

PERFORMANCE EVALUATION OF AISi10Mg MOULD INSERT MATERIAL
FABRICATED BY SELECTIVE LASER MELTING PROCESS

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PTTA UTHM
PERPUSTAKAAN TUNKU TUN AMINAH

Special dedication to my beloved parents, wife and family.....

Thanks for the love, support and memories



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ABSTRACT

In this thesis the physical properties, mechanical properties, different profile building feasibility and dimension accuracy of AlSi10Mg samples fabricated by selective laser melting (SLM) technique, as well as novel fabrication strategies as an alternative to conventional methods in order to produce of plastic injection mould (PIM) tools was investigated. Response surface method (RSM) and variance analysis (ANOVA) are utilized to optimize the SLM parameters and develop the mathematical models. The optimum values input parameters for laser power, scan speed and hatch distance recommended to achieve optimum value of relative density and ultimate tensile strength (UTS) were 348.14 Watt, 1483.25 mm/s and 0.1207 mm, respectively. Other than almost full density achievement with the value of 99.3547% from the experiment, the experimental value of UTS (411.881MPa) was higher compared to A360F and A360T6 HDPC alloys. The feasibility and accuracy results indicate that the benchmark model fabricated by SLM technique revealed the potential of producing near net shape parts. Only 0.5mm offset was added in the normal direction during the fabrication of PIM tool inserts for post-processing purpose. The total time reduction in fabricating the PIM tool inserts using the combination of SLM and high speed machining (HSM) strategy was 34 hours. By introducing square fin conformal cooling channel (SFCCC) in PIM tool inserts has shorten the cycle time and improved the injected product quality due to uniform and faster heat dissipation during the moulding cycle. Whereas the total impact of conformal cooling channel and AlSi10Mg as PIM tool insert materials led to almost 32% reduction on cycle time during the moulding cycle compared to the reference PIM tool. Although with the reduction of fabrication time and cycle time, still the cost modelling result highlights that, in order the SLM AlSi10Mg fabricated PIM with square fin conformal cooling to be cheaper than the reference PIM, an endurance of at least 40 000 cycles is required.

ABSTRAK

Dalam tesis ini, sifat fizikal, sifat mekanik, kebolehlentukan pembinaan profil yang berlainan dan ketepatan dimensi sampel AlSi10Mg yang dihasilkan oleh teknik peleburan laser selektif (SLM), serta strategi fabrikasi novel sebagai alternatif kepada kaedah konvensional untuk menghasilkan suntikan plastik alat acuan (PIM) telah disiasat. Kaedah permukaan tindak balas (RSM) dan analisis varians (ANOVA) digunakan untuk mengoptimumkan parameter SLM dan membangunkan model matematik. Parameter input nilai optimum untuk kuasa laser, kelajuan imbasan dan jarak menetas yang disyorkan untuk mencapai nilai optimum ketumpatan relatif dan kekuatan tegangan muktamad (UTS) adalah masing-masing 348.14 Watt, 1483.25 mm / s dan 0.1207 mm. Selain pencapaian kepadatan hampir penuh dengan nilai 99.3547% daripada eksperimen, nilai eksperimen UTS (411.881MPa) lebih tinggi berbanding aloi A360F dan A360T6 HDPC. Keputusan kebolehlaksanaan dan ketepatan menunjukkan bahawa model penanda aras yang direka oleh teknik SLM mendedahkan potensi menghasilkan bentuk produk hampir tepat. Hanya 0.5mm offset yang telah ditambah dalam arah normal semasa pembuatan alat PIM untuk tujuan pemrosesan akhir. Pengurangan jumlah masa dalam membuat alatan PIM menggunakan kombinasi SLM dan strategi pemesinan kelajuan tinggi (HSM) adalah 34 jam. Dengan memperkenalkan saluran penyejukan conformal fin persegi (SFCCC) dalam alatan PIM telah memendekkan masa kitaran dan meningkatkan kualiti produk yang disuntik kerana pelepasan haba yang seragam dan lebih cepat semasa kitaran pengacuan. Manakala kesan keseluruhan saluran penyejukan conformal dan AlSi10Mg sebagai bahan alatan PIM menyebabkan pengurangan hampir 32% pada masa kitaran semasa kitaran acuan berbanding dengan alatan PIM sedia ada. Walaupun dengan pengurangan masa fabrikasi dan masa kitaran, namun hasil pemodelan kos menunjukkan bahawa, agar alatan PIM AlSi10Mg dengan penyejukan conformal persegi yang lebih murah daripada PIM sedia ada, penyuntikan plastik sekurang-kurangnya 40 000 kitaran diperlukan.

