

# The Application of Additive Manufacturing in the Field of Model Rocketry

or

**How I learned to build really heavy rockets with a fancy hot  
glue gun**

# In This Presentation...

- I have no idea what I'm doing
- Printer background
- General design considerations
- Rocket specific considerations (aka, why you are here)
- Example Rocket

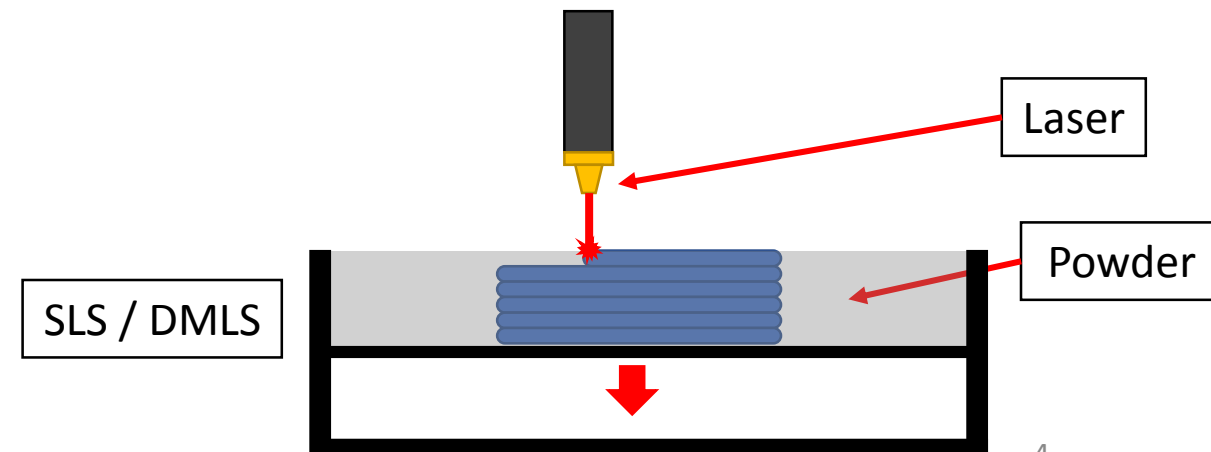
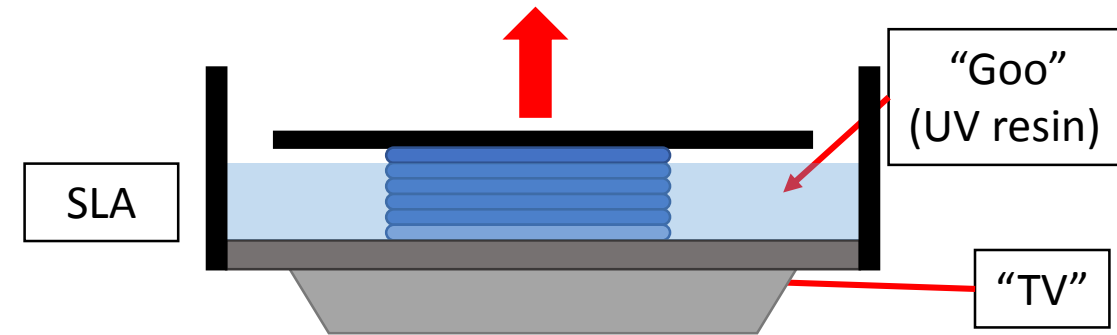
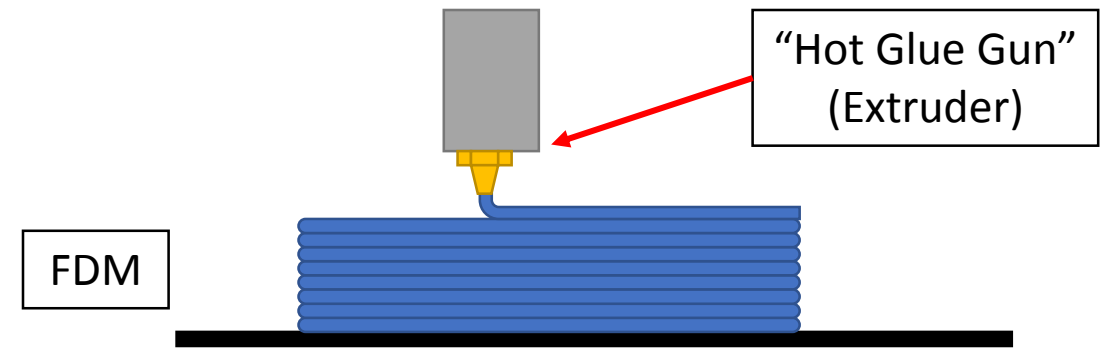
# Disclaimer!

