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Influence of build orientation on porosity, strength and dimensional accuracy of laser sintered polyamide porous bone scaffolds

Keywords: build orientation, compressive strength, impact strength, PA2200, porous bone scaffold, selective laser sintering

Development of synthetic bone graft via bone tissue engineering involves seeding of patient's stem cells onto a porous scaffold in presence of growth factors. Porosity, strength and dimensional accuracy of the porous scaffold play a vital role in this process. This work aims at ascertaining influence of build orientation on porosity, mechanical strength and dimensional accuracy of the selectively laser sintered polyamide porous scaffolds. Initially, CAD models of test specimens with pre-designed porosity were created in Solidworks[®] software. All the specimens were fabricated on EOSINT P395, a selective laser sintering machine, along various primary (Flat, Edge, Upright and Flat_diag) and secondary (0°, 30°, 45°, 60° and 90°) orientations. Results show that measured porosity of most of the specimens was (range: 42.89-35.26%) less than the designed porosity (41.71%). Maximum average tensile strength (16.84 MPa) was recorded for specimens printed along Flat_0° orientation. Specimens printed along Upright_90° orientation showed highest average compressive strength (8.26 MPa). Specimens printed along Flat orientation showed relatively better average impact strength. Best dimensional accuracy was obtained for specimens printed along Flat orientation.

1. Introduction

Bone consists of two different structures, 1) a hard outer layer known as cortical bone and 2) a soft, spongy inner layer known as cancellous bone. This unique structure makes bone hard and strong yet light in weight. Bone is well known for its excellent self-healing abilities. However, external intervention is usually needed to heal the critical-sized defect completely [1]. The external



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intervention mainly involves tissue-grafting and synthetic material replacement. Two tissue-grafting approaches, namely auto graft (bone taken from the patient's own body) and allograft (bone taken from a donor) are quite popular. However, tissue-grafting as well as synthetic material-replacement has certain limitations. Tissue grafting includes limitations such as donor-site morbidity, unavailability of adequate volume and quality of bone, non-availability of donor, infection and rejection by the host body. Synthetic materials do not show a perfect integration with host tissue and usually fail over a period due to wear and fatigue [2-5].

Bone tissue engineering (BTE), a sub-branch of tissue engineering, has emerged as one of the most promising approaches to repair critical-sized bone defects [6]. BTE involves development of implantable bone substitutes by seeding isolated cells onto a porous scaffold in presence of tissue-inducing substances. For successful regeneration of bone, porous scaffold should be biocompatible, biodegradable, osteoconductive and osteoinductive. In addition, it must possess adequate compressive strength to withstand the pressure exerted by the sprouting cells [7-9]. Researchers developed several techniques such as freeze-drying, salt leaching, solvent casting, fibre bonding, electro spinning, gas foaming etc. to fabricate porous scaffold. However, these techniques do not offer any precise mechanism to control the shape and size of interconnected pores. Furthermore, customized shapes are also difficult to be produced [10-11]. In order to overcome the aforementioned limitations, researchers started exploring additive manufacturing (AM) to fabricate porous scaffolds for BTE. Several researchers found AM to be very much capable of controlling not only the shape and size of the pores but also very efficient in producing custom-shaped scaffolds [12-15]. Researchers have explored different AM technologies, namely liquid resin based stereolithography, extrusion based fused deposition modelling, ceramic powder based inkjet 3D printing, powder bed based selective laser sintering as well as directed energy deposition based technologies for this purpose [16-19].

Selective laser sintering (SLS) is one of the most widely used AM technologies for fabricating polymer based porous scaffolds. SLS technology involves selective sintering of polyamide powder material spread onto a platform by using a laser beam. In comparison to stereolithography or fused deposition modelling, SLS does not require any support structure as loose unfused powder spread onto the platform itself becomes support to the sintered portion. This reduces post processing time and cost. Polyamide (PA12) is a widely used polymer for SLS technology. It is a biocompatible material and suitable for bone scaffold [20]. Due to inherent additive nature of the SLS technology, certain amount of inconsistencies in size, shape, porosity and mechanical properties of the fabricated parts are likely to occur.

Several researchers tried establishing relationship between process parameters and properties of the produced parts by conducting various kinds of physical, mechanical, and micro structural investigations [21-25]. Jain et al. (2008) [26]

conducted experiments to evaluate tensile strength of PA2200 parts fabricated via SLS process and identified layer thickness, part bed temperature, hatch pattern and refresh rate as key parameters, which affect the part strength. Pilipovic et al. [27] studied effect of energy density on flexural strength of selective laser sintering parts. They varied energy densities by changing beam overlay at constant speed and power to conduct various experiments. They evaluated flexural properties at different density as well as effect of beam overlay on density of the fabricated parts. Singh et al. [28] investigated compressive strength of polyamide (PA2200) scaffold structures useful in tissue engineering. They designed porous structures using computer-aided design (CAD) modelling software and fabricated on SLS system at different energy densities. Authors observed higher contribution of laser power, scan spacing, and layer thickness than scan speed on compressive strength of the fabricated scaffolds. Mousa [29] employed Taguchi design of experiment approach to investigate the effect of process parameters on the curling of the selective laser sintered specimens. The specimens were fabricated using composites of PA12 and PA12 mixed with a rigid multiphase-coated particle. They found layer thickness as the largest influencer for curling of the fabricated specimens. Other parameters like laser power, bed temperature and filler ratio had little contribution towards curling of the specimens.

Goodridge et al. [30] revealed through their investigation that selective laser sintering of polymer powder was influenced majorly by layer thickness, energy density, build orientation, build position, rate of cooling and type of powder (fresh or recycled). Mengqi et al. [31] investigated effects of orientation of three mutually perpendicular planes on the resolution of wedges and lithospheres geometries fabricated in PA12 material. The resolution was measured using stereomicroscopy for the mutually perpendicular planes. They observed better contrast and resolution for parts fabricated in vertical planes rather than horizontal plane. Guido et al. [32] conducted experiments on selective laser sintering, laser melting and fused deposition modelling processes for identifying the geometrical characteristics of additively manufactured parts. For selective laser sintering process, basic geometrical elements were fabricated using PA2200 polymeric material. After sample evaluation, authors reported the best possible orientations, directions, thicknesses and radius for different elements. Berti et al. [33] investigated mechanical properties of PA-Al₂O₃ composite samples fabricated via selective laser sintering process. The samples were fabricated at different orientation angles in the build chamber. They observed a higher anisotropy in vertical direction of sintering. Moreover, higher influence of sintering direction was found with increasing temperature of build chamber. Stoia et al. [34] conducted experiments to identify the influence of orientation on tensile strength of polyamide PA2200 samples fabricated through selective laser sintering process and observed best tensile properties for samples oriented at 0°.

