

EXPLORING THE 3D PRINTING OF METAL VACUUM SEALS

ARTICLE TYPE

RESEARCH ARTICLE
This article reports on a research project that explored the possibilities of 3D printing of metal vacuum seals. The project was funded by the European Union's Horizon 2020 research and innovation programme under the Marie Skłodowska Curie grant agreement. The project was part of the 3D printing challenge of the 2021-2022 research and innovation programme.

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3D printing has been on the rise for some time now. Starting from plastic prototyping and our first steps in functional brass and copper we now can print, with industry experts continuously learning about how to optimize materials, machines, processes and procedures. The 3D printing of metal products for high-tech industrial applications remains quite the challenge however, with very demanding specifications in terms of accuracy, tolerances, surface finish, strength, etc. KMWI SCF joined forces with Settel's Savenja to build up experience in the 3D-printing of metal vacuum seals.

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Research scope

The KMWI SCF business unit is researching the additive manufacturing, primarily focused on 3D printing, of metal structures and machine tool in collaboration with eight partners in the additive consortium. Initial idea for the 3D printing pilot factory for the production of industrial metal parts in stainless steel, and it is clear that KMWI works on manufacturing for design, parameter optimization, support strategy, material research and comparison with existing technologies in order to deliver additively manufactured parts.

The Research & Innovation team of Settel's Savenja development department took part in additive design challenge 2021 with a well-working vacuum seal designed for reducing construction space in high-tech vacuum systems for vacuum-related and process industries.

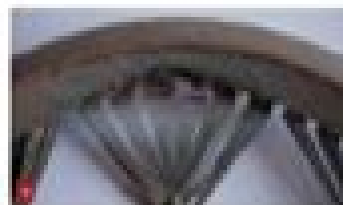
After meeting during the design challenge finale, KMWI SCF and Settel's started working together to bring this design to reality. KMWI is eager to learn about printing industrial products in stainless steel and titanium, while Settel is exploring the opportunities to meet a new standard for vacuum seals.

To kick off the research, a pilot job was built using the original seal design, printed in an upright position and

supported by an added handle. The position was chosen to minimize the total amount of supports and material required, including the machining effort for



1. First test printed in stainless steel, supported by an added handle. The position was chosen to minimize the total amount of supports and material required, including the machining effort for



removing the structure in an added handle. Figure 1 shows the angle and on the picture after the 3D printing process the limited and most of the printing powder has been removed.

The prototype made during the first pilot job demonstrates the difficulty of printing the design and the need manufacturing because of the choice of support structure for Figure 1. The following observations can be made: a full structure support leads to: cleaning powder remaining in the structure. It is a lot of post-processing time needed to remove structure and clean up the part.

A new approach leads to: it is rough surface finish because of the absence of support structure. Two new methods 1 in Figure 2 or support structure that are too fragile for new method 1 in Figure 2. A low thermal conductivity in these areas near the surface is needed.

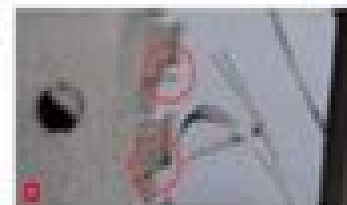
Partners: KMWI and Settel's Savenja

KMWI is a leading vacuum technology manufacturer, operating in metal vacuum systems and parts for the high-tech applications: laboratory, semiconductor, medical. The company operates in high-tech, low volume, high complexity manufacturing, it designs and delivers a wide range of complex, customised industrial components, average quality standards, competitive cost factors, customer and delivery to meet the demands of customers in the medical, semiconductor, process and industrial automation sectors.

Settel's Savenja is a group of companies that provides high-tech manufacturing with expertise for people. The group handles design, manufacturing, assembly and sales of high-tech products, machines, tools and equipment. Their international customer base like shipping, semiconductor, medical, aerospace and other markets.

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2. The handle is made of stainless steel and is supported by a handle. The position was chosen to minimize the total amount of supports and material required, including the machining effort for



it might be made in the new structure which has automatically supported for Figure 3.

Examples of support structure

The vacuum seal design was optimized for 3D printing using the lessons learned from the first pilot job. The following principles were applied for this new design:

1. The product is placed at an angle of 1° off the vertical (upright) orientation with respect to the horizontal to avoid having to use vertical supports.
2. Additions are incorporated into the support structure, so the structure can be removed easily.
3. The support structure changed from one support to another support, so there can be removed more easily (post processing). Changing from a closed to an open support structure means less material is needed.



3. One of the second pilot job with a handle support structure and a support structure.

During the same with the seal design, it was decided to also optimize for seal design built for printing. When a hole is required, most mechanical engineers will choose automatically choose a circular shape, as this can be easily made by machining on a lathe or a milling machine. Different rules apply for 3D printing however: a vertical printed circular hole requires a support structure, while a square hole does not. In such a square hole is cheaper and easier to make using 3D printing than conventional machining. Other constraints were made by reducing the amount of features, while still applying the Savenja logo.

Parker Vacuum Seal Design Guide

Puja Mehta



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