- I am not a 3D printer guy, just a guy who 3D prints
- I trial-and-errored my way to victory
  - The information here is not “the one true way” ....
  - ... but it is “a way”



# How do work?

- All work using layers
  - 3D model is “sliced” into layers of a specific thickness
    - Usually 0.1mm to 0.2mm ( 4 to 8 thou in ‘murrican)
  - Printer “draws” each layer on top of the previous layer
- Many different types
  - FDM – Fused Deposition Modeling (hot glue gun)
  - SLA – Stereolithography (TVs and fancy goo)
  - SLS – Selective Laser Sintering (shoot laser at ~~corn~~ starch powdered plastic)
  - DMLS – Direct Metal Laser Sintering (shoot laser at rocket fuel)
  - And many more...
- Most hobby printers are FDM, so I will focus on those

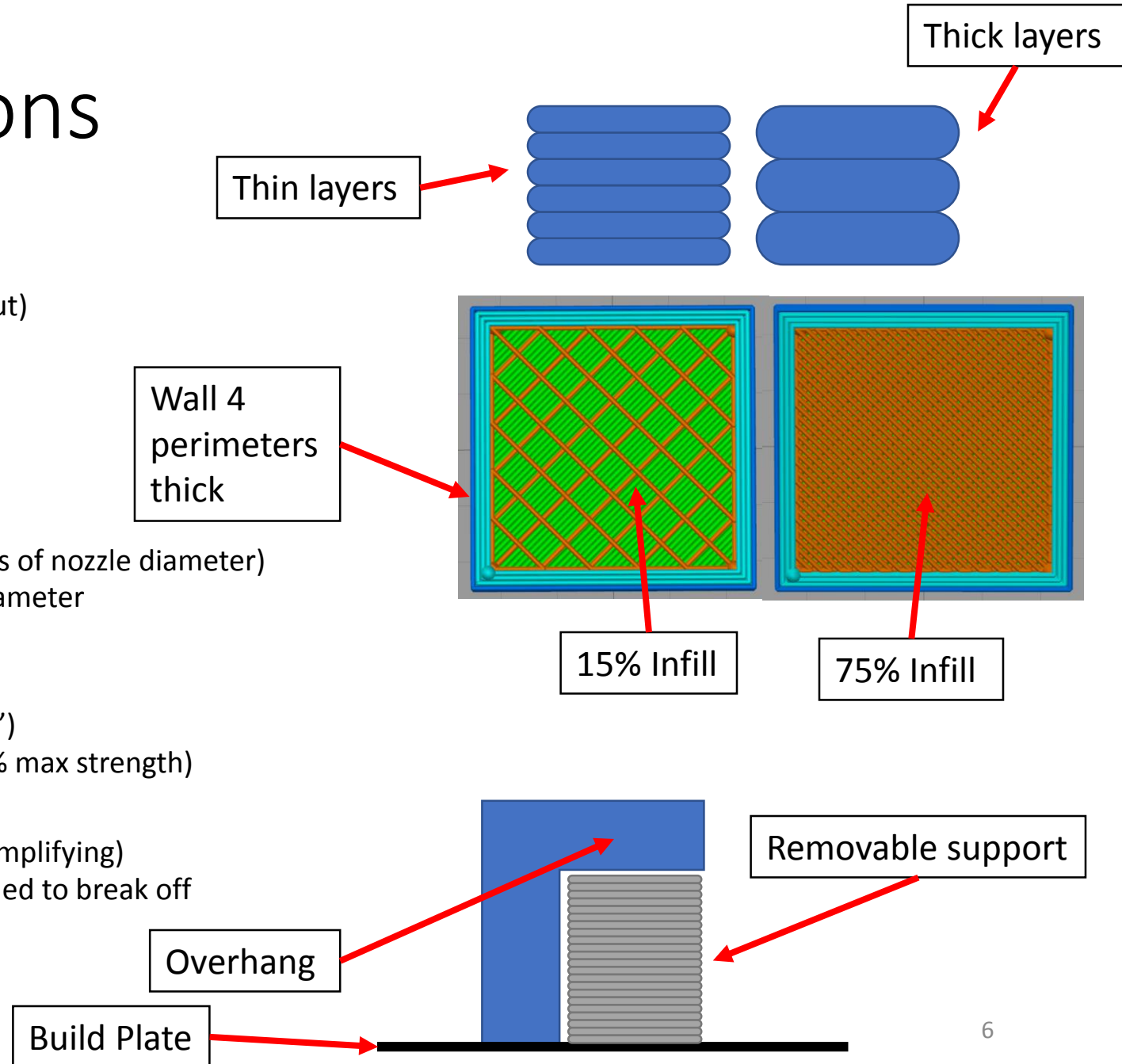


# NOT MAGIC

- Important to note that printers are not magic
- Just like every other form of manufacturing, they have their pros and cons
- Pros:
  - Can create geometries that are not possible by traditional machining
  - It's almost like a replicator (that "almost" is important)
  - Low "hands on" time (you aren't running it like a lathe, can leave it alone)
  - Don't need to worry about getting a tool into tight places
- Cons:
  - Can't create geometries that can be made by traditional machining
  - Still finicky to get working
  - Material properties (for hobby printers) are horrible
  - Surface finish is horrible
  - Slow printing speeds - "You are extruding your part through a 0.4mm nozzle; it's going to take a long time".