Feng et al. [35] fabricated specimens at different orientations on FDM printer with polyamide-12 filament prepared using fresh and recycled powder material. They studied effect of orientation on tensile, bending and impact strength of the specimens and concluded that specimens fabricated along x-axis with fresh powder were superior in terms of mechanical properties. Zárbybnická [36] investigated influence of additives and print orientations (along x-, y- and z-axis) on tensile strength, surface roughness and toughness of the PA-12 specimens fabricated on EOS's SLS system. A decrease in tensile strength and an increase in toughness and surface roughness of the printed samples were observed on inclusion of additives. Tensile strength of the samples printed along z-axis was found worst; whereas, along x- and y-axis, it was found quite similar and better than the z-axis. El Magri et al. [37], studied influence of laser power and hatch orientation on the tensile strength of the selective laser sintered PA12 parts. Results showed best tensile strength at highest laser power and at 0° orientation in XY plane.

It has been observed from literature review that orientation of part in build chamber play a significant role in deciding mechanical strength of the fabricated parts. Nevertheless, majority of the studies have been performed using solid specimens. Only a few studies reported consideration of porous specimens to conduct the mechanical tests. In light of all the findings from the literature review, a good scope is realised for a comprehensive study that ascertains effect of important part build orientations via fabrication of porous specimens. This study aims to evaluate the influence of part orientation on measured porosity, mechanical properties and dimensional accuracy of the selective laser sintered PA2200 porous specimens mimicking the porous bone scaffolds.

2. Material and methods

2.1. Material

PA2200 powder, a proprietary material by EOS GmbH, Germany, was used to fabricate all the porous specimens in this study. It is a nylon based on polyamide-12. PA2200 is a semi-crystalline, white coloured, fine-grained polymer material with average grain size 56 μm . It is a biocompatible (according to EN ISO 10993-1 and USP/level VI/121 °C) material having a melting temperature range from 172-180°C. The bulk density of the powder is 450 Kg/m^3 and density of laser-sintered part is 930 Kg/m^3 . Its ability to offer good strength, durability and heat resistance make it suitable for wide range of medical applications [38]. The powder used to carry out this study is a mixture of new and old (recycled) powder. The new and old powders were mixed in ratio of 30:70. The old powder was already recycled two times.

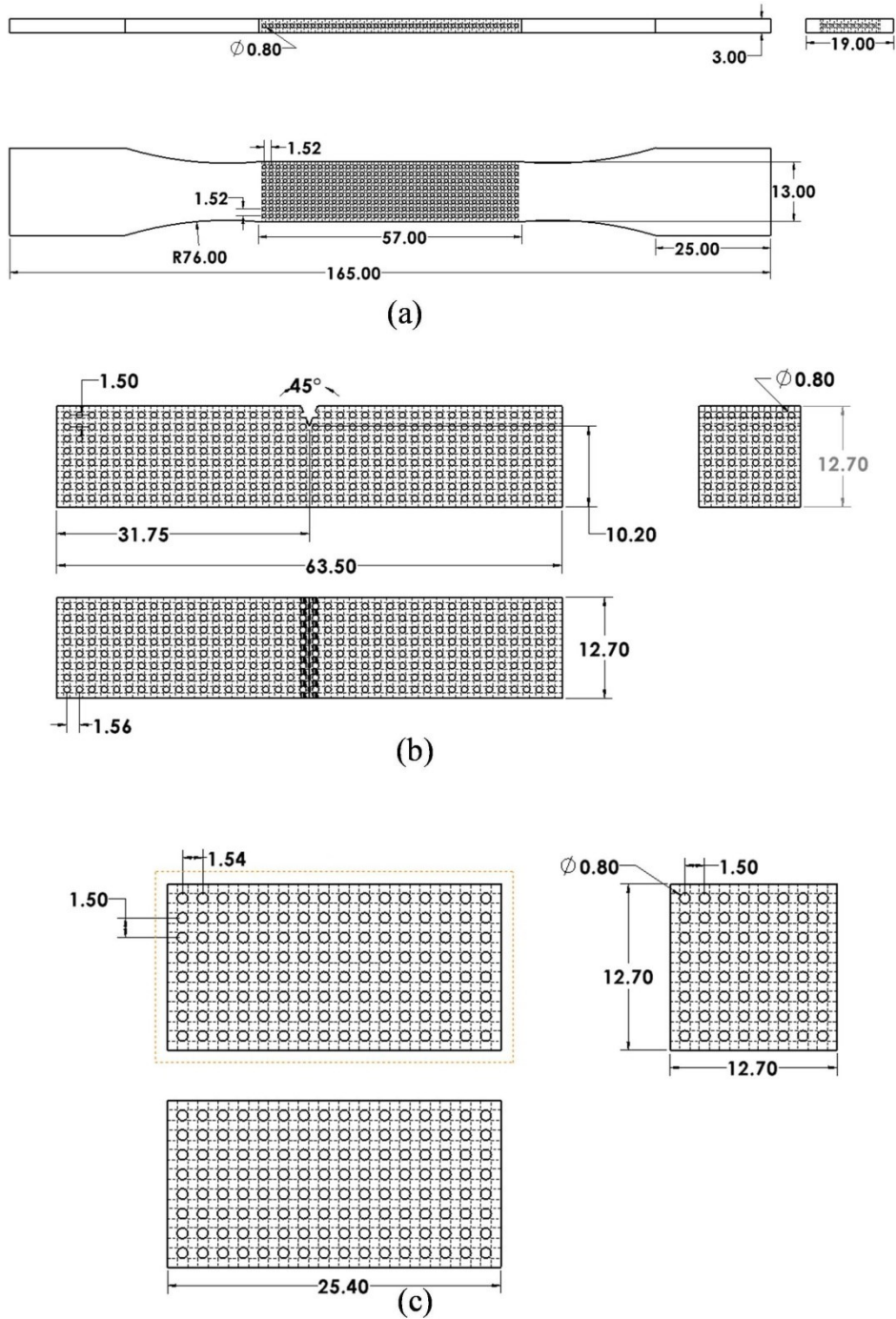


Fig. 1. Orthographic views of (a) tensile, (b) compression, and (c) impact (Izod) test specimens

2.2. CAD Modelling of test specimens

It is a known fact that porosity of synthetic scaffolds should be enough to allow cell proliferation and nutrient flow. Pore size ranging from 100 to 900 μm and porosity in range of 30-70% were found suitable by researchers for cell attachment, proliferation and nutrient flow through porous scaffolds [39, 40]. De-powdering of the hollow features has been an important consideration for powder bed printers. Authors of this paper via pilot study for PA2200 powder on EOSINT P395 m/c found 800 μm to be the smallest pore size that can be de-powdered easily. SO, considering all these facts, it was decided to keep the pore size approx. 800 μm and porosity not less than 30% for the test specimens.

CAD models of the porous specimens were created using Solidworks[®] software (Dassault Systems, France). Test specimens for tensile, compression and impact test were prepared according to ASTM D638, ASTM D695 and ASTM D256 standards respectively. The CAD models of tensile, compression and impact test (Izod) are shown in Fig. 1.

2.3. Additive manufacturing of test specimens

The prepared CAD models of the specimens were first saved into AM compatible .stl file format. It was important to choose .stl parameters carefully, so that minute details of the porous specimens could be maintained. The .stl file parameters for compression model were as follows: deviation tolerance: 0.01426996 mm, angle tolerance: 10°, number of triangles: 691564. The size of .stl file was 691564 MB.

