformation</u> <u>curve for Ti-6Al-4v alloy [99]...</u>

<u>Figure 8.38 Micro-hardness values with respect to the secondary arms spacing...</u>

<u>Figure 8.39 The micro-hardness values with respect to the secondary arms spa...</u>

<u>Figure 8.40 Microstructure of Ti-6Al-4V manufactured by LPBF, (a) after stre...</u>

<u>Figure 8.41 Micro-hardness plot with respect to the alpha lath width for Ti6...</u>

<u>Figure 8.42 The property window presents yield</u> <u>strength vs. elongation for v...</u>

<u>Figure 8.43 The property window presents yield</u> <u>strength vs. elongation for T...</u>

Figure 8.44 The fatigue behavior of (a) 316L and (b) LPBF-manufactured 17-4 ...

<u>Figure 8.45 The schematic shows the breaking up</u> of Laves phase and split-up ...

<u>Figure 8.46 The fatigue plot shows strain amplitude</u> vs. reversals to failure...

Chapter 9

<u>Figure 9.1 The production route of metal matrix composites in AM.</u>

<u>Figure 9.2 Schematic illustration of the collision</u> <u>between grinding ball and...</u>

<u>Figure 9.3 Geometrical presentation of the particle motion trajectory in an ...</u>

Figure 9.4 Formation mechanism of TiC reinforced 316L matrix composite, (a) ...

<u>Figure 9.5 Microstructure showing the morphology</u> of matrix, interface, and W...

<u>Figure 9.6 The schematic diagram shows that the formation mechanism of ferro...</u>

<u>Figure 9.7 Schematic presentation for the formation of TiB phase from in-sit...</u>

<u>Figure 9.8 Schematic depiction of the formation mechanism of quasi-continuou...</u>

<u>Figure 9.9 Schematic presentation of the microstructural development in pure...</u>

<u>Figure 9.10 Schematic microstructure of the asprinted Ti-6Al-4V/MG composit...</u>

Figure 9.11 SEM micrograph showing Ti-6Al-4V-3% B₄C composite.

<u>Figure 9.12 The schematic diagram illustrates the mechanism of Inconel-TiB₂ ...</u>

<u>Figure 9.13 Demonstration of various failure</u> <u>approaches during compressive l...</u>

Figure 9.14 (a) The influence of Marangoni flow, (b) TiC particles under int...

Chapter 10

<u>Figure 10.1 Topological and functional integrated</u> <u>design framework for AM....</u>

<u>Figure 10.2 Multidiscipline optimization (MDO) for a multifunctional thermal...</u>

Figure 10.3 AM-enable design framework.

<u>Figure 10.4 Design workflow for hybrid design</u> <u>solutions by topology optimiza...</u>

Figure 10.5 Multifunctional design methodology.

Figure 10.6 AM model for product family design.

<u>Figure 10.7 Poor and good part orientation for the avoidance of the "curl ef...</u>

<u>Figure 10.8 Types of support structures, from left to right: fill, lattice, ...</u>

<u>Figure 10.9 Guidance on the use of support</u> structures.

Figure 10.10 Modification of circular profile to avoid "dropping effect."...

<u>Figure 10.11 Hollow features printed with the hollow extrusion (a, b) perpen...</u>

<u>Figure 10.12 Line-of-sight powder removal: (a)</u> <u>small radius, (b) large radiu...</u>

Figure 10.13 A feature with (a) sharp corners and (b) smooth corners.

<u>Figure 10.14 Design variations showing some thin</u> <u>sections that can encourage...</u>

<u>Figure 10.15 The three classifications of structural optimization. (a) Sizin...</u>

<u>Figure 10.16 Classification of topology optimization methods.</u>

<u>Figure 10.17 How topology optimization transforms</u> the structural form of (a)...

<u>Figure 10.18 Influence of volume fraction on interpolation function for SIMP...</u>

Figure 10.19 Linear filter for a 2D mesh.

