

LIST OF FIGURES

• Figure 2-1. Additive Manufacturing timeline [1].	26
• Figure 2-2. Estimation of total Automotive AM market for the next decade. [2]	27
• Figure 2-3. Unit cost comparison between formative, subtractive and additive manufacturing. [3]	27
• Figure 2-4. General steps of AM processes: (a) creating a CAD file from an idea or scanning a piece, (b) converting it in a STL file and slice the piece in layers, (c) manufacturing process, removal of the piece and optional postprocessing [15].	28
• Figure 2-5. Principal 3D printing processes with polymers	29
• Figure 2-6. Selective laser sintering (SLS) process [17].	30
• Figure 2-7. Characteristic thermoplastic polymers available for SLS process [18].	31
• Figure 2-8. Differential Scanning Calorimetry Thermograph with SLS sintering window [19].	32
• Figure 2-9. Stiffness/Toughness balance diagram of commercial SLS materials by Ligon et al.[23]	33
• Figure 2-10. Kitagawa-Takahashi diagram with the Kitagawa-Takahashi prediction (blue line) and El Haddad empirical model (dashed red line). The green area is the integrity area, the red area is the failure area and yellow area is the area where the models differ. The three different crack stages are differentiated (microstructurally short crack (MSC), physically short crack (PSC) and long crack (LC)).	57
• Figure 4-1. Dumbbell and compact tension (CT) specimens oriented at 0 ° and at 90 °. Sintered layers on each orientation are outlined.	62
• Figure 4-2. Tensile dumbbell specimens with dimensions according to ASTM D638 [143].	65
• Figure 4-3. MTS Alliance RF/100 with environmental chamber MTS 651.06E-03 and load train installed for tensile tests at -50 °C and 50 °C.	66
• Figure 4-4. Tensile specimen painted with a random dot pattern.	67
• Figure 4-5. MTS Alliance RF/100 equipped for tensile tests at room temperature, with contact extensometer MTS 634.12F-54 and VIC 2D videoextensometer.	67
• Figure 4-6. Compact Tension (CT) specimen dimensions used in fracture tests according to ASTM D5045 Standard [144] and in fatigue tests according to ASTM E647[145].	68

• Figure 4-7. SEM image of the razor blade tip of the microtome with the diameter measurement [147].	69
• Figure 4-8. Load train assembly inside environmental chamber MTS 651.06E-03 for tests at - 50 °C and 50 °C.	70
• Figure 4-9. MTS 810 Materials Testing machine configured for performing fatigue crack growth tests in CT specimens.	74
• Figure 4-10. MTS 810 Materials Testing set for fatigue life tests.	76
• Figure 5-1. Micrographs of SLS PA-12 at 0° orientation (a) and at 90° orientation (b) and of IM PA-12 (c). Dotted lines delineate spherulite contours.	83
• Figure 5-2. Spherulite size distribution for IM PA-12 and SLS PA-12 at 0° and 90° orientations.	84
• Figure 5-3. Cross-section of IM-PA12 with a core-skin morphology. The arrows indicate the skin of the material.	85
• Figure 5-4: Thermographs obtained from DSC tests of SLS-PA 12 (a) at 0° orientation, (b) at 90° orientation and of (c) IM PA-12. The light red line represents the first heating of the test, the blue line shows the cooling process and the dark red line the second heating.	86
• Figure 5-5. Thermal scans obtained from DMA tests containing the Storage Modulus, the Loss Modulus and the tan δ from -110 °C to 170 °C for: (a) SLS PA-12 at 0° orientation (b) SLS PA- 12 at 90° orientation and (c) IM PA-12.	89
• Figure 5-6. Characteristic engineering stress-strain curves -50 °C, 23 °C and 50 °C obtained from tensile tests in SLS PA-12 at 0° orientation.	91
• Figure 5-7. Characteristic engineering stress-strain curves at -50 °C, 23 °C and 50 °C obtained from tensile tests in SLS PA-12 at 90° orientation.	91
• Figure 5-8. Characteristic engineering stress-strain curves at 23 °C obtained from tensile tests of IM PA-12 and of SLS PA-12 at 0° and 90° orientations.	92
• Figure 5-9. Evolution of the Young's modulus with temperature in SLS PA-12 at 0° and 90° orientations and with the manufacturing process at 23 °C.	93
• Figure 5-10. Evolution of the tensile strength with temperature in SLS PA-12 at 0° and 90° orientations and with the manufacturing process at 23 °C.	94

