
The software (Ansys, Acunia, Linspire, or PTC) is a part of the software distribution of the machine which, by combining their inbuilt and in situ solid state, allows for the possibility of creating parts with missing/notched corners and open spaces of various sizes [149]. The software is used to manage the manufacturing of AM objects through an interactive interface with the machine and a library of available materials and slices. In particular, the software can import the information about the 3D model, describe and generate the slicing rules to produce parts. The user can also define the list of materials that he will use to produce the object. The software can save, optimize and create the required slicing rules and then export them to the machine. The slicing parameters that are to be created can be shared or given as a template for each part. The shared parameters can then be used as a template to recreate the same part but from the original model. The material distribution is described in detail to generate slicing rules that can be translated to a part via a material that can be extracted from the model (e.g. a steel or a plastic).

Fig. 18.5 Examples of parts prepared with AM (Reprinted from [144] with permission from Elsevier) In Fig. 18.5 (above) an AM-sculpted part is shown: in particular the model was printed in steel with the following parameters: layer thickness (100–600 μm), infill density (100–900%), and extrusion temperature (200–600 $^{\circ}\text{C}$). As a result the part shown was printed with steel, with a 100% infill, and at a temperature of 200 $^{\circ}\text{C}$. The model shown in the picture is made from aluminum oxide, with a 10% infill, and at a temperature of 400 $^{\circ}\text{C}$. The part is shown before the post-processing steps to form it to its final shape. The final part, shown on the right, is made of aluminum, with 100% infill, and at a temperature of 300 $^{\circ}\text{C}$. In Fig. 18.6 (above) the results of the part shown in Fig. 18.5 are shown. The part is shown sliced with plastic: the slicing process was performed using a thickness of 200 μm , 100% infill, and the extrusion temperature of the plastic was set to 250 $^{\circ}\text{C}$, whereas the infill density was 50%. The result of the slicing process is shown on the left 82157476af

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