

Advanced Micro & Nanosystems
Volume 3

**Microengineering of Metals
and Ceramics**

Part I

Design, Tooling
and Injection Molding

Volume Editors

Detlef Löhe and Jürgen Haußelt



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Preface

Machines and their design and production have fascinated mankind from the very beginnings of culture. The last decades have shown mechanical contraptions decreasing in size to almost invisible dimensions. The implementation of micromechanics has become not only a technological challenge, but also a necessity for a successful future development of whole industrial branches. Adequate design and replication techniques of micromechanical components as well as a deep knowledge of their properties are indispensable for further progress in this field. At the same time the variety of materials used in micro system technology has increased significantly. Today not only silicon and polymers, but also metals and ceramics are of increasing interest for a large number of applications. In contrast to silicon and polymers, however, which can be structured by technologies well known from microelectronics, metals and ceramics require new forming and structuring techniques for dimensions in the sub millimeter range. In addition, mechanical properties of metallic and ceramic microparts are of special interest because they differ significantly from those measured in macroscopic dimensions.

It is because of these considerations that the German Research Council (Deutsche Forschungsgemeinschaft, DFG) has decided to fund a collaborative research center (SFB 499) with approximately 2 million euros p.a. which tackles the problems arising when trying to design, produce and characterize advanced microstructures made of metals and ceramics.

The two-volume book in hand presents the results of five years of research on micro engineering utilizing metallic and ceramic materials. It comprises the whole process chain from design and modeling of microcomponents along production preparation and two central replication techniques (micro powder injection molding and micro casting) to characterization and quality insurance, the scope encompassing both theoretical and experimental topics. The book is structured roughly according to the project groups which form SFB 499:

The first volume contains sections on design, tooling and replication techniques based on injection molding. The first section focuses on *micro-component design* including design environment, design flow, modeling and validation as well as on the modeling of micro powder injection molding (cf. chapters 1 to 3).

The second section on *tooling* describes preparatory steps for the production process. The production of mold inserts by micro milling, laser ablation, micro electro discharge machining and techniques based on lithography and electroforming is investigated, surface treatment methods using shot peening and ultrasonic energy are presented, and optimized mold materials for micro casting are identified (cf. chapters 4 to 9).

The third section on *micro injection molding* (chapters 10 to 12) is concerned with the production itself, focusing on the actual molding processes. Following an introductory chapter on general aspects of micro injection molding, micro injection molding of metals and ceramics including the challenging process steps of debinding and sintering (cf. chapters 11 and 12) are described.

The second volume comprises three sections on replication techniques other than injection molding, on automation and on properties of the components produced.

The section on special replication techniques focuses on microcasting (chapter 13) and electroforming (chapter 14) of metals and on selected techniques for the manufacturing of ceramic microcomponents (chapter 15).

The second section of volume 2 deals with *automation and quality insurance* and includes chapters on the automation of μ PIM, on assembly and on quality insurance and dimensional measuring techniques (chapters 16 to 18).

The last section addresses the *properties* of metals and ceramics and of the components produced. Microstructure and mechanical properties including micromechanical testing under quasi-static and cyclic loading as well as tribology are investigated and numerical wear simulation is performed (cf. chapters 19 to 22).

Working groups concerned with aspects touching all five project sections (e.g. on relationships between manufacturing processes) act as links between the projects. Cooperation within SFB 499 is further enforced by concerted work on a demonstration device consisting of a micro-turbine and a sun-and-planet gearing.

For a comprehensive treatment the chapters which directly deal with the research projects of SFB 499 are supplemented by several important research topics concerning micromechanical components (e.g. laser structuring, lithographic processes, electroforming, assembly) which are not part of the collaborative research center. In these cases guest authors have been asked to contribute. They come from Bremen University (Institut für angewandte Strahltechnik, BIAS), from Braunschweig University (Institut für Werkzeugmaschinen und Fertigungstechnik, IWF) and several scientific institutes of Forschungszentrum Karlsruhe.

By covering most aspects of the design, production, and properties of micro-mechanical components outside the silicon world, the authors hope to present a useful guide to students and readers looking for a comprehensive overview as a starting point of in-depth research in this field. However, the detailed presentation of latest SFB 499 research results as well as contributions from literature should also be a source of new insights and inspiration for micro-engineering experts from research institutions and industry.

Foreword

We are proud to present the third and fourth volumes of *Advanced Micro & Nanosystems (AMN)*, entitled *Microengineering of Metals and Ceramics*.

Although microtechnology is often associated with semiconductor cleanroom processes, this is by no means the only means of production available. The processes we associate with traditional mechanical engineering mass production have also been the focus of microtechnologists, with tremendous successes already in place and a huge potential for further progress. Of course, every new technology pairs the development of suitable materials with that of production technology, and in the sub-millimeter range the challenges become immense. Not only must raw materials be produced in particulate form fine enough to reproduce the molds they are formed into, and molds need to be prepared at the correct dimensions and surface quality, but new ideas are needed to make use of machine parts produced in this manner, and new methods to assemble parts into complete systems. In these two volumes you will find a comprehensive treatment of a variety of challenges that arise in the process of producing micro-parts from metals and ceramics, from materials, testing, production, computer aided engineering all the way to assembly. We hope that these volumes will inspire the transfer of these fascinating techniques not only to other research groups, but also to industry and so broaden the range of items that can be successfully miniaturized.

