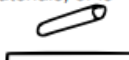
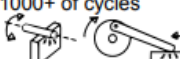

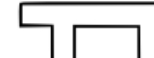
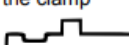
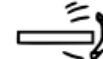

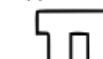
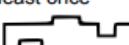
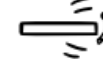



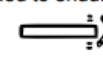
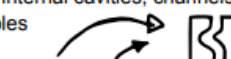
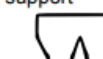
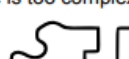


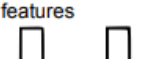


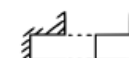
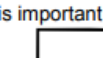
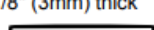

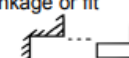
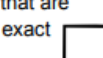
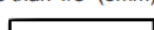

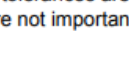
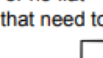


Design for Additive Manufacturing

A quick method for reducing the number of printing and prototyping failures, by Joran Booth
Instructions: Mark one for each category for the part you plan to print. Check daggers and stars first, then scores

Mark One	Complexity	Mark One	Functionality	Mark One	Material Removal	Mark One	Unsupported Features	Sum Across Rows	Totals
<input checked="" type="radio"/>	The part is the same shape as common stock materials, or is completely 2D 	<input checked="" type="radio"/>	Mating surfaces are bearing surfaces, or are expected to endure for 1000+ of cycles 	<input type="radio"/>	The part is smaller than or the same size as the required support structure 	<input type="radio"/>	There are long, unsupported features 	x5 =	5
<input checked="" type="radio"/>	The part is mostly 2D and can be made in a mill or lathe without repositioning it in the clamp 	<input checked="" type="radio"/>	Mating surfaces move significantly, experience large forces, or must endure 100-1000 cycles. 	<input type="radio"/>	There are small gaps that will require support structures 	<input type="radio"/>	There are short, unsupported features 	x4 =	4
<input type="radio"/>	The part can be made in a mill or lathe, but only after repositioning it in the clamp at least once 	<input type="radio"/>	Mating surfaces move somewhat, experience moderate forces, or are expected to last 10-100 cycles 	<input type="radio"/>	Internal cavities, channels, or holes do not have openings for removing materials 	<input type="radio"/>	Overhang features have a sloped support 	x3 =	0
<input type="radio"/>	The part curvature is complex (splines or arcs) for a machining operation such as a mill or lathe 	<input type="radio"/>	Mating surfaces will move minimally, experience low forces, or are intended to endure 2-10 cycles 	<input type="radio"/>	Material can be easily removed from internal cavities, channels, or holes 	<input type="radio"/>	Overhanging features have a minimum of 45deg support 	x2 =	0
<input type="radio"/>	There are interior features or surface curvature is too complex to be machined 	<input type="radio"/>	Surfaces are purely non-functional or experience virtually no cycles 	<input checked="" type="radio"/>	There are no internal cavities, channels, or holes 	<input checked="" type="radio"/>	Part is oriented so there are no overhanging features 	x1 =	2

Mark One	Thin Features	Mark One	Stress Concentration	Mark One	Tolerances	Mark One	Geometric Exactness	Sum Across Rows	Totals
<input type="radio"/>	Thin features will almost always break Some walls are less than 1/16" (1.5mm) thick 	<input type="radio"/>	Interior corners must transition gradually Interior corners have no chamfer, fillet, or rib 	<input type="radio"/>	Mating parts should not be the same size Hole or length dimensions are nominal 	<input checked="" type="radio"/>	The part has large, flat surfaces or has a form that is important to be exact 	x5 =	5
<input checked="" type="radio"/>	Walls are between 1/16" (1.5mm) and 1/8" (3mm) thick 	<input type="radio"/>	Interior corners have chamfers, fillets, and/or ribs 	<input checked="" type="radio"/>	Hole or length tolerances are adjusted for shrinkage or fit 	<input type="radio"/>	The part has medium-sized, flat surfaces, or forms that are should be close to exact 	x3 =	6
<input type="radio"/>	Walls are more than 1/8" (3mm) thick 	<input checked="" type="radio"/>	Interior corners have generous chamfers, fillets, and/or ribs 	<input type="radio"/>	Hole and length tolerances are considered or are not important 	<input type="radio"/>	The part has small or no flat surfaces, or forms that need to be exact 	x1 =	1

Starred Ratings	Total Score	Overall Total
<input checked="" type="radio"/> Consider a different manufacturing process	33-40 Needs redesign	23
<input checked="" type="radio"/> Strongly consider a different manufacturing process	24-32 Consider redesign	
	16-23 Moderate likelihood of success	
	8-15 Higher likelihood of success	

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