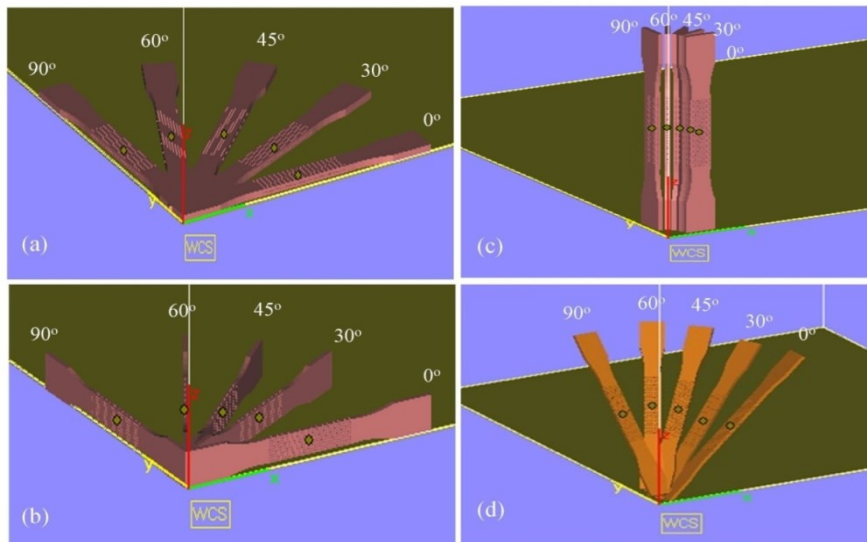


Fig. 2. Representation of primary a) Flat, b) Edge, c) Upright, and d) Flat_diag along with secondary orientations of specimens inside build chamber

Once all the CAD models were converted into .stl format, they were loaded into MagicsRP software for build preparation. In order to study the effect of part orientation in build chamber, specimens were kept in different orientations. The specimens were kept along four primary (Flat, Edge, Upright and Flat_diag) and five secondary (0°, 30°, 45°, 60° and 90°) orientations in build chamber as depicted in Fig. 2. Three copies of each CAD model were arranged in each orientation to avoid the fabrication as well as measurement errors.

After preparing the build volume, slicing of the models was performed using RP Tools software. Finally, sliced data was transferred to PSW 3.6 software of the EOSINT P395, a selective laser sintering machine by Electro Optical System (EOS) Germany. All the specimens were fabricated at the following process parameters; laser type: CO₂, laser power: 50 W, scan speed: 8 m/s, build temperature: 176 °C and layer thickness: 0.12 mm. Initially, AM machine was kept on warm-up mode for 2 hours to bring the temperature inside chamber to desired level. After that, fabrication of specimen started in layer-by-layer manner. After fabrication, machine was left idle for about 8-9 hours to cool down the chamber and avoid warpage and distortion of the fabricated specimens. Three specimens of each type were fabricated to enhance the repeatability and accuracy of results. Finally, all the specimens were removed from the build chamber. Image of specimen of each type is shown in Fig. 3.

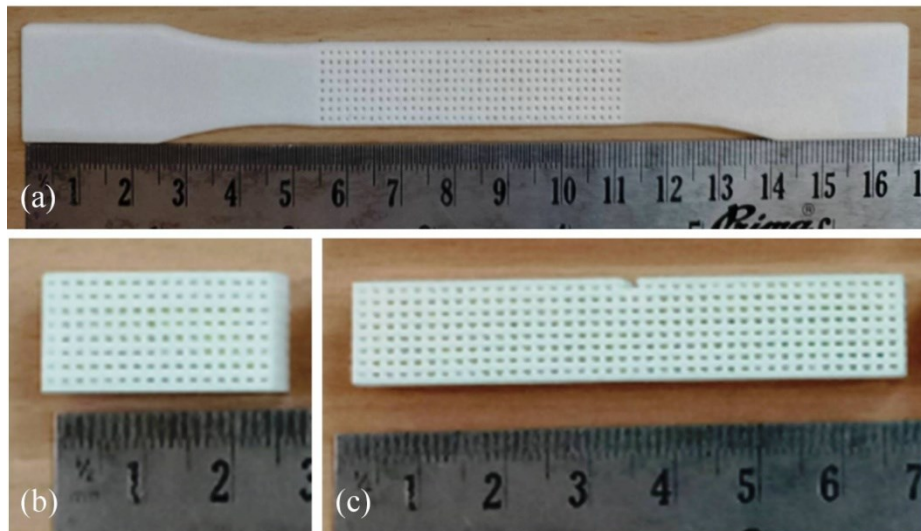


Fig.3. Photographs of the fabricated specimens a) Tensile, b) Compression, and c) Impact

2.4. Methods of measurement and testing

Particle size distribution of PA2200 powder was performed using a sieve shaker as well as Malvern particle size analyser. X-ray diffraction (XRD) of the powder material was carried out using Panalytical Empyrean XRD diffractometer. The scanning electron microscope (SEM) images were obtained

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through high-resolution field emission scanning electron microscope (ULTRA Plus, Zeiss). Macro porosity measurement was done using micro-CT scanning and reconstruction of 3D virtual model of the porous specimens. Mechanical performance of the fabricated specimens was assessed through tensile, compression and impact strength testing. A compression-testing machine, Tinius Olsen H5KL with 10 kN load-cell and a cross-head loading rate of 0.5 mm per minute was employed to measure the tensile and compressive strength of the fabricated prototypes. Tinius Olsen, IT 503 plastics impact tester was used to conduct the Izod impact test of the specimens. Digital Vernier calliper with least count 0.01 mm was used to measure the linear dimension of the fabricated specimens.

3. Results and discussions

3.1. Material characterization

Particle size distribution (PSD) has significant effect on final quality of the selective laser sintered parts. Particles with diameter higher than 40 μm usually exhibit a good flowability. Smaller particles inhibit smooth flow due to sticky characteristics [41]. A sieve shaker consisting of a set of sieves ranging from 1700 to 53 μm mesh was used for the purpose and the result obtained is shown in Fig. 4.

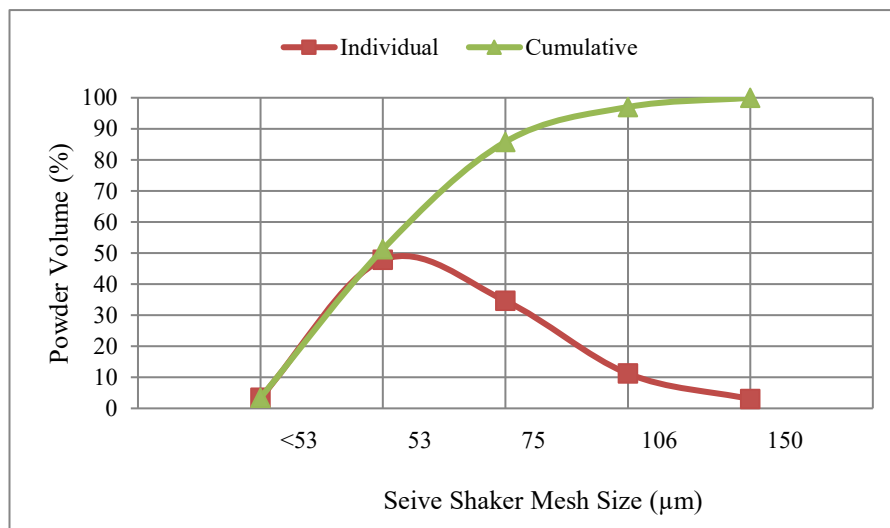


Fig.4. Particle size distribution of PA2200 powder via sieve shake

It can be observed that about 85% particles are below 75 μm and about 96% particles are smaller than 106 μm . Analysis on particle size analyser revealed that D_{10} , D_{50} and D_{90} values were corresponding to 33.7 μm , 56.4 μm and 75.2 μm

respectively. This means that 50% of the particles are equal or smaller than 56.4 μm and 90% particles are equal or smaller than 75.2 μm .

