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Additive manufacturing of polymers — Feedstock materials — Qualification of materials for laser-based powder bed fusion of parts

Fabrication additive de polymères — Matières premières — Qualification des matériaux pour la fusion laser de pièces sur lit de poudre

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ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11

Email: copyright@iso.org
Website: www.iso.org

ASTM International
100 Barr Harbor Drive, PO Box C700
West Conshohocken, PA 19428-2959, USA
Phone: +610 832 9634
Fax: +610 832 9635
Email: khooper@astm.org
Website: www.astm.org

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Foreword

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This document was prepared by ISO/TC 261, *Additive manufacturing*, in cooperation with ASTM Committee F42, *Additive Manufacturing Technologies*, on the basis of a partnership agreement between ISO and ASTM International with the aim to create a common set of ISO/ASTM standards on additive manufacturing, and in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 438, *Additive manufacturing,* in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

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Additive manufacturing of polymers — Feedstock materials — Qualification of materials for laser-based powder bed fusion of parts

1 Scope

This document provides guidance and recommendations for the qualification of polymeric materials intended for laser-based powder bed fusion of polymers (PBF-LB/P). The parameters and recommendations presented in this document relate mainly to the material polyamide 12 (PA12), but references are also made to polyamide 11 (PA11). The parameters and recommendations set forth herein cannot be applicable to other polymeric materials.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO/ASTM 52900, *Additive manufacturing — General principles — Fundamentals and vocabulary*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO/ASTM 52900, apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

4 Symbols and abbreviations

4.1 Symbols

The following symbols are used throughout this document:

Symbols	Designation	Unit
D_{V10}	10 % quantile of particle size based on the sample volume	µm
D_{V50}	50 % quantile of particle size based on the sample volume	µm
D_{V90}	90 % quantile of particle size based on the sample volume	µm
H_R	Hausner ratio	—
s_r	standard deviation of repeatability	—
s_R	standard deviation of reproducibility	—
T_B	processing temperature range	°C
T_{ic}	initial crystallisation temperature	°C
T_{im}	initial melting temperature	°C
V_∞	bulk volume	mL
V_0	tapped volume	mL

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