• Figure 5-11. Evolution of the elongation at break with temperature in SLS PA-12 at 0° and 90° orientations and with the manufacturing process at 23°C.	95
• Figure 5-12. Evolution of the Poisson's ratio with temperature in SLS PA-12 at 0° and 90° orientations and with the manufacturing process at 23 °C.	96
• Figure 5-13. Fracture surfaces from tensile tests of SLS PA-12 at 0° orientation at different temperatures: (a) -50°C, (b) 23°C and (c) 50°C.	97
• Figure 5-14. Fracture surfaces from tensile tests of SLS PA-12 at 90° orientation at different temperatures: (a) -50°C, (b) 23°C and (c) 50°C.	97
• Figure 5-15. Detail of crazing mechanism: voids surrounded by amorphous stretched and broken PA-12 filaments.	99
• Figure 5-16. Fracture surfaces from tensile tests of IM PA-12 at 23°C: (a) panoramic view with the surface defect starter of failure delimited with a dotted line, (b) detail of ductile tearing.	99
• Figure 5-17. Representative load-displacement curves obtained from fracture tests at -50 °C of SLS PA-12 at 0° and 90° orientations.	100
• Figure 5-18. Representative load-displacement curves at 23 °C obtained from fracture tests of IM PA-12 and of SLS PA-12 at 0° and 90° orientations.	101
• Figure 5-19. Representative load-displacement curves at 50 °C obtained from fracture tests of SLS PA-12 at 0° and 90° orientations.	102
• Figure 5-20. Fracture toughness of SLS PA-12 at 0° and 90° orientation determined at -50 C and at 23 °C and of IM PA-12 at 23 °C.	103
• Figure 5-21. Influence of the temperature in SLS PA-12: J-R curves at 23 °C and 50 °C of SLS PA-12 at 0° orientation.	104
• Figure 5-22. Influence of the temperature in SLS PA-12: J-R curves at 23 °C and 50 °C of SLS PA-12 tested at 90° orientation.	105
• Figure 5-23. Influence of the manufacturing process at 23 °C: J-R curves of SLS PA-12 at 0° and 90° orientations and of IM PA-12.	107
• Figure 5-24. Energy at crack growth initiation as a function of the testing temperature and the orientation in SLS PA-12. The influence of the manufacturing technique at 23°C is also displayed including the values obtained from IM PA-12 fracture specimens.	108
• Figure 5-25. Fracture surfaces of SLS PA-12 at 0° orientation tested at: (a) -50°C, (b) 23°C and (c) 50°C. The arrow shows the crack growth direction.	109

- Figure 5-26. Fracture surfaces of SLS PA-12 at 90° orientation tested at:
(a) -50°C, (b) 23°C and (c) 50°C. The arrow shows the crack growth
direction. 109
- Figure 5-27. Detail of "Crazes" observed at 23°C. 110
- Figure 5-28. Fracture surface obtained from fracture tests
of IM PA-12 at 23°C. 110
- Figure 5-29. Fatigue crack growth curves of PA-12 manufactured
by SLS at (a) 0° orientation and (b) at 90° orientation and (c) by IM. 111
- Figure 5-30. Fatigue crack growth behaviour comparison for PA-12
manufactured by SLS at 0° orientation (blue) and at 90° orientation
(green) and by IM (red). 115
- Figure 5-31. Panoramic view of the fracture surfaces obtained
from fatigue crack growth tests of PA-12 manufactured by (a) SLS at 0°
orientation, (b) SLS at 90° orientation (b) and (c) IM. The arrow points
out the crack growth direction. 117
- Figure 5-32. Detail of the fracture surfaces obtained from fatigue
crack growth tests of PA-12 manufactured by (a) SLS at 0° orientation,
by (b) SLS at 90° orientation (b) and (c) by IM. 118
- Figure 5-33. Detail of the patchwork structure due to craze formation
of PA-12 manufactured by SLS at 0° orientation (a) and at 90° orientation
(b) and by IM (c). The nucleation sites of damage initiation are pointed out
by arrows. The white arrows point to unmolten particles or the voids left
behind by them and the blue arrows point to spherulitic nuclei. 120
- Figure 5-34. Fatigue river markings in amorphous filaments left behind the
crack growth that surround the dimples generated after craze nucleation,
growth and coalescence of (a) SLS PA- 12 at 0° orientation, (b) SLS PA-12
at 90° orientation and of (c) IM PA-12. 121
- Figure 5-35. Detail of the micromechanism of failure, where the craters
left behind the fatigue crack path are originally generated by unmolten
particles (pointed out by white arrows) or by spherulitic nuclei in form
of ill-defined discs (a) or irregular rectangles (b), that act as damage
precursors (pointed out by blue arrows). 123
- Figure 5-36. Lifetime fatigue curves of IM PA-12 and SLS PA-12 0°
and 90° orientations. $\rightarrow$ symbol represents run-outs, that is, tests
which reached 10^6 cycles without break. 124
- Figure 5-37. Lifetime fatigue curves IM PA-12 and SLS PA-12 at 0°
and at 90° orientations representing the average values of each
load level. The fitting of the experimental results to the Basquin
type equation $\Delta\sigma = BBNmB$ is also displayed. 126

