

## Table of Contents

Page

1	Introduction .....	1
1.1	Motivation and Ambition .....	2
2	Basics of Additive Manufacturing .....	8
2.1	Additive Manufacturing Process .....	11
2.2	Selective Laser Melting Process .....	13
2.3	Capabilities of Selective Laser Melted Parts .....	16
2.4	Limitations of Selective Laser Melting .....	17
3	State of the Art Cost Efficient Design with Additive Manufacturing .....	21
3.1	General Aspects for Cost Efficient Design in AM .....	23
3.2	Additive Manufacturing – Cost models .....	24
3.2.1	Cost Model from Hopkins and Dickens .....	26
3.2.2	Cost model from Ruffo, Tuck and Hague .....	30
3.2.3	Cost Model from Gibson, Rosen and Stucker .....	33
3.2.4	Further Cost Models .....	34
3.2.5	Cost Models for AM - Summary .....	35
3.3	Additive Manufacturing - Build Time Estimation .....	37
3.3.1	Build Time estimation - Manufacturing Preparation Software.....	39
3.3.2	Build Time Estimation - Build Volume .....	40
3.3.3	Build Time Estimation – According to Merlus and Reeves .....	41
3.3.4	Build Time Estimation – According to Baumers .....	42
3.3.5	Build Time Estimation - According to Ruffo, Tuck und Hague.....	43
3.3.6	Build Time Estimation - According to Gibson, Rosen and Stucker .....	44
3.3.7	Build Time Estimation - Summary .....	45
3.4	Additive Manufacturing – Methodology for Selecting Parts .....	46
3.5	Methodological Design in Product Development .....	50
3.6	Cost Accounting .....	52
3.6.1	Activity Based Costing .....	53
3.6.2	Foundations of the Lifecycle Costing .....	55
3.6.3	Lifecycle Costing according to VDI 2884.....	58
3.6.4	Lifecycle Costing according to DIN 60300-3-3 .....	58
3.6.5	Summary – Cost Accounting.....	60
3.7	Cost Efficient Design and AM - Need for Action .....	62
4	Cost Calculation Framework Development for Cost Efficient Design and Planning .....	68
4.1	Development of a Methodology to estimate Production Costs .....	68

4.1.1	Cost Centre - Build Preparation .....	72
4.1.2	Cost Centre - Production.....	74
4.1.3	Cost Centre - Post Processing.....	79
4.1.4	Cost Centre - Product Finishing .....	80
4.1.5	Cost Centre - Quality Management.....	82
4.1.6	Exemplary Application of the Model .....	85
4.2	Build Time Estimation and Manufacturing Speed Curves.....	88
4.2.1	Manufacturing Speed – Terms, Definitions and Influences .....	88
4.2.2	Development of a Standard to Measure Manufacturing Speeds .....	95
4.2.3	Build Time Prediction – Experimental approach.....	104
4.2.4	Build Platform for comparison of Manufacturing Speeds.....	107
4.2.5	Application of the Method and Comparison of Technologies .....	109
4.2.6	Build Time Estimation with an Analytical Approach.....	118
4.2.7	Documentation of Machine Capabilities .....	120
4.3	Approach for estimating Lifecycle Costs.....	122
4.4	Scenario based Lifecycle Costing and Application Example .....	127
5	Cost Efficient Design and Planning Process – Discussion of Tools .....	133
5.1	Producing parts with Additive Manufacturing? – Strategic Tools .....	134
5.2	Customer Satisfaction and AM .....	136
5.3	Future AM Part Cost estimation .....	137
5.4	Product Requirements, Documentation and Black Box Design .....	141
5.5	Creativity Techniques – Unlocking the potential of AM.....	146
5.6	Methodology for Selecting Parts and Applications for AM .....	149
5.7	Knowledge Management – Catalogue for Cost Efficient AM Design .....	158
6	Framework Enabling a Cost Efficient Design Process .....	164
6.1	Composition of a basic Framework to enable Cost Efficient Design.....	164
6.2	Application Example – Framework for Cost Efficient Design .....	172
6.3	Discussion on Requirements Fulfilment .....	177
7	Summary and Outlook .....	180
8	References .....	185
9	Appendix.....	195