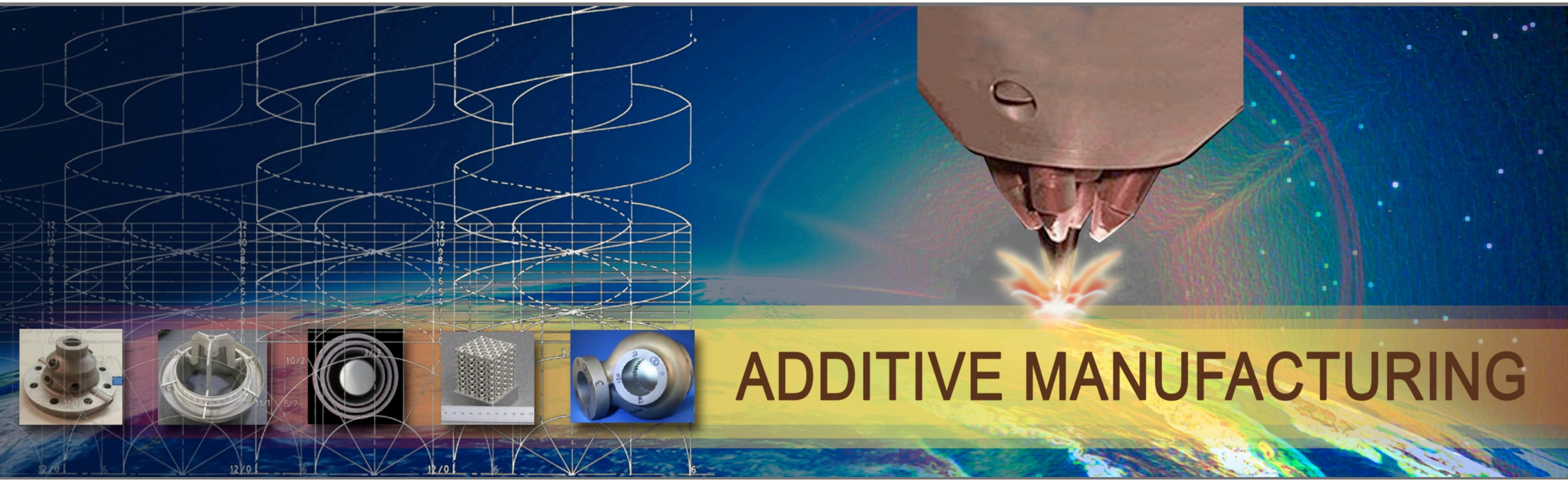
National Aeronautics and Space Administration



American Institute of Engineers Symposium on 3D Printing and Additive Manufacturing for Defense and Government • October 21-22, 2014

NASA Perspective and Initiatives in Additive Manufacturing

R. G. Clinton, Jr.
Deputy Manager, Science & Technology Office
Marshall Space Flight Center

Agenda

- NASA Headquarters Structure and Sponsorship
- Aeronautics Applications
- “FOR Space” Additive Manufacturing
- “IN Space” Additive Manufacturing
  - National Research Council Committee on Space-Based Additive Manufacturing (COSBAM) Report Synopsis
  - Initiatives
- Cross-Cutting Activities
- Summary

Science & Technology Office

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Marshall Space Flight Center – Frank Ledbetter, Kristin Morgan, Niki Werkheiser, Janet Salverson

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University of Southern California – Berok Khoshnevis

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NASA Structure Related to Additive Manufacturing

Administrator
Deputy Administrator
Associate Administrator

- Chief of Staff
- Associate Deputy Administrator
- Associate Deputy Administrator for Strategy and Policy
- Assistant Associate Administrator

- Office of Safety and Mission Assurance (OSMA)
- Aeronautics Research Mission Directorate
- Science Mission Directorate
- Human Exploration and Operations Mission Directorate
  - Exploration Systems Development Division
  - International Space Station Division
  - Advanced Exploration Systems Division
- Space Technology Mission Directorate
  - Game Changing Development
  - Flight Opportunities
  - SBIR/STTR
  - NIAC/CIF

Centers:

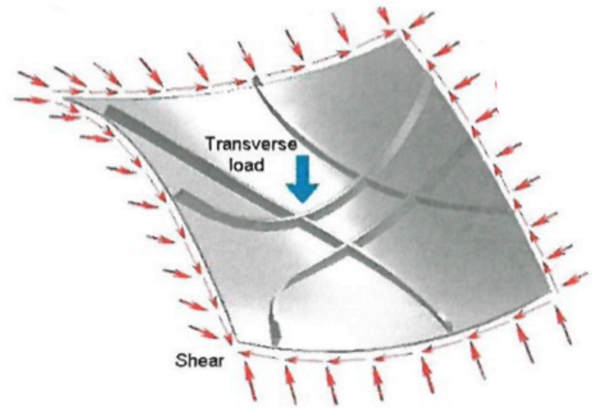
- Ames Research Center
- Johnson Space Center
- Armstrong Flight Research Center
- Kennedy Space Center
- Glenn Research Center
- Langley Research Center
- Goddard Space Flight Center
- Marshall Space Flight Center
- Jet Propulsion Laboratory
- Stennis Space Center

