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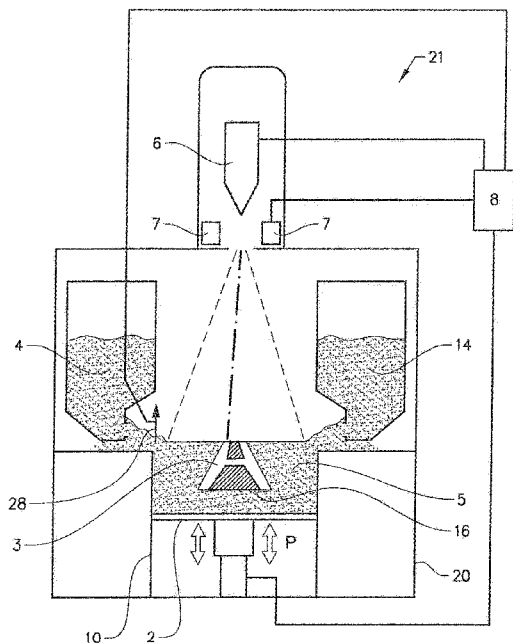


FIG. 2

(57) Abstract: Method for forming a three-dimensional article (3) through successively depositing individual layers of powder material (5) that are fused together so as to form the article, said method comprising the steps of: providing at least one electron beam source (6) emitting an electron beam for heating and/or fusing said powder material. Controlling the electron beam source in a first mode when said formation of said three dimensional article is in a first process step. Controlling said electron beam in a second mode when said formation of said three dimensional article is in a second process step, wherein in said first mode an electron beam current from said electron beam source is controlled in a feed-forward mode and in said second mode said electron beam current is controlled in a feed-back mode.

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CONTROL OF ADDITIVE MANUFACTURING METHOD FOR FORMING THREE-DIMENSIONAL ARTICLES USING TWO CONTROL MODES

BACKGROUND

Related Field

[0001] The present invention relates to a method for additive manufacturing of a three dimensional article by successively fusing individual layers of powder material.

Description of Related Art

[0002] Freeform fabrication or additive manufacturing is a method for forming three-dimensional articles through successive fusion of chosen parts of powder layers applied to a worktable.

[0003] An additive manufacturing apparatus may comprise a work table on which the three-dimensional article is to be formed, a powder dispenser or powder distributor, arranged to lay down a thin layer of powder on the work table for the formation of a powder bed, a high energy beam for delivering energy to the powder whereby fusion of the powder takes place, elements for control of the energy given off by the energy beam over the powder bed for the formation of a cross section of the three-dimensional article through fusion of parts of the powder bed, and a controlling computer, in which information is stored concerning consecutive cross sections of the three-dimensional article. A three-dimensional article is formed through consecutive fusions of consecutively formed cross sections of powder layers, successively laid down by the powder dispenser.

[0004] In additive manufacturing a short manufacturing time and high quality of the finalized product is of utmost importance. Desired material properties of the final product may depend on the ability to control the fusion process. One important parameter is the ability to fast and accurately control the actual beam output during the fusion process. In most electron beam sources the output current from the source may vary over time. If not having a full control of this variation in the beam current over time, there is a great risk that the actual material properties of the final product will deviate from the desired material properties.

BRIEF SUMMARY

[0005] An object of the invention is to provide a method which fast and accurately controls the beam current from an electron beam source in an additive manufacturing process for improving the material characteristics of the manufactured 3-dimensional article.

[0006] The above mentioned object is achieved by the features in the method according to claim 1.

[0007] In a first aspect of the invention it is provided a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, the method comprising the steps of: providing at least one electron beam source emitting an electron beam for heating and/or fusing the powder material, where the electron beam source comprises a cathode, an anode, and a grid between the cathode and anode, controlling the electron beam source in a first mode when the formation of the three dimensional article is in a first process step, controlling the electron beam source in a second mode when the formation of the three dimensional article is in a second process step, wherein an electron beam current from the electron beam source is controlled in a feed-forward mode in the first mode and the electron beam current is controlled in a feed-back mode in the second mode.

[0008] The advantage of the present invention is that the electron beam current may be controlled differently depending on process step. Some process steps may require accurate electron beam current while other process steps are more or less insensitive to the manipulation of the electron beam current. This insight may be used in order to improve the end quality of the three-dimensional article.

[0009] In various example embodiments of the present invention the first process step is the fusion of the powder material for forming the three-dimensional article.

[0010] During the fusion of the three-dimensional article the accuracy of the electron beam current may be critical for achieving particular material characteristics. A desired electron beam current is achieved by feeding forward a predetermined steering parameter to the electron beam source.

[0011] In various example embodiments of the present invention the second process step is one of the group of: preheating of the surface prior to applying a new powder layer onto the surface, preheating of a new powder layer, powder distribution or post heat treatment of an already fused powder layer. During the preheating, post heat treatment or powder distribution the accuracy of the

value of the electron beam current is not critical for achieving the desired material characteristics. In the second process step the steering parameter may be configured or updated for achieving a predetermined electron beam current. The steering parameter may be stored in a look up table or transformed into a mathematical function. The look-up table or mathematical function may define a relationship between the steering parameter and the electron beam current.

[0012] In various example embodiments of the present invention the method further comprising the steps of: applying a predetermined fixed accelerator voltage between the cathode and the anode, applying a predetermined number of different grid voltages between the grid and the cathode for producing a corresponding predetermined number of electron beam currents, creating or updating a look-up table or mathematical function during the second mode wherein the look-up table or mathematical function defines a relationship between a desired electron beam current and an applied grid voltage.

[0013] In the second process step when the electron beam current is not used for fusing the powder material, one may update or create the relationship between the steering parameter and the electron beam current. The grid voltage may be set between two different extreme values for creating maximum electron beam current and zero electron beam current. A predetermined number of different grid voltages between these two extreme values may be applied while measuring the actual electron beam current. The resulting measurement data may be extrapolated in order to achieve the necessary accuracy. The measurement data may be stored in a look-up table or transformed to a mathematical function, i.e., the actual electron beam current is feed-back where it later can be retrieved from.

[0014] In various example embodiments the method further comprising the steps of: comparing a first actual electron beam current with a first desired electron beam current, updating the look-up table or mathematical function if the difference between the first actual and first desired electron beam currents is greater than a predetermined value.

[0015] After having used a particular look-up table or mathematical function a number of times, the look-up table or mathematical function may not be up to date, i.e., the applied grid voltage will not result in a desired electron beam current. The reason for the mismatch after a certain period of usage is that the cathode element becomes more and more used. For this reason it may be necessary to update the electron beam current as a function of the grid voltage after a certain period of time.

The trigger for this update may be when the measurement of an actual beam current deviates more than a predetermined amount from a desired electron beam current.

[0016] In various example embodiments of the present invention the updating is instead performed after fusing a predetermined number of layers of the three-dimensional article. It may be known beforehand that the electron beam current may be out of specification for a given applied grid voltage after a number of fused powder layers and therefore the update of the electron beam current as a function of the grid voltage is performed in a periodically which is determined before the actual formation of the three-dimensional article starts.

[0017] In various example embodiments of the present invention the updating is instead performed between the fusion process of each layer. In order to always use the most accurate electron beam current available the update of the electron beam current as a function of the grid voltage may be performed between each fusion process of each layer. This may become useful when the build area is increasing in size.

[0018] In various example embodiments of the present invention the method further comprising the steps of: retrieving the predetermined grid voltage for producing the desired electron beam current from the look-up table or a mathematical function, changing the predetermined grid voltage from a first grid voltage to a second grid voltage during the first mode for changing the electron beam current from a first value to a second desired value during fusion of a predetermined layer.

[0019] Different electron beam currents may be used when fusing a particular powder layer. Switching from a first electron beam current to a second electron beam current may be performed by amending the grid voltage from a first grid voltage to a second grid voltage. The grid voltages are retrieved from a look-up table or from a mathematical function. It may be known beforehand when the electron beam current has to be changed from a first level to a second level. The optimal electron beam current may be known from simulations of the manufacturing of the specific three dimensional article for achieving predetermined material characteristics.

[0020] In various example embodiments of the present invention the predetermined grid voltage is changed from a first grid voltage to a second grid voltage during fusion of at least one individual scan line for changing the electron beam current in the scan line from a first value to a second desired value.

[0021] The change of electron beam current from a first value to a second value is performed by amending the grid voltage from a first to a second value. Since this may be done relatively quickly

the electron beam current may be changed during a specific scan line. This may be advantageous for decreasing the manufacturing time while at the same time achieving the desired material characteristics.

[0022] In another aspect of the present invention it is provided a program element configured and arranged when executed on a computer a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, the method comprising the steps of: providing at least one electron beam source emitting an electron beam for heating and/or fusing the powder material, where the electron beam source comprising a cathode, an anode, and a grid between the cathode and anode, controlling the electron beam source in a first mode when the formation of the three dimensional article is in a first process step, controlling the electron beam source in a second mode when the formation of the three dimensional article is in a second process step, wherein an electron beam current from the electron beam source is controlled in a feed-forward mode in the first mode and the electron beam current is controlled in a feed-back mode in the second mode.

[0023] In still another aspect of the present invention it is provided a computer readable medium having stored thereon the program element.

