Contents

1. Introduction **1**

2. State of the Art **5**

2.1. Conventional Manufacturing Techniques 5

2.2. Additive Manufacturing Techniques 7

2.2.1. Stereolithography 9

2.2.2. Laminated Object Manufacturing 11

2.2.3. Fused Deposition Modeling 12

2.2.4. 3D-Printing 14

2.2.5. Direct Inkjet Printing 15

2.2.6. Selective Laser Sintering 16

2.2.7. Further Additive Manufacturing Techniques 19

2.3. Preliminary Conclusion 20

3. SLM for Ceramics **23**

3.1. Principle 23

3.2. Process Parameters 24

3.3. Experimental Setup Stationary CO_2 Laser Preheating 26

3.4. State of the Art in SLM of Ceramics 28

4. Applied Materials **31**

4.1. Material Properties 31

4.1.1. Alumina 31

4.1.2. Zirconia 32

4.1.3. The System Al_2O_3 / ZrO_2 33

4.2. Powder Characteristics 35
4.2.1. Size Distribution and Particle Shape 35
4.2.2. Flowing Ability 39
4.3. Preliminary Conclusion 41

5. Characterization of Optical Properties **43**
5.1. Fundamentals 43
5.2. Spectroscopic Analysis 49
5.2.1. Methods 49
5.2.2. Results and Discussion 50
5.3. Online Measurement 52
5.3.1. Methods 52
5.3.2. Results and Discussion 56
5.4. Preliminary Conclusion 61

6. Machinery Development for High-Temperature SLM of Ceramics **63**
6.1. Motivation 63
6.2. Inductive Preheating 65
6.2.1. Concept 65
6.2.2. Heating Source 66
6.2.3. Design of the Inductive Heating Device 66
6.2.4. Implementation of Machinery Equipment 72
6.3. Selective Laser Preheating 73
6.3.1. Concept 73
6.3.2. Laser Sources 74
6.3.3. Optical Design 75
6.3.4. Implementation of Machinery Equipment 81
6.4. Preliminary Conclusion 82

7. Temperature Distribution **85**
7.1. Methods 85
7.2. Results and Discussion 88
7.2.1. Inductive Preheating 88
7.2.2. Selective Laser Preheating 91
7.2.3. Stationary CO_2 Laser Preheating 95
7.3. Preliminary Conclusion 97

8. Preheating Strategies and Resulting Property Profiles **101**
8.1. Fundamentals . . . 101
8.1.1. Mechanisms of Crack Formation . . . 101
8.1.2. Microstructural Formation . . . 103
8.1.3. Phase Distribution . . . 105
8.2. Methods . . . 106
8.3. Results and Discussion . . . 108
8.3.1. Inductive Preheating . . . 108
8.3.2. Selective Laser Preheating . . . 118
8.3.3. Stationary CO_2 Laser Preheating . . . 126
8.4. Preliminary Conclusion . . . 133

9. Surface Quality Analysis **135**
9.1. Methods . . . 135
9.2. Single Track Analysis . . . 139
9.2.1. Variation of Preheating Temperature . . . 139
9.2.2. Variation of Mean Particle Size and Layer Thickness . . . 145
9.2.3. Variation of Focused Spot Size . . . 146
9.3. Volumetric Part Analysis . . . 147
9.3.1. Variation of Scan Sequence . . . 147
9.3.2. Variation of Contour Hatch Distance . . . 148
9.3.3. Variation of Scan Delay . . . 150
9.3.4. Dimensional Accuracy Measurements . . . 153
9.4. Preliminary Conclusion . . . 155

10. Conclusion and Outlook **157**

Bibliography **161**

A. Applied Laser Sources **181**

B. Absorptivity Measurements **183**

C. Dimensioning of the Inductive Preheating **185**
C.1. Fundamentals . . . 185
C.2. Constructive Design . . . 186
C.3. Cooling Element . . . 187
C.3.1. Temperature Distribution Insulation . . . 187

C.3.2. Cooling Capacity of the Cooling Element 193
C.4. Thermal Radiation of Preheated Area 195

D. Dimensioning of the Selective Laser Preheating **197**
D.1. Dichroitic Mirror 197
D.2. Estimated Spot Size of the SLM Laser 198
D.3. Estimated Spot Size of the Preheating Laser 199
D.4. Estimated Laser Power for the Preheating Laser 200
D.5. Raw Beam Intensities of the Applied Laser Sources 201

E. Simulative Analyses **203**
E.1. Approach and Material Constants 203
E.2. Heat source 204
E.3. Model and Element Size 205

F. Measurement of Surface Roughness **207**
F.1. Fundamentals 207
F.2. Diagrams 209
F.2.1. Variation of Preheating Temperature Standard Deviations 209
F.2.2. Parameter Variation for Mean Particle Size and Layer Thickness . 210

Glossary **227**

Acronyms **231**

Latin Symbols **235**

Greek Symbols **239**