# Design Considerations

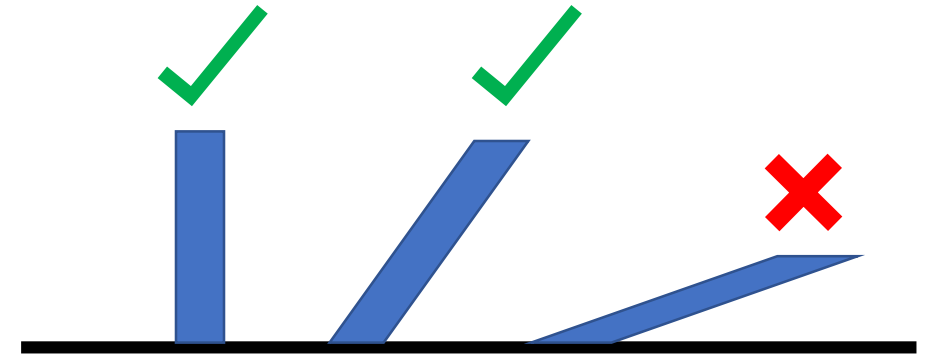
- Nozzle Diameter
  - Larger nozzle, faster print (more stuff coming out)
  - Also have poorer quality (pen vs marker)
- Layer height
  - Similar to nozzle diameter (speed vs quality)
  - Controlled by software instead of hardware
- Wall thickness
  - Usually set in “perimeters” or “shells” (multiples of nozzle diameter)
  - Design thin parts to be in multiples of nozzle diameter
- Infill
  - Part “density”
  - Different styles (grid, hex, triangle, “weird stuff”)
  - Strength not linear (50% infill stronger than 50% max strength)
- Support
  - Can’t print in thin air (well...., you can but I’m simplifying)
  - Structure that supports overhangs and is designed to break off
  - Has very bad surface finish



# Geometry Tips

- Overhangs

- Generally, there is a maximum overhang angle that can be printed ( $\sim 45^\circ$ )
- Use angles instead of full horizontal to avoid support material
  - Wasted material (\$)
  - Wasted time



- Holes (the horizontal kind)

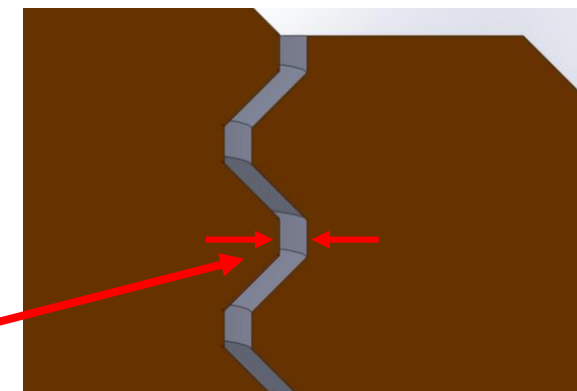
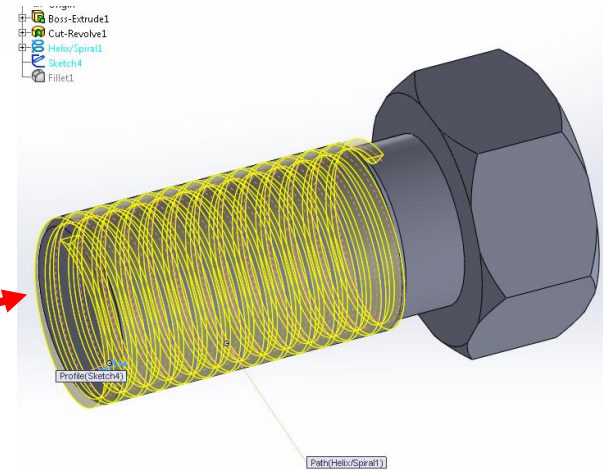
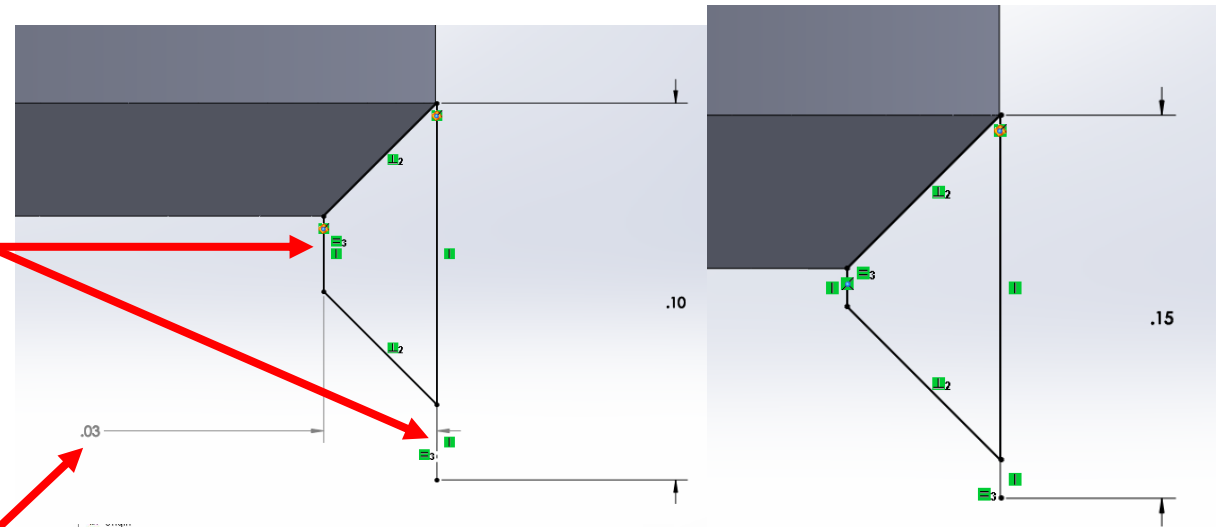
- Small holes are generally fine ( $\sim 1/4''$ )
- Larger holes will have "sag"
- Teardrop holes can help with this
  - Keeps overhangs within  $45^\circ$
  - Assumes you just need a "hole" (not round)
  - Can use support for circular holes