Science & Technology Office

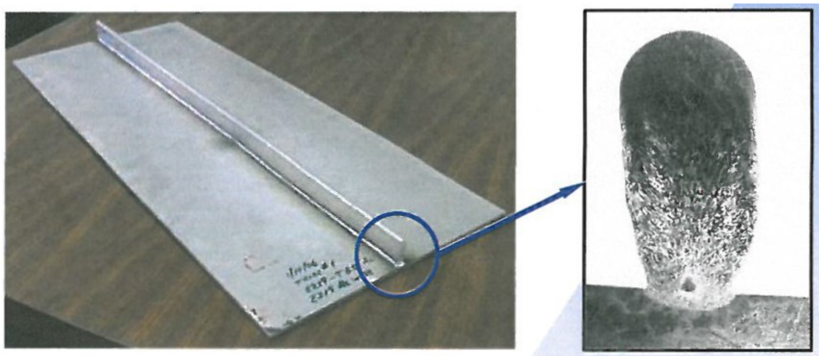
Aeronautics Applications

AM for Aeronautics at Langley Research Center: Structures

- Engineered materials coupled with tailored structural design enable reduced weight and improved performance for future aircraft fuselage and wing structures
- Multi-objective optimization:
  - Structural load path
  - Acoustic transmission
  - Durability and damage tolerance
  - Minimum weight
  - Materials functionally graded to satisfy local design constraints
- Additive manufacturing using new alloys enables unitized structure with functionally graded, curved stiffeners
- Weight reduction by combined tailoring structural design and designer materials



Design optimization tools integrate curvilinear stiffener and functionally graded elements into structural design



High toughness alloy at stiffener base for damage tolerance, transitioning to metal matrix composite for increased stiffness and acoustic damping

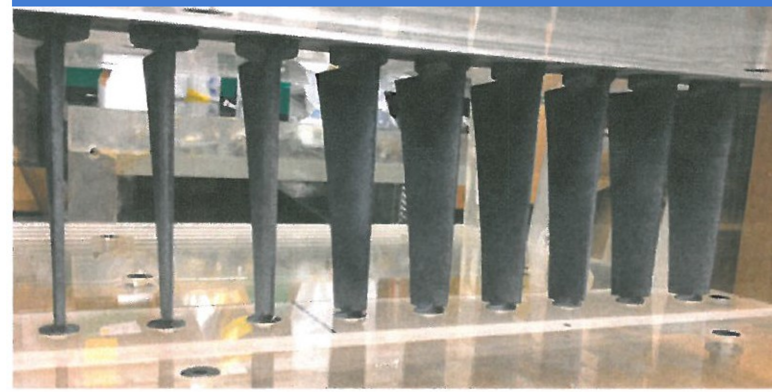
POC: Karen.M.Taminger@nasa.gov

AM for Aeronautics at Glenn Research Center: Propulsion

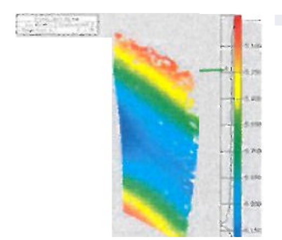
- Objective: Conduct the first comprehensive evaluation of emerging materials and manufacturing technologies that will enable fully non-metallic gas turbine engines.
- Assess the feasibility of using additive manufacturing technologies to fabricate gas turbine engine components from polymer and Ceramic matrix composites.
  - Fabricate prototype components and test in engine operating conditions
- Conduct engine system studies to estimate the benefits of a fully non-metallic gas turbine engine design in terms of reduced emissions, fuel burn and cost
- Focusing on high temperature and fiber reinforced polymer composites fabricated using FDM, and fundamental development of high temperature ceramics / CMC's using binder jet process

NASA GRC POC: Joseph Grady

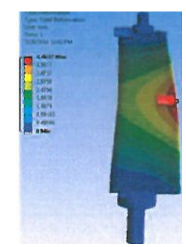
A Fully Non-Metallic Gas Turbine Engine Enabled by Additive Manufacturing



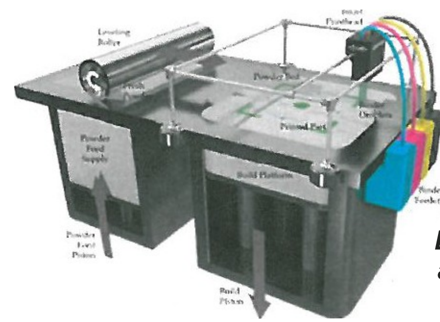
Polymer Vane Configuration in Cascade wind tunnel Rig



Digital Image CorrelationMeasurements



Finite Element Analysis

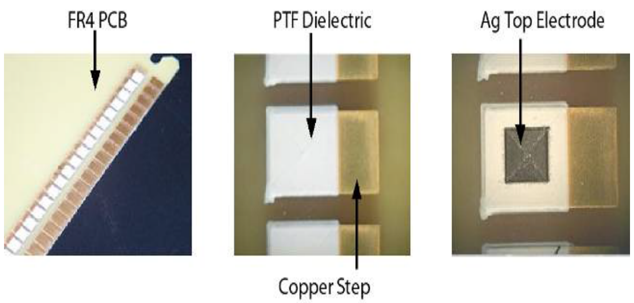


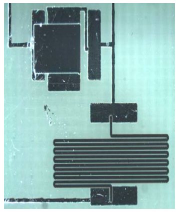
Binder jet process was adapted for SiC fabrication

“FOR Space” Additive Manufacturing

FOR Space: Spacecraft Electronics, Sensors and Coatings – Goddard Space Flight Center

- Aerosol jet printing of various circuit building blocks: crossovers, resistors, capacitors, chip attachments, EMI shielding.



