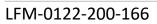
LFM-0122-200-166



ReportNumber: 01					L								ProjectNumber:													LFM-0122-200-166				
				FΝ	FM-0122-200-166								InquiryNumber:												_	LFM-0122-200-166.001				
				00-	0-01							DrawingNumber:												_	LFM-0122-200-166.idw					
· —				ur	urbine blade							Visual testing date:												_	04.05.2022					
													_					_									_			
				_								es	stii	ng		fo														
	standard		•		DIN EN 13018								Printing process:												-	FDM (metal)				
	nstructio	n:	-		internal								Order specifications:												-	Sintered (external)				
Test scope: 1				10	100%									Acceptance rule:												_	internal			
Test o	Test device: D				Digital vernier caliper								Testing aids:													Lamp, Camera, Lens				
Illumi	inance m	eter:		V	Voltcraft LX-10								L	.ux	m	eas	su	red	d:						_	455				
Meas	uring de	vice n	0.:	16	1662853																									
L													Т	es	st ı	es	ul	ts												
			-		Visual inspection - documentation according to DIN EN 1303										018				Evaluation 2)											
Exam a	rea	Target [mm]	Scope ¹⁾ / Actual [mm]	100	101	102	104	105	107	108	109	110	111	112	113	114	115	116	117	118	118-a	118-b	201	202	301	302	303	А	NA	Remark
					Ш		Ш		L					ari	t nr	оре	rti	05												
	Outer		ES100		П	Т	П	Т	T	Г				aii	l þi	ope	1 (1	E3	T											But further pro-
(1)	sphere		E3100			_		_										_											Х	cessing for paper But further pro-
(2)	Drilling		ES100																										Х	cessing for paper
(3)	Initial layer		ES100																										х	But further pro- cessing for paper
	Part dimensions																													
(D1)	Overall length																												х	
(D2)	Overall width																												х	
(D3)	Hole diameter																												х	
(D4)	Overall																												х	
Legend	heigth d:																													
	Exterio Suppor							2)		٠											ed									
Surface irregularities: 100 General 101 Rough surface 102 Blobs on surface				107 Layer delamination 108 Curling 109 Warping								114 Bad corners 115 Bad overhangs 116 Waves on surfaces												2	Infill irregularities: 201 False infill 202 Defect infill					
103 Over extrusion				110 Overheating							117 z-seam on surfaces													Other irregularities:						
104 Under extrusion 105 Gaps in Walls				111 Layershifting 112 Bad support structures								118 Dimensional issue 118-a Undersize													301 Clogged extruder 302 Broken filament					
106 Stringing				113 Missing support							118-b Oversize													303 No print bed adhesion						
	Appendix XYES / NO (Description/Pages)				General test instructions, acceptance rule, part properties/ 3 pages																									
Remarks:				 Parts were safely packed Part completely broke apart during sintering. 																										

Further processing of defective parts for validation of the documentation process





	Checked		Rated	Customer release (if requested)				
Name:	Inspector #1	Name:	Production manager	Name:				
Test location:	Test area							
Date:	04.05.2022	Date:	04.05.2022	Date:				
Signature:	XXX	Signature:	XXX	Signature:				

Doc.-No.: DO-06 Rev.-No.: 0 Page 2 of 4

LFM-0122-200-166



Appendix

Acceptance rule	 For this reason, only internal evaluation standards can be used. The acceptance of the examinations here is based on the individual assessment of the examiner. Part images for final quality control						
Acceptance rule	,						
Test instruction	 The assessment and evaluation must be carried out by experienced and trained personnel. Visual inspection after receiving the part from the sintering service provider. 						

LFM-0122-200-166



View under test conditions	
View of the defects	
(if occurred)	