PA2200 powder consists of crystalline as well as amorphous region, making it a semi-crystalline polymer. It mainly exhibits two different crystal structures, namely metastable α -structure and stable γ -crystalstructure. Fig. 5 shows x-ray diffraction pattern of the used PA2200 powder material. The XRD pattern mainly exhibits the metastable α -phase, which has a molecular chain oriented in an anti-parallel manner with a high crystalline ratio [22, 23]. Diffraction peaks at the angle 9.5° and 10° show α - crystal structure.

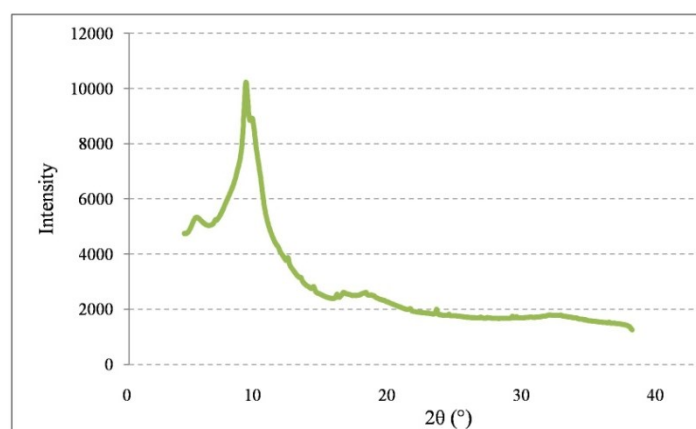


Fig.5. XRD pattern of PA2200 powder

SEM images, shown in Fig. 6, were obtained using a high-resolution field emission scanning electron microscope (ULTRA Plus, Zeiss). Fig. 6(a) reveals that powder particles have spherical as well as irregular shapes. Surface of some of the particles has cracks also. This may be due to mixing of new with old powder. New particles are likely to be regular in shape. In Fig. 6(b), we can see that shape of the hole is not perfectly circular, due to sticking of powder particles. This may be one of the prominent reasons behind variation in measured macro porosity from the designed porosity.

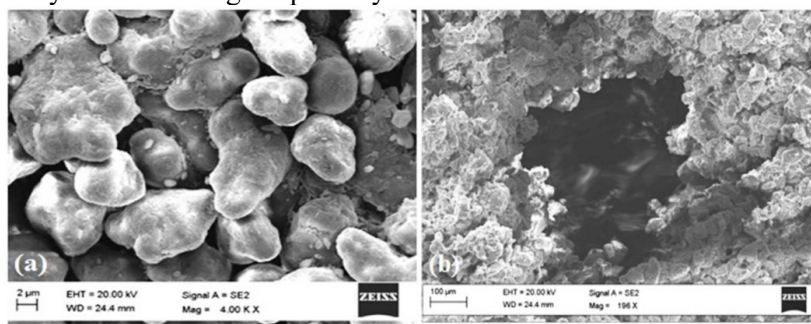


Fig.6. SEM images of PA200 a) powder, and b) fabricated specimen

3.2. Macro porosity

The cuboid shaped (compression test) porous specimen, shown in Fig. 3(b), was used to analyse the macro porosity of the fabricated specimens. The individual as well as average macro porosity of three specimens along with one standard deviation (SD), was computed and summarised in Table 1.

Table 1. Individual and average measured porosity (%) for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	S1	40.7	40.58	39.85	39.42	41.68
	S2	41.9	39.82	39.55	40.26	41.36
	S3	40.22	40.13	38.46	38.57	42.89
	Avg±SD	40.94±0.87	40.18±0.38	39.29±0.73	39.42±0.85	41.98±0.81
Edge	S1	42.25	39.34	39.72	40.85	38.72
	S2	40.14	39.88	38.26	39.65	41.36
	S3	41.37	38.67	40.12	38.94	40.14
	Avg±SD	41.25±1.06	39.30±0.61	39.37±0.98	39.81±0.97	40.07±1.32
Upright	S1	39.72	39.72	37.42	38.53	38.78
	S2	39.68	37.28	36.58	35.66	39.36
	S3	38.08	39.36	38.25	39.78	39.18
	Avg±SD	40.16±0.94	38.79±1.32	37.42±0.84	37.99±2.11	39.11±0.30
Flat_diagonal	S1	36.47	37.78	38.45	38.84	38.2
	S2	38.56	35.26	35.42	37.68	36.06
	S3	36.88	38.75	35.77	36.14	37.82
	Avg±SD	37.30±1.11	37.26±1.80	36.55±1.66	37.55±1.35	37.36±1.14

The designed porosity of the cuboid shaped specimen was calculated as 41.71% through Solidworks® software. Careful observation of Table 1 reveals that measured porosity is less than the designed porosity for almost all the specimens printed along various orientations. The highest individual measured porosity obtained is 42.89% for specimen printed along Flat_90° orientation; whereas, the lowest porosity obtained is 35.26% for specimen printed along Flat_diag_30° orientation.

To visualise and compare the results in a better and easy way, average measured porosity for various orientations is depicted in Fig. 7.