[0024] In yet another aspect of the present invention it is provided a non-transitory computer program product comprising at least one non-transitory computer-readable storage medium having computer-readable program code portions embodied therein. In these embodiments, the computer-readable program code portions comprises: an executable portion configured for controlling an electron beam source in a first mode when formation of a three dimensional article is in a first process step, the electron beam source emitting an electron beam for at least one of heating or fusing individual layers of a powder material together so as to form the three-dimensional article, the electron beam source comprising a cathode, an anode, and a grid between the cathode and anode; and an executable portion configured for controlling the electron beam source in a second mode when the formation of the three dimensional article is in a second process step, wherein an electron beam current from the electron beam source is controlled in a feed-forward mode in the first mode and the electron beam current is controlled in a feed-back mode in the second mode.

[0025] In yet another aspect of the present invention it is provided a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article. The method comprises the steps of: providing at

least one electron beam source emitting an electron beam for at least one of heating or fusing the powder material, where the electron beam source comprises a cathode, an anode, and a grid between the cathode and anode; controlling the electron beam source in at least two modes during the formation of the three dimensional article; applying a predetermined accelerator voltage between the cathode and the anode; applying a predetermined number of different grid voltages between the grid and the cathode for producing a corresponding predetermined number of electron beam currents; and at least one of creating or updating a look-up table or mathematical function during one of the at least two modes, wherein the look-up table or mathematical function defines a relationship between a desired electron beam current and an applied grid voltage.

[0026] All examples and exemplary embodiments described herein are non-limiting in nature and thus should not be construed as limiting the scope of the invention described herein. Still further, the advantages described herein, even where identified with respect to a particular exemplary embodiment, should not be necessarily construed in such a limiting fashion.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0027] Having thus described the invention in general terms, reference will now be made to the accompanying drawings, which are not necessarily drawn to scale, and wherein:

[0028] FIG. 1 depicts, in a schematic view, an example embodiment of an electron beam source in which the inventive method may be implemented;

[0029] FIG. 2 depicts, in a schematic view, an example embodiment of an apparatus for producing a three dimensional product which may have an electron beam source according to figure 1;

[0030] FIG. 3 depicts the grid potential - cathode potential as a function of electron beam current for different emissivity of a filament in an electron beam source;

[0031] FIG. 4 is a block diagram of an exemplary system **1020** according to various embodiments;

[0032] FIG. 5A is a schematic block diagram of a server **1200** according to various embodiments; and

[0033] FIG. 5B is a schematic block diagram of an exemplary mobile device **1300** according to various embodiments.

DETAILED DESCRIPTION OF VARIOUS EMBODIMENTS

[0034] Various embodiments of the present invention will now be described more fully hereinafter with reference to the accompanying drawings, in which some, but not all embodiments of the invention are shown. Indeed, embodiments of the invention may be embodied in many different forms and should not be construed as limited to the embodiments set forth herein. Rather, these embodiments are provided so that this disclosure will satisfy applicable legal requirements. Unless otherwise defined, all technical and scientific terms used herein have the same meaning as commonly known and understood by one of ordinary skill in the art to which the invention relates. The term “or” is used herein in both the alternative and conjunctive sense, unless otherwise indicated. Like numbers refer to like elements throughout.

[0035] Still further, to facilitate the understanding of this invention, a number of terms are defined below. Terms defined herein have meanings as commonly understood by a person of ordinary skill in the areas relevant to the present invention. Terms such as “a”, “an” and “the” are not intended to refer to only a singular entity, but include the general class of which a specific example may be used for illustration. The terminology herein is used to describe specific embodiments of the invention, but their usage does not delimit the invention, except as outlined in the claims.

[0036] The term “three-dimensional structures” and the like as used herein refer generally to intended or actually fabricated three-dimensional configurations (e.g., of structural material or materials) that are intended to be used for a particular purpose. Such structures, etc. may, for example, be designed with the aid of a three-dimensional CAD system.

[0037] The term “electron beam” as used herein in various embodiments refers to any charged particle beam. The sources of charged particle beam can include an electron gun, a linear accelerator and so on.

[0038] Figure 2 depicts an embodiment of a freeform fabrication or additive manufacturing apparatus 21 in which the inventive method according to the present invention may be implemented.

[0039] The apparatus 21 comprising an electron beam gun 6; deflection coils 7; two powder hoppers 4, 14; a build platform 2; a build tank 10; a powder distributor 28; a powder bed 5; and a vacuum chamber 20.

[0040] The vacuum chamber 20 is capable of maintaining a vacuum environment via a vacuum system, which system may comprise a turbo molecular pump, a scroll pump, an ion pump and one or more valves which are well known to a skilled person in the art and therefore need no further explanation in this context. The vacuum system is controlled by a control unit 8.

[0041] The electron beam gun 6 is generating an electron beam which is used for pre heating of the powder, melting or fusing together powder material provided on the build platform 2 or post heat treatment of the already fused powder material. At least a portion of the electron beam gun 6 may be provided in the vacuum chamber 20. The control unit 8 may be used for controlling and managing the electron beam emitted from the electron beam gun 6. At least one focusing coil (not shown), at least one deflection coil 7, an optional coil for astigmatic correction (not shown) and an electron beam power supply (not shown) may be electrically connected to the control unit 8. In an example embodiment of the invention the electron beam gun 6 may generate a focusable electron beam with an accelerating voltage of about 15-60kV and with a beam power in the range of 3-10kW. The pressure in the vacuum chamber may be 10^{-3} mbar or lower when building the three-dimensional article by fusing the powder layer by layer with the energy beam.

[0042] The powder hoppers 4, 14 comprise the powder material to be provided on the build platform 2 in the build tank 10. The powder material may for instance be pure metals or metal alloys such as titanium, titanium alloys, aluminum, aluminum alloys, stainless steel, Co-Cr alloys, nickel based super alloys, etc.

[0043] The powder distributor 28 is arranged to lay down a thin layer of the powder material on the build platform 2. During a work cycle the build platform 2 will be lowered successively in relation to a fixed point in the vacuum chamber. In order to make this movement possible, the build platform 2 is in one embodiment of the invention arranged movably in vertical direction, i.e., in the direction indicated by arrow P. This means that the build platform 2 starts in an initial position, in which a first powder material layer of necessary thickness has been laid down. Means for lowering the build platform 2 may for instance be through a servo engine equipped with a gear, adjusting screws, etc. The servo engine may be connected to the control unit 8.

[0044] An electron beam may be directed over the build platform 2 causing the first powder layer to fuse in selected locations to form a first cross section of the three-dimensional article 3. The beam is directed over the build platform 2 from instructions given by the control unit 8. In the control unit 8 instructions for how to control the electron beam for each layer of the three-

dimensional article is stored. The first layer of the three dimensional article 3 may be built on the build platform 2, which may be removable, in the powder bed 5 or on an optional start plate 16. The start plate 16 may be arranged directly on the build platform 2 or on top of a powder bed 5 which is provided on the build platform 2.

[0045] After a first layer is finished, i.e., the fusion of powder material for making a first layer of the three-dimensional article, a second powder layer is provided on the build platform 2. The thickness of the second layer may be determined by the distance the build platform is lowered in relation to the position where the first layer was built. The second powder layer is in various embodiments distributed according to the same manner as the previous layer. However, there might be alternative methods in the same additive manufacturing machine for distributing powder onto the work table. For instance, a first layer may be provided via a first powder distributor 28, a second layer may be provided by another powder distributor. The design of the powder distributor is automatically changed according to instructions from the control unit 8. A powder distributor 28 in the form of a single rake system, i.e., where one rake is catching powder fallen down from both a left powder hopper 4 and a right powder hopper 14, the rake as such can change design.

[0046] After having distributed the second powder layer on the build platform, the energy beam is directed over the work table causing the second powder layer to fuse in selected locations to form a second cross section of the three-dimensional article. Fused portions in the second layer may be bonded to fused portions of the first layer. The fused portions in the first and second layer may be melted together by melting not only the powder in the uppermost layer but also remelting at least a fraction of a thickness of a layer directly below the uppermost layer.

[0047] Sometimes it may be necessary to consider the charge distribution that is created in the powder as the electrons hit the powder bed 5. The charge distribution density depends on the following parameters: beam current, electron velocity (which is given by the accelerating voltage), beam scanning velocity, powder material and electrical conductivity of the powder, i.e., mainly the electrical conductivity between the powder grains. The latter is in turn a function of several parameters, such as the non-limiting examples of temperature, degree of sintering and powder grain size/size distribution.

[0048] Thus, for a given powder, i.e., a powder of a certain material with a certain grain size distribution, and a given accelerating voltage, it is possible, by varying the beam current (and thus the beam power) and the beam scanning velocity, to affect the charge distribution.

[0049] By varying these parameters in a controlled way, the electrical conductivity of the powder can gradually be increased by increasing the temperature of the powder. A powder that has a high temperature obtains a considerably higher conductivity which results in a lower density of the charge distribution since the charges quickly can diffuse over a large region. This effect is enhanced if the powder is allowed to be slightly sintered during a pre-heating process. When the conductivity has become sufficiently high, the powder can be fused together, i.e., melted or fully sintered, with predetermined values of the beam current and beam scanning velocity.

[0050] Figure 1 depicts, in a schematic view, an exemplary embodiment of an electron beam source in which the inventive method may be implemented. The electron beam source 100 comprises a cathode 102, a grid 104 and an anode 106. Electrons emitted at the cathode 102 being on negative potential are accelerated towards the anode 106 and finally a target surface 118. A grid 104 is set at a predetermined distance from the cathode 102. The cathode 102 may be provided with a voltage which may cause the cathode to heat up, where upon the cathode 102 releases electrons by thermionic emission.