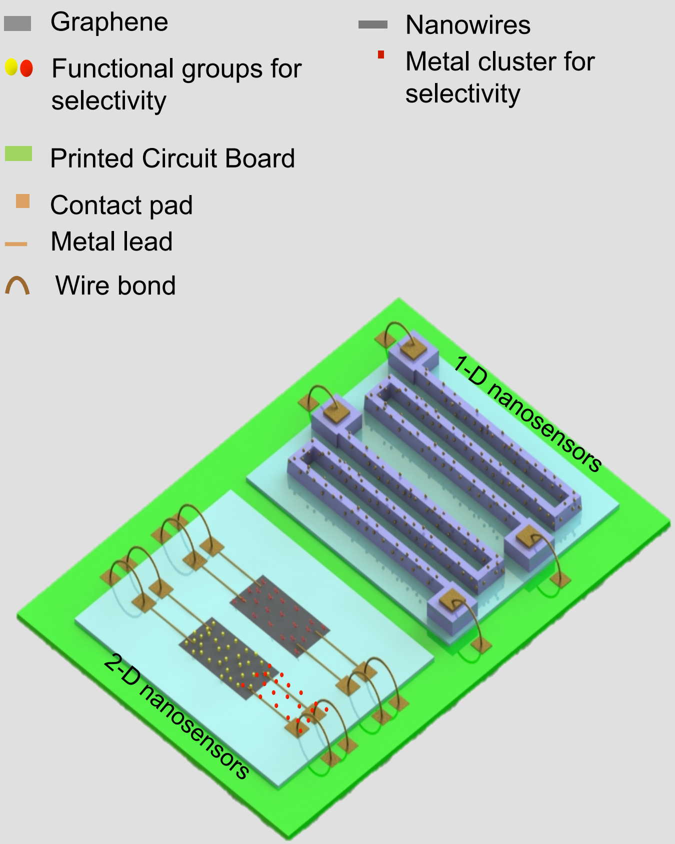


Printed RC filter

Multi-layer deposition, Polyimide dielectric and Ag deposited onto Cu pads to make a simple capacitor

- Nanosensors printed directly on a daughter board for chemical detection
- Super-black nanotechnology coating: Enable Spacecraft instruments to be more sensitive without enlarging their size. Demonstrated growth of a uniform layer of carbon nanotubes through the use of Atomic Layer Deposition.

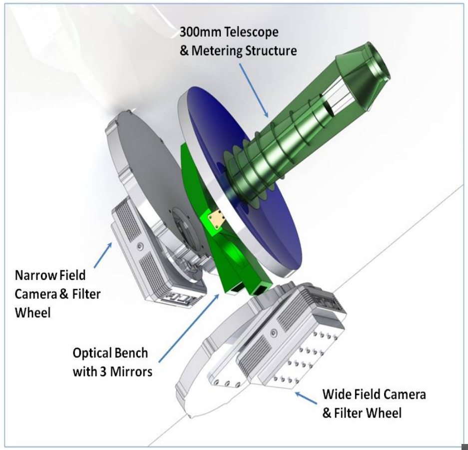
Printed Nanosensor



FOR Space: Spacecraft Instruments and Components – Goddard Space Flight Center

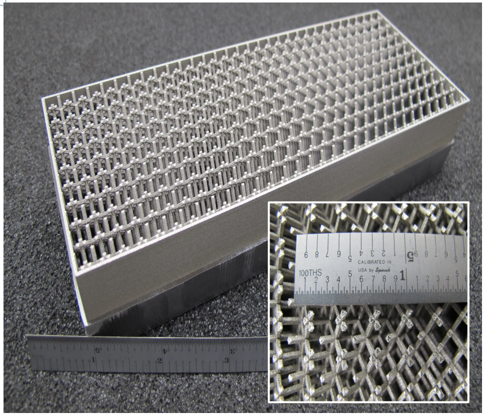
- GSFC's first Additive Manufacturing (AM) part for instrument prototype/possible flight use (FY12) - Titanium tube - in a tube – in a tube for cryo thermal switch for ASTRO-H
- First to fly AM component in space (FY13) – battery case on suborbital sounding rocket mission
- Miniaturizing telescopes: Utilize new Direct Metal Laser Sintering (DMLS) to produce <u>dimensionally stable</u> integrated instrument structures at lower cost
- Unitary core-and-face-sheet optical bench material
  - Features tailored alloy composition to achieve desired coefficient of thermal expansion
- Efficient radiation shielding through Direct Metal Laser Sintering:
  - Develop a method for mitigating risk due to total ionizing dose (TID) using direct metal laser sintering (DMLS) and the commercially-available Monte-Carlo particle transport code, NOVICE to enable otherwise difficult to fabricate component-level shielding

Battery Case

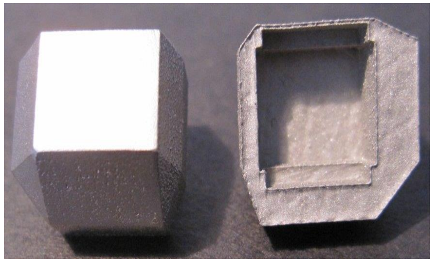


0.3m Telescope via DMLS

CubeSat-class 50-mm (2") imaging camera/instrument - mirrors and integrated optical-mechanical structures- manufacturing with 3D-printed parts



Optical bench core material sample



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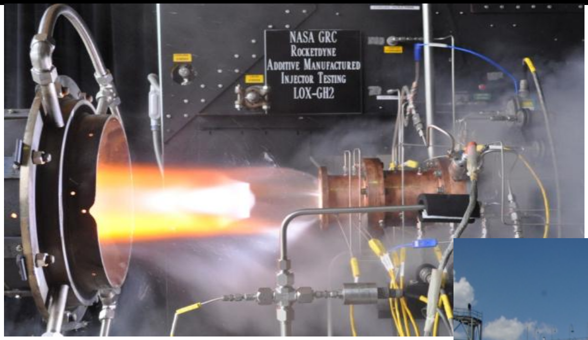
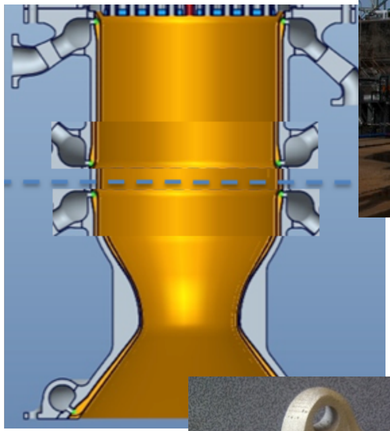
FOR Space Applications: Rocket Propulsion