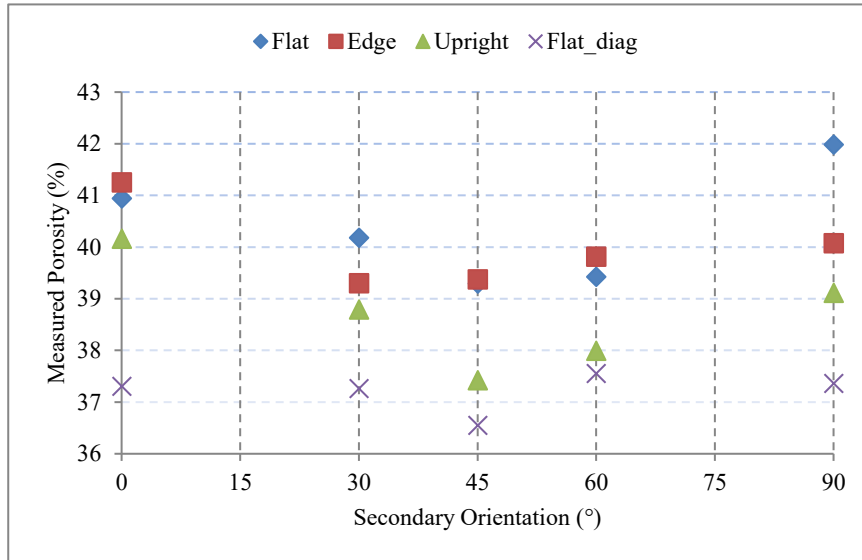


Fig.7. Average measured porosity for various orientations

We can see that average porosity of specimens printed along Flat and Edge orientations is comparatively higher than other primary orientations. Similar results for Flat and Edge orientations are due to identical printing conditions for cuboid shaped specimen. Porosity is lowest for Flat_diag orientation. Rough surface and uneven profile of the pores is bound to occur due to inherent nature of the powder bed process. Relatively higher number of layers is needed to print specimen along Flat_diag and Upright orientations. More number of layers introduces more inaccuracy in cylindricity of the pores. The lowest porosity for Flat_diag orientation may be attributed to slant orientation of the specimens making axes of pores slant to the layer being printed. In this case, staircase effect comes into picture as shown in Fig 8.

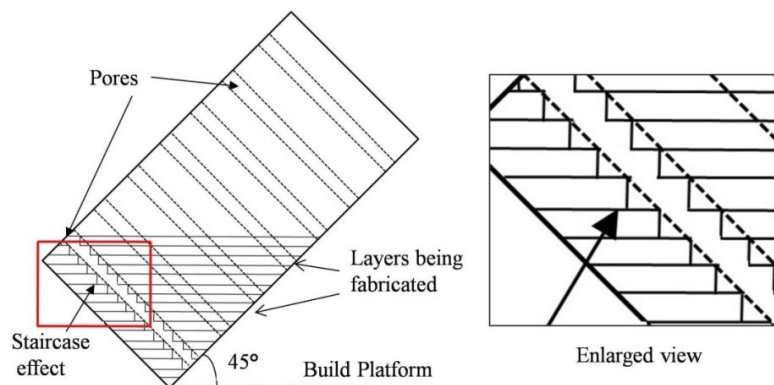


Fig. 8. Mechanism of layer deposition in Flat_diag orientation (Picture only for representation and not to scale)

The bar chart depicted in Fig. 9, shows percentage reduction from designed to measured porosities for various orientations. It is clear that relatively low reduction is obtained in case of Flat/Edge orientations.

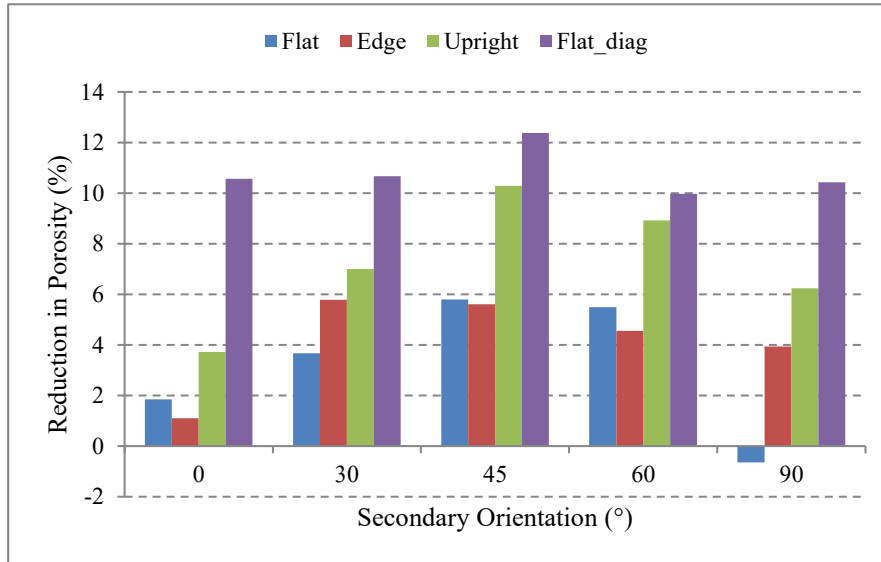


Fig. 9. Reduction in porosity for various orientations

3.3. 3.3 Mechanical Properties

Tensile, compression and impact testing were conducted to assess the mechanical behaviour of the fabricated porous specimens. Tensile test was performed using porous dog-bone specimen, shown in Fig. 1(a). The individual as well as average tensile strength (ultimate) with one SD for various primary and secondary orientations is provided in Table 2.

Table 2 reveals that tensile strength of the individual specimens printed along Flat orientation is comparatively higher than all other orientations. Tensile strength is lowest for the specimens printed along Upright orientation. This may be understood by the way printing take place in different orientations. For specimens printed along Flat orientation, cross-section of the layers and layers' orientation remain along the tensile loading. Hence, greater load is needed to break the bond between layers. On the other hand, specimens printed in Upright and Flat_diag orientations have relatively small cross-section; moreover, tensile loading is perpendicular to layers. Hence, smaller tensile load is required to break the bond between two adjacent layers. It is also noteworthy that SD for specimens printed along 0° orientations is lowest for a particular primary orientation. Stress-Strain diagram of specimens for 0° orientation is shown in Fig. 10.

Table 2. Individual and average tensile strength (MPa) for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	S1	17.24	14.73	16.3	16.32	16.22
	S2	16.82	15.85	14.8	15.62	17.14
	S3	16.45	13.96	16.1	14.96	15.42
	Avg±SD	16.84±0.4	14.85±0.9	15.73±0.8	15.63±0.6	16.26±0.8
Edge	S1	14.78	15.12	13.56	14.32	15.24
	S2	14.23	13.68	14.63	12.62	13.45
	S3	15.37	13.84	14.84	13.74	13.92
	Avg±SD	14.79±0.5	14.21±0.7	14.34±0.6	13.56±0.8	14.20±0.9
Upright	S1	11.24	10.74	10.2	9.62	10.356
	S2	9.84	8.56	10.85	7.92	10.43
	S3	9.96	8.78	9.18	10.12	12.37
	Avg±SD	10.35±0.7	9.36±1.20	10.08±0.8	9.22±1.15	11.05±1.1
Flat_diag	S1	12.87	10.68	10.55	10.67	11.2
	S2	11.35	11.85	14.22	12.74	13.7
	S3	12.25	12.36	12.43	13.53	12.3
	Avg±SD	12.16±0.7	11.63±0.8	12.40±1.8	12.31±1.4	12.40±1.2

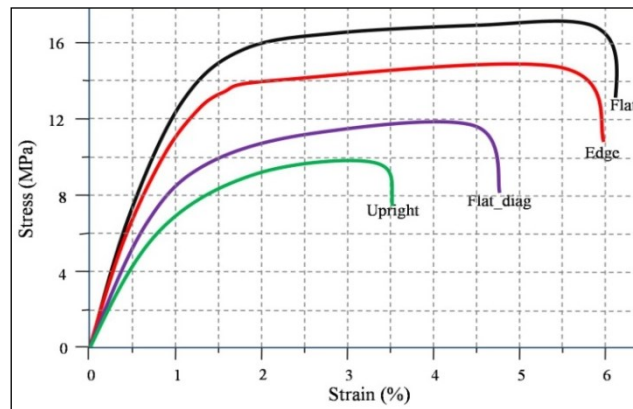


Fig. 10. Stress-strain diagram for specimens fabricated along 0° orientation

To visualise, interpret and compare the effect of orientations on tensile strength, results are plotted in Fig. 11. It can be seen that tensile strength of the specimens printed along Flat orientation is highest; slightly less for Edge orientation and lowest for Upright orientation for all the secondary orientations. It is also interesting to see that relatively higher tensile strength is obtained for specimens printed along 0° orientation for all the primary orientations.