<u>Figure 10.20 Classification of design-dependent loads for topology optimizat...</u>

<u>Figure 10.21 Thermomechanically loaded</u> <u>structures (a) with constant temperat...</u>

<u>Figure 10.22 Workflow for density-based topology optimization methods.</u>

Figure 10.23 Initial design domain and optimized bridge-like designs with in...

<u>Figure 10.24 Different allowable minimum self-supporting angles for satisfyi...</u>

Figure 10.25 Element density with supporting elements in a 2D FE mesh.

<u>Figure 10.26 Optimum designs showing difference</u> in the topologies resulting ...

<u>Figure 10.27 Topology-optimized half MBB beam</u> with AM filter and Heaviside p...

<u>Figure 10.28 Optimized designs of an aerospace</u> bracket. The right bracket wa...

<u>Figure 10.29 Neighboring elements to element *e* for a single layer.</u>

Figure 10.30 (a) Unconstrained and (b) constrained topology-optimized cantil...

Figure 10.31 Some examples of 2D unit cells.

Figure 10.32 Some 3D unit cell types. (a) 3d Hexagon, (b) "X" shape, (c) oct...

<u>Figure 10.33 Relationship between a lattice</u> <u>structure and its framework.</u>

Figure 10.34 Lattice orientation showing Euler angles α , β , γ

Figure 10.35 Uniform lattice structure.

Figure 10.36 Comparison between (a) uniform and (b) conformal lattices.

<u>Figure 10.37 Voronoi-based lattice structures. (a)</u> <u>Normal Voronoi structure,...</u>

<u>Figure 10.38 Design workflow of multiscale</u> geometric modeling of lattice str...

Figure 10.39 SIMP results for 0.5 volume fraction with penalty value (a) set...

<u>Figure 10.40 Representative structures with a volume fraction of 0.5. (a) So...</u>

Figure 10.41 Library of surface-based unit cells: (a) G (Schoen's Gyroid), (...

Figure 10.42 Schwarz's P surfaces (for value of t = 0.37); (a) $f_P(x,y,z) \le$

<u>Figure 10.43 Example of a linear material grading</u> <u>for (a) strut-based BCC la...</u>

Figure 10.44 Workflow for RDM method.

<u>Figure 10.45 Elements' centroids from strut *j*.</u>

Figure 10.46 Screening process for RDM.

Figure 10.47 Effect of build orientation on a dogbone sample. (a) CAD model ...

<u>Figure 10.48 Orientation angles for framework build showing support structur...</u>

Figure 10.49 Angle threshold of ≤30° of cylindrical axis to building directi...

Figure 10.50 Maximum displacement in the framework.

<u>Figure 10.51 Maximum residual stress in the framework.</u>

<u>Figure 10.52 Volume of support structure used for</u> the build.

Figure 10.53 Residual stress and deformation plots for 22.5° rotation about ...

<u>Figure 10.54 Inverted Y (a) and Y "tree-like" (b)</u> <u>structures supporting a th...</u>

<u>Figure 10.55 Cantilever CAD geometry supported</u> <u>by lattice structures.</u>

Figure 10.56 Unit cell voxel types.

Figure 10.57 Designs with intricate features supported by minimal cellular s...

Figure 10.58 Workflow for integrated topology optimization and support struc...

<u>Figure 10.59 Different support types compared</u> (Part in black and support in ...

<u>Figure 10.60 Enhanced workflow of a topology</u> <u>optimization integrated support...</u>

<u>Figure 10.61 Workflow for redesign of aerospace bracket.</u>

Figure 10.62 Original CAD.

<u>Figure 10.63 Topology-optimized solution and reconstructed design.</u>

Figure 10.64 Stress distribution of original design (a) and topology-optimiz...

<u>Figure 10.65 Design domain, boundary, and load conditions.</u>

<u>Figure 10.66 Topology-optimized result from Altair HyperMesh.</u>

<u>Figure 10.67 Printed and machined structural</u> members.

<u>Figure 10.68 (a and b) Initial denture framework,</u> (c) projection of X-ray sh...

<u>Figure 10.69 Optical images of dental framework's</u>
(a) green state (b) sinter...