[0051] An accelerator voltage 160 is provided between the cathode and the anode 106. The accelerator voltage 160 causes the emitted electrons from the cathode 102 to accelerate towards the anode 106 thus establishing an electron beam 120. The electron beam 120 may impinge on a substrate surface 118, which may be a powder layer in an additive manufacturing process. In order to guide and focus the electron beam there may further be arranged at least one focusing coil and at least one deflection coil.

[0052] In the electron beam source 100 the grid 104 is provided between the cathode 102 and the anode 106. The grid 104 may be arranged as a plate having an aperture. The aperture may be aligned with the cathode 102. The size of the aperture in the grid 104 may correspond to a cross section of the electron beam 120 at the position of the grid 104.

[0053] A grid voltage 180 may be provided between the grid 104 and the cathode 102 and may be adjusted between a negative blocking voltage and a full power voltage and thereby adjusting an electron beam current between 0 - maximum electron beam current. In Figure 1 the cathode 102

may be provided with a negative potential of -20kV to -100kV. A first connection point 110 of the accelerator voltage 160 and a first connection point 114 of the grid voltage 180 may be fixed to the same potential of -20kV to -100kV. A second connection point 108 of the accelerator voltage 160 may be provided with ground potential. A second connection point 112 of the grid voltage 180 may be varied between the negative blocking voltage and the full power voltage. A second control unit 150 may be controlling the voltage on the second connection point 112 of the grid voltage in order to adjust the electron beam current to a desired value. The second control unit 150 may be a physically separate control unit in connection with the control unit 8 or fully integrated in the control unit 8.

[0054] The target surface 118 may be set to ground potential or a positive potential. The electron beam source 100 may also comprise means 170 for detecting the actual electron beam current. An example means for detecting the electron beam current on the target surface may be to detect the actual loading of the high voltage source providing the accelerator voltage 160, indicated by box 170 in Figure 1. This may be done by simply measuring the electron beam passing between the first and second connection points 110 and 108 respectively. If the cathode is provided with a fixed negative voltage of -60kV the negative blocking voltage may be around -61kV, i.e., the second connection point 112 of the grid voltage is set at -61kV and the first connection point 114 is set to -60kV, for blocking the electrons by the grid 104. If starting to decrease the negative blocking voltage at the second connection point 112, some of the electrons emitted from the cathode will be allowed to pass the grid 104. By varying the grid voltage in this example embodiment between -61kV to \sim -60kV, when the cathode is provided with a fixed negative potential of -60kV, the electron beam current may vary from 0mA – maximum electron beam current which may be 25mA for a predetermined size and shape of the cathode and a predetermined size and shape of the aperture in the grid 104. Other accelerator voltages and/or other size, shape and emissivity of the cathode and/or other size and shape of the aperture in the grid may affect the maximum electron beam current to be higher or lower than the exemplified 25mA.

[0055] Figure 3 depicts the grid potential - cathode potential as a function of electron beam current for different emissivity of a filament. When the grid voltage 180 is at a sufficiently high negative potential, i.e., the potential on connection point 112 is provided with a sufficient negative potential (negative blocking potential) compared to the negative potential on connection point 114, the electrons emanating from the cathode 102 will be blocked (repelled) by the negative potential on

the grid 104 resulting in no electrons passing through the aperture in the grid 104. In such a case we are at the leftmost position in the graph in Figure 3, i.e., zero electron beam current. As the potential difference between the cathode 102 and grid 104 is decreasing the electron beam current is increasing, i.e., we are moving to the right in the graph in Figure 3. U_C represents the cathode potential and U_G represents the grid potential.

[0056] A cathode 102 at different temperatures may emanate different amounts of electrons. In Figure 3 it is illustrated 4 different graphs 310, 320, 330 and 340. A first graph 310 may represent a cathode at a first temperature. A second graph 320 may represent a cathode at a second temperature. A third graph 330 may represent a cathode at a third temperature. A fourth graph 310 may represent a cathode at a fourth temperature. The first temperature < the second temperature < the third temperature < the fourth temperature. Not only the temperature of the cathode may affect the numbers of emanating electrons. When the cathode is used its emissivity of electron may change in a similar manner as depicted in Figure 3. An unused cathode may be represented by graph 340. The more the cathode 102 is used the last portion of the graph is shifted to the left. A combination of a change in temperature of the cathode and the degree of use may also be represented by the different graphs in Figure 3, i.e., for relatively cold cathodes and well used the last portion will be shifted to the left and for a relatively hot and new cathode the graph will be shifted to the right.

[0057] The graph in Figure 3 may be defined by applying a predetermined number of different U_G-U_C potentials and measuring the resulting electron beam current for the U_G-U_C potentials. The graph may be approximated by a mathematical expression, for instance a polynomial which is fitted to the graph.

[0058] In an example embodiment of the present invention it is provided a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article. At least one electron beam source is provided for emitting an electron beam for heating and/or fusing the powder material, where the electron beam source comprises a cathode, an anode, and a grid between the cathode and anode. The electron beam source is controlled in a first mode when the formation of the three dimensional article is in a first process step. The electron beam is controlled in a second mode when the formation of the three dimensional article is in a second process step. In the first mode an electron beam current from the electron beam source is controlled in a feed-forward mode and in the second mode the electron beam current is controlled in a feed-back mode.

[0059] In the feed-back mode the grid potential as a function of electron beam current is created or updated. This may be done by measuring the actual electron beam currents for different applied grid voltages. The resulting measurement may be stored in a look-up table and/or be approximated by a mathematical function. The feed-back mode may be accomplished during preheating of a non-fused powder layer, post heat treatment of a fused powder layer, powder distribution or machine idling, i.e., the feed-back mode may be performed during the manufacturing process steps where the accuracy of the electron beam current is not critical. The mathematical function may for instance be of the type $A + Bx + Cx^2 + Dx^3$ or any other suitable mathematical function which will best fit the actual measurement data. If using a look-up table the data points in between actual measured data point may be suitably extrapolated in order to achieve a desired accuracy of the electron beam current. An update of the U_C-U_G as a function of the electron beam current may be performed once in between each fusion of the individual powder layers. The creation of the look-up table or mathematical function may be performed before starting a new manufacture of a three-dimensional article. This will make sure that the correct electron beam fusion current is used when fusing the powder layer from the first powder layer.

[0060] In the feed forward mode a predetermined grid potential is applied for achieving a predetermined electron beam current. The grid potential is taken from a look-up table or calculated from a mathematical function. The feed forward mode is used during the fusion process of the three dimensional article, i.e., when powder material is melted or fused by the electron beam impinged on the powder layer. By extracting the correct grid voltage for achieving a desired electron beam current from either a look up table or a mathematical function the electron beam current may be switched from a first predetermined electron beam current to a second predetermined electron beam current by just switching the potential on the grid from a first grid potential to a second grid potential. This may enable fast switching of the electron beam current during the fusion process with accuracy from a first electron beam current to a second electron beam current. This may be helpful when an electron beam current has to be switched from a first electron beam current to a second electron beam current during a scan line of the electron beam in order to achieve final material characteristics. A simulation before starting the actual build of the three dimensional article may show that the electron beam has to be changed during a particular scan line for a particular reason, which may be material characteristics, final dimension accuracy, or maintenance of the build temperature. By using the inventive feed forward mode for controlling the electron beam

current during the fusion process the accuracy and predictability of the material characteristics of the three dimensional article may be improved. By changing the grid potential from a first value to a second value, the electron beam current may instantaneously change from a first electron beam current to a second desired electron beam current. The fast response of the amendment of the grid potential and the corresponding electron beam current makes it suitable as an addressing method for electron beam current in an additive manufacturing process where the electron beam may need to be amended several times during a small time interval. A sufficiently quick change in the electron beam current may for some applications be the key factor for a successful 3-dimensional article with the desired material properties and dimensional tolerances.

[0061] In the feed-forward mode a predetermined grid potential is applied for achieving a predetermined electron beam current on the powder surface for fusing the powder. Here one is using the grid potential as a function of beam current which is already created and updated. This will make sure that a desired electron beam current will impinge on the powder layer for a predetermined grid potential. This may also enable a fast switching during a fusion process from a first electron beam current to a second electron beam current. This may be necessary during a scan line depending on which, when and/or where a specific type of structure to be melted.

[0062] In an example embodiment of the present invention it is provided a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, the method comprising the steps of: providing at least one electron beam source emitting an electron beam for heating and/or fusing the powder material, where the electron beam source comprising a cathode, an anode, and a grid between the cathode and anode, and changing the electron beam current from the electron beam source from a first electron beam current to a second electron beam current by switching an applied potential on the grid from a first value to a second value.

[0063] The switching may be performed during the fusion of a particular layer of the three dimensional article. In another example embodiment the switching may be performed during the fusion of a particular scan line. The grid potential and the corresponding electron beam currents may be stored in a look up table or be represented by a mathematical function. The look-up table or the mathematical function may be created or updated during preheating of the surface prior to applying a new powder layer onto the surface, preheating of a new powder layer, powder distribution or post heat treatment of an already fused powder layer.

[0064] In another aspect of the invention it is provided a program element configured and arranged when executed on a computer to implement a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, the method comprising the steps of: providing at least one electron beam source emitting an electron beam for heating and/or fusing the powder material, where the electron beam source comprising a cathode, an anode, and a grid between the cathode and anode, controlling the electron beam source in a first mode when the formation of the three dimensional article is in a first process step, controlling the electron beam source in a second mode when the formation of the three dimensional article is in a second process step, wherein an electron beam current from the electron beam source is controlled in a feed-forward mode in the first mode and the electron beam current is controlled in a feed-back mode in the second mode. The program may be installed in a computer readable storage medium. The computer readable storage medium may be the control unit 8, the control unit 150, or another separate and distinct control unit. The computer readable storage medium and the program element, which may comprise computer-readable program code portions embodied therein, may further be contained within a non-transitory computer program product. Further details regarding these features and configurations are provided, in turn, below.

