



BSI Standards Publication

Additive Manufacturing — Qualification principles — Installation, operation and performance (IQ/OQ/PQ) of PBF-LB equipment

National foreword

This Published Document is the UK implementation of CEN ISO/ASTM/TS 52930:2021. It is identical to ISO/ASTM TS 52930:2021.

The UK participation in its preparation was entrusted to Technical Committee AMT/8, Additive manufacturing.

A list of organizations represented on this committee can be obtained on request to its committee manager.

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English Version

**Additive Manufacturing - Qualification principles -
Installation, operation and performance (IQ/OQ/PQ) of
PBF-LB equipment (ISO/ASTM/TS 52930:2021)**

Fabrication additive - Principes de
qualification - Installation, fonctionnement et
performances (IQ/OQ/PQ) de l'équipement
de PBF-LB (ISO/ASTM/TS 52930:2021)

Additive Fertigung - Grundlagen der Qualifizierung
- Installation, Funktion und Leistung (IQ/OQ/PQ)
von PBF-LB-Anlagen (ISO/ASTM/TS 52930:2021)

This Technical Specification (CEN/TS) was approved by CEN on 23 July 2021 for provisional application.

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European foreword

This document (CEN ISO/ASTM/TS 52930:2021) has been prepared by Technical Committee ISO/TC 261 "Additive manufacturing" in collaboration with Technical Committee CEN/TC 438 "Additive Manufacturing" the secretariat of which is held by AFNOR.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

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Endorsement notice

The text of ISO/ASTM TS 52930:2021 has been approved by CEN as CEN ISO/ASTM/TS 52930:2021 without any modification.

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 261, *Additive manufacturing*, in cooperation with ASTM Committee F42, *Additive Manufacturing Technologies*, on the basis of a partnership agreement between ISO and ASTM International with the aim to create a common set of ISO/ASTM standards on Additive Manufacturing, and in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 438, *Additive manufacturing*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

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Introduction

Additive manufacturing is a machine-centric process. This document provides recommended practices for machine-related process qualification for serial production of metal parts produced with the powder bed fusion by laser beam process (PBF-LB/M). This document is addressed to organizations that already have a comprehensive quality system in place.

While this document is process specific, it is intended to apply to any industry with strict quality requirements. In such industries, it is not possible to complete machine qualification without ensuring repeatable production of the desired process result, given the current state of AM process knowledge. Operational quality and part performance quality sections are included for this reason.

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Additive Manufacturing — Qualification principles — Installation, operation and performance (IQ/OQ/PQ) of PBF-LB equipment

1 Scope

This document addresses installation qualification (IQ), operational qualification (OQ), and performance qualification (PQ) issues directly related to the additive manufacturing system that has a direct influence on the consolidation of material. The first three elements of process validation, process mapping, risk assessment, and validation planning, are necessary pre-conditions to machine qualification, however, they are outside the scope of this document.

This document covers issues directly related to the AM equipment and does not cover feedstock qualification or post processing beyond powder removal.

Physical facility, personnel, process and material issues are only included to the extent necessary to support machine qualification.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

[ISO/ASTM 52900](#), *Additive manufacturing — General principles — Fundamentals and vocabulary*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in [ISO/ASTM 52900](#) and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1

installation qualification

IQ

establishment by objective evidence that all key aspects of the process equipment and ancillary system installation adhere to the manufacturer's approved specification and that the recommendations of the supplier of the equipment are suitably considered

3.2

operational qualification

OQ

establishment by objective evidence process control limits and action levels which result in product that meets all predetermined requirements