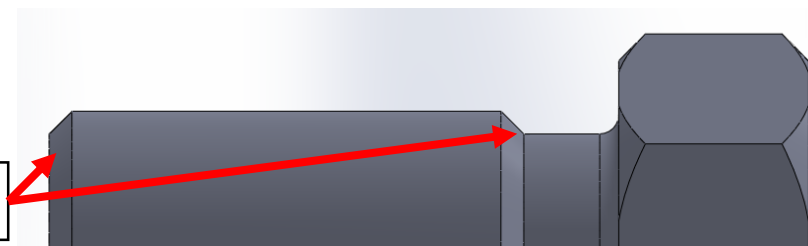
# Threads

- Many standards, so I made my own (XKCD comic #927)
  - Revolved 90° trapezoid
  - Two flavors:
    - 0.1" thread pitch
    - 0.15" thread pitch
    - Any diameter you want
- Created by making a profile...
  - 0.1" pitch uses a 0.03" deep cut
  - 0.15" pitch uses a to 0.06" deep cut
- ...then revolving it around a helix
- Diameter difference between internal and external threads varies with diameter and desired slop
  - Test prints are required to determine the correct gap
  - Usually in the 10 thou to 15 thou range

Equal length constraint



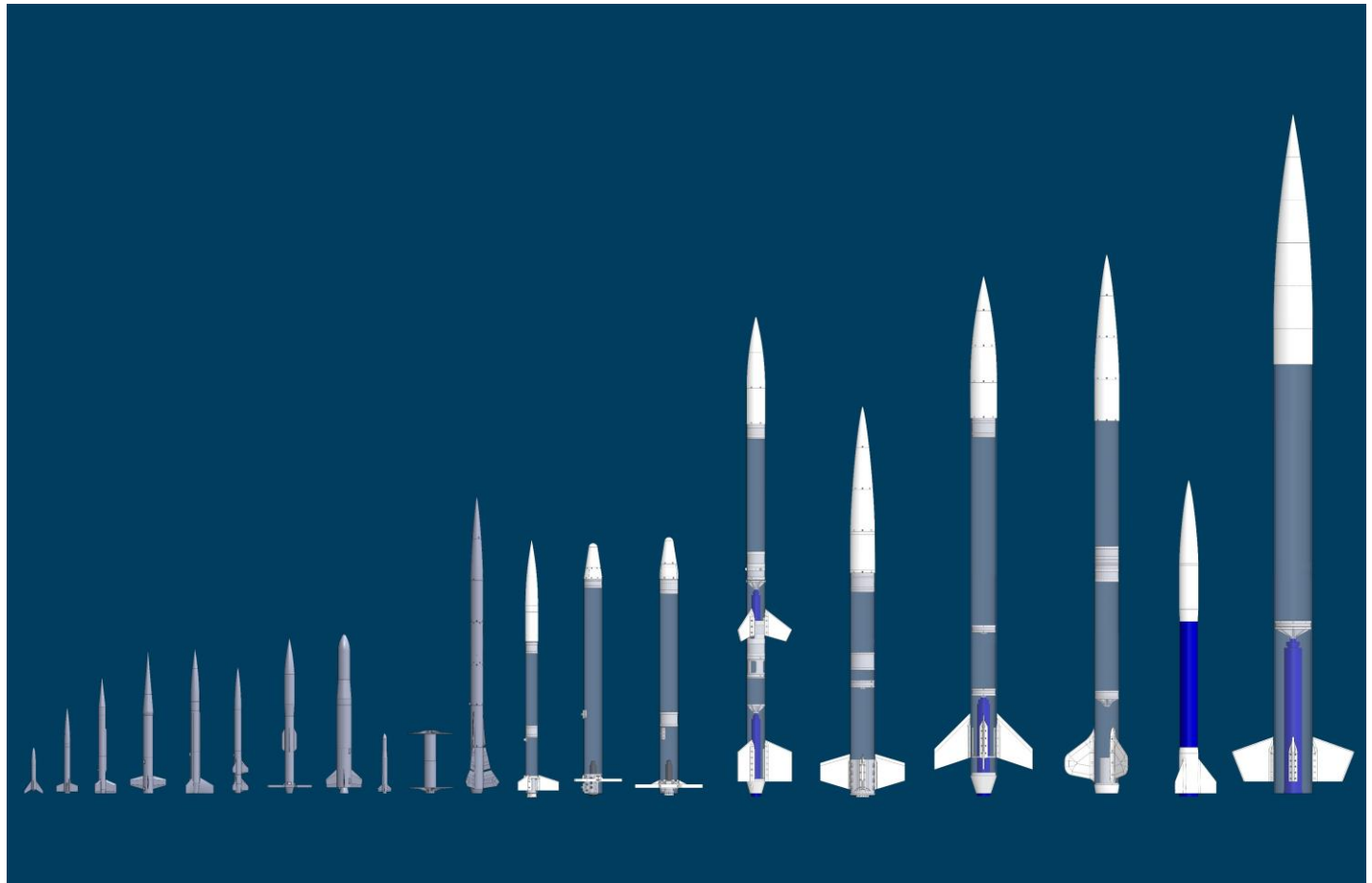
Chamfer start and end of threads





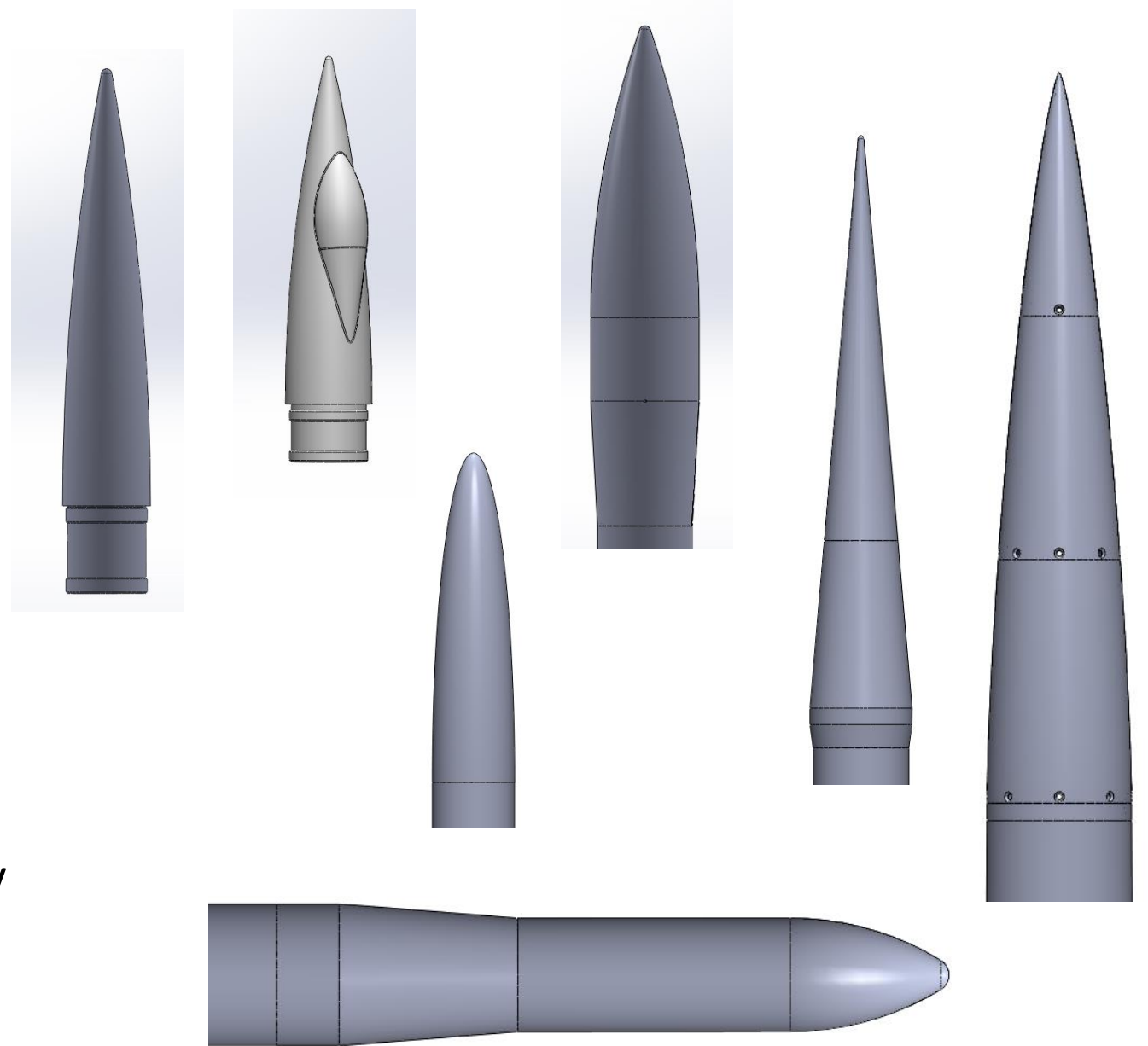
# Rocket Stuff!!!!1 (finally)

