FROM CONCEPT TO COMPONENT

Additive Manufacturing
The next dimension in HPDC tooling

voestalpine Additive Manufacturing
www.voestalpine.com/additive
ADDITIVE MANUFACTURING  
THE NEXT DIMENSION IN HPDC TOOLING

For decades we have been recognised as a global leader in the manufacture and the supply of tool steel, as a result we understand the challenges that our customers face in the high-pressure die casting industry. Customer intimacy and technical understanding is a major factor when developing successful solutions with our partners.

Our attention to detail goes far beyond the design of the tool. Our additive manufacturing experts develop printing parameters specifically optimized to suit our range of high performance HPDC materials, giving our customers unique solutions with superior results.

Unique tools require unique solutions. Working together with our customers, using our state-of-the-art additive manufacturing and materials knowledge, we develop tailor-made AM solutions optimized specifically for high-pressure die casting.

Your trusted AM partner

OPTIMIZED DESIGN

AM expertise paired with extensive HPDC know-how ensures we deliver the best possible tooling solutions to our customers. We support our customers through a detailed consultation process to develop the right solution for the right application, using state-of-the-art tools to support the manufacturing process from initial concept to functional parts. Where needed our HPDC experts can help our customers re-design tools according to the exact requirements of their application.

Our data driven approach to cooling channel design analyses processing parameters and mechanical loads to develop detailed computer models and process simulations. This method of optimising thermal management is essential to ensure the right balance between efficient cooling and the mechanical performance of the tool.

This process goes far beyond regular conformal cooling channel design. We understand HPDC.
We ensure the highest possible quality, reliability and consistency by managing every step of the value chain from powder production to the delivery of the finished part. Whether for a single part order or series production, our internal quality systems ensure we meet your requirements every time. We use state-of-the-art tools to continually improve and refine our internal printing processes. Design of Experiments, Statistical Process Control, and Process Monitoring form the basis of our methodology. Continued innovation from our AM and materials groups ensures we deliver superior material properties in the most demanding applications. As a result, our customers can put parts into service with the highest degree of confidence.

We understand the interactions between laser and material. This deep understanding of AM and HPDC allows customers to add value to their business and realise competitive advantage.
**OPTIMIZED POWDER**

**BÖHLER W360 AMPO**

Our long history of developing materials for the HPDC industry, means the powders we use are of the highest quality and deliver superior tool life. BÖHLER W360 AMPO is our premium grade for HPDC applications. This proprietary grade has been designed to outperform many traditional tool steels such as 1.2709 (Maraging 300), 1.2343 ESR (H11) and 1.2344 ESR (H13).

**IN SHORT**
- High temper back and hot wear resistance
- Recommended hardness in use 48 - 56 HRC
- High toughness
- Designed for high demanding tooling applications like HPDC and reinforced plastics

**CHEMICAL COMPOSITION**

<table>
<thead>
<tr>
<th>Elements¹</th>
<th>C</th>
<th>Si</th>
<th>Mn</th>
<th>Cr</th>
<th>Mo</th>
<th>V</th>
<th>Fe</th>
</tr>
</thead>
<tbody>
<tr>
<td>[wt.%]</td>
<td>0.50</td>
<td>0.20</td>
<td>0.25</td>
<td>4.50</td>
<td>3.00</td>
<td>0.55</td>
<td>Bal.</td>
</tr>
</tbody>
</table>

**MECHANICAL PROPERTIES**

Based on our own optimized printing parameters we can ensure superior mechanical properties of the printed parts:

<table>
<thead>
<tr>
<th>Properties²</th>
<th>Tensile strength³ [MPa]</th>
<th>Yield strength³ [MPa]</th>
<th>Elongation at break³ [%]</th>
<th>Notch impact energy⁴ [J]</th>
</tr>
</thead>
<tbody>
<tr>
<td>48-50 HRC⁵</td>
<td>1500 - 1650</td>
<td>1200 - 1400</td>
<td>5.5 - 8%</td>
<td>15 - 20</td>
</tr>
<tr>
<td>54-56 HRC⁵</td>
<td>2000 - 2100</td>
<td>1600 - 1800</td>
<td>4 - 6%</td>
<td>10 - 12</td>
</tr>
</tbody>
</table>