- GRC and Aerojet Rocketdyne tested an additively manufactured injector in 2013 under the Manufacturing Innovation Project (MIP)
- MSFC successfully tested two complex injectors printed with additive manufacturing August 2014
- GRC, LaRC, and MSFC Team building on success of MIP program to develop and hot fire test additively manufactured thrust chamber assembly
  - Copper combustion chamber and nozzle produced via Selective Laser Melting (SLM)
  - Grade from copper to nickel for structural jacket and manifolds via EBF^3
- RL10 Additive Manufacturing Study (RAMS) task order between GRC and Aerojet-Rocketdyne sponsored by USAF.
  - Related activity - Generate materials characterization database on additively manufactured (AM) Ti-6Al-4V to facilitate the design and implementation of an AM gimbal cone for the RL10 rocket engine.
- GRC, AFRL, MSFC Additive Manufacturing of Hybrid Turbomachinery Disk:



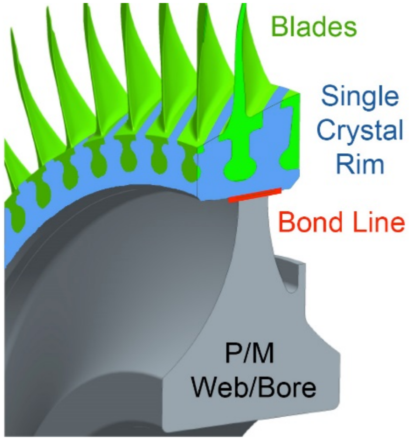
GRC and Aerojet Rocketdyne test

MSFC AM engine test



CAD sketch of rocket nozzle

Full Scale from ORNL



Hybrid Disk Concept

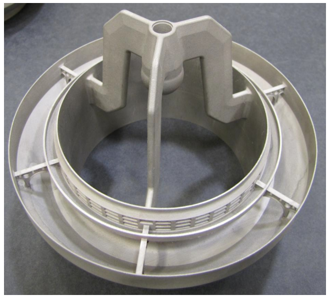
FOR Space Applications: Rocket Propulsion (concluded)

- Powder Bed Fusion (PBF) technologies enable rapid manufacturing of complex, high-value propulsion components.
- Flexibility inherent in the AM technologies increases design freedom; enables complex geometries. Designers can explore lightweight structures; integrate functionality; customize parts to specific applications and environments.
- Goal: reduce part count, welds, machining operations → reduce $ and time

J-2X Gas Generator Duct

Pogo Z-Baffle

Turbopump Inducer



RS-25 Flex Joint

Part	Cost Savings	Time Savings
J-2X Gas Generator Duct	70%	50%
Pogo Z-Baffle	64%	75%
Turbopump Inducer	50%	80%

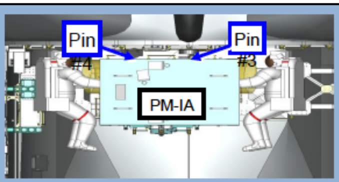
RS-25 Flex Joint	Heritage Design	SLM Design
Part Count	45	17
# Welds	70+	26
Machining Operations	~147	~57

FOR Space Applications: Environmental Control and Life Support Systems and ISS Tools

- AM techniques can create extremely fine internal geometries that are difficult to achieve with subtractive manufacturing methods.

