

Processing parameters for Kera®S-Powder

General process conditions:

Oxygen value in the installation space $\leq 0.17\%$

Layer thickness: 25 μm

Focus position: Focus + 3.5 mm

Pump frequency Circulation: 60 l / min

Laser parameters:

For support structure:

Exposure time: 80 μs

Point distance: 20 μm

Laser current: 2300 mA (corresponds to approx. 53 W)

Contour: lower performance to for better surface quality

Exposure time: 30 μs

Point distance: 10 μm

Laser current: 1500 mA (corresponds to approx. 30 W)

Hatch / hatching:

Exposure time: 40 μs

Point distance: 20 μm

Laser current: 4000 mA (corresponds to approx. 100 W)

Hatch distance: 60 μm

Hatchoff set: 20 μm

Rotate the Hatch by 90° after each layer (xy strategy)