CONTENTS

DECLARATION	ii
DEDICATION	iii
ACKNOWLEDGEMENT	iv
ABSTRACT	v
CONTENTS	vii
LIST OF TABLES	xii
LIST OF FIGURES	xv
LIST OF SYMBOLS AND ABBREVIATIONS	xxiii
CHAPTER 1 INTRODUCTION	1
1.1 Background of the Research	1
1.2 Problem Statements	5
1.3 Objectives of the Study	7
1.4 Scopes of Study	8
1.5 Organization of the Thesis	9
CHAPTER 2 LITERATURE REVIEW	10
2.1 Introduction	10
2.2 Overview of Selective Laser Melting	11
2.2.1 Selective Laser Melting Process	12
2.2.2 Key Parameters in Selective Laser Melting	14
2.2.2.1 Laser Power	15
2.2.2.2 Laser Scan Speed	16
2.2.2.3 Laser Spot Size	17
2.2.2.4 Layer Thickness	17
2.2.2.5 Hatch distance	18
2.2.2.6 Scan Strategy	20

2.2.2.7	Energy Density and Heat Flux	21
2.2.3	Powder Characteristic	22
2.2.4	Powder Deposition	24
2.2.5	Sintering Atmosphere	24
2.3	Review of the Current State of Optimisation Approaches	25
2.4	Fabrication Rules for Selective Laser Melting (SLM)	32
2.4.1	Support Structure and Sloping Angle	32
2.4.2	Minimum Slot and Wall Thickness	34
2.4.3	Chamfers and Fillet	35
2.5	Plastic Injection Moulding Process	37
2.5.1	Plastic Injection Moulding Tool	39
2.5.2	Mould Strength and Durability	42
2.5.3	Mould Material	43
2.5.4	Processing Parameters	46
2.6	Overview of Rapid Tooling	48
2.6.1	Indirect Processes	49
2.6.2	Direct Processes	52
2.7	Design and Performance of Conformal Cooling Channel	60
2.8	Design of Experiments (DOE)	67
2.8.1	Applications of DOE in AM process	68
2.8.2	Central Composite Design	70
2.9	Summary of Literature Review	71
CHAPTER 3	METHODOLOGY	74
3.1	Introduction	74
3.2	Powder Particles Characterization	77
3.2.1	Particle Morphology and Shape Characterization	77
3.2.2	Particle Size and Distribution	78
3.3	Selective Laser Melting Machine Preparation	79
3.3.1	Materialise Magics Software	80
3.3.2	Building Environment	81
3.3.3	Balancing the Re-Coater Blade	82
3.4	Defining Variable Parameters and Range for SLM	82

3.4.1	Process Parameter Investigations to Produce Near Fully Dense Parts	83
3.4.2	Parameters Optimization Development on Relative Density and Tensile Strength	84
3.5	Physical and Mechanical Properties	86
3.5.1	Part Density	86
3.5.2	Hardness Test	87
3.5.3	Tensile Test	88
3.5.4	Compression Test	89
3.6	Metallographic Analysis	90
3.6.1	Optical Microscopy	91
3.6.2	X-Rays Diffraction Analysis	92
3.6.3	Scan Electron Microscopy	93
3.7	Benchmark Model Development for Accuracy and Feasibility test	93
3.7.1	Measurement	96
3.8	Analysis of Mould Material	97
3.9	Plastic injection moulding tool inserts fabrication	100
3.10	Plastic Injection Moulding Evaluation	101
3.10.1	Analysis of Plastic Injection Moulding Process through Simulation	101
3.10.2	Injection Moulding Trial/ Reproducibility	102
3.10.3	Shrinkage and Warpage Measurement	104
3.10.4	Wear Measurement	107
CHAPTER 4	DATA ANALYSIS AND RESULTS	108
4.1	Introduction	108
4.2	AlSi10Mg Powder Characterization	109
4.2.1	Particles Size, Shape and Distribution	109
4.2.2	Morphology	110
4.2.3	Chemical Compounds	111
4.3	SLM Parameters and Range	113