Covering recent advances from the world of micro and nanosystems, future AMN issues will either focus on a particular subject, such as *CMOS-MEMS* and the present twin topical volumes *Microengineering of Metals and Ceramics*, or be a carefully chosen set of cutting-edge overview and review articles like the first AMN volume on *Enabling Techniques for MEMS and Nanodevices*.

Looking ahead, we hope to welcome you back, dear reader, to the upcoming fifth member of the AMN series, in which we take a close look at the fascinating field of *Micro Process Engineering*. The articles will range from the fundamentals and engineering over device conception and simulation to fabrication strategies and techniques, and finally cover application and operational issues. To cover such a wide spectrum, we are very glad to have the support of Dr. Nor-

bert Kockmann from the University of Freiburg, Germany, who will edit this volume.

*Henry Baltes, Oliver Brand, Gary K. Fedder, Christofer Hierold, Jan G. Korvink,
and Osamu Tabata*

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Contents

Preface V

Foreword VII

List of Contributors XI

I Design

1 Design Environment and Design Flow 3

A. Albers, J. Marz

2 Modeling and Validation in Design 29

A. Albers, D. Metz

3 Modeling Micro PIM 51

D. Kauzlaric, A. Greiner, J.G. Korvink, M. Schulz, R. Heldele

II Tooling

4 Strategies for the Manufacture of Mold Inserts 87

J. Fleischer, C. Buchholz, J. Kotschenreuther

5 Micro End Milling of Hardened Steel 107

J. Schmidt, J. Kotschenreuther

6 3D Microstructuring of Mold Inserts by Laser-based Removal 131

A. Stephen, F. Vollertsen

7 Micro-EDM for Mold Inserts 161

J. Schmidt, M. Knoll, T. Masuzawa

8	Lithographic Fabrication of Mold Inserts	187
	<i>M. Guttman, J. Schulz, V. Saile</i>	
9	Material States and Surface Conditioning for Mold Inserts	221
	<i>Ch. Horsch, V. Schulze, D. Löhe</i>	
 III Replication Techniques – Microinjection Molding		
10	Microinjection Molding – Principles and Challenges	253
	<i>R. Ruprecht, G. Finnah, V. Piotter</i>	
11	Micro Metal Injection Molding	289
	<i>V. Piotter, L. Merz, G. Örygsson, S. Rath, R. Ruprecht, B. Zeep</i>	
12	Micro Ceramic Injection Molding	325
	<i>W. Bauer, J. Hausselt, L. Merz, M. Müller, G. Örygsson, S. Rath</i>	
 Subject Index XVII, end of the book		

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Subject Index

a

- ABAQUS 36, 120, 561, 610
- ablation
 - laser-based removal 131 ff
 - mask projection 143
 - mold inserts 98
 - PIM automation 460
- abrasion
 - binders 293
 - mold inserts 93, 97
 - surface conditioning 240 f
 - tribologics 579, 598–604
 - wear 609
- absorbers 192
- accuracy
 - EDM 99, 170
 - feedstocks 300
 - industrial robots 479
 - LIGA 189
 - microassemblies 475–498
 - microcasting 357 f, 385
 - mold inserts 89
- acrylamide/acrylate 433
- actuators 7, 476
- additives 294
- adhesion 328
- adhesion grippers 456 ff, 490
- agarose 434
- age hardening 370, 387, 524
- agglomeration 328, 332
- air trapping 347, 484 f, 563
- alkylphenol polyglycol ether 345
- alloys
 - electroforming 395–395
 - microcasting 369 ff
 - micro-metal injection molding 292, 296
- alumina
 - ceramic replication 423 ff, 427 ff
 - electrophoretic deposition 430
 - gel casting 434
 - steel milling 113
 - tribologics 579–604
- aluminum oxide
 - EDM 175
 - investment casting 374
 - μ CIM 342
- ammonia 375
- ammonium iodide 176
- ammonium phosphate 375
- amorphous nickel phosphorus alloys 90
- amorphous polymers 257
- annealing 401, 544 ff
- application specific design 22
- arc flame melting 364
- Archard wear model 605–624
- Armco-iron 113, 246
- arrays
 - electroforming 406
 - electrophoretic deposition 430
 - microgrinding 97
 - PZT 424
- Arrhenius type dependence 145
- aspect ratio
 - EDM 99, 164, 170
 - electroforming 395 ff, 400, 408
 - laser etching 149, 153
 - LIGA 189
 - lost molds 275
 - LPIM 344
 - microcasting 357, 388
 - μ CIM 328
 - micro-metal injection molding 322