- Figure 5-38. Up-and-down fatigue tests for the estimation of the fatigue limit at 10^6 cycles: (a) SLS PA-12 at 0° orientation, (b) SLS PA-12 at 90° orientation and (c) IM PA-12. The representations include run-out tests ○ and failure ones ✗. 127
- Figure 5-39. Panoramic views of (a) SLS PA-12 at 0° orientation (a) SLS PA-12 at 90° orientation and (c) IM PA-12, identifying different: Region I or subcritical crack growth zone outlined with a dashed green line, Region II or transition region delineated with a dotted blue line and region III or unstable crack growth region surrounded with a dotted red line. 129
- Figure 5-40. Morphology of the subcritical crack growth zone of SLS PA-12. 131
- Figure 5-41. Morphology of the subcritical crack growth zone of IM PA-12. 132
- Figure 5-42. Transition region: The filaments of amorphous PA-12 suffered high elongation along crack propagation direction. 132
- Figure 5-43. Fatigue marks visible in the high elongated filaments in the transition region. 133
- Figure 5-44. (a) Border between the transition zone and the unstable crack growth region, and (b) morphology of the unstable crack growth area of SLS PA-12. 134
- Figure 5-45. Morphology of the unstable crack growth region of IM PA-12 135
- Figure 5-46. Hysteresis loops obtained from the cyclic load-displacement records of the last cycle before rupture of the tests at stress ratios of 0.7 and 0.85 performed in PA-12 at 0° orientation. 137
- Figure 6-1. Residual strength diagrams including modified Kitagawa-Takahashi (continuous line) and El Haddad predictions (dashed line) of: a) SLS PA-12 at 0° orientation b) SLS PA-12 at 90° orientation and c) IM PA-12. Experimental data obtained from fracture tests and tensile tests carried out in plain specimens and samples with small and medium-size cracks are included as filled orange circles. 140
- Figure 6-2 Residual strength diagrams including modified Kitagawa-Takahashi (continuous line) and El Haddad predictions (dashed line) for static loading of SLS PA-12 at 0° orientation (blue), SLS PA-12 at 90° orientation (green) and IM PA-12 (red). 142
- Figure 6-3. Normalized residual strength diagrams including modified Kitagawa-Takahashi (continuous line) and El Haddad predictions (dashed line) of SLS PA-12 at 0° orientation (blue), SLS PA-12 at 90° orientation (green) and IM PA-12 (red). Experimental data obtained from fracture tests and tensile tests carried out in plain specimens and samples with small and medium-size cracks are included as filled circles. 143

- *Figure 6-4. Kitagawa-Takahashi diagram (blue line) including El Haddad empirical model (purple line) of a) SLS PA-12 at 0° orientation, b) SLS PA-12 at 90° orientation and c) IM PA- 12.ex Experimental data from AG-decreasing tests are plotted with orange filled circles, and the run-outs and failures of the tests employed for the fatigue limit determination are plotted as diamonds and crosses, respectively.* 144
- *Figure 6-5. Kitagawa-Takahashi diagrams (continuous line) including El Haddad empirical models (dotted line) of SLS PA-12 at 0° orientation (blue), SLS PA-12 at 90° orientation (green) and IM PA-12 (red).* 147
- *Figure 6-6. Kitagawa-Takahashi diagrams (continuous line) including El Haddad empirical models (dotted line) in normalized coordinates of SLS PA-12 at 0° orientation (blue), SLS PA-12 at 90° orientation (green) and IM PA-12 (red).* 147
- *Figure 6-7. Kitagawa-Takahashi diagrams (continuous lines) including El Haddad empirical models (dotted lines) for infinite fatigue lifetime in green and for fracture at one cycle in red of SLS PA12 at 0° orientation: a) full diagrams and b) detail of LC regime with Fatigue Crack Propagation Results obtained from AG -increasing tests.* 148
- *Figure 6-8. Kitagawa-Takahashi diagrams (continuous lines) including El Haddad empirical models (dotted lines) for infinite fatigue lifetime in green and for fracture at one cycle in red of SLS PA12 at 90° orientation: a) full diagrams and b) detail of LC regime with Fatigue Crack Propagation Results obtained from AG -increasing tests.* 150
- *Figure 6-9. Kitagawa-Takahashi diagrams (continuous lines) including El Haddad empirical models (dotted lines) for infinite fatigue lifetime in green and for fracture at one cycle in red of IM PA12: a) full diagrams and b) detail of LC regime with Fatigue Crack Propagation Results obtained from AG -increasing tests.* 152
- *Figure 6-10. Schematic Kitagawa-Takahashi of SLS PA-12 at 0° orientation in blue, SLS PA-12 at 90° orientation in green and IM PA-12 in red.* 153
- *Figure 6-11. Maps of fatigue in normalized coordinates with extended Kitagawa-Takahashi diagrams to finite life with 10.000 cycles in purple and 100.000 cycles in blue between the boundary conditions for fracture and one cycle in red and infinite fatigue life in green of (a) SLS PA-12 at 0° orientation, (b) SLS PA-12 at 90° orientation and (c) IM PA-12.* 153