4.3.1	Defining SLM Processing Parameters Range on Density	113
4.3.2	Optimum Setting for SLM Processing Parameters Using Response Surface Method	116
4.3.2.1	Mathematical Models Development	117
4.3.2.2	Adequacy of the Developed Models	118
4.3.2.3	Response Surface and Counter Plots Analysis for Relative Density	121
4.3.2.4	Response Surface and Counter Plots Analysis for Ultimate Tensile Strength	122
4.3.2.5	Optimization on SLM Parameters	124
4.4	Physical and Mechanical Properties as Built	125
4.4.1	Part Density	126
4.4.2	Micro Hardness Test	127
4.4.3	Tensile Test	131
4.4.4	Compression Test	133
4.5	Microstructural and Structure Characterization	135
4.5.1	Optical Images	136
4.5.2	SEM Images	137
4.5.3	XRD Characterization	141
4.6	Benchmark Analysis on Dimensional Accuracy and Feasibility	142
4.6.1	Results on Dimensional Accuracy and Feasibility	143
4.6.2	Building Limitations on Dimensional Accuracy and Feasibility	152
4.7	Results of Mould Materials Study through Simulation	154
4.8	Summary	156
CHAPTER 5	CASE STUDY ON FABRICATION OF PLASTIC INJECTION MOULDING TOOL USING SLM	158
5.1	Introduction	158
5.2	Product Evaluation	160
5.2.1	Plastic Injection Moulding Tool Insert Design	161

5.3 Fabrication of the New Plastic Injection Moulding Tool	
Inserts	169
5.3.1 SLM Fabrication Process	169
5.3.2 CNC Machining Process	174
5.3.3 Plastic Injection Moulding Tool Assembly	175
5.4 Moulding Trial Procedure and Measurements	176
5.4.1 Results of Plastic Injection Moulding Tool through Simulation	176
5.4.2 Results of Plastic Injection Moulding Tool through Experiment	181
5.4.3 Results of Additional Experiment on Cooling Time	183
5.4.4 Results of Plastic Injection Moulding Tool Insert Measurement	186
5.5 Cost Analysis	188
5.6 Summary	192
CHAPTER 6 CONCLUSION AND RECOMMENDATIONS	193
6.1 Conclusions	193
6.2 Recommendations	196
6.3 Significance of the Study	197
REFERENCES	198
APPENDIX A-1	215
APPENDIX A-2	216
APPENDIX A-3	217
APPENDIX A-4	218
APPENDIX A-5	219
APPENDIX B-1	220
VITA	221

LIST OF TABLES

2.1 Mean values of tensile properties of aluminium alloy DMLS sample fabricated referring to ASTM E8M with different orientations, compared to a similar alloy as-fabricated	31
2.2 Design rules for self-supporting convex radii	36
2.3 Advantages and disadvantages of the PIM	37
2.4 Thermal conductivity and material properties	44
2.5 A summary of the review studies on optimisation of conformal cooling channel	61
3.1 Chemical composition of the investigated AlSi10Mg alloy (Wt. %)	77
3.2 Technical Specification of the SLM System SLM 280 HL 20130218	80
3.3 The actual levels of the design parameters with using α value of 1.68179.	85
3.4 Parameters optimization design by RSM (3 factor CCD design, 1 block)	85
3.5 Specification details of ASTM – E8M for tensile test specimen	89
3.6 Developed features on the benchmark models	95
3.7 Control factors for simulation analysis	98
3.8 Physical and mechanical properties of the thermoplastics	99
3.9 Technical specifications for injection moulding machine, Sumitomo SH100A.	104
4.1 Chemical composition of the investigated AlSi10Mg alloy (wt. %)	112
4.2 Density measurement by archimedes method	114
4.3 Design of experiment and the corresponding results of relative density and tensile test	117
4.4 Analysis of variance (ANOVA) for the relative density	118