- mold inserts 89ff, 93, 97
- quality assurance 501
- tribologics 581
- assembly concepts 475ff
- ATN ($\text{Al}_2\text{O}_3/\text{TiN}$) 342
- atomic force microscopy (AFM) 504, 605ff
- attenuators 142
- austenite 485
- austenizing 223, 232f
- automation 449–521
- AZ9260 resist 192

b

- backlash 483, 489
- Bagley correction 76
- bainitic materials 238
- batch handling automation 453
- batch production 88, 477
- beam scanning 135
- beeswax 294
- bending tests
 - HPIM 341
 - microcasting 381
 - micro-metal injection molding 316
 - micro-PIM 81
 - modeling 30, 36
 - Stabilor G[®] 526ff, 547ff
 - steel milling 112
 - zirconia 555, 560–578
- beryllium wafers 192, 213
- binary systems 371
- binders
 - ceramic replication 422ff
 - HPIM 331f, 339
 - investment casting 374
 - LPIM 345
 - μCIM 327ff
 - microinjection molding 271, 303
 - micro-metal injection molding 290ff, 293ff, 298
 - micro-PIM 71, 271, 453, 463
 - tribologics 581
 - zirconia 556
- Bingham flow 302
- biocompatibility 369
- biopolymers 434
- Biosil f 373–394
- blasting 240f, 359
- blending 290
- blowhole-like defects 276
- boiling points, etchants 145, 207
- Boltzmann constant 58
- boric acid 397
- boring 102, 291
- borosilicon carbonitride 439
- boundary conditions 23ff
 - handling 466
 - μCIM 343
 - micro-PIM 68
- Bragg peaks 559
- brass
 - diamond cutting 90
 - EDM 166
 - microinjection molding 268
 - tribologics 580ff, 586ff, 597ff
- bridging-the-gap 53
- brittleness
 - μCIM 326
 - steel milling 113
 - surface conditioning 224
 - zirconia 571
- bronze 357–394
- brown compacts 453, 467
- bubbles
 - cavitation 245
 - electrophoretic deposition 429
 - HPIM 339
 - zirconia 563
- built-up edges 225
- bulk temperature 76
- bulk viscosity 54
- burrs
 - EDM 179
 - steel milling 125
 - surface conditioning 221, 229ff, 236
- butyldiglycol (BDG) 199

c

- calcium sulfate dihydrate 377
- calibration 44, 516
- capability, steel milling 125
- capillaries 56, 175
- capillary forces 490
- capillary micromolding 421ff
- carbide tools 90ff, 109
- carbides
 - surface conditioning 223, 234
 - tribologics 581
 - see also: cemented carbides*
- carbon absorption 397
- carbon black 271, 404, 409
- carbon fiber-filled plastics 271
- carboxylic acid 331
- casting 357–394
 - alloys 369ff
 - ceramic replication 421ff

- design flow 18
- μ CIM 326
- Stabilor G[®] 523–554
- catalytic decomposition 310
- Catamold
 - HPIM 330
 - micro-metal injection molding 294
 - tribologics 583 ff
 - zirconia feedstocks 558
- cavities
 - EDM 98
 - electroforming 403 f, 411
 - LBM 102
 - LIGA 203
 - microinjection molding 254, 259 f, 270
 - micro-metal injection molding 290, 304, 309, 322
 - micro-PIM 54, 70
 - mold inserts 87 ff
 - tribologics 580
 - wet peening 245
- cemented carbides
 - diamond cutting 90
 - electrodes 173, 178
 - feedstocks 301
 - micro-metal injection molding 289, 316
 - steel milling 109, 114
 - surface conditioning 224, 234 f
 - tribologics 581
- centrifugal casting 360, 367 f, 386
 - Stabilor G[®] 523–554
- ceramic components 273
- ceramic crucibles 364
- ceramic feedstocks
 - HPIM 336
 - micro-metal injection molding 292
 - tribologics 579 ff
- ceramic injection molding (CIM) 325–356
- ceramic powders 271
- ceramic process technology 253 ff
- ceramic reactor system 354
- ceramic replication techniques 421–448
- ceramic slurries 373
- ceramic suspensions 441
- CFX-4 package 54
- chain linked polymers 55
- chamfer width 121
- Chapman–Enskog method 72
- characterization
 - mold inserts 579–604
 - Stabilor G[®] 528 ff
 - zirconia 562 ff
- chemical composition, Stabilor G[®] 527
- chemical degradation 294
- chemical deposition *see*: electroless deposition
- chemical etching 133 f
- chemical-mechanical polishing 610
- chemical properties, gold base materials 369
- chip thickness 227
- chitosan 434
- chromatographic electroforming 397
- chrome-quartz masks, I 141, 192
- clamping 254 ff, 262 f, 304
- cleaning 207, 397, 414
- climb milling 126
- C-Mold package 55
- coagulation casting 421, 436 ff
- coatings
 - investment casting 379
 - LIGA 193, 213
 - mold inserts 93
 - tribologics 581
- cobalt-based hard metals 110
- cobalt powders 300
- CoCrMo alloy 357 ff, 372–394
- codeposition 402
- coil angle 121
- cold ablation 143
- colloids 53, 422, 434
- columns 189
- compactors 298
- compliant mechanism 486 ff
- compounding feedstocks
 - HPIM 331
 - LPIM 346
 - MIM 298 ff
- compression injection molding 256, 278
- compression strength 112
- compressive testing 224, 229
- computational fluid dynamics (CFD) 52 ff
- computer aided design (CAD) 12, 21 ff, 53
- concentricity errors 223
- conductivity
 - electroforming 395, 401, 408
 - LIGA 194
 - mask projection 143
 - microinjection molding 259
 - micro-PIM 76, 80
- contact angles 70
- contact areas, wear 606, 611 ff, 618 ff
- contaminants 607
- continuous furnace 471

