

LENS[®] MACHINE TOOL SERIES

LENS 3D Hybrid 20 Controlled Atmosphere System

Affordable Hybrid Machine Tool for the Fabrication and Restoration of High Value Metal Components.

The LENS 3D Hybrid 20 Controlled Atmosphere System sets a new standard in affordability and performance for titanium and aluminum metal additive manufacturing applications. The system incorporates an Optomec proprietary hermetically sealed Class 1 enclosure and an integrated gas purification system that maintains oxygen and moisture levels to below 40 ppm. For less demanding applications, the system can also operate in open atmosphere mode through unique LENS technology that surrounds the build area with a protective shield gas during deposition.

Built on a rugged cast iron CNC platform, the system features high precision ball screws, spindle, and 8 tool ATC for precision machining operations. Additive functionality is enabled with integrated Optomec LENS technology including Steady-flow[™] powder feeders, water-cooled LENS processing head with interchangeable powder delivery nozzles, and SmartAM[™] closed loop controls. A high power fiber laser and advanced Siemens controls complete the system.



LENS 3D HY 20 CA System. An Additive only model, LENS 3D AM 20, is also available.

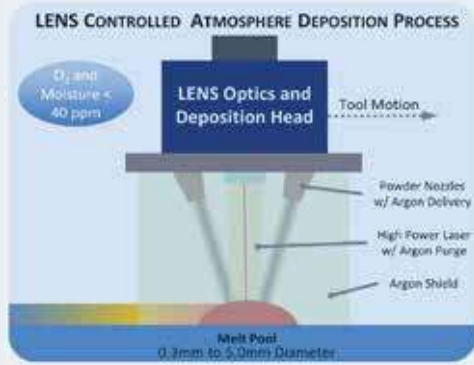
LENS FEATURES

- ▶ Full Atmosphere Control – superior metal quality
- ▶ Cast Iron CNC Platform – affordable rugged base
- ▶ Full CNC Machining Capability – finished parts in one set-up
- ▶ Full LENS Additive Capability – industry proven technology
- ▶ Up to 5 Axis Motion – for complex parts/repairs
- ▶ Fiber Laser – high performance/reliability
- ▶ Closed Loop Controls – part to part consistency
- ▶ Common materials: Inconel Alloys, Stainless Steels, Titanium alloys

LENS APPLICATIONS

- ▶ Hybrid Manufacturing
- ▶ Finished Functional Prototypes
- ▶ Repair damaged/worn parts
- ▶ Restore mis-machined components
- ▶ Remanufacturing of legacy parts

Laser Engineered Net Shaping



How the LENS process works

In the Optomec Machine Tool Series with atmosphere control, the LENS process is housed in a chamber which is purged with argon such that oxygen and moisture levels stay below 40 parts per million. This ensures there is no impurity pickup during deposition. The LENS Deposition head delivers the laser and powder to the deposition zone. Metal powder is conveyed through nozzles to the focal point of the laser creating a melt pool. Argon gas is used to deliver the powder and protect the melt pool from contamination. A curtain of argon gas provides additional shielding for the local build area. Tool-paths created from standard G & M codes or from a CAD model instruct the LENS machine how to build the part. The part is built layer by layer under the control of software that monitors a variety of parameters to ensure geometric and mechanical integrity. When complete, the part is removed and can be heat-treated, Hot-Isostatic Pressed, machined, or finished in any other manner.

LENS 3D Hybrid 20 CA

	Feature	Description
MACHINE TOOL PLATFORM	Lower Base	Rugged cast iron construction, precision linear ways.
	Upper Enclosure	Class I Laser Enclosure
	Gas Purification System	Unit maintains $O_2 \leq 40$ ppm.
	Isolated Pass Through Chamber	15" (375 mm) diameter antechamber for moving small parts in/out of system without compromising atmosphere.
	Door/Glove Ports	Door and glove ports which are interlocked to prevent possible exposure to laser beam during normal operation.
	Process Work Envelope	Machining = 20"x14"x20" (500x350x500 mm) Deposition = 14x14x20" (350x350x500 mm)
	Additive Only Work Envelope	Deposition = 20"x14"x20" (500x350x500 mm)
	Table Size/Load	12"x24"/450 lbs. (300x600 mm/200 kg.) evenly distributed
	Ball Screw Size	Precision ground 1.00" (25 mm) ball screws
	Motion	3 Axis Standard; X, Y Linear Table, Z Gantry Optional 4th Axis Rotary Table, 6" (150 mm) Diameter Plate Optional 4th/5th Axis Tilt/Rotate Table, 6.5" (162 mm) Diameter Plate
	Positional Accuracy	+/- 0.0002" (5 microns)
	Positional Repeatability	+/- 0.0001" (2.5 microns)
	Linear Resolution	0.0001" (2.5 microns)
	Machine Control	Siemens 828 Controller with additive/subtractive HMI. Conversational mode, G&M programming and Optional Wizards for easy additive tool path generation.
MACHINE WEIGHT	Machine Dimensions	65x80x80" (1650x2050x2050 mm)
	Machine Weight	5,500 lbs. (2,500 kg)

MACHINING	Motor HP (Peak)	7.5 HP
	Spindle Speed	Standard: 60 - 8,000 RPM, Optional: 30,000 RPM
	Spindle Torque (Max)	35 ft.-lbs. @ 350 RPM (4.8m-kgs)
	Cutting Feed rate	0.001- 400 IPM (0.025 - 10160 MPM)
	Tool Type/Taper	CAT 40 (BT-optional)
	Tool Storage Capacity	8 Station Automatic Tool Changer

LENS LASER DEPOSITION	LENS Processing Head	Water tight, water cooled assembly with adjustable laser spot sizes. Application specific powder deliver nozzles.
	Laser	500W or 1 kW Fiber Laser with chiller.
	Powder Feeder	SteadyFlow™ Powder Feeder with capacity to hold up to 2 liters of powder. Optionally up to 4 Powder Feeders for alloys and functional gradients.
	Deposition rate	0.25 lbs. (0.1 kgs)/hr. @ 500 W, 0.5 lbs. (0.2kgs)/hr. @ 1 kW
	Deposition Process Controls	Optional SmartAM™ coaxial closed loop control
	CAD to Additive Tool Path Software	Optional PartPrep for 2.5D tool path generation

ABOUT OPTOMECH

Optomec® is the world-leading provider of additive manufacturing solutions for high-performance applications in the Electronics, Solar, Medical, and Aerospace & Defense markets. These systems utilize Optomec's patented Aerosol Jet Printed Electronics technology and LENS powder-metal fabrication technology. The company has a global customer base of more than 200 users that includes many industry-leading manufacturers.