4.5 Analysis of variance (ANOVA) for the UTS	119
4.6: Optimum SLM parameters values against relative density and UTS	125
4.7 Measured density through archimedes method	126
4.8 Micro hardness on top surface with test load of 2.942 N (HV0.3)	128
4.9 Micro hardness on wall surface with test load of 2.942 N (HV0.3)	129
4.10 Hardness value of SLM AlSi10Mg samples and HPDC alloy A360F and HDPC alloy A360T6	131
4.11 HPDC alloys (both A360TF and A360F) and SLM AlSi10Mg samples' mechanical properties	132
4.12 Compression value of SLM AlSi10Mg samples	134
4.13 Average surface roughness for top, down and side of the benchmark	144
4.14 Dimension measurements of stairs for accuracy in 'Z axis' direction	144
4.15 Dimension measurements of rectangular slot with different relating position for accuracy in 'X axis' direction	145
4.16 Dimension measurements of rectangular slot with different relating position for accuracy in 'Y axis' direction	145
4.17 Dimension measurements of cylinders for external diameter accuracy	146
4.18 Dimension measurements of variable rectangular slots for accuracy in 'X axis' direction	146
4.19 Dimension measurements of variable rectangular slots for accuracy in 'Y axis' direction	147
4.20 Dimension measurements of constant diameter cylinders with different angular position	147
4.21 Dimension measurements of rectangular thin wall slots	148
4.22 Dimension measurements of internal cylinders hole	148
4.23 Dimension measurements of angular planes on side	149
4.24: Results for the simulations first simulation study	154
5.1 Information on reference PIM tool from the industry	160
5.2 Technical specifications for injection moulding parameters	161

5.3 Selection of the priority fabrication process based on topological, fabrication criteria	164
5.4 Cross-sections of SFCCC designs and the corresponding result of the cooling time	168
5.5 Dimension accuracy measurement of the cavity main insert	173
5.6 Dimension accuracy measurement of the core main insert	173
5.7: Fabrication duration for the reference PIM tool inserts and the new PIM tool inserts	175
5.8: Parameters generated form the simulation analysis for the new PIM tool inserts and parameter for the reference PIM tool inserts	176
5.9 Processing parameters for new PIM Inserts trial	181
5.10 Shrinkage results for new PIM tool inserts and reference PIM tool inserts	182
5.11 Warpage results for new PIM tool inserts and reference PIM tool inserts	183
5.12 Dimension accuracy measurement of the cavity main insert after the 1000 shots moulding trail activity	187
5.13 Dimension accuracy measurement of the core main insert after the 1000 shots moulding trail activity	188
5.14 Weight and wall thickness of the door panel parts	189
5.15 Cost per moulding and a cost index for both PIM tool inserts with different fabrication strategy	191



LIST OF FIGURES

1.1 Illustration of traditional cooling channel and conformal cooling channel	3
2.1 (a) Simplified SLM schematic diagram; (b) Fabrication process of SLM technique	12
2.2 Controlling parameters in DMLS/SLM process	14
2.3 The quality of a surface printed on loose powder at different laser powers(P) and different scan speeds (V)	15
2.4 Schematic representation of the effect of higher point distance on the roughness	16
2.5 Front view of a section of laser tracks	19
2.6 Different quality zones for the 10 x 10 plate on loose powder dependent on scan spacing (S) and scan speed (V)	19
2.7 Scan strategies available in the Magics 19 software.	20
2.8 FESEM micrograph showing the morphology of the AlSi10Mg powder by (a) LPW; (b) EOS	23
2.9 Porosity evolution in AlSi10Mg samples processed using different combinations of scan speeds and scan strategies	27
2.10 Square island with raster scan strategy	29
2.11 Comparison of shrinkage (%) obtained experimentally, empirical model and predicted by ANOVA	29
2.12 Illustration of upskin, core and downskin of a part	30
2.13 Four different orientations strategy for producing DMLS parts	30
2.14 Non-contour profile of each layer is rotated of 67° in comparison to the previous sintered layer	31
2.15 Laser beam offset strategies and process parameters	32