continuum-based computational fluid
 dynamics (c-CFD) 57 ff
 continuum theory 52 ff
 convex polyhedrons 31
 cooling
 – microcasting 383
 – microinjection molding 259
 – micro-metal injection molding 291,
 312
 – PIM automation 470
 – Stabilor G[®] 523, 528 ff
 – zirconia 557 f
 coordinate measuring machine
 (CMM) 210, 512
 copper
 – diamond cutting 90
 – EDM 100, 166
 – electroforming 403, 416
 – feedstocks 301
 – laser-based removal 138
 – layers 194, 202
 – Stabilor G[®] 524
 copper alloys 318, 371
 copper sulfuric-type plating 202
 correlation image, Stabilor G[®] 536
 corrosion, laser etching 148
 corrosion resistant castings 371 ff
 counter structures 132
 CPM9V, tribologics 559–604
 cracks
 – HPIM 339
 – LIGA 209
 – μ CIM 329
 – micro-metal injection molding 294
 – surface conditioning 231
 cristobalite 374, 377
 Cross model 75
 crosslinked polymer solvent gel cast-
 ing 433 f
 crucibles 364
 crystal growth 365
 crystalline melting temperatures 271
 current correlation function 73
 cutting
 – EDM 165
 – mold inserts 88 ff, 95
 – PIM automation 460
 – steel milling 109, 123
 – surface conditioning 223 ff, 230 ff
 cuvette embedding 377
 cycles 64, 308
 cyclic three-point bending,
 Stabilor G[®] 549 f

d

dark etching layers 232
 dark-field image, Stabilor G[®] 546
 debinding
 – HPIM 338
 – μ CIM 329
 – micro-metal injection molding 289 ff,
 310 ff
 – PIM 454, 468 ff
 – zirconia 557
 deburring 222, 241
 Debye–Hückel equation 428
 decomposition
 – HPIM 339
 – investment casting 376
 – mask projection 143
 – microcasting 370
 – microinjection molding 271
 – micro-metal injection molding 310
 – zirconia 564
 defects
 – LIGA 209
 – microcasting 365
 – microinjection molding 259, 271, 276
 – modeling 31
 – zirconia 564, 572
 deflasking 376
 deflection
 – industrial robots 489
 – LIGA 204
 – steel milling 115 f, 123
 – zirconia 574
 deformation
 – demolding 268
 – LPIM 347
 – Stabilor G[®] 525 ff, 549 ff
 – surface conditioning 229, 239
 – wear 607
 degassing, zirconia 562
 degradation
 – electroforming 402
 – HPIM 339
 – LIGA 203, 213
 – microinjection molding 260
 – micro-metal injection molding 294,
 308 ff
 degrees of freedom (DOF), industrial ro-
 bots 481
 Deguvest 379 f, 385 f, 527, 534 f
 demagnifying mask projection 143
 demolding 261, 461, 464 f
 dendrites 365, 372
 dental casting 357–394

- dental gold alloy, Stablor G® 523–554
 - dental prosthesis surfaces 241
 - depths
 - engraving 103
 - laser etching 149
 - LIGA 210
 - design 1–85, 3–28, 454
 - see also*: system design
 - design-rule-check (DRC) 21, 24ff
 - destruction tribologics 580
 - developer solution 194, 199
 - dewetting 68
 - diamond tools 90f, 109, 269
 - dibenzol peroxide (DBPO) 195
 - dicing 95
 - die casting 358
 - die cavities 290
 - die sinking EDM (SEDM) 100, 161–174
 - dielectric fluids 163
 - Diesel effect 259, 308
 - differential scanning calorimetry (DSC) 76
 - diffraction
 - LIGA 209ff
 - Stablor G® 545
 - zirconia 559
 - diffusion interface 402
 - diffusivity 76
 - diffusor components 81
 - dilatometers 78, 303
 - dimensional measurement
 - technology 499–520
 - dimensional product qualification 385, 406
 - dimensions, manufacturing 17
 - dimethylaniline (DMA) 195
 - DIN EN ISO 4288 529, 558
 - diode pumped Nd:YAG laser 102
 - Dirac δ function 58
 - direct coagulation casting (DCC) 421, 436ff
 - direct writing, laser-based removal 131, 135ff
 - direction change 80
 - discrete components 478
 - dislocation movement 525
 - dispersion
 - ceramic replication 422
 - electroforming 400
 - HPIM 331
 - LPIM 345
 - μ CIM 329
 - dissipative particle dynamics (DPD) 51–62
 - dissociation 427
 - dissolution
 - EDM 163
 - laser etching 148
 - micro-metal injection molding 294
 - distortions 294, 580
 - disulfitoaureate 399
 - doctor blade process 422
 - domain growth 53
 - DoseSim 196
 - double layers 428
 - drilling
 - EDM 100, 165
 - LBM 102
 - micro-metal injection molding 291
 - mold inserts 88ff, 93
 - quality assurance 510
 - tribologics 581
 - drop molds 367
 - dry micropeening 222, 247
 - drying 346, 442
 - ductility 233, 400
 - dynamics, microproduction 7
- e**
- edge radius, zirconia 555, 561–578
 - effect analysis, quality assurance 500
 - ejection systems
 - microinjection molding 262, 266
 - micro-metal injection molding 305
 - PIM automation 460
 - elastic anisotropy 29–50
 - elastoplastic deformation 229
 - electric microinjection molding 262
 - electrical conductivity 194
 - electrochemical deposition 395ff
 - electrochemical replication 405
 - electrochemical surface conditioning 240
 - electrodes
 - ceramic replication 421, 430f
 - EDM 163, 168
 - mold inserts 100
 - electrodischarge machining (EDM) 161–190
 - LIGA 205
 - mold inserts 88ff, 98
 - steel milling 108, 117f
 - tribologics 581
 - zirconia 559
 - electroforming
 - LIGA 201
 - lost molds 275
 - metals 395–420