[0065] As mentioned, various embodiments of the present invention may be implemented in various ways, including as non-transitory computer program products. A computer program product may include a non-transitory computer-readable storage medium storing applications, programs, program modules, scripts, source code, program code, object code, byte code, compiled code, interpreted code, machine code, executable instructions, and/or the like (also referred to herein as executable instructions, instructions for execution, program code, and/or similar terms used herein interchangeably). Such non-transitory computer-readable storage media include all computer-readable media (including volatile and non-volatile media).

[0066] In one embodiment, a non-volatile computer-readable storage medium may include a floppy disk, flexible disk, hard disk, solid-state storage (SSS) (e.g., a solid state drive (SSD), solid state card (SSC), solid state module (SSM)), enterprise flash drive, magnetic tape, or any other non-transitory magnetic medium, and/or the like. A non-volatile computer-readable storage medium may also include a punch card, paper tape, optical mark sheet (or any other physical medium with patterns of holes or other optically recognizable indicia), compact disc read only

memory (CD-ROM), compact disc compact disc-rewritable (CD-RW), digital versatile disc (DVD), Blu-ray disc (BD), any other non-transitory optical medium, and/or the like. Such a non-volatile computer-readable storage medium may also include read-only memory (ROM), programmable read-only memory (PROM), erasable programmable read-only memory (EPROM), electrically erasable programmable read-only memory (EEPROM), flash memory (e.g., Serial, NAND, NOR, and/or the like), multimedia memory cards (MMC), secure digital (SD) memory cards, SmartMedia cards, CompactFlash (CF) cards, Memory Sticks, and/or the like. Further, a non-volatile computer-readable storage medium may also include conductive-bridging random access memory (CBRAM), phase-change random access memory (PRAM), ferroelectric random-access memory (FeRAM), non-volatile random-access memory (NVRAM), magnetoresistive random-access memory (MRAM), resistive random-access memory (RRAM), Silicon-Oxide-Nitride-Oxide-Silicon memory (SONOS), floating junction gate random access memory (FJG RAM), Millipede memory, racetrack memory, and/or the like.

[0067] In one embodiment, a volatile computer-readable storage medium may include random access memory (RAM), dynamic random access memory (DRAM), static random access memory (SRAM), fast page mode dynamic random access memory (FPM DRAM), extended data-out dynamic random access memory (EDO DRAM), synchronous dynamic random access memory (SDRAM), double data rate synchronous dynamic random access memory (DDR SDRAM), double data rate type two synchronous dynamic random access memory (DDR2 SDRAM), double data rate type three synchronous dynamic random access memory (DDR3 SDRAM), Rambus dynamic random access memory (RDRAM), Twin Transistor RAM (TTRAM), Thyristor RAM (T-RAM), Zero-capacitor (Z-RAM), Rambus in-line memory module (RIMM), dual in-line memory module (DIMM), single in-line memory module (SIMM), video random access memory VRAM, cache memory (including various levels), flash memory, register memory, and/or the like. It will be appreciated that where embodiments are described to use a computer-readable storage medium, other types of computer-readable storage media may be substituted for or used in addition to the computer-readable storage media described above.

[0068] As should be appreciated, various embodiments of the present invention may also be implemented as methods, apparatus, systems, computing devices, computing entities, and/or the like, as have been described elsewhere herein. As such, embodiments of the present invention may take the form of an apparatus, system, computing device, computing entity, and/or the like

executing instructions stored on a computer-readable storage medium to perform certain steps or operations. However, embodiments of the present invention may also take the form of an entirely hardware embodiment performing certain steps or operations.

[0069] Various embodiments are described below with reference to block diagrams and flowchart illustrations of apparatuses, methods, systems, and computer program products. It should be understood that each block of any of the block diagrams and flowchart illustrations, respectively, may be implemented in part by computer program instructions, e.g., as logical steps or operations executing on a processor in a computing system. These computer program instructions may be loaded onto a computer, such as a special purpose computer or other programmable data processing apparatus to produce a specifically-configured machine, such that the instructions which execute on the computer or other programmable data processing apparatus implement the functions specified in the flowchart block or blocks.

[0070] These computer program instructions may also be stored in a computer-readable memory that can direct a computer or other programmable data processing apparatus to function in a particular manner, such that the instructions stored in the computer-readable memory produce an article of manufacture including computer-readable instructions for implementing the functionality specified in the flowchart block or blocks. The computer program instructions may also be loaded onto a computer or other programmable data processing apparatus to cause a series of operational steps to be performed on the computer or other programmable apparatus to produce a computer-implemented process such that the instructions that execute on the computer or other programmable apparatus provide operations for implementing the functions specified in the flowchart block or blocks.

[0071] Accordingly, blocks of the block diagrams and flowchart illustrations support various combinations for performing the specified functions, combinations of operations for performing the specified functions and program instructions for performing the specified functions. It should also be understood that each block of the block diagrams and flowchart illustrations, and combinations of blocks in the block diagrams and flowchart illustrations, could be implemented by special purpose hardware-based computer systems that perform the specified functions or operations, or combinations of special purpose hardware and computer instructions.

[0072] Figure 4 is a block diagram of an exemplary system **1020** that can be used in conjunction with various embodiments of the present invention. In at least the illustrated

embodiment, the system **1020** may include one or more central computing devices **1110**, one or more distributed computing devices **1120**, and one or more distributed handheld or mobile devices **1300**, all configured in communication with a central server **1200** (or control unit) via one or more networks **1130**. While Figure 4 illustrates the various system entities as separate, standalone entities, the various embodiments are not limited to this particular architecture.

[0073] According to various embodiments of the present invention, the one or more networks **1130** may be capable of supporting communication in accordance with any one or more of a number of second-generation (2G), 2.5G, third-generation (3G), and/or fourth-generation (4G) mobile communication protocols, or the like. More particularly, the one or more networks **1130** may be capable of supporting communication in accordance with 2G wireless communication protocols IS-136 (TDMA), GSM, and IS-95 (CDMA). Also, for example, the one or more networks **1130** may be capable of supporting communication in accordance with 2.5G wireless communication protocols GPRS, Enhanced Data GSM Environment (EDGE), or the like. In addition, for example, the one or more networks **1130** may be capable of supporting communication in accordance with 3G wireless communication protocols such as Universal Mobile Telephone System (UMTS) network employing Wideband Code Division Multiple Access (WCDMA) radio access technology. Some narrow-band AMPS (NAMPS), as well as TACS, network(s) may also benefit from embodiments of the present invention, as should dual or higher mode mobile stations (e.g., digital/analog or TDMA/CDMA/analog phones). As yet another example, each of the components of the system **5** may be configured to communicate with one another in accordance with techniques such as, for example, radio frequency (RF), Bluetooth™, infrared (IrDA), or any of a number of different wired or wireless networking techniques, including a wired or wireless Personal Area Network (“PAN”), Local Area Network (“LAN”), Metropolitan Area Network (“MAN”), Wide Area Network (“WAN”), or the like.

[0074] Although the device(s) **1110-1300** are illustrated in Figure 4 as communicating with one another over the same network **1130**, these devices may likewise communicate over multiple, separate networks.

[0075] According to one embodiment, in addition to receiving data from the server **1200**, the distributed devices **1110**, **1120**, and/or **1300** may be further configured to collect and transmit data on their own. In various embodiments, the devices **1110**, **1120**, and/or **1300** may be capable of receiving data via one or more input units or devices, such as a keypad, touchpad, barcode

scanner, radio frequency identification (RFID) reader, interface card (e.g., modem, etc.) or receiver. The devices **1110**, **1120**, and/or **1300** may further be capable of storing data to one or more volatile or non-volatile memory modules, and outputting the data via one or more output units or devices, for example, by displaying data to the user operating the device, or by transmitting data, for example over the one or more networks **1130**.

[0076] In various embodiments, the server **1200** includes various systems for performing one or more functions in accordance with various embodiments of the present invention, including those more particularly shown and described herein. It should be understood, however, that the server **1200** might include a variety of alternative devices for performing one or more like functions, without departing from the spirit and scope of the present invention. For example, at least a portion of the server **1200**, in certain embodiments, may be located on the distributed device(s) **1110**, **1120**, and/or the handheld or mobile device(s) **1300**, as may be desirable for particular applications. As will be described in further detail below, in at least one embodiment, the handheld or mobile device(s) **1300** may contain one or more mobile applications **1330** which may be configured so as to provide a user interface for communication with the server **1200**, all as will be likewise described in further detail below.

[0077] Figure 5A is a schematic diagram of the server **1200** according to various embodiments. The server **1200** includes a processor **1230** that communicates with other elements within the server via a system interface or bus **1235**. Also included in the server **1200** is a display/input device **1250** for receiving and displaying data. This display/input device **1250** may be, for example, a keyboard or pointing device that is used in combination with a monitor. The server **1200** further includes memory **1220**, which preferably includes both read only memory (ROM) **1226** and random access memory (RAM) **1222**. The server's ROM **1226** is used to store a basic input/output system **1224** (BIOS), containing the basic routines that help to transfer information between elements within the server **1200**. Various ROM and RAM configurations have been previously described herein.