2.16	Some types of support structure	33
2.17	Layer overhang with 0.0075mm with 45° sloping angles	33
2.18	Minimum building angles for DMLS machine	34
2.19	Benchmark model for sloping angel effect	34
2.20	Minimum wall thickness able to be built by SLM machine	35
2.21	Ledge, chamfer, convex radius and concave radius	35
2.22	Construction of radius for fillets that is detailed in Figure 2.21	36
2.23	Basic sequence of the moulding cycle	37
2.24	Injection moulding machine – basic element and structure	38
2.25	Schematic lay-out of injection mould tools	39
2.26	Cooling channel layout	43
2.27	Heat flow in the plastic injection moulding tool	46
2.28	Classification of rapid tooling	50
2.29	Prototype and conformal cooling channels placed in aluminium frame	52
2.30	Core and cavity inserts for rapid cooling in the injection-moulding process	52
2.31	Core and cavity made by epoxy tooling	53
2.32	The geometry of the conformal cooling flow channels	53
2.33	The moulding after being ejected from the SL tool	54
2.34	New prototyped mould protected fabricated by DMLS	55
2.35	Schematic architecture of the laser direct metallic rapid tooling system	55
2.36	Plastic injection moulding (core/cavity) inserts	56
2.37	DTM rapid tooling using SLS approach	56
2.38	(a) Conformal cooling channel on core plate and straight-drilled cooling channel on cavity plate. (b) Conventional with straight drilled cooling channels. (c) Conventional with the straight drilled cooling channel at cavity plate and with a baffle at core plate	57
2.39	Cavity insert (a) and core insert (b) with straight-drilled cooling channels	58

2.40	Cavity insert (a) and core insert (b) with conformal cooling channels	58
2.41	DMLS mold developed for hub gear	59
2.42	Rapid tooling with conformal cooling channels	60
2.43	Proposed conformal cooling design based on a feature-recognition algorithm	62
2.44	(a) Straight Conventional cooling channel design. (b). Parallel conformal cooling channel (c) Series conformal cooling design (d) Conformal cooling channel with additive cooling lines	63
2.45	Cooling channels with array of baffle	64
2.46	Mould cavity with scaffold design	65
2.47	MGSS conformal cooling channels	65
2.48	Various of VRCCC design	66
2.49	(a) Conformal cooling channel and (b) conventional cooling channels layout	67
3.1	Research methodology flowchart	75
3.2	Field emission scan electron microscope (FESEM, JSM-7600F)	78
3.3	Mastersizer 2000 laser diffraction particle size analyser	78
3.4	Schematic overview of a SLM Machine	79
3.5	Magics RP version 19.01 for part support structure and part orientation	81
3.6	Levelling of the re-coater using the clock gauge	82
3.7	SLM parameters range for density experiment measurement	83
3.8	Photographs of the SLM process in action: (a) a deposited powder layer, started for lasing; (b) lasing of cross sectional area of part(s); (c) the lasing finished, the build is lowered one layer thickness, deposition mechanism dispenses and levels powdered material for the next layer.	84
3.9	Archimedes Technique for part's density	87
3.10	Micro-hardness machine Shimadzu HMV-2T E	88
3.11	Gotech tensile testing machine	89
3.12	Testometric M500 compression testing machine	90

3.13 Olympus BX 60 Digital Optical Microscope	91
3.14 (a) Top and side surfaces for general characterisation of the microstructure; (b) (10x10x10) mm cube produced by SLM.	92
3.15 Bruker D8 Series 2 X-ray diffractometer (XRD) Theta/2Theta	92
3.16 Energy dispersive X-ray spectroscopy machine (JSM-638OLA)	93
3.17 Surface roughness measurement on the top, side and bottom feature	94
3.18 Benchmark model consist various features and variant sloping angle	95
3.19 Benchmark model consist various internal channel profile	96
3.20 Numerical control 3-D coordinate measuring machine	96
3.21 Submerge gating system for the front panel housing	98
3.22 Cooling channel design and meshing of the parts	99
3.23 The measurement location for (a) cavity main insert (b) core main insert	100
3.24 Surface roughness measurement of the core main insert after post processing by Perthometer PGK 120 equipment	101
3.25 The new design conformal cooling channels with square fin profile	102
3.26 The injection mould for front panel housing is assembled into the injection moulding machine.	103
3.27 Injection moulding machine, Sumitomo SH100A, 100 tonnage used for mould testing.	103
3.28 The injected part was placed on fixture to give a stable position during the measuring process using CMM	105
3.29 Measuring point on front panel housing to measure the shrinkage which leads the warpage in x and y direction.	105
3.30 Measuring point to determine the dimension at point 1, 2 and 3	106
3.31 Measuring point to determine the dimension at point 4, 5 and 6	106
3.32 Measurement of the moulded part thickness	107
4.1 Particle size distribution of as-received aluminium alloy powder	110