- microinjection molding 268 ff
- mold inserts 187 ff
- electrohydraulic effect (EHE) 164
- electroless metal deposition 90, 403
- electrolytes 204, 276, 397 ff
- electromagnetic effect (EME) 164
- electromagnetic radiation 101
- electronspectroscopy for chemical analysis (ESCA) 414
- electrophoretic deposition (EPD) 421, 426 ff
- electroplating
 - accuracy 476
 - automation 452 ff
 - ceramic particles 402
 - laser-induced removal 152 ff
 - LIGA 194
 - lost molds 275
- electrostatic grippers 456 ff, 490 ff
- electrosteric stabilization 427 f
- electrotactile sensors 506
- elongation-to-fracture
 - microcasting 370
 - Stabilor G® 531
 - surface conditioning 229
- embodiment design unit 20
- embossing 421–427, 442
- EN ISO 9283, industrial robots 479, 489
- end milling 107–130, 222, 248
- endeffector 479
- engraving 102, 165
- environment, design 3–28
- enzyme catalyzed reactions 436
- EPON SU-8 resists 194, 215, 406, 417
- epoxy-based resists 214, 443
- equation-of-state (EOS) 59 f
- equipment technology 478
- erosion 416, 579 ff
- etching
 - accuracy 476
 - laser-based 131 ff, 144 ff, 149
 - layers 232
 - microinjection molding 268
- ethyl acetate 207
- Euler angles 32
- eutectic point 372
- evacuation techniques 259 ff
- excimer laser 102, 140, 152
- expansion, thermal 76 f
- extruders 296, 332, 346

f

- fabrication
 - automation 451 ff
 - electrophoretic deposition 429 ff
 - lithographic 187–219
 - micro-metal injection molding 290 f
 - quality assurance 508
 - soft molding 441
- failure
 - LIGA 213
 - μ CIM 343
 - steel milling 118
 - wear 606, 609
 - zirconia 566, 572 f
- failure modes and effect analysis (FMEA) 500
- fatigue resistance 112
- fault-tree analysis (FTA) 500
- feeding, industrial robots 479
- feedstocks
 - HPIM 330
 - LPIM 345
 - μ CIM 325–356
 - microinjection molding 87, 261 ff, 271, 273 f
 - micro-metal injection molding 290 ff, 293 ff
 - micro-PIM 71 f, 460, 463
 - quality assurance 509 f
 - soft molding 438
 - tribologics 579–604
 - zirconia 556
- FEPAKOM (production of passive optical components) 502
- ferrites 98, 223
- ferrous metals 110
- ferrules 256
- fiber probes 389, 505 ff
- field distortions 136
- fillers
 - investment casting 374 ff
 - microcasting 388
 - microinjection molding 260 f, 264 f
- finishing 205 f, 240
- finite element method (FEM) 29, 33, 36, 57
 - Stabilor G® 526
 - wear 605–624
 - zirconia 556, 561–578
- flame retardants 581
- flank angle 115 ff, 121 f
- flexure hinges 475, 483 ff, 487 ff

- flow characteristics
 - HPIM 335
 - microcasting 388
 - micro-PIM 52–59, 67 ff
- flow chart *see*: system design
- FLOW-3D 54
- fluorescence 212
- fly cutting 91
- flying mask 152
- focused ion beam (FIB) 115
- focusing laser-based removal 134 ff
- foil turning 91
- Fokker–Planck–Boltzmann equation 72
- form errors 99, 229
- form filling 366, 388, 403, 411
- fracture surfaces
 - Stabilor G® 531, 537, 540 f, 551
 - zirconia 560, 566 ff
- fracture toughness 112, 224, 229 ff
- fragile microparts 455, 504
- freezing 259
- frequencies 7, 134
- Fresnel diffraction 90, 97, 211
- friction
 - industrial robots 483, 489
 - micro-PIM 56 f, 69, 72 f
 - mold inserts 579–604
 - wear 607 ff
- frozen-wall particles 69
- furnaces 471
- g**
- Galilean invariance 57
- galvanic deburring 241
- galvanic forming 397
 - laser-induced removal 154
 - seed layer 201
 - Stabilor G® 529
- galvanometer scanning 135
- gas sensor set-up 443
- gate systems 266
- Gauss distribution 68
- Gaussian modes 133 ff, 144, 152
- G-CuAl10Ni alloy 371
- gearhousing 172
- gearwheels
 - gel casting 434
 - HPIM 337
 - LPIM 354
 - micro-metal injection molding 306
 - modeling 42
 - soft molding 441
 - steel milling 127
- gel casting 421, 432 ff
- geometric effects
 - design flow 10, 23 ff
 - EDM 170
 - microcasting 389
 - microcomponents 47
 - micro-PIM 73, 80
 - steel milling 121, 127
 - tool edges 90, 95
- glass fibers 256
- glass-transition temperature 65, 271
- gluing 195
- gold absorbers 192
- gold-based alloys
 - copper 205, 525
 - dental 31–48
 - microcasting 357–394
 - silver copper 370
 - Stabilor G® 523–554
- gold layers 202, 205
- gold sulfite electrolytes 399
- gold sulfuric plating 202
- grain boundary hardening 525
- grain dissolution 163
- grain growth 289, 296, 328
- grain orientation 29, 41–50
- grain size
 - microcasting 383
 - micro-metal injection molding 314, 317
 - Stabilor G® 533 ff
 - tribologics 583
 - zirconia 556, 564 ff
- grain structures 31, 112
- granulates 259 f, 264 f, 453
- graphite
 - EDM electrodes 100
 - investment casting 375
 - microcasting 364
- grating structures 189, 202
- gravitational forces 264, 351
- gray-scale correlation image, Stabilor G® 536
- green compacts 302 ff
 - ceramic replication 422 ff
 - gel casting 432
 - μ CIM 326 f, 343 ff
 - PIM automation 453, 467
- grinding
 - EDM 161
 - microinjection molding 276
 - mold inserts 88 ff
 - PIM automation 460