[0078] In addition, the server **1200** includes at least one storage device or program storage **210**, such as a hard disk drive, a floppy disk drive, a CD Rom drive, or optical disk drive, for storing information on various computer-readable media, such as a hard disk, a removable magnetic disk, or a CD-ROM disk. As will be appreciated by one of ordinary skill in the art, each of these storage devices **210** are connected to the system bus **1235** by an appropriate

interface. The storage devices **1210** and their associated computer-readable media provide nonvolatile storage for a personal computer. As will be appreciated by one of ordinary skill in the art, the computer-readable media described above could be replaced by any other type of computer-readable media known in the art. Such media include, for example, magnetic cassettes, flash memory cards, digital video disks, and Bernoulli cartridges.

[0079] Although not shown, according to an embodiment, the storage device **1210** and/or memory of the server **1200** may further provide the functions of a data storage device, which may store historical and/or current delivery data and delivery conditions that may be accessed by the server **1200**. In this regard, the storage device **1210** may comprise one or more databases. The term “database” refers to a structured collection of records or data that is stored in a computer system, such as via a relational database, hierarchical database, or network database and as such, should not be construed in a limiting fashion.

[0080] A number of program modules (e.g., exemplary modules **1400-1700**) comprising, for example, one or more computer-readable program code portions executable by the processor **1230**, may be stored by the various storage devices **1210** and within RAM **1222**. Such program modules may also include an operating system **1280**. In these and other embodiments, the various modules **1400, 1500, 1600, 1700** control certain aspects of the operation of the server **1200** with the assistance of the processor **1230** and operating system **1280**. In still other embodiments, it should be understood that one or more additional and/or alternative modules may also be provided, without departing from the scope and nature of the present invention.

[0081] In various embodiments, the program modules **1400, 1500, 1600, 1700** are executed by the server **1200** and are configured to generate one or more graphical user interfaces, reports, instructions, and/or notifications/alerts, all accessible and/or transmittable to various users of the system **1020**. In certain embodiments, the user interfaces, reports, instructions, and/or notifications/alerts may be accessible via one or more networks **1130**, which may include the Internet or other feasible communications network, as previously discussed.

[0082] In various embodiments, it should also be understood that one or more of the modules **1400, 1500, 1600, 1700** may be alternatively and/or additionally (e.g., in duplicate) stored locally on one or more of the devices **1110, 1120, and/or 1300** and may be executed by one or more processors of the same. According to various embodiments, the modules **1400,**

1500, 1600, 1700 may send data to, receive data from, and utilize data contained in one or more databases, which may be comprised of one or more separate, linked and/or networked databases.

[0083] Also located within the server **1200** is a network interface **1260** for interfacing and communicating with other elements of the one or more networks **1130**. It will be appreciated by one of ordinary skill in the art that one or more of the server **1200** components may be located geographically remotely from other server components. Furthermore, one or more of the server **1200** components may be combined, and/or additional components performing functions described herein may also be included in the server.

[0084] While the foregoing describes a single processor **1230**, as one of ordinary skill in the art will recognize, the server **1200** may comprise multiple processors operating in conjunction with one another to perform the functionality described herein. In addition to the memory **1220**, the processor **1230** can also be connected to at least one interface or other means for displaying, transmitting and/or receiving data, content or the like. In this regard, the interface(s) can include at least one communication interface or other means for transmitting and/or receiving data, content or the like, as well as at least one user interface that can include a display and/or a user input interface,, as will be described in further detail below. The user input interface, in turn, can comprise any of a number of devices allowing the entity to receive data from a user, such as a keypad, a touch display, a joystick or other input device.

[0085] Still further, while reference is made to the “server” **1200**, as one of ordinary skill in the art will recognize, embodiments of the present invention are not limited to traditionally defined server architectures. Still further, the system of embodiments of the present invention is not limited to a single server, or similar network entity or mainframe computer system. Other similar architectures including one or more network entities operating in conjunction with one another to provide the functionality described herein may likewise be used without departing from the spirit and scope of embodiments of the present invention. For example, a mesh network of two or more personal computers (PCs), similar electronic devices, or handheld portable devices, collaborating with one another to provide the functionality described herein in association with the server **1200** may likewise be used without departing from the spirit and scope of embodiments of the present invention.

[0086] According to various embodiments, many individual steps of a process may or may not be carried out utilizing the computer systems and/or servers described herein, and the degree

of computer implementation may vary, as may be desirable and/or beneficial for one or more particular applications.

[0087] Figure 5B provides an illustrative schematic representative of a mobile device **1300** that can be used in conjunction with various embodiments of the present invention. Mobile devices **1300** can be operated by various parties. As shown in Figure 5B, a mobile device **1300** may include an antenna **1312**, a transmitter **1304** (e.g., radio), a receiver **1306** (e.g., radio), and a processing element **1308** that provides signals to and receives signals from the transmitter **1304** and receiver **1306**, respectively.

[0088] The signals provided to and received from the transmitter **1304** and the receiver **1306**, respectively, may include signaling data in accordance with an air interface standard of applicable wireless systems to communicate with various entities, such as the server **1200**, the distributed devices **1110**, **1120**, and/or the like. In this regard, the mobile device **1300** may be capable of operating with one or more air interface standards, communication protocols, modulation types, and access types. More particularly, the mobile device **1300** may operate in accordance with any of a number of wireless communication standards and protocols. In a particular embodiment, the mobile device **1300** may operate in accordance with multiple wireless communication standards and protocols, such as GPRS, UMTS, CDMA2000, 1xRTT, WCDMA, TD-SCDMA, LTE, E-UTRAN, EVDO, HSPA, HSDPA, Wi-Fi, WiMAX, UWB, IR protocols, Bluetooth protocols, USB protocols, and/or any other wireless protocol.

[0089] Via these communication standards and protocols, the mobile device **1300** may according to various embodiments communicate with various other entities using concepts such as Unstructured Supplementary Service data (USSD), Short Message Service (SMS), Multimedia Messaging Service (MMS), Dual-Tone Multi-Frequency Signaling (DTMF), and/or *Subscriber Identity Module Dialer* (SIM dialer). The mobile device **1300** can also download changes, additions, and updates, for instance, to its firmware, software (e.g., including executable instructions, applications, program modules), and operating system.

[0090] According to one embodiment, the mobile device **1300** may include a location determining device and/or functionality. For example, the mobile device **1300** may include a GPS module adapted to acquire, for example, latitude, longitude, altitude, geocode, course, and/or speed data. In one embodiment, the GPS module acquires data, sometimes known as

ephemeris data, by identifying the number of satellites in view and the relative positions of those satellites.

[0091] The mobile device **1300** may also comprise a user interface (that can include a display **1316** coupled to a processing element **1308**) and/or a user input interface (coupled to a processing element **308**). The user input interface can comprise any of a number of devices allowing the mobile device **1300** to receive data, such as a keypad **1318** (hard or soft), a touch display, voice or motion interfaces, or other input device. In embodiments including a keypad **1318**, the keypad can include (or cause display of) the conventional numeric (0-9) and related keys (#, *), and other keys used for operating the mobile device **1300** and may include a full set of alphabetic keys or set of keys that may be activated to provide a full set of alphanumeric keys. In addition to providing input, the user input interface can be used, for example, to activate or deactivate certain functions, such as screen savers and/or sleep modes.

[0092] The mobile device **1300** can also include volatile storage or memory **1322** and/or non-volatile storage or memory **1324**, which can be embedded and/or may be removable. For example, the non-volatile memory may be ROM, PROM, EPROM, EEPROM, flash memory, MMCs, SD memory cards, Memory Sticks, CBRAM, PRAM, FeRAM, RRAM, SONOS, racetrack memory, and/or the like. The volatile memory may be RAM, DRAM, SRAM, FPM DRAM, EDO DRAM, SDRAM, DDR SDRAM, DDR2 SDRAM, DDR3 SDRAM, RDRAM, RIMM, DIMM, SIMM, VRAM, cache memory, register memory, and/or the like. The volatile and non-volatile storage or memory can store databases, database instances, database mapping systems, data, applications, programs, program modules, scripts, source code, object code, byte code, compiled code, interpreted code, machine code, executable instructions, and/or the like to implement the functions of the mobile device **1300**.

[0093] The mobile device **1300** may also include one or more of a camera **1326** and a mobile application **1330**. The camera **1326** may be configured according to various embodiments as an additional and/or alternative data collection feature, whereby one or more items may be read, stored, and/or transmitted by the mobile device **1300** via the camera. The mobile application **1330** may further provide a feature via which various tasks may be performed with the mobile device **1300**. Various configurations may be provided, as may be desirable for one or more users of the mobile device **1300** and the system **1020** as a whole.

[0094] The invention is not limited to the above-described embodiments and many modifications are possible within the scope of the following claims. Such modifications may, for example, involve using a different source of energy beam than the exemplified electron beam such as a laser beam. Other materials than metallic powder may be used, such as the non-limiting examples of: electrically conductive polymers and powder of electrically conductive ceramics.

CLAIMS

1. A method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, said method comprising the steps of:
 - providing at least one electron beam source emitting an electron beam for at least one of heating or fusing said powder material, where said electron beam source comprises a cathode, an anode, and a grid between said cathode and anode;
 - controlling the electron beam source in a first mode when said formation of said three dimensional article is in a first process step; and
 - controlling said electron beam source in a second mode when said formation of said three dimensional article is in a second process step,
 - wherein an electron beam current from said electron beam source is controlled in a feed-forward mode in said first mode and said electron beam current is controlled in a feed-back mode in said second mode.
2. The method according to claim 1, wherein said first process step is said fusion of the powder material for forming said three-dimensional article.
3. The method according to claim 1, wherein said second process step is one of the group of: preheating of the surface prior to applying a new powder layer onto said surface, preheating of a new powder layer, powder distribution, or post heat treatment of an already fused powder layer.
4. The method according to claim 1, further comprising the steps of:
 - applying a predetermined accelerator voltage between said cathode and said anode;
 - applying a predetermined number of different grid voltages between said grid and said cathode for producing a corresponding predetermined number of electron beam currents; and

at least one of creating or updating a look-up table or mathematical function during said second mode wherein said look-up table or mathematical function defines a relationship between a desired electron beam current and an applied grid voltage.