**COMPARISON WITH TYPICAL FORGED HOT WORK TOOL STEELS**

<table>
<thead>
<tr>
<th>Material</th>
<th>Hot temp. toughness</th>
<th>Hot temp. wear resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.2343</td>
<td>★★★★★</td>
<td>★ ★</td>
</tr>
<tr>
<td>1.2344</td>
<td>★★★★</td>
<td>★★★★</td>
</tr>
<tr>
<td>1.2709</td>
<td>★★★★</td>
<td>★★</td>
</tr>
<tr>
<td>BÖHLER W360 AMPO</td>
<td>★★★★</td>
<td>★★★★</td>
</tr>
</tbody>
</table>

**PROCESS DATA**

| Build chamber size | 243 x 243 x 270 mm³ |

**IN SHORT**

- High temper back and hot wear resistance
- Recommended hardness in use 48 - 56 HRC
- High toughness
- Designed for high demanding tooling applications like HPDC and reinforced plastics

1. BÖHLER W360 AMPO is a brand of voestalpine Böhler Edelstahl GmbH & Co KG. The chemical composition & processing is protected by registered intellectual property rights.
2. All mechanical properties measured were from specimens with a relative density ~99.9%.
3. Tensile test performed according to method DIN EN ISO 6892-1B, specified by VDI 3405 Part 2 at room temperature, the specimens were built according to DIN EN ISO 50125.
4. Charpy V-notch test according to DIN EN ISO 148-1 at 20°C.
5. Hardness test performed according to DIN EN ISO 6506-1.

*The Austrian Foundry Research Institute (ÖGI Austria) is accredited as a testing laboratory in accordance with the Austrian Accreditation Law.*
OPTIMIZED POWDER

We tested the bulk samples of the materials and compared them to the 3D printed BÖHLER W360 AMPO using following testing criteria:

- Thermo-Chemical Resistance (diving / stirring test)
- Crack Resistance
- Heat Checking Resistance

All results compared to the reference values of 1.2343 ESR / H11 bulk material (red line on each graph).

THERMO-CHEMICAL RESISTANCE

<table>
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<tr>
<th></th>
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</tr>
</thead>
<tbody>
<tr>
<td>Thermo-chemical resistance</td>
<td>12343 ESR BULK (44-46 HRC)</td>
<td>12343 ESR BULK (44-46 HRC)</td>
<td>W360 BULK (54-56 HRC)</td>
<td>W360 AMPO (54-56 HRC)</td>
</tr>
</tbody>
</table>

BÖHLER W360 AMPO displays exceptional performance when compared with traditional tool steels.
TAILORMADE SOLUTIONS

OPTIMIZED DESIGN. OPTIMIZED PRINTING. OPTIMIZED POWDER. OPTIMIZED FOR YOU.

Our three-pillared approach to additive manufacturing has shown to deliver significant performance improvements to our HPDC customers across a range of applications, such as sliders, sub-inserts, sprues, and distributors (and distributor rings).

**SLIDER**

Application: clutch housing

» Scrap rate reduction
» Life time improvement

Performance compared to conventional cooled slider:

Life time: >600%

**Application: gear box**

» Scrap rate reduction
» Life time improvement

Performance compared to conventional cooled slider:

Scrap rate reduction: -10%

**DISTRIBUTOR**

Application: aluminium HPDC

» Cycle time reduction
» Life time improvement

Performance compared to conventional cooled distributor:

Cycle time: -3 sec
Life time: >150%

Application: aluminium HPDC

» Cycle time reduction
» Life time improvement

Performance compared to conventional cooled distributor:

Cycle time: -2.5 sec
Life time: >200%
TAILORMADE SOLUTIONS

OPTIMIZED DESIGN.
OPTIMIZED PRINTING.
OPTIMIZED POWDER.
OPTIMIZED FOR YOU.

SUB-INSERT

Application: pump housing
» Scrap rate reduction
» Life time improvement
Performance compared to conventional cooled sub-insert:
Life time: >350%

Application: differential housing
» Scrap rate reduction
» Life time improvement
Performance compared to conventional cooled sub-insert:
Scrap rate reduction from 20% to 6%

FROM CONCEPT TO COMPONENT

As a global steel and technology leader, we offer the full suite of production techniques and services throughout the value chain, supporting and driving innovation and development based on lengthy experience around materials and processing. Starting from the alloy development and metal powder production, to design and manufacturing and including post-processing. We offer the end-to-end solutions to reduce waste and mitigate risk in the supply chain with the goal of being your trusted and reliable business partner. We deliver tailormade solutions from concept to component.