- steel milling 109
- surface conditioning 224
- tribologies 581
- wet peening 246
- grippers
 - industrial robots 479
 - microassemblies 475, 490 ff
 - PIM automation 455 ff, 459 ff, 465 ff
- grooves
 - EDM 99
 - laser etching 147 ff
 - laser-based removal 132 ff
 - microgrinding 97
 - microinjection molding 266
 - steel milling 109, 119
 - surface conditioning 222, 229, 234
 - Sysmelec Autoplace 411 492
 - WEDG 178
- gyration radius 54

h

- hair, microgrinded 98
- Hall–Petch relation 525, 543, 546 f
- handling 451, 465 ff, 490 ff
- hard metals 289, 310 ff
- Hardcore Poisson process 32
- hardened steels
 - end milling 107–130
 - laser etching 148
 - microinjection molding 270
 - surface conditioning 221
- hardening
 - laser-based removal 138
 - microcasting 370
 - Stabilor G® 524 f
 - surface conditioning 231, 240 f
- hardness
 - LIGA 210 ff
 - nickel alloys 401
 - microcasting 370
 - mold inserts 579–604
 - steel milling 112, 122
 - surface conditioning 224, 232 ff
 - wear 608
- HASYLAB beamline 558
- heat capacity 59, 76
- heat exchanger plate 425
- heat flow 79
- heat treatments 221–234, 289
- heating
 - laser-based removal 134
 - microcasting 363
 - micro-metal injection molding 312

- PIM automation 460
- Hele–Shaw flow model 54
- Helmholtz double layers 397
- Helmholtz–Smucholski equation 428
- Henry factor 428
- Hertz formula 615 ff, 620 ff
- high precision 195, 512
- high-pressure capillary rheometer (HPCR) 302, 334, 341
- high-pressure injection molding (HPIM) 325, 330 ff
 - zirconia 555–578
- high-speed tool steels (HSS) 93
- high-strength materials 372 ff
- hole-type templates 412
- holes 99, 177
- homogenizer 142
- hot-crack susceptibility 364
- hot embossing
 - laser-based removal 132 ff, 152, 155
 - LIGA 188
 - mask projection 143
- hot isostatic pressing 312
- hot molding 344
- hot pressing 100
- housing
 - EDM 172
 - hermetically sealed 154
 - laser-induced removal 154
 - microcasting 382
 - microinjection molding 257, 27, 29, 307
- hybrid parallel robots MICABO 483
- hydraulic microinjection molding 262
- hydrocarbon chains 331
- hydrogen atmosphere 318
- hydrogen evolution 397
- hydroxyapatite (HAP) 423 ff
- hysteresis curves 148

i

- IGES design flow 21
- illumination 145
- image structuring 143
- impurities 397
- incrementals 620
- induction heating 364
- industrial environments 170
- industrial robots 478 ff
- inert electrodes 399
- infiltrating 379
- information units 20
- injection molding 93

injection molding
 – laser-based removal 132 ff
 – mask projection 143
 – PIM automation 451–474
 – quality assurance 502
 – tribologics 579–604
 – zirconia 555–578
 injection pressure 327
 injection transfer molding (ITM) 279
 injection velocity 308, 341
 injector components 81
 in-mold assembly 253, 274 f
 insert injection molding 274 f, 305, 409
 inserts *see*: mold inserts
 insulating walls 275
 integrated circuits (ICs) 4
 intermediate masks 192, 205
 investment casting 357 ff, 368 f, 373 ff, 386
 ion beaming 114
 ion etching 268
 ion-exchange cleaning 397
 ionization 427
 iridium segregation 525
 iron/alloys 271, 296
 see also: steel
 irradiation 145, 190, 199
 island-type templates 412
 ISO standards, industrial robots 479, 489
 isoelectric point (IEP) 437
 isometric drawing 443
 isotropic behavior 31
 isotropic finishing 241

j

jet chemical etching 146 ff
 jewelry casting 357–394
 jewelry housings 291
 joints 277

k

Karush–Kuhn–Tucker condition 44
 kinematic behavior, industrial robots 480, 485
 kinematic viscosity 73
 kneaders 290 f, 33, 346
 knowledge-based engineering (KBE) 3, 24 ff
 KoMeth database 21, 24 f