5. The method according to claim 4, further comprising the steps of:
 - comparing a first actual electron beam current with a first desired electron beam current; and
 - updating at least one of the look-up table or mathematical function if the difference between said first actual and first desired electron beam currents is greater than a predetermined value.
6. The method according to claim 5, wherein the updating is performed after fusing a predetermined number of layers of the three-dimensional article.
7. The method according to claim 5, wherein the updating is performed between the fusion process of each layer.
8. The method according to claim 1, further comprising the steps of:
 - retrieving said predetermined grid voltage for producing said desired electron beam current from said look-up table or a mathematical function; and
 - changing said predetermined grid voltage from a first grid voltage to a second grid voltage during said first mode for changing said electron beam current from a first value to a second desired value during fusion of a predetermined layer.
9. The method according to claim 8, wherein said predetermined grid voltage is changed from a first grid voltage to a second grid voltage during fusion of at least one individual scan line for changing said electron beam current in said scan line from a first value to a second desired value.

10. A program element configured and arranged when executed on a computer to implement a method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, said method comprising the steps of:
 - providing at least one electron beam source emitting an electron beam for at least one of heating or fusing said powder material, where said electron beam source comprises a cathode, an anode, and a grid between said cathode and anode;
 - controlling the electron beam source in a first mode when said formation of said three dimensional article is in a first process step; and
 - controlling said electron beam source in a second mode when said formation of said three dimensional article is in a second process step, wherein an electron beam current from said electron beam source is controlled in a feed-forward mode in said first mode and said electron beam current is controlled in a feed-back mode in said second mode.
11. A computer readable medium having stored thereon the program element according to claim 10.
12. A non-transitory computer program product comprising at least one non-transitory computer-readable storage medium having computer-readable program code portions embodied therein, the computer-readable program code portions comprising:
 - an executable portion configured for controlling an electron beam source in a first mode when formation of a three dimensional article is in a first process step, the electron beam source emitting an electron beam for at least one of heating or fusing individual layers of a powder material together so as to form said three-dimensional article, the electron beam source comprising a cathode, an anode, and a grid between said cathode and anode; and
 - an executable portion configured for controlling said electron beam source in a second mode when said formation of said three dimensional article

is in a second process step, wherein an electron beam current from said electron beam source is controlled in a feed-forward mode in said first mode and said electron beam current is controlled in a feed-back mode in said second mode.

13. A method for forming a three-dimensional article through successively depositing individual layers of powder material that are fused together so as to form the article, said method comprising the steps of:

providing at least one electron beam source emitting an electron beam for at least one of heating or fusing said powder material, where said electron beam source comprises a cathode, an anode, and a grid between said cathode and anode;

controlling the electron beam source in at least two modes during said formation of said three dimensional article;

applying a predetermined accelerator voltage between said cathode and said anode;

applying a predetermined number of different grid voltages between said grid and said cathode for producing a corresponding predetermined number of electron beam currents; and

at least one of creating or updating a look-up table or mathematical function during one of the at least two modes, wherein said look-up table or mathematical function defines a relationship between a desired electron beam current and an applied grid voltage.

14. The method according to claim 13, wherein:

the at least two modes comprise a first mode and a second mode;

the first mode is utilized to control the electron beam source in a first process step;

the second mode is utilized to control the electron beam source in a second process step;

said first process step is said fusion of the powder material for forming said three-dimensional article; and

said second process step is one of the group of: preheating of the surface prior to applying a new powder layer onto said surface, preheating of a new powder layer, powder distribution, or post heat treatment of an already fused powder layer.

15. The method according to Claim 13, further comprising the steps of:
 - comparing a first actual electron beam current with a first desired electron beam current; and
 - updating at least one of the look-up table or mathematical function if the difference between said first actual and first desired electron beam currents is greater than a predetermined value.
16. The method according to claim 15, wherein the updating is performed after fusing a predetermined number of layers of the three-dimensional article.
17. The method according to claim 15, wherein the updating is performed between the fusion process of each layer.
18. The method according to claim 13, further comprising the steps of:
 - retrieving said predetermined grid voltage for producing said desired electron beam current from said look-up table or a mathematical function; and
 - changing said predetermined grid voltage from a first grid voltage to a second grid voltage during said first mode for changing said electron beam current from a first value to a second desired value during fusion of a predetermined layer.
19. The method according to claim 18, wherein said predetermined grid voltage is changed from a first grid voltage to a second grid voltage during fusion of at least one individual scan line for changing said electron beam current in said scan line from a first value to a second desired value.

