PROBLEM
Additive Manufacturing is an emerging technology, but despite the obvious benefits when adopting AM, a knowledge gap remains across the tooling industry. We have identified three common problems tool designers face when looking to adopt Additive Manufacturing for the first time:

» Designers may apply conventional or traditional design rules to conformal cooling designs.

» Designers may not have a clear understanding of the applicable design rules they should follow when designing for AM.

» Designers may not be aware of the mechanical loads and the potential negative impacts they may have on the tool.

SOLUTION
As a solutions provider to the High Pressure Die Casting industry, we work closely with our customers to optimise tooling specifically for their production processes. If our customer has an existing production issue, our HPDC experts can perform failure analysis on the tool to determine the root cause. We put all of our know how into design, materials and printing to deliver maximum performance.

SUMMARY
While many HPDC failure modes such as Soldering, Heat-Checking, and Erosion can be prevented by selecting a premium material such as BOHLER W360 AMPO, crack initiation often starts in areas with the highest mechanical stress loads. Only the right design, combined with the right material can deliver superior tool performance.
Case 1: Part failed because of cracks

Failure analysis
Crack starts inside the cooling channel and insert failed due to high stress concentration.

Stress analysis
Thermo-mechanical stresses

Solution
Redesign - Stress was reduced by over 50%.

Results
Conventional Tool 1.2343: 20,000 shots
AM design competitor: 3,000 shots
voestalpine AM design: 60,000 shots

Conclusion: Stress concentration exactly where the crack started.

Case 2: Part failed because of soldering and cracks which leads to a leakage in cooling system

Previous design
New design

Results
The original design didn’t minimize the stress level. Therefore the crack started from the area in the cooling channel with high stresses. Via redesign of the channels the stress could be significantly be reduced and the cooling even improved.

Case 3: Part failed because of cracks

Failure analysis
Cracks initiated from the cooling channels lead to leakage and to part failure. Stress analysis showed the highest thermo-mechanical stresses exactly in the area where the crack started.

Results
Adjusted redesign to reduce the maximum stress by 20% while keeping the cycle time and cooling rate.

voestalpine High Performance Metals Australia
282 – 290 Greens Road, Dandenong, Victoria, 3175, Australia.
+61 3 9767 5554
melbourne.sales.hpm-australia@voestalpine.com
www.voestalpine.com/hpm/australia/en/am

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