l

labeling 102
 Langevin approach 53
 laser ablation

 – EDM 161
 – steel milling 116
 – tribologics 581
 laser-based removal 131–160
 laser-based surface conditioning 240
 laser-beam machining (LBM) 88 ff, 101
 – design flow 6
 – steel milling 115
 laser etching 144 ff
 laser-flash method 76
 laser patterning 270
 lathe machine 179
 layers
 – electroforming 403
 – electrophoretic deposition 428, 432
 – LIGA 190 ff, 201 ff, 213
 – microcasting 371
 – micro-metal injection molding 314
 – surface conditioning 232
 lead zirconate titanate (PZT)
 – ceramic replication 423 ff, 432 ff
 – gel casting 436
 – soft molding 439
 Lennard–Jones potential 61
 lenses 209, 136
 Licomont® 294, 330, 334
 life times 500
 LIGA (Lithografie Galvanoformung Abformung) 4, 187 ff
 – ceramic replication 423 ff
 – electroforming 399, 404
 – laser-based removal 132
 – microcasting 359
 – microinjection molding 255, 268
 – mold inserts 88, 100
 – Stabilor G® 524, 429
 – worldwide facilities 216
 ligaments 170
 light microscopy 528, 558
 line widths 170
 linear elastic materials 31
 linear regression 565
 liquid-phase jet chemical etching 144 ff
 liquid silicone rubber (LSR) 259
 liquid vapor systems 53 ff, 61
 lithium aluminate structure 424
 lithography
 – LBM 102
 – microinjection molding 268
 – mold inserts 187–219
 – soft molding 437
 – steel milling 107
 loading, zirconia 555

- look-and-move procedures 496
- lost molds 275, 357, 360 ff
- low pressure injection molding (LPIM) 325 ff, 344 ff
 - zirconia 555–578
- low viscosity feedstocks 438
- Lowe–Andersen thermostat 58 ff, 63, 72, 80
- lubrication 579–607
- m**
- machining
 - accuracy 476
 - LPIM 348 f
 - microinjection molding 262
 - micro-metal injection molding 304
 - surface conditioning 221
- magnesium pyrophosphate 375
- manufacturing
 - automation 451 ff
 - construction requirements 507
 - design flow 13 ff
 - microassemblies 491
 - μ CIM 326 ff
 - mold inserts 87–106
 - polymer microparts 413
 - steel milling 114 f
- many-body dissipative particle dynamics (MDPD) 60 f
- Martens hardness 225
- martensite 485
- martensitic structures 223
- mask projection method 140 ff
- masking
 - electroforming 395
 - LIGA 188
 - substrate package 196
- material-flow automation 467
- material properties 521–624
 - mold inserts 221–254
 - tribological 579–604
- materials
 - microproduction 7
 - steel milling 111
- Maxwell distribution 60, 68, 72
- measurement technology 499–520
- mechanical erosion techniques 416
- mechanical feedstock data 261
- mechanical grippers 456 f, 466 f, 490 f
- mechanical microproduction 5 ff
- mechanical properties
 - Biosil 373 f
 - gold base alloys 370
 - microcasting 381, 387
 - Stabilor G® 523–554
 - surface conditioning 222 ff, 230, 234
 - zirconia 555–578
- melting
 - investment casting 375
 - laser-based removal 134
 - microcasting 363
 - microinjection molding 254
- melting points
 - LIGA 212
 - microinjection molding 271 ff
 - micro-metal injection molding 294, 317
 - paraffin 345
- membrane methods 421 ff
- mesastructures 132 f
- mesh generation 33
- mesoscopic colloid dynamics 53
- mesoscopic heat flow 79
- metal electroforming 395–420
- metal growth 408
- metal injection molding (MIM) 289–330
- metal-ion complexation 434
- metallic feedstocks 336
- metallic microbending 34
- metallization 213, 414
- metallographics 253, 312
- metallurgical alloys 292
- methacrylamide (MAM) 434
- methodological design flow 3 ff
- methylcellulose 379
- methylenebisacrylamide (MBAM) 433
- methylethyl ketone (MEK) 424
- methylmethacrylate (MMA) 195
- MICABO parallel robots 481 ff, 494 ff
- microassemblies 475–498
- microbending tests 30, 36
 - HPIM 341
 - Stabilor G® 526 ff, 547 ff
- microcasting 357–394
 - design flow 18
 - quality assurance 513
 - Stabilor G® 523–554
- microcavities
 - microinjection molding 270
 - micro-metal injection molding 304, 309
 - micro-PIM 54
 - tribologics 580
- microceramic injection molding (μ CIM) 325–356
- microchannels 54
- microcomponents
 - electroforming 400