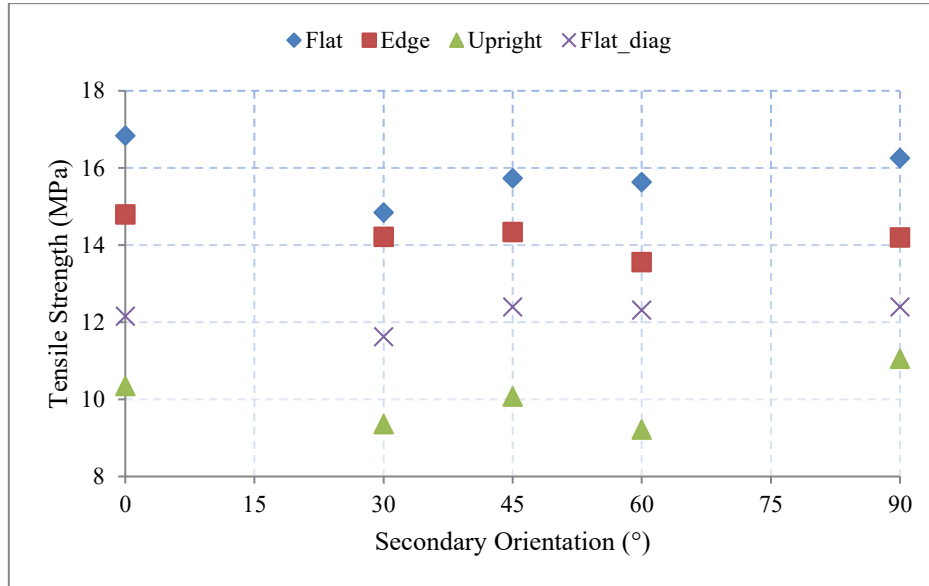


Fig. 11. Average tensile strength for various build orientations

Individual and average Young’s modulus along with one SD for all the specimens have been summarised in Table 3.

Table 3. Individual and average Young’s modulus (MPa) for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	S1	727	689	724	755	714
	S2	809	769	792	782	689
	S3	688	724	682	636	785
	Avg±SD	741.33±61.76	727.33±40.10	732.67±55.51	724.33±77.68	729.33±49.80
Edge	S1	720	649	735	695	765
	S2	748	688	658	715	675
	S3	698	724	692	642	710
	Avg±SD	722.00±25.06	687±37.51	695±38.59	684±37.72	716.67±45.37
Upright	S1	720	585	626	672	624
	S2	634	662	705	712	653
	S3	672	665	613	628	737
	Avg±SD	675.33±43.10	637.33±45.35	648.00±49.79	670.67±42.02	671.33±58.69
Flat_diag	S1	745	713	746	658	633
	S2	643	682	715	696	726
	S3	718	665	617	598	764
	Avg±SD	702.00±52.85	686.67±24.34	692.67±67.34	650.67±49.41	707.67±67.40

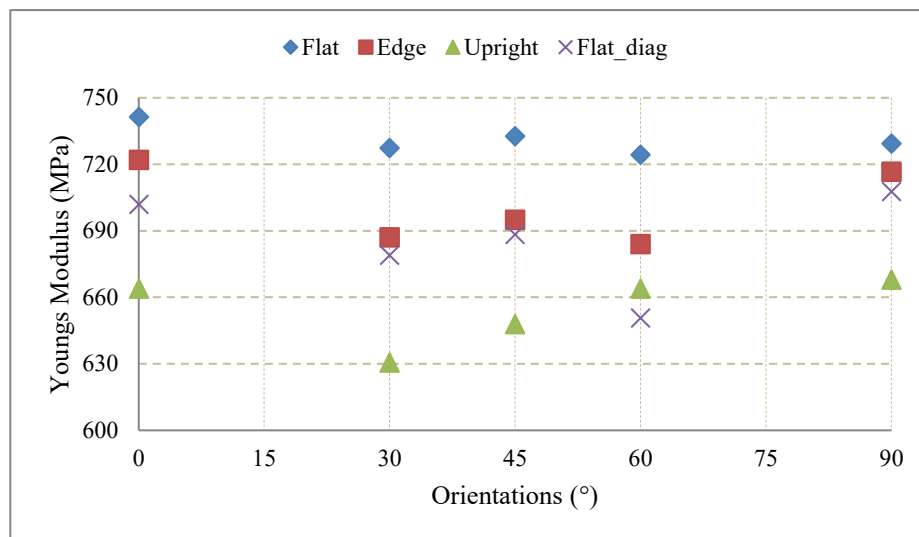


Fig. 12. Average Young's modulus for various build orientations

As can be seen from the Fig. 12, highest values of average Young's modulus is obtained for specimens printed along Flat orientation; average values ranging from 724 to 741 MPa for various secondary orientations. Here again lowest values are obtained for Upright orientations. This indicates that specimens printed along Flat orientation are stiffer and resistant to deformation in elastic range.

Compressive strength of the porous scaffold is very crucial for both load and non-load bearing cases. For load bearing cases, scaffold must be able to withstand the load and should not collapse until tissues proliferate and support the scaffold. For non-load bearing and *in-vitro* applications, scaffold must possess adequate strength so that it does not break or collapse under the pressure exerted by sprouting cells. To analyse the behaviour of the porous scaffold under compression, cuboid shaped specimen was used. The individual and average compressive strength values along with one SD have been summarised in Table 4. The compressive strength of various specimens ranges from 4.82 to 8.94 MPa.

Average compressive strength for various orientations has been presented in Fig. 13. From the Fig., it is clearly visible that specimens printed along Upright orientation are superior in comparison with Flat and Edge orientations. It may be because of more number of layers printed in Upright orientation; moreover, layers are stacked parallel to loading direction, leading to more compressive load requirement for breaking the specimen. It is also interesting to see that compressive strength of specimens printed along Flat and Edge orientation are very close to each other. It is due to cuboid shaped specimen. For specimens printed along Flat_diag orientation, layers remain 45° inclined to loading direction and fails easily, leading to low compressive strength.