4.2	Field emission scan electron microscope (FESEM, JSM-7600F) micrograph of AlSi10Mg powder	111
4.3	EDS of the AlSi10Mg powder particles confirming elements	112
4.4	AlSi10Mg 10 x 10 x 10 mm ³ samples fabricated by SLM	113
4.5	Relative density with SLM parameters (Laser power, scan speed and Hatch distance) based on OFAT approach	115
4.6	The tensile and compression samples built by the SLM process	116
4.7	(a) Normal plot of residuals for Relative Density (b) Normal plot of residuals for UTS	120
4.8	(a) Predicted vs. actual for Relative Density (b) Predicted vs. actual for UTS	120
4.9	3D surface and contour plots density vs. laser power and scan speed	121
4.10	3D surface and contour plots density vs. laser power and hatch distance	122
4.11	3D surface and contour plots density vs. scan speed and hatch distance	122
4.12	3D surface and contour plots UTS vs. laser power and scan speed	123
4.13	3D surface and contour plots UTS vs. laser power and hatch distance	124
4.14	3D surface and contour plots UTS vs. scan speed and hatch distance	124
4.15	The positioning of the parts on SLM base	125
4.16	The porosity microstructure of the (a) side surface sample 5	127
4.17	Diamond shape of Vickers indentation a) Top surface, b) Wall surface.	128
4.18	Micro-hardness values of top surface for eight samples at nine indentation locations	129
4.19	Micro-hardness values of wall surface for eight samples at nine indentation locations	130

4.20	The stress-strain representation along x-z direction for AlSi10Mg samples	132
4.21	Tensile fracture surface which contained unmelted powder in pores	132
4.22	EDX data for Tensile fracture surface sample.	133
4.23	a) Compression sample under 100kN loading b) Compression samples before and after testing	134
4.24	The stress-strain representation for AlSi10Mg compression samples	135
4.25	Optical microscopy image of “fish scale” morphology at the side wall of the AlSi10Mg sample	136
4.26	Optical microscopy image of dissimilar laser beam pattern at the cross-sections of the top surface	137
4.27	SEM micrograph of the top surface of the AlSi10Mg samples by SLM	138
4.28	SEM micrograph of the side surface of the AlSi10Mg samples by SLM	138
4.29	SEM images of the (a) horizontal (XY plane) of AlSi10Mg samples fabricated by SLM	140
4.30	SEM image of the horizontal cross section of an SLM specimen encompassing the border between the laser scan tracks	141
4.31	XRD pattern for AlSi10Mg samples processed by SLM	142
4.32	The benchmark model and the down skin effect on the ellipse channel	143
4.33	(a) Ave. absolute linear error in X, (b) Ave. relative linear in X	150
4.34	(a) Ave. absolute linear error in Y, (b) Ave. relative linear in Y	150
4.35	(a) Ave. absolute linear error in Z, (b) Ave. relative linear in Z	150
4.36	(a) Ave. absolute radial error external diameter, (b) Ave. relative radial error external diameter	151
4.37	(a) Ave. absolute radial error internal diameter, (b) Ave. relative radial error internal diameter	152

4.38 (a) Benchmark model that was fabricated to evaluate the support structure for the internal channel profile during the SLM fabrication, (b) Overhang structure with 50° chamfer angle was successfully built without the support	153
4.39 a) Filling time for aluminium base. b) Total warpage for aluminium base.	155
5.1 PIM tool development procedures	159
5.2 Front panel switch casing	161
5.3 MGSS conformal cooling channels milled directly on the cavity insert a) cavity insert assembled with the O-ring, b) exploded view of the cavity insert	162
5.4 MGSS conformal cooling channels milled directly on the core insert a) core insert assembled with the O-ring, b) exploded view of the core insert	162
5.5 Software application on fabrication method selection	165
5.6 The design of the PIM tool inserts assembly	166
5.7 (a) Cooling profile of conformal cooling channel assembled on cavity insert (b) exploded view of cavity insert	166
5.8 (a) Cooling profile of conformal cooling channel assembled on core insert (b) exploded view of core insert	167
5.9 The new design conformal cooling channels with square fin profile	168
5.10 The time estimation that been automatic generated by the SLM machine software.	170
5.11 Sliced view of main cooling profile of SFCCC as analysed by Magics software (a) layer 275 (b) layer 308	171
5.12 The orientation and support structure in the magic 19.1 software	171
5.13 The cross-section of SFCCC fabrication by SLM	172
5.14 SLM fabricated core and cavity main insert	172
5.15 (a) SLM fabricated conformal cooling for core (b) SLM fabricated conformal cooling for cavity	173
5.16 Semi-finished cavity base insert	175
5.17 The assembly flow process for the new PIM tool inserts	177