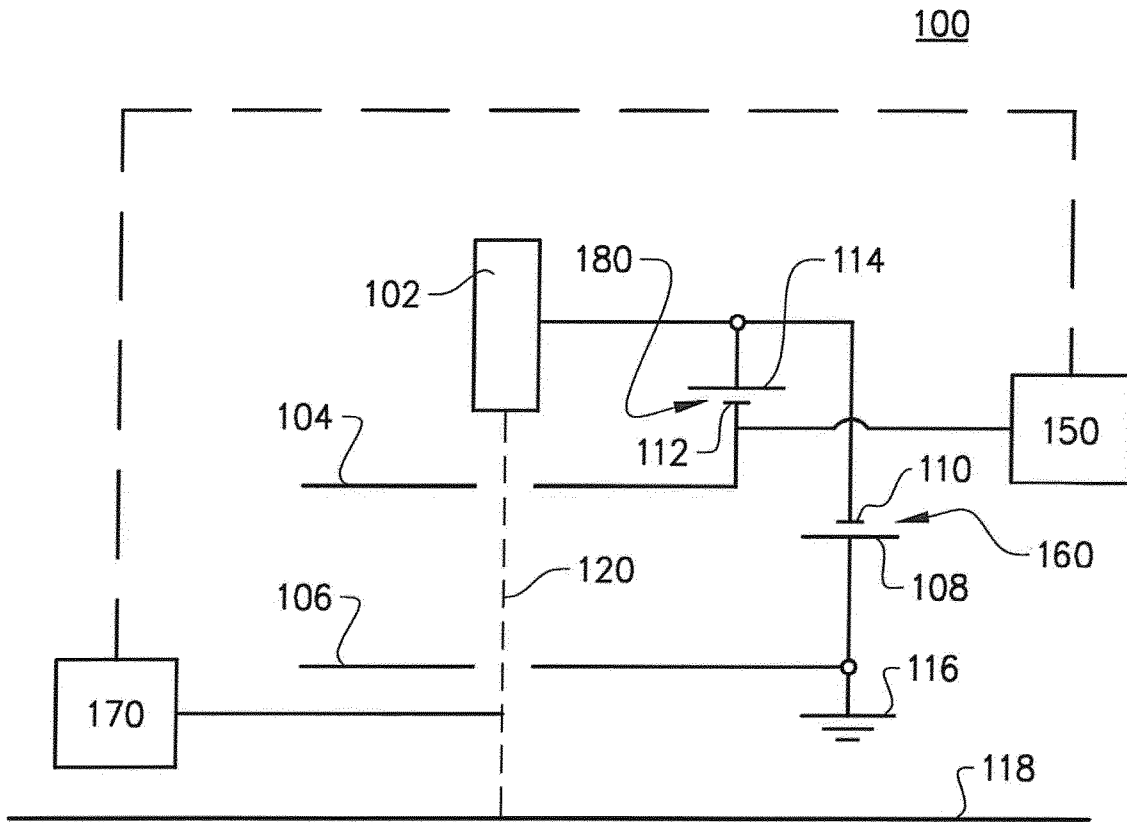


FIG. 1

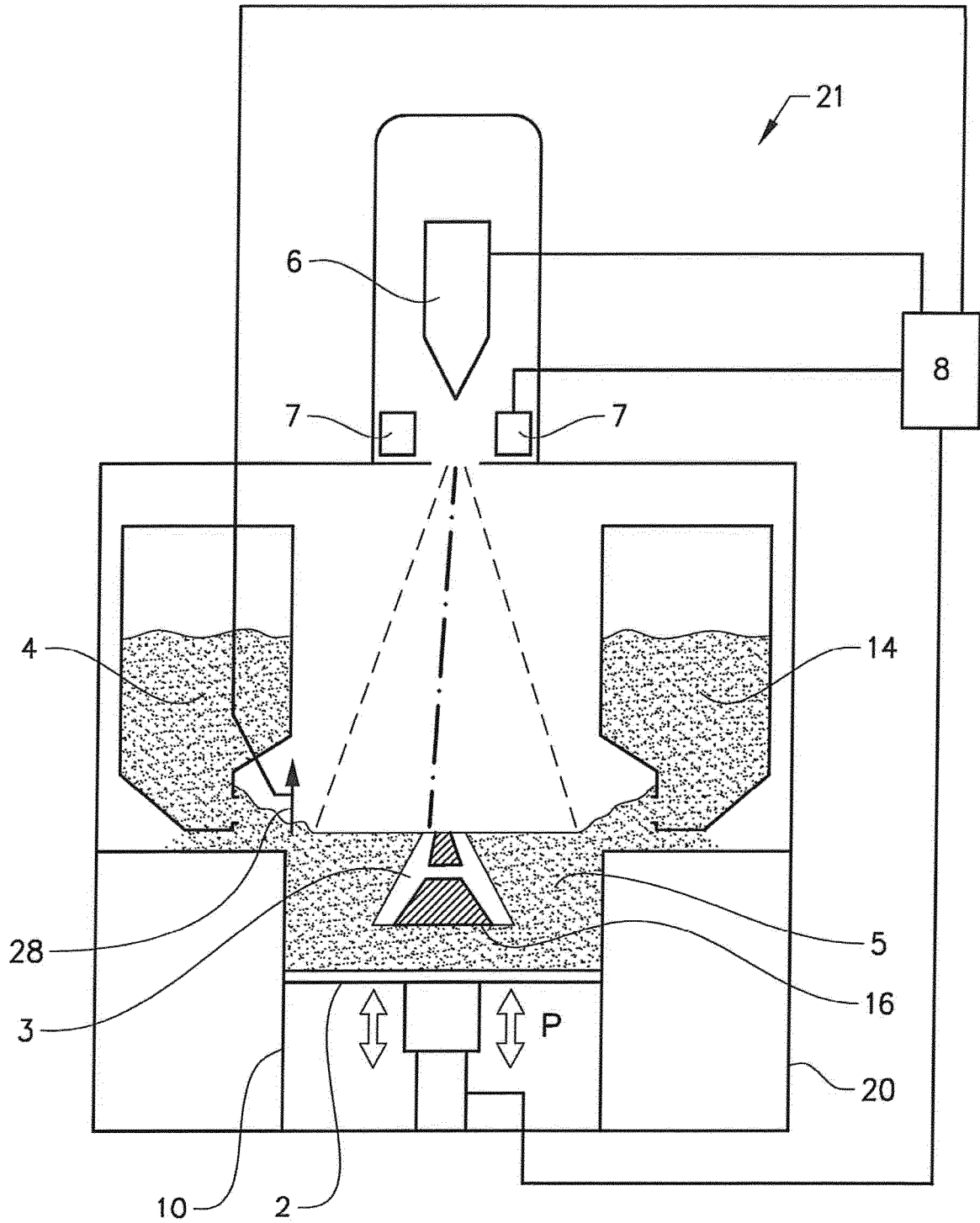


FIG. 2

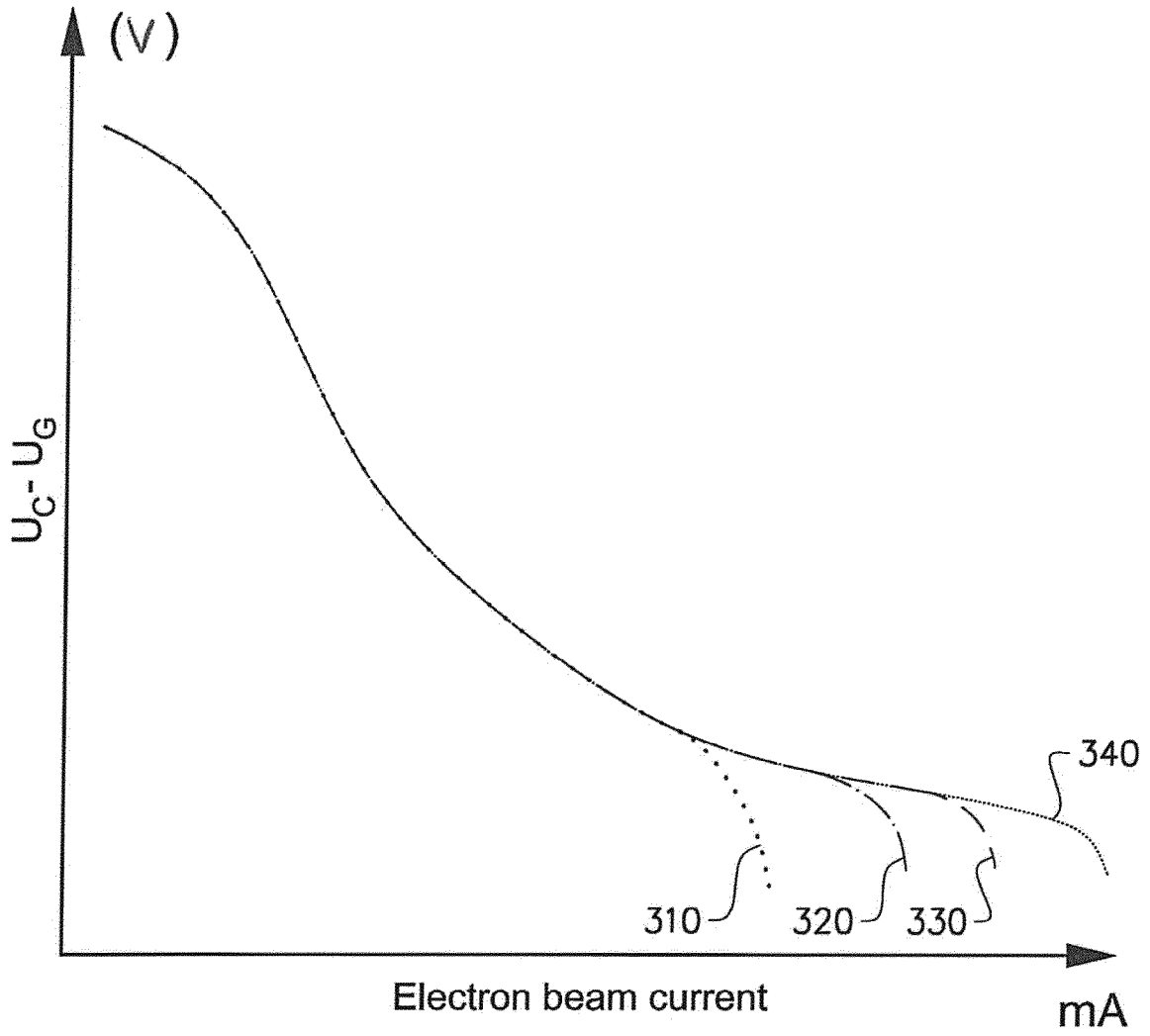
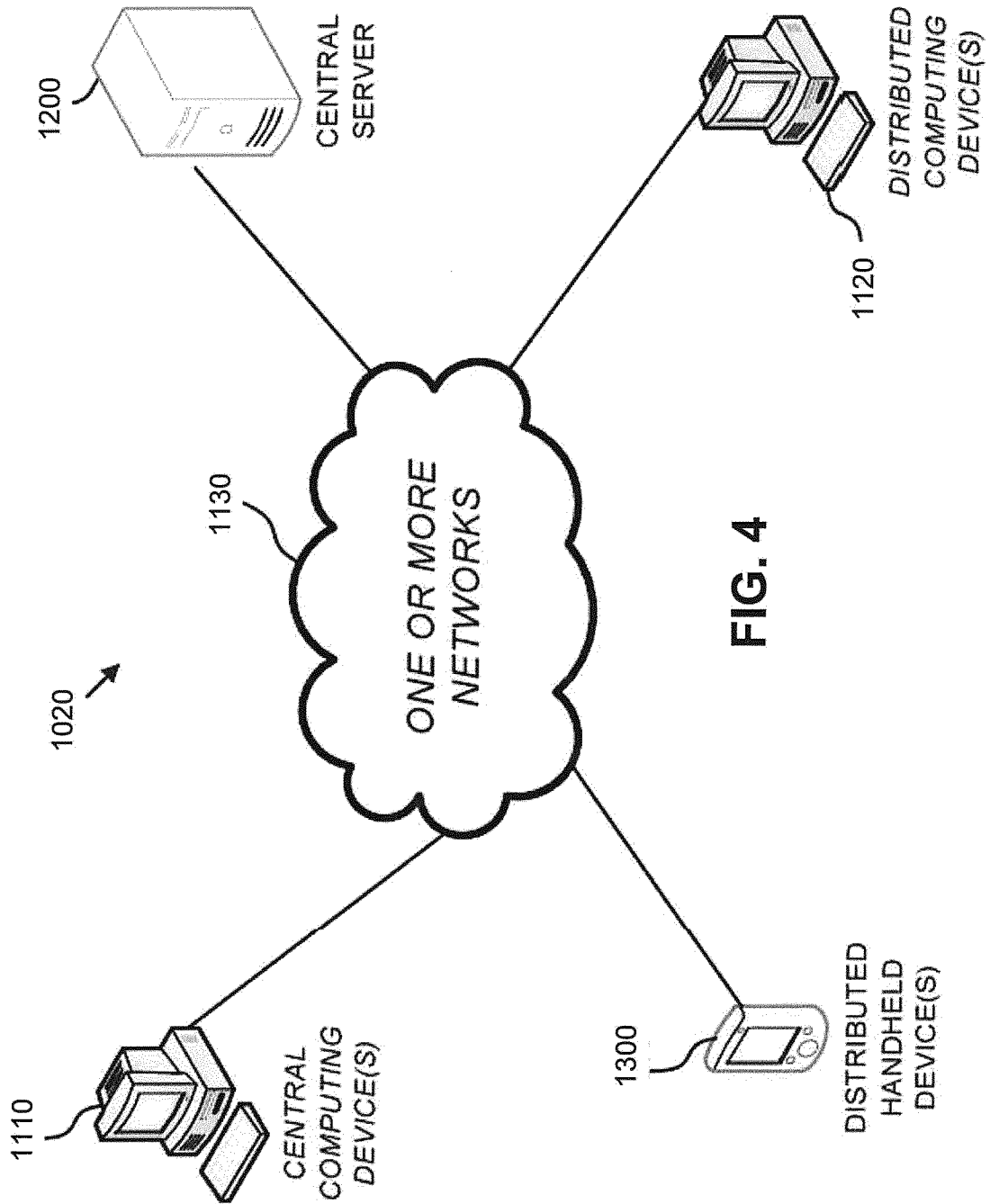