Table 4. Individual and average compressive strength (MPa) for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	S1	7.85	6.57	6.92	7.68	8.16
	S2	6.92	7.16	7.12	6.34	7.26
	S3	7.9	7.68	7.43	8.12	6.64
	Avg±SD	7.56±0.55	7.14±0.56	7.16±0.26	7.38±0.93	7.35±0.76
Edge	S1	7.45	6.44	7.28	6.85	8.14
	S2	6.38	8.22	6.9	7.15	6.75
	S3	8.12	6.98	8.22	6.73	7.74
	Avg±SD	7.32±0.88	7.21±0.91	7.47±0.68	6.91±0.22	7.54±0.72
Upright	S1	7.85	7.65	7.67	7.98	8.52
	S2	8.66	7.78	8.12	7.32	8.94
	S3	8.1	8.42	7.26	8.18	7.32
	Avg±SD	8.20±0.41	7.95±0.41	7.68±0.43	7.83±0.45	8.26±0.84
Flat_diag	S1	6.23	5.11	6.85	4.82	6.78
	S2	5.23	4.87	5.46	5.86	6.45
	S3	6.34	5.72	5.24	5.46	5.65
	Avg±SD	5.93±0.61	5.23±0.44	5.85±0.87	5.38±0.52	6.29±0.58

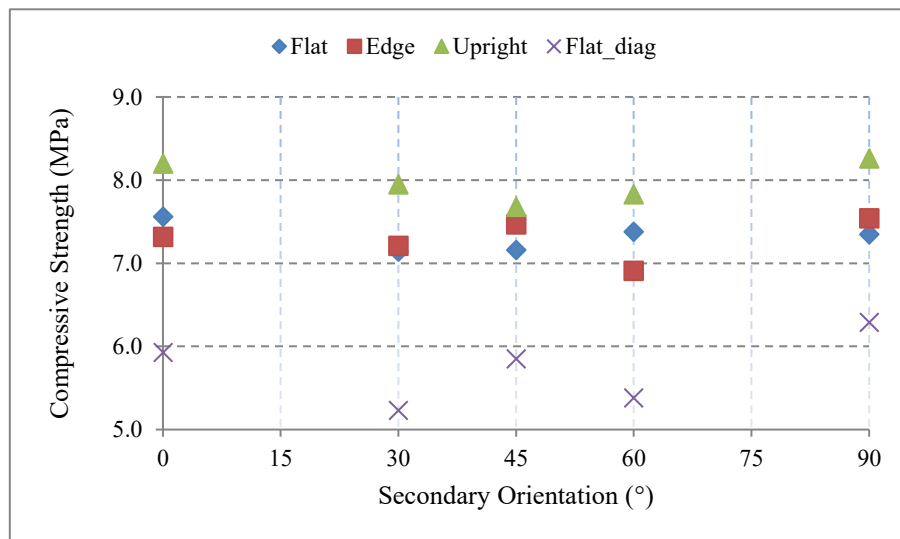


Fig.13. Average compressive strength for various build orientations

Impact strength of the porous specimens has also been analysed. The Izod impact strength (J/m) for individual specimen is given in Table 5. The highest individual impact strength is recorded for Flat_90° orientation; whereas lowest individual impact strength is recorded for Upright_30°. From Fig. 14, we can see

that highest average impact strength is obtained for Flat_{0°} orientation. It is evident that relatively better impact strength is obtained for Flat orientation. For Flat_{diag} orientation, impact strength is not inferior to Flat and Edge orientation. Upright orientation provides worst impact strength for all the secondary orientations.

Table 5 Individual and average Izod impact strength (J/m) for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	1	76.84	74.52	74.36	74.16	76.35
	2	77.32	75.44	73.24	72.47	77.54
	3	75.94	76.86	72.64	73.48	75.22
	Avg±SD	76.70±0.7	75.61±1.18	73.41±0.87	73.37±0.85	76.37±1.16
Edge	1	73.46	74.44	74.56	70.64	75.43
	2	74.62	72.28	72.34	72.62	72.85
	3	74.28	73.14	73.14	72.18	74.43
	Avg±SD	74.12±0.60	73.29±1.09	73.35±1.12	71.81±1.04	74.24±1.30
Upright	1	69.58	63.47	65.36	66.38	70.64
	2	68.48	69.73	68.24	69.48	71.58
	3	65.85	65.82	68.88	65.42	64.24
	Avg±SD	67.97±1.92	66.34±3.16	67.49±1.88	67.09±2.12	68.82±3.99
Flat _{diag}	1	72.86	72.92	69.54	72.28	73.58
	2	73.58	70.23	72.72	73.54	73.48
	3	74.28	73.14	70.82	71.44	72.82
	Avg±SD	73.57±0.71	72.1±1.62	71.03±1.60	72.42±1.06	73.29±0.41

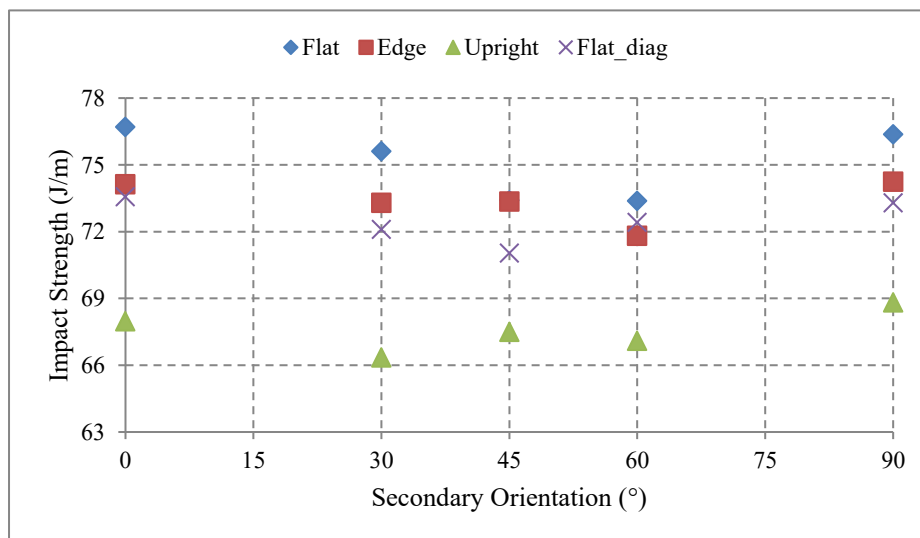


Fig. 14. Average impact strength for various build orientations

3.4. Dimensional analysis

To analyse the effect of build orientation on linear dimensions, we selected length (25.4 mm) of the compression test specimen, shown in Fig. 1(b). The length of each specimen for various orientations is measured. The average of three specimens along with one standard deviation (SD) is calculated and shown for each orientation angle in the Table 6. From Table 6, we find that the length of specimens fabricated in Flat and Edge orientations are significantly close to each other and their SD ranges between 0.01 to 0.04 mm. On the other hand, individual values in Upright and Flat_diag orientation are relatively distinct from each other and show a relatively higher SD. This variation in dimensions can be understood by the printing pattern of the specimens in different orientations. The overall length in Flat/Edge orientation is not affected by the number of layers deposited; whereas it is highly affected in Upright/Flat_diag orientation. The cumulative thickness of all the layers gives overall length in case of Upright orientation, which leads to more chances of larger deviation in comparison with Flat orientation.