- Nose cones
- Body Tubes
- Motor Mounts
- Fins
- Etc.....



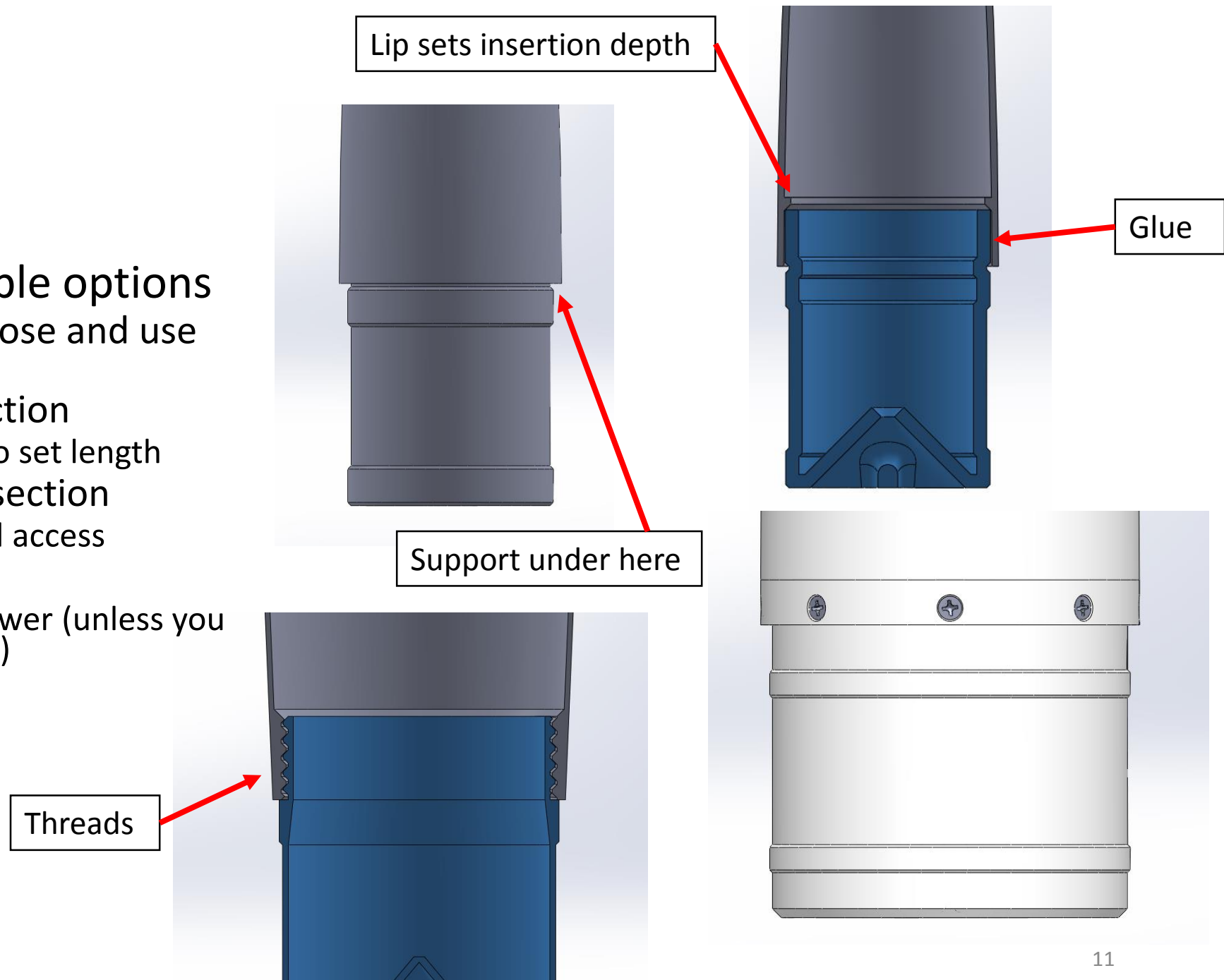
# Nose Cones

- Shape only limited by your CAD skills...
  - Conical
  - Parabolic
  - Elliptical
  - Ogive
  - Von Karman (equation driven curves are your friend)
  - X-20 Dynasoar / hammerhead / pumpkin / snowman / potato / etc.



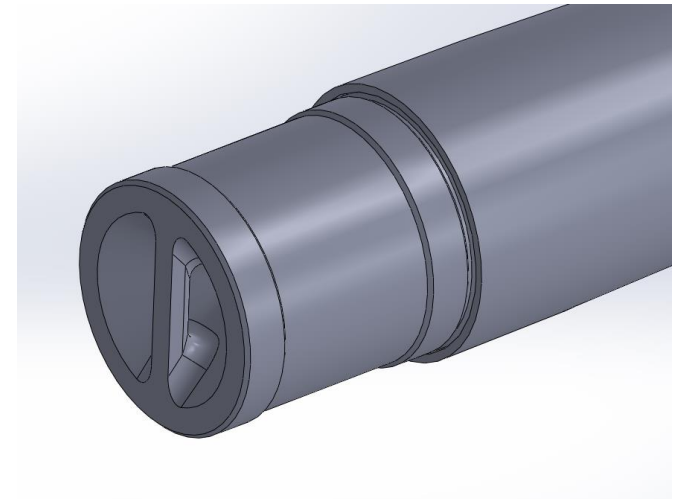