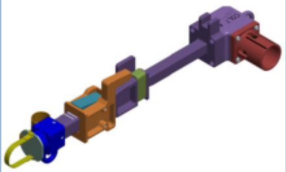
ISS Urine Processor Assembly

Air Filter/ Scrubbers

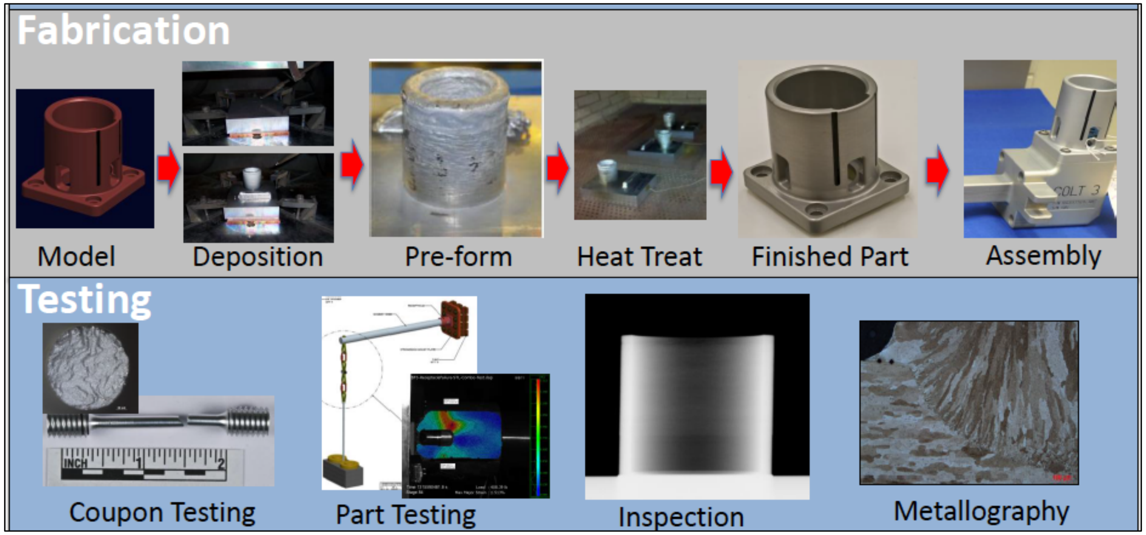


STS-135 Pump Module Return

ISS EVA Tool Fabrication & Certification Demo



COLT EVA Contingency Tool

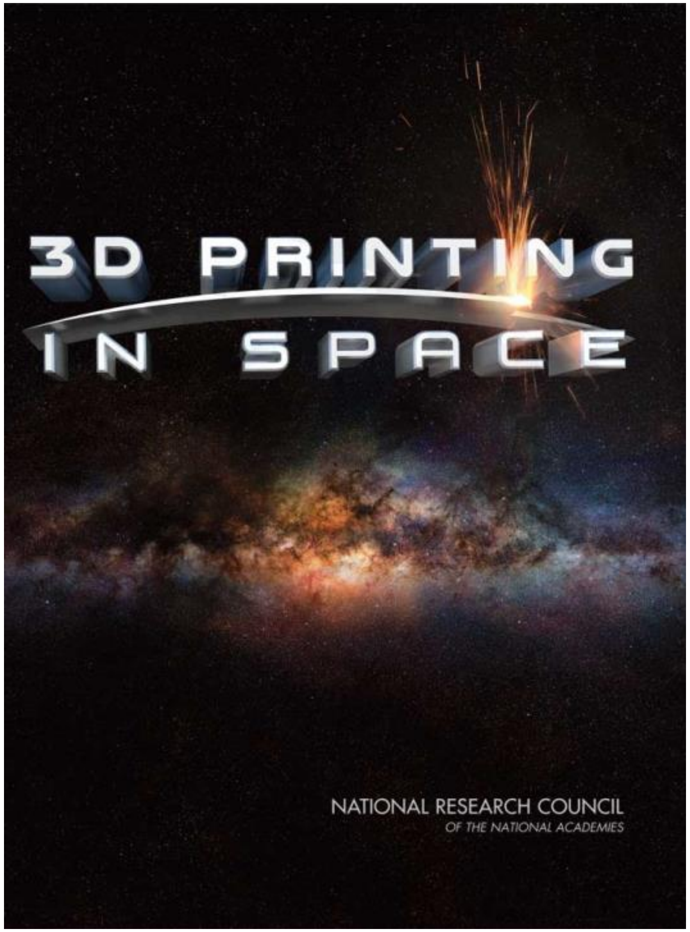


- ISS Tool Design for Manufacturability and Processing
- Structural Integrity Verification
  - Material Properties
  - Non-destructive Evaluation
  - Structural Analysis and Testing

"IN Space" Additive Manufacturing

National Research Council Committee on Space-Based Additive Manufacturing of Space Hardware – Task Summary

- Air Force Space Command and the Air Force Research Laboratory Space Vehicles Directorate and the NASA Science and Technology Mission Directorate, requested the US National Research Council (NRC) to
  - Evaluate the feasibility of the concept of space-based additive manufacturing of space hardware
  - Identify the science and technology gaps
  - Assess the implications of a space-based additive manufacturing capability
  - Report delivered in July
  - Printed in September



NRC Report: http://www.nap.edu/download.php?record_id=18871

NRC Summary Recommendations for Air Force and NASA

- **Analysis**. Agencies need to do systems *and* cost benefit analyses (CBA) related to the value of AM in space. The analyses should not focus just on how AM could replace traditional manufacturing but how it can enable entirely new structures and functionalities that were not possible before. A specific area where a CBA would be helpful is in the manufacture of smaller satellites on the ISS.
- **Investment**. Targeted investment is needed in areas such as standardization and certification, and infrastructure. The investment should be strategic, and use workshops and other information-sharing forums to develop roadmaps with short and long-term targets.
- **Platforms**. Given the short life of the ISS, agencies should leverage it to the extent feasible to test AM and AM parts.
- **Cooperation, coordination and collaboration**. Instead of stove-piped parallel development in multiple institutional settings, it is critical that there be cooperation, coordination and collaboration within and across agencies, sectors, and nations. It would be useful to develop working groups, conferences and leverage existing efforts such as the *America Makes*.
- **Education and training**. Agencies need to develop capabilities related to relevant fields such as material science and others that would be important for the development of the field of AM.

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NASA IN Space Manufacturing Technology Development Vision

Earth-based

Pre-2012

Ground & Parabolic centric:

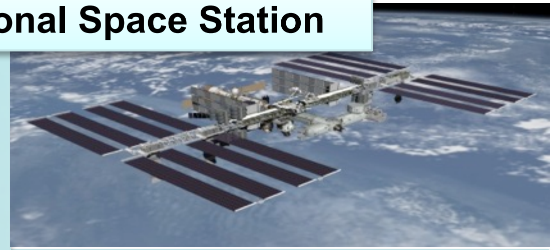
- Multiple FDM Zero-G parabolic flights
- Trade/System Studies for Metals
- Ground-based Printable Electronics/Space-craft
- Verification & Certification Processes under development
- Materials Database
- Cubesat Design & Development

International Space Station

3D Print Tech Demo

2014

- **POC 3D Print: First Plastic Printer on ISS Tech Demo**
- **NIAC Contour Crafting**
- **NIAC Printable Spacecraft**
- **Small Sat in a Day**
- **NRC Study**
- **Center In-house work in additive, SynBio, ISRU, robotics**



Metal Printing

Optical Scanner

Printable Electronics

SmallSats

Recycler

Add Mfg. Ctr. Facility

Self-repair/ replicate

2015 2016 2017 2018

- Next Generation 3DPrint
- Print-a-Sat: First cubesat printed in space
- Recycler Demo: recycle printed plastic part back into feedstock
- Metal Demo
- ISS Printed Part Utilization Catalogue