Table 6 Individual and average length (mm) of the specimens for various orientations

Primary Orientation	Specimen No.	Secondary Orientation				
		0°	30°	45°	60°	90°
Flat	S1	25.42	25.4	25.41	25.37	25.39
	S2	25.39	25.36	25.42	25.42	25.37
	S3	25.38	25.39	25.4	25.38	25.4
	Avg±SD	25.40±0.02	25.38±0.02	25.41±0.01	25.39±0.03	25.39±0.02
Edge	S1	25.4	25.44	25.36	25.35	25.4
	S2	25.36	25.36	25.39	25.37	25.38
	S3	25.42	25.4	25.41	25.43	25.37
	Avg±SD	25.39±0.03	25.40±0.04	25.39±0.03	25.38±0.04	25.38±0.02
Upright	S1	25.46	25.4	25.41	25.42	25.38
	S2	25.41	25.47	25.49	25.4	25.43
	S3	25.38	25.39	25.48	25.51	25.49
	Avg±SD	25.42±0.04	25.42±0.04	25.46±0.04	25.44±0.06	25.43±0.06
Flat_diag	S1	25.37	25.42	25.49	25.45	25.42
	S2	25.48	25.45	25.42	25.5	25.38
	S3	25.46	25.43	25.39	25.41	25.45
	Avg±SD	25.44±0.06	25.43±0.02	25.43±0.05	25.45±0.05	25.42±0.04

From Fig. 15, it is clear that the average length values of specimens fabricated along Flat/Edge orientation show much closeness to nominal value (25.4 mm). Flat and Edge orientations are identical in this case due to cuboid shaped specimen. On the other hand, specimens printed along Upright and Flat_diag orientation possess length more than the nominal value and their values ranges between 25.42 to 25.46 mm. Deviation in length values is highest in case of Upright orientation, which ranges between 0.04 to 0.06 mm. Moreover, length of all the specimens fabricated along Upright and Flat_diag orientations are higher than nominal value at least by 0.02 mm. Individual values of length varies from 25.36 to 25.51 mm, which gives max. deviation 0.15 mm, which is well within the tolerance suggested by the surgeon, approx. 0.5 mm for maxillofacial surgeries [42, 43]. It is interesting to note that SD for the specimens printed along Flat and Edge orientations are relatively smaller than specimens printed along Upright and Flat_diag orientations. It indicates that specimens printed along Flat and Edge orientations are consistent and close to the mean value.

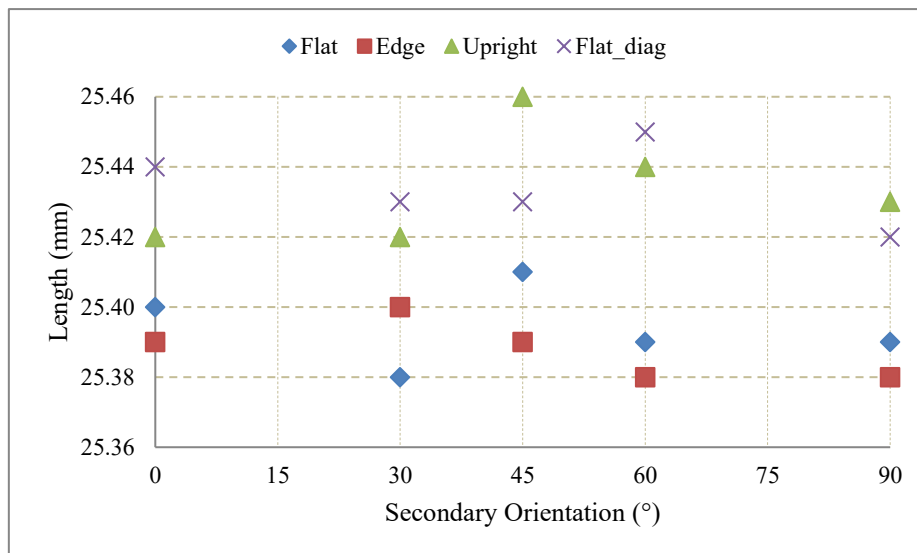


Fig. 15. Average length for various build orientations

The results of the current study are in line with results obtained by previous researchers through their studies. For example, Stoia et al. [44] observed best tensile properties for selective laser sintered PA2200 samples printed along 0° and 90° orientations in comparison with other orientations similar to present study. Calignano et al. [45] also studied tensile behaviour of selective laser sintered PA12 parts at different orientations. They observed relatively higher tensile strength for Flat and Edge orientation; moreover, strength along x- and y-axis is very close to each other. In this study also, we observed similar trends for tensile strength and tensile modulus. Stoia, et al. [46] tested impact properties of laser-sintered polyamide PA2200 on various orientations. They obtained better

impact strength (Charpy) for Flat and Edge orientation; whereas, lowest impact strength for vertical orientation which are similar to present study. However, they reported highest impact strength for Edge orientation; whereas, present study revealed highest strength for Flat orientation. Tomanik et al. [47] studied effect of part orientation on mechanical properties of PA12 part fabricated on desktop SLS system. They obtained best tensile properties for parts printed along 0° , which is quite similar to present study. However, they found that part orientation to be insignificant for compression properties that is not the case with the present study.

4. Conclusions

A comprehensive experimental study was performed to analyse the influence of part orientation inside the build chamber on selective laser sintered polyamide porous specimens mimicking the porous bone scaffolds. A good balance of porosity and mechanical strength in fabricated scaffold is vital for success of tissue engineering process. In this work, a systematic study was carried out to assess the effect of part orientation on macro porosity, mechanical strength and dimensional accuracy of the porous polyamide specimens. Four primary (Flat, Edge, Upright and Flat_diag) and five secondary (0° , 30° , 45° , 60° , 90°) orientations were considered to cover all the possible part orientations. Results confirm that part orientation has significant influence on measured macro porosity, mechanical strength and dimensional accuracy of the fabricated porous specimens. Following conclusions have been drawn:

- Measured macro porosity of the specimens for all the orientations was found less than the designed porosity. Best porosity was obtained for Flat_90° orientation. In general, specimens printed along Flat/Edge orientation have shown better closeness to the designed porosity.
- Higher tensile strength was observed for porous specimens printed along Flat orientation. Maximum average tensile strength (16.84 MPa) was obtained for Flat_0° orientation; whereas, minimum (9.22 MPa) obtained for Upright_60° orientation.
- Specimens printed along Upright orientation have shown better compressive strength in general. Maximum average compressive strength (8.26 MPa) obtained for Upright_90° orientation and minimum (5.23 MPa) obtained for Flat_diag_30° orientations.
- Relatively better average impact strength was obtained for specimens printed along Flat orientation. The highest average impact strength (76.70 MPa) recorded for Flat_0° orientation; whereas lowest average impact strength (66.34 MPa) recorded for Upright_30°. Upright orientation provided worst impact strength for all the secondary orientations.
- For dimensional accuracy, Flat orientation found to provide length closest to nominal value in comparison with other primary orientation.

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- It is concluded that build orientation has a significant influence on porosity, strength and dimensional accuracy of the fabricated porous polyamide specimens. Careful selection of the primary and secondary build orientations may result in optimal values of the scaffold parameters.

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