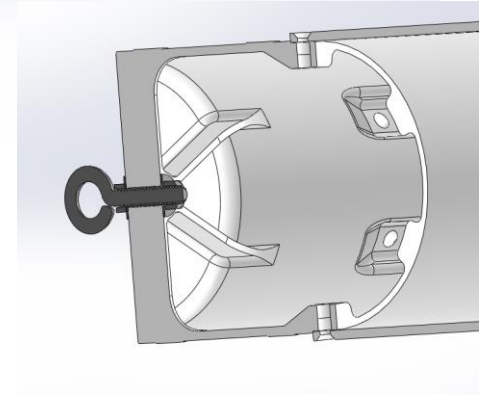
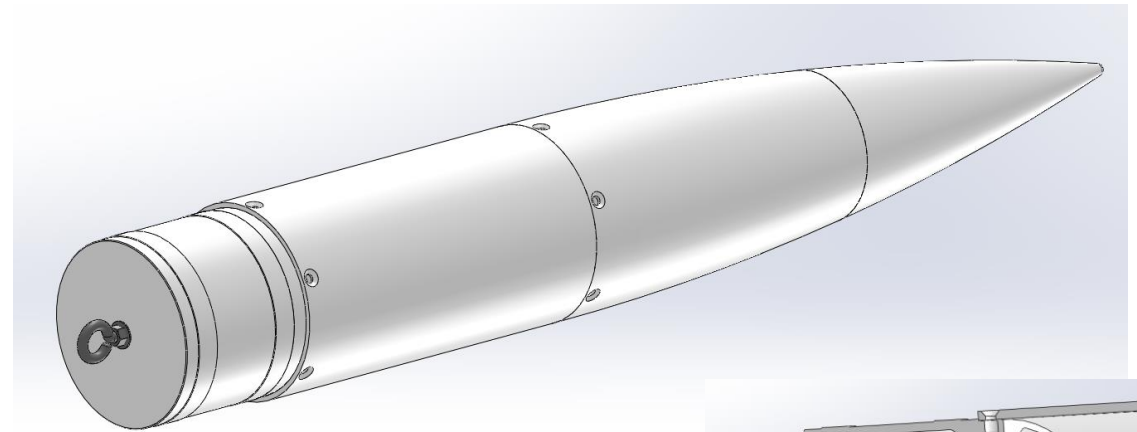
# More Cones

- Shoulder has multiple options
  - Print attached to nose and use support material
  - Glue in coupler section
    - Use internal lip to set length
  - Thread in coupler section
    - Good for payload access
- Bolts!
  - Good for high power (unless you like #2-56 screws)



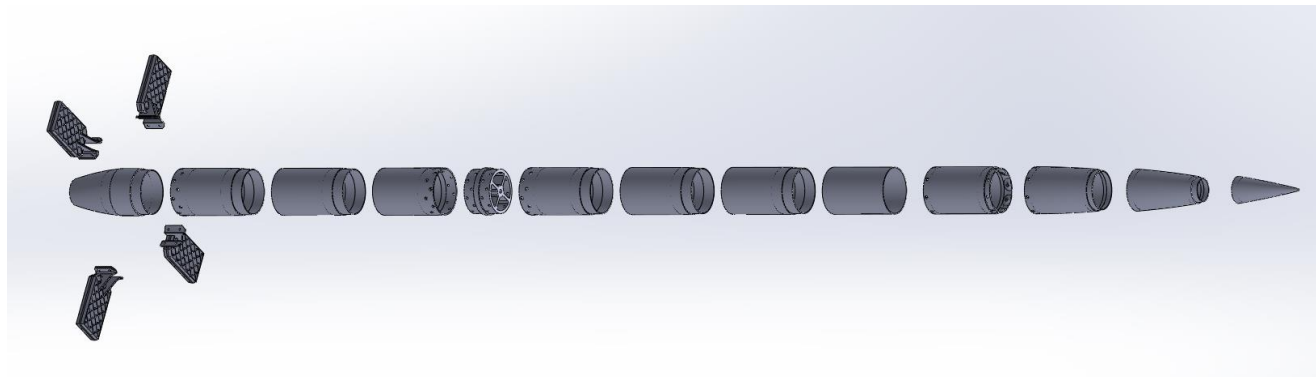
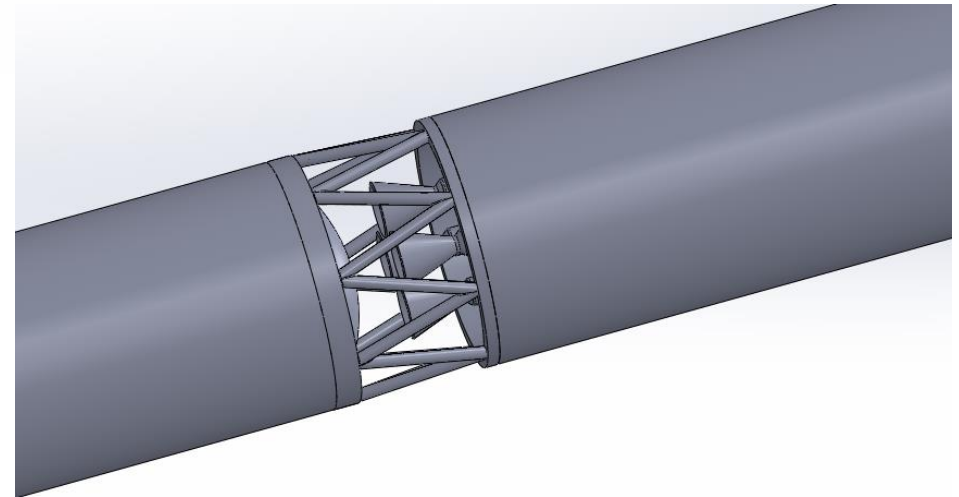
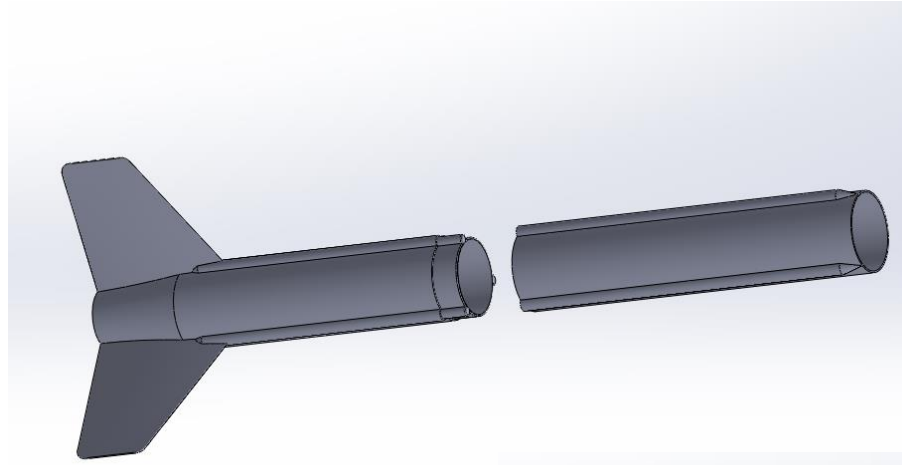
# EVEN MORE CONES

- Recovery attachment
  - Hole for eyebolt
    - Plastic not as strong
    - Add reinforcement structure
  - Printed hard point
- Can “print in” nose weight