- microinjection molding 255
- modeling 35, 42
- properties 521–624
- tribologics 579–604
- microcutting 108
- microdrilling 93, 268, 581
- microelectrodischarge machining
 - (μ EDM) 161–186
- microinjection molding 268
- zirconia 559
 - see also*: electrodischarge machining
- microelectroforming 395–420
- microelectromechanical systems (MEMS) 98, 606
- microend milling 107–130, 222
- microfeatures 499, 508ff
- microgears 89, 441, 276, 279, 512
- MicroGlider 386, 406
- microgrinding 95
- microgrippers 455 468, 490ff
- microholes 95
- microhousing 271
- microinjection molding 108, 152ff, 253–292
- micromachining 451ff, 605–624
- micromechanical components 453, 508
- micro-metal injection molding 289–330
- micrometrology, dimensional 499–520
- micromilling
 - casting 360
 - design flow 6, 13
 - injection molding 86, 268
 - surface conditioning 221, 240
 - tribologics 581
 - zirconia 556
- micromolding-in-capillaries (MIMIC) 421, 438ff
- micromolds 107, 161
 - see also*: molds, molding
- microoptical systems (MOEMS) 189
- microparts
 - casting 381
 - CIM 325–356
 - injection molding 253ff
- micropatterning
 - ceramic replication 422
 - microinjection molding 255, 266ff
 - soft molding 442
- micropeening 221, 240f
- micropowder injection molding (μ PIM) 51–86, 253, 289
 - design flow 6, 14ff
 - quality assurance 502ff, 513ff
- tribologics 579–604
- microprecision components 190, 255
- microproduction 5ff
- micropunching 180f
- microreplication techniques 437
- microrings 337
- microsegregation 365
- microspecific design flow 7
- microspecimen 34
 - Stabilor G[®] 526
 - zirconia 555–578
- microstructures 231
 - components 421, 429ff
 - electroforming 402
 - microcasting 357f, 383, 390
 - micro-metal injection molding 289, 313
 - modeling 29–50
 - Stabilor G[®] 523–554
 - tribologics 586ff
 - zirconia 555–578
- microsystem technology (MST) 254, 397
- microtechnology
 - design flow 4ff
 - μ CIM 325–356
 - wear 605–624
- microtensile testing 36ff
 - HPIM 340
 - Stabilor G[®] 526–538ff
- microthree-point bending, zirconia 555, 561–578
- microtransfer molding (μ TM) 421, 438ff
- microtribology 579–604
- microturbine 353
- microwave plasma treatment 414
- milling
 - design flow 6, 13
 - EDM 161, 167ff, 172ff, 177
 - microcasting 360
 - microinjection molding 258
 - micro-metal injection molding 291
 - mold inserts 92
 - quality assurance 510
 - surface conditioning 221, 238
 - tribologics 581
 - zirconia 556
- miniaturization
 - automation 451ff
 - mold inserts 88
 - steel milling 107
- minimum sizes 16ff
- mirrors 209
- Mises stress distribution 38f, 44, 118
- mixing phenomena 59

- mobility, electrophoretic 428
- modeling 29–50, 605–624
- mold inserts
 - design flow 13
 - EDM 172
 - electroforming 402
 - fabrication 87–106, 187 ff
 - investment casting 379
 - laser based removal 131–160
 - microinjection molding 266 ff
 - micro-metal injection molding 305, 309
 - micro-PIM 70
 - specifications 87–106, 187 ff
 - steel milling 127
 - tribologics 579–604
- MoldFlow simulation 55, 261
- molding
 - automation 451–474
 - ceramic replication 421 ff
 - high-pressure 336
 - LIGA 188
 - materials 271
 - quality assurance 502, 513
 - steel milling 108
 - zirconia 555–578
- see also:* micro-, injection, etc.
- molecular dynamics 53
- molochite 374
- molybdenum wires 166
- momentum vectors 57
- monocrystalline alumina 113
- monocrystalline silicon 95
- moving masks 141
- MPM 9 steel 122
- MSC.Patran meshing 33
- mullite 374
- multicomponent microinjection mold-
ing 81
- multilayer compounded components 477
- Multivac 368

- n**
- NanoFocus 386, 558
- Navier–Stokes equation 57
- Nd:YAG lasers 102, 132 ff
- Newtonian fluids 54, 75, 347
- nickel
 - electroforming 203, 395–420
 - feedstocks 301
 - microinjection molding 268
 - tribologics 580, 597
- nickel alloys
 - diamond cutting 90
 - electroforming 395–420
 - laser etching 144 ff
 - microinjection molding 268
 - micro-metal injection molding 292, 318
- nickel–gold interface 205
- nickel layers 201 f
- nickel sulfamate plating 202
- nickel surfaces 139
- no-slip condition 67
- nodal displacement 44
- noise amplitude 58
- noncontact laser-based methods 134
- nondirected nickel electroplating 403 ff
- nonsilicon candidates 188
- notch factor 40, 575
- nozzles
 - drilling 511
 - EDM 172
 - HPIM 337, 341
 - laser etching 144
 - microcasting 382
- nucleation 365

- o**
- object/operation system 3 ff
- octadecylamine 345
- open flame technique 363
- optical glass fibers 256
- optical probing 502 ff, 505 ff
- optimization 44 ff
- optotactile sensors 512
- ordering hardening 525
- outsertmolding 274
- overmolding 274, 304
- Owens–Wendt–Rabel–Kaelble method 414
- oxide layers 371

- p**
- PA12-C 271
- packaging 462, 477 f
- pale etching layers 232
- paraffin
 - electrophoretic deposition 430
 - LPIM 345
 - μ CIM 327
 - zirconia 557
- parallel assembly 477 ff
- parallel robots 475, 480
- particle packing theory 430
- particles 154, 290, 297, 328
- passivation 147
- passive optical components 502
- PATRAN 33, 612