5.18: Simulation result of the injection pressure and packing pressure for the new PIM tool inserts	178
5.19 Simulation result of the filling time for the new PIM tool inserts	179
5.20 Simulation result of the cooling time for the new PIM tool inserts	180
5.21 Simulation result of the clamping force for the new PIM tool inserts	180
5.22 Severely warpage and shrinkage formation on the moulded part for the cooling time of 5.5 seconds	183
5.23 Badly warpage and shrinkage formation on the moulded part for the cooling time of 6.0 seconds	184
5.24 Badly warpage and shrinkage formation at the gate location on the moulded part for the cooling time of 6.5 seconds	184
5.25 Slightly warpage and shrinkage formation at the gate location on the moulded part for the cooling time of 7.0 seconds	185
5.26 No warpage and shrinkage formation at the gate location on the moulded part for the cooling time of 7.5 seconds	185
5.27 Sprue bush mark on the core insert surface.	187
5.28 Comparison of additional moulding cost for rapid tooling aluminium mould with the square fin conformal cooling design with conventional steel mould	191



LIST OF SYMBOLS AND ABBREVIATIONS

2D		2 Dimensional
3D	-	3 Dimensional
AA6061	-	Aluminium 6061
ABS	-	Acrylonitrile Butadiene Styrene
Adeq. precision	-	Adequate precision
Adj. R^2	-	Adjusted R^2
AlSi10Mg	-	Aluminium Silicon Magnesium
AM	-	Additive manufacturing
ANOVA	-	Analysis of Variance
ASTM	-	American Society for Testing and Materials
C.V. %	-	Coefficient of variation
CAD	-	Computer aided design
CCD	-	Central composite design
CI	-	Chemically induced melting
CIAST	-	Centre for Instructor and Advance Skill Training
CNC	-	Computer Numerical Control
CO ₂	-	Carbon Dioxide
Cor. total	-	Totals of all information corrected for the mean

d.f.	-	Degrees of freedom
DMLS	-	Direct metal laser sintering
DOE	-	Design of experiment
EBM	-	Electron beam melting
EDM	-	Electrical discharge machining
EDS	-	Energy-dispersive spectroscopy
EDX	-	Energy dispersive X-ray
F	-	Force
FEM	-	Finite element method
FM	-	Full melting
HAZ	-	Heat affected zone
HPDC	-	High pressure die cast
HV	-	Hardness Vickers
LENS	-	Laser Engineered Net Shaped
LPS	-	Liquid Phase Sintering
MFI	-	Moldflow Insight
MGSS	-	Milled groove square shape
MSDS	-	Material Safety Data Sheets
OFAT	-	One Factor at a Time
OM	-	Optical Microscopy
PIM	-	Plastic Injection Moulding
Pred. R^2	-	Predicted R^2
PRESS	-	Predicted residual error sum of squares
POM	-	Precision Optical Manufacturing
R^2	-	Coefficient of determination
RD	-	Relative Density

RM	-	Rapid Manufacturing
RP	-	Rapid Prototyping
RSM	-	Response Surface Methodology
RT	-	Rapid Tooling
Std. Dev.	-	Square root of the residual mean square
STL	-	Stereolithography
SEM	-	Scan electron microscopy
SFCCC	-	Square fin conformal cooling channel
SLA	-	Stereo-lithography
SLM	-	Selective laser melting
SSS	-	Solid State Sintering
T	-	Temperature
t	-	Holding Time
Ti-6Al4V	-	Titanium 6% aluminium 4% vanadium
UniMap		University Malaysia Perlis
UTHM		Universiti Tun Hussein Onn Malaysia
UTS	-	Ultimate Tensile Strength
XRD	-	X-ray diffraction



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