FIG. 3



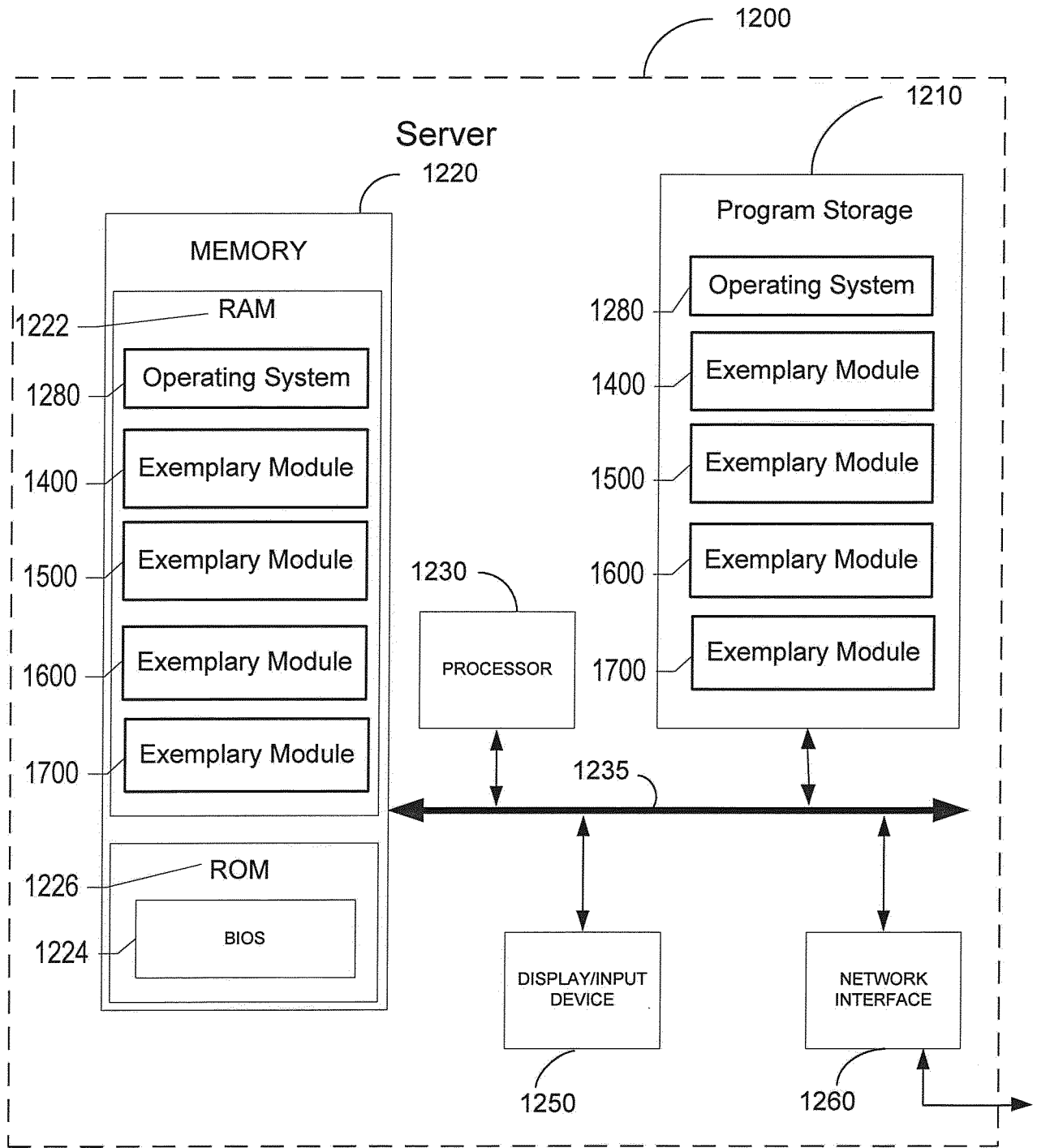


FIG. 5A

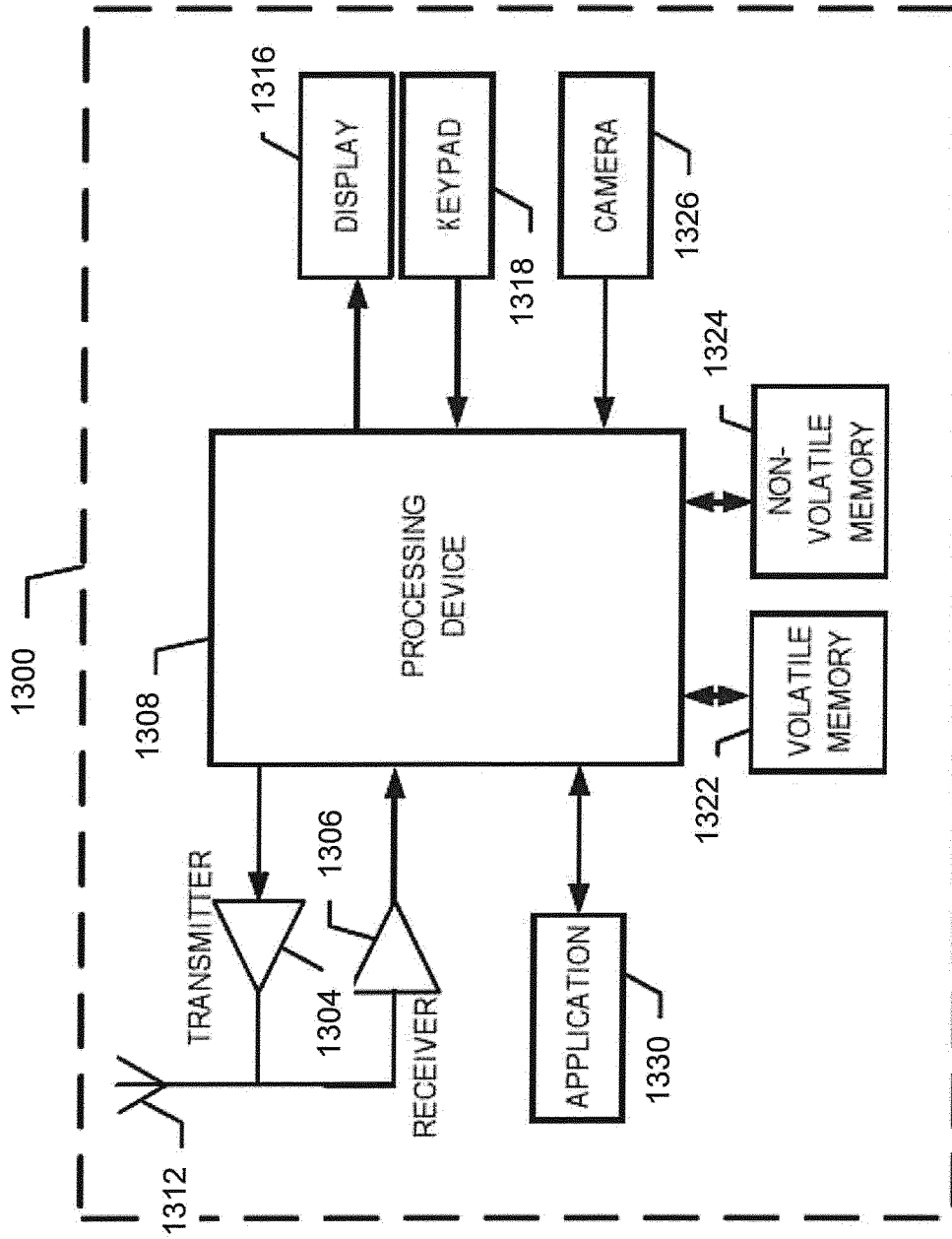


FIG. 5B

INTERNATIONAL SEARCH REPORT

International application No
PCT/EP2014/077582

A. CLASSIFICATION OF SUBJECT MATTER
 INV. B29C67/00 B22F3/105 B33Y10/00 B33Y50/02
 ADD.
 According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
 Minimum documentation searched (classification system followed by classification symbols)
 B29C B22F B33Y

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
 EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 2013/300286 A1 (LJUNGBLAD ULRIC [SE] ET AL) 14 November 2013 (2013-11-14) paragraph [0050] - paragraph [0054] paragraph [0056]; figure 1a -----	1-19
A	WO 2013/098050 A1 (ARCAM AB [SE]) 4 July 2013 (2013-07-04) claim 1; figure 2 -----	1-19
A	US 2013/055568 A1 (DUSEL KARL-HEINZ [DE] ET AL) 7 March 2013 (2013-03-07) claims 21, 23; figure 1 -----	1-19
A	US 6 537 052 B1 (ADLER RICHARD J [US]) 25 March 2003 (2003-03-25) claim 1; figure 1 -----	1-19

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents :

<p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier application or patent but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p>	<p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art</p> <p>"&" document member of the same patent family</p>
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Date of the actual completion of the international search 17 April 2015	Date of mailing of the international search report 29/04/2015
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer Pierre, Nathalie
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INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No PCT/EP2014/077582

Patent document cited in search report	Publication date	Patent family member(s)	Publication date	
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