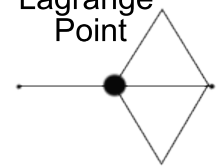
ISS: *Utilization/ Facility Focus*

- Integrated Facility Systems for stronger types of extrusion materials for multiple uses including metals & various plastics
- Printable Electronics Tech Demo
- Synthetic Bio Demo
- SmallSat Build & Deploy

Exploration

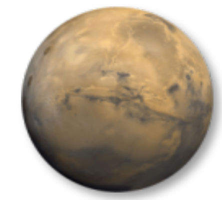
Asteroids

Lagrange Point



Lunar

Mars



2020-25

Lunar, Lagrange FabLabs

- Initial Robotic/ Remote Missions
- Provision some feedstock
- Evolve to utilizing in situ materials (natural resources, synthetic biology)
- Product: Ability to produce multiple spares, parts, tools, etc. "living off the land"
- Autonomous final milling to specification

2025

Planetary Surfaces Points Fab

- Transport vehicle and sites would need Fab capability
- Additive Construction

2030 - 40

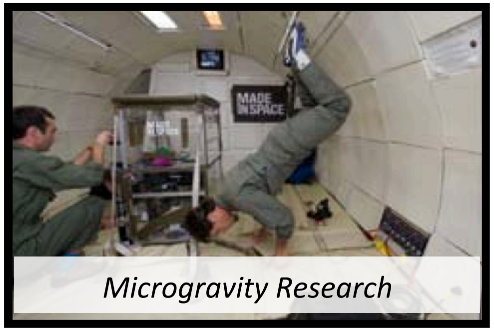
Mars Multi-Material Fab Lab

- Utilize in situ resources for feedstock
- Build various items from multiple types of materials (metal, plastic, composite, ceramic, etc.)
- Product: Fab Lab providing self-sustainment at remote destination

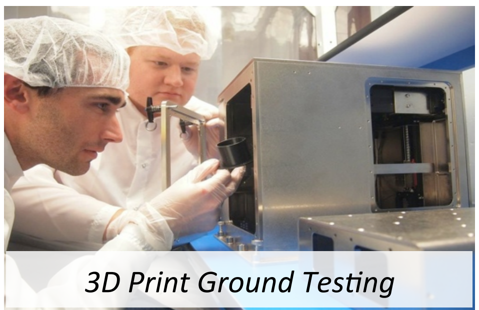
Meets objectives of Agency Decadal Survey AP10 and STMD Technology Areas 7 and 12

ISS Technology Demonstrations are Key in 'Bridging' Technology Development to Full Implementation of this Critical Exploration Technology.

IN Space Manufacturing: ISS Tech Demo – 3D Print



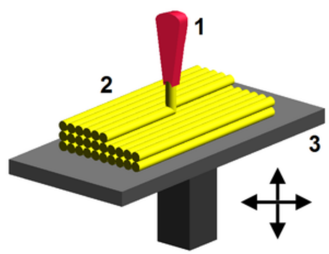
Microgravity Research



3D Print Ground Testing

Potential Mission Accessories

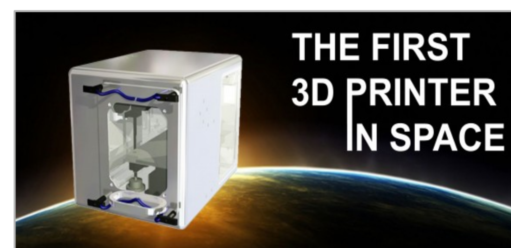
The 3D Print project will deliver the first 3D printer on the ISS and will investigate the effects of consistent microgravity on melt deposition additive manufacturing by printing parts in space.



Melt deposition modeling:
1) nozzle ejecting molten plastic,
2) deposited material (modeled part),
3) controlled movable table

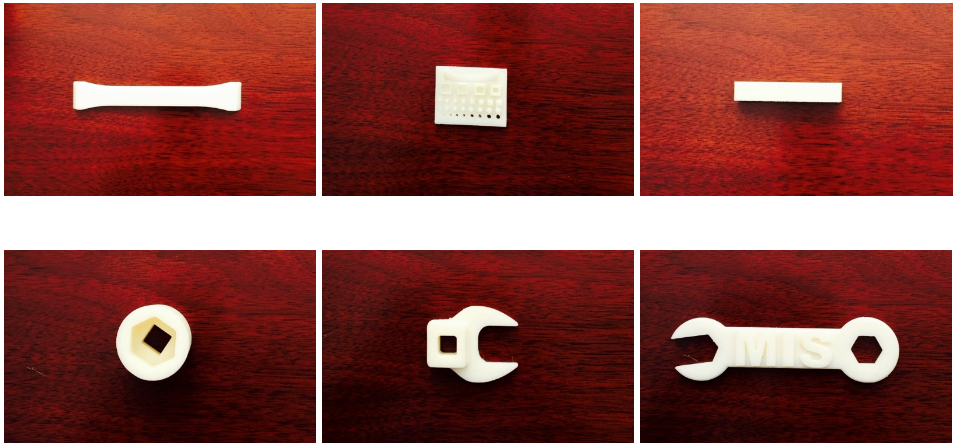
3D Print Specifications	
Dimensions	33 cm x 30 cm x 36 cm
Print Volume	6 cm x 12 cm x 6 cm
Mass	20 kg (w/out packing material or spares)
Est. Accuracy	95 %
Resolution	.35 mm
Maximum Power	176W (draw from MSG)
Software	MIS SliceR
Traverse	Linear Guide Rail
Feedstock	ABS Plastic

3D Print in Micro-G Science Glovebox (MSG)

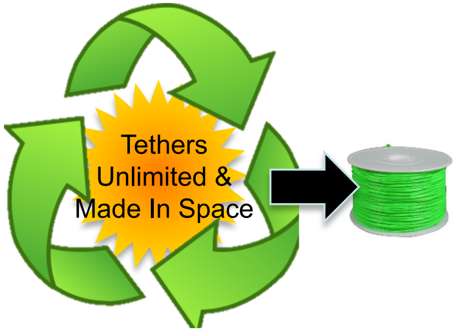


IN Space Manufacturing (ISM) Activities

- **3D Printing in Zero-G Continuation:**
  - MSFC analyses of Flight Parts compared to ground samples, publish results
- **Utilization Catalogue Development**
  - MSFC/JSC working with ISS IVA Tools and Operations Support Offices to define, first AM Parts for In-space Utilization
- **ISS Scanner/In-space Verification & Validation**
  - Made in Space, Inc.: provides CoTS Scanner for ISS Flight
- **In-space Materials Characterization Database**
  - MSFC Foundation for In-space utilization, analyses, testing, & verification
- **Recycler Tech Demo**
  - Two Phase I SBIRs awarded which will be completed early FY15.



Original Part Printed

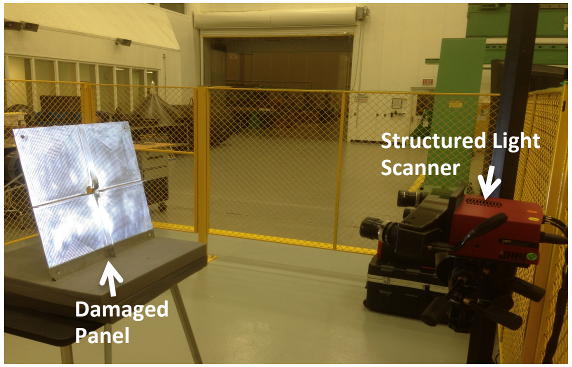


Recycle printed part back into Feedstock Filament

IN Space Manufacturing (ISM) Activities

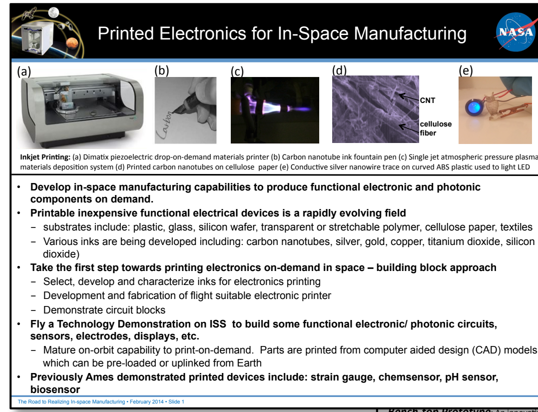
- **Printable Electronics**
  - ARC/MSFC/JPL: Develop in-space manufacturing capabilities to produce functional electronic and photonic component on demand.
- **In-space Additive Repair**
  - JSC/MSFC: working with JSC and MMOD Office to develop and test process for ground-based repair of MMOD simulated damaged panels for future in-space capability.

Close-up of simulated MMOD Damage to External ISS Panel



Scanning the Damaged Panel

- **Additive Construction**
  - Co-led by KSC & MSFC: Joint project with Engineer Research and Development Center – Construction Engineering Research Laboratory, U. S. Army Corp of Engineers.



Printed Electronics for In-Space Manufacturing

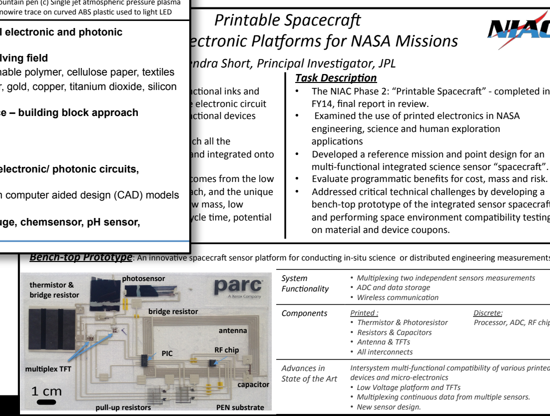
(a) (b) (c) (d) (e)

CNT
cellulose fiber

Inkjet Printing: (a) Dimatix piezoelectric drop-on-demand materials printer (b) Carbon nanotube ink fountain pen (c) Single jet atmospheric pressure plasma materials deposition system (d) Printed carbon nanotubes on cellulose paper (e) Conductive silver nanowire trace on curved ABS plastic used to light LED

- **Develop in-space manufacturing capabilities to produce functional electronic and photonic components on demand.**
- **Printable inexpensive functional electrical devices is a rapidly evolving field**
  - substrates include: plastic, glass, silicon wafer, transparent or stretchable polymer, cellulose paper, textiles
  - Various inks are being developed including: carbon nanotubes, silver, gold, copper, titanium dioxide, silicon dioxide)
- **Take the first step towards printing electronics on-demand in space – building block approach**
  - Select, develop and characterize inks for electronics printing
  - Development and fabrication of flight suitable electronic printer
  - Demonstrate circuit blocks
- **Fly a Technology Demonstration on ISS to build some functional electronic/ photonic circuits, sensors, electrodes, displays, etc.**
  - Mature on-orbit capability to print-on-demand. Parts are printed from computer aided design (CAD) models which can be pre-loaded or uplinked from Earth
- **Previously Ames demonstrated printed devices include: strain gauge, chemsensor, pH sensor, biosensor**

The Road to Realizing In-space Manufacturing • February 2014 • Slide 1



Printable Spacecraft
ectronic Platforms for NASA Missions
ndra Short, Principal Investigator, JPL

ctional inks and
electronic circuit
ctional devices

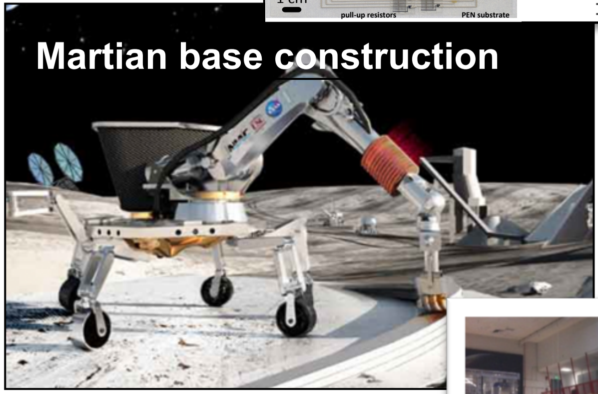
ch all the
nd integrated onto

comes from the low
ch, and the unique
w mass, low
ycle time, potential

Task Description
- The NIAC Phase 2: "Printable Spacecraft" - completed in FY14, final report in review.
- Examined the use of printed electronics in NASA engineering, science and human exploration applications
- Developed a reference mission and point design for an multi-functional integrated science sensor "spacecraft".
- Evaluate programmatic benefits for cost, mass and risk.
- Addressed critical technical challenges by developing a bench-top prototype of the integrated sensor spacecraft and performing space environment compatibility testing on material and device coupons.

Bench-top Prototype: An innovative spacecraft sensor platform for conducting in-situ science or distributed engineering measurements

System Functionality	• *Multiplexing two independent sensors measurements* • *ADC and data storage* • *Wireless communication*	
Components	*Printed :* • *Thermistor & Photoresistor* • *Resistors & Capacitors* • *Antenna & TFTs* • *All interconnects*	*Discrete:* *Processor, ADC, RF chip*
Advances in State of the Art	*Intersystem multi-functional compatibility of various printed devices and micro-electronics* • *Low Voltage platform and TFTs* • *Multiplexing continuous data from multiple sensors.* • *New sensor design.*	



SWAMP WORKS
NASA KENNEDY SPACE CENTER

Science & Technology Office

Cross-Cutting

Cross-Cutting: Additive Manufacturing Development Processing-Structure-Property Relationships

Technical Objectives

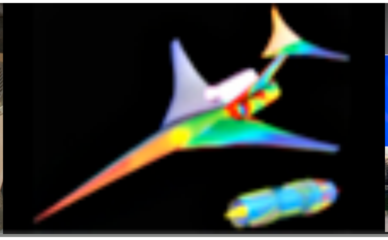
Build the standard level of information on AM powder bed fusion processes that is required for qualification of any new critical process used for aerospace applications

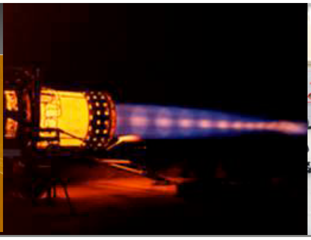
Expand and extend the manufacturing base for aerospace hardware through standardization and qualification of critical AM processes. Better understanding of controlling process parameters and process failure modes will be achieved through completion of this study. Opportunities for industry participation are available in each of the tasks below.

1. Build Interactions / Effects – ARC/LaRC/MSFC ***Objective:*** *Understand how basic AM build factors influence part properties.*
2. Powder Influence / Effects – GRC ***Objective:*** *Understand how basic powder feedstock characteristics influence a part's physical, mechanical, and surface properties.*
3. Thermal Processing / Effects – LaRC/MSFC ***Objective:*** *a) Understand how standard wrought thermal processes influence AM mechanical properties, and b) explore the potential cost and benefit of AM-specific thermal processing.*
4. Surface Improvement / Effects – MSFC ***Objective:*** *Understand how as-built and improved AM surface texture influence part performance and fatigue life.*
5. Applied Materials Characterization – GRC/LaRC/MSFC ***Objective:*** *Enable use of AM parts in severe aerospace environments.*
6. Qualification of AM Critical Components – MSFC ***Objective:*** *Develop an Agency-wide accepted practice for the qualification of AM processes for aerospace hardware.*

Related Task: Process Modeling – GRC,MSFC *Objective: Use precipitation modeling to predict location specific microstructure in as-fabricated and post-processed 718, which has been fabricated with selective laser sintering*






Cross-Cutting: Certification – NDE

- **Activity Title:** Foundational NDE Methodology for Certification of Additive Manufacturing (AM) Parts and Materials
- **Purpose:** Develop certification methodologies designed to ensure the production of safe and reliable AM parts for spaceflight applications. Emphasis will be placed on metals and AM processes used in fabrication of propulsion system components.
- **Justification:** AM is a rapidly emerging technology and there is a recognized lag in AM process and part validation and certification methodologies. NDE has been identified as one key technology to close this gap.
- **Summary:** The OSMA state of the art AM report will be used to define highest priority needs/gaps for NDE of AM parts. Resources will be used to down select and optimize NDE techniques that will then be combined with NDE modeling for a cost-effective methodology for verifying part quality. A workshop will be held mid year to assess progress and further define needs.

Summary

- NASA, including each Mission Directorate, is investing in, experimenting with, and/or utilizing AM across a broad spectrum of applications and projects.
- Centers have created and are continuing to create partnerships with industry, other Government Agencies, other Centers, and Universities.
- In-house additive manufacturing capability enables rapid iteration of the entire design, development and testing process, increasing innovation and reducing risk and cost to projects.
- For deep space exploration, AM offers significant reduction to logistics costs and risk by providing ability to create on demand.
- There are challenges: Overwhelming message from recent JANNAF AM for Propulsion Applications TIM was “certification.”
- NASA will continue to work with our partners to address this and other challenges to advance the state of the art in AM and incorporate these capabilities into an array of applications from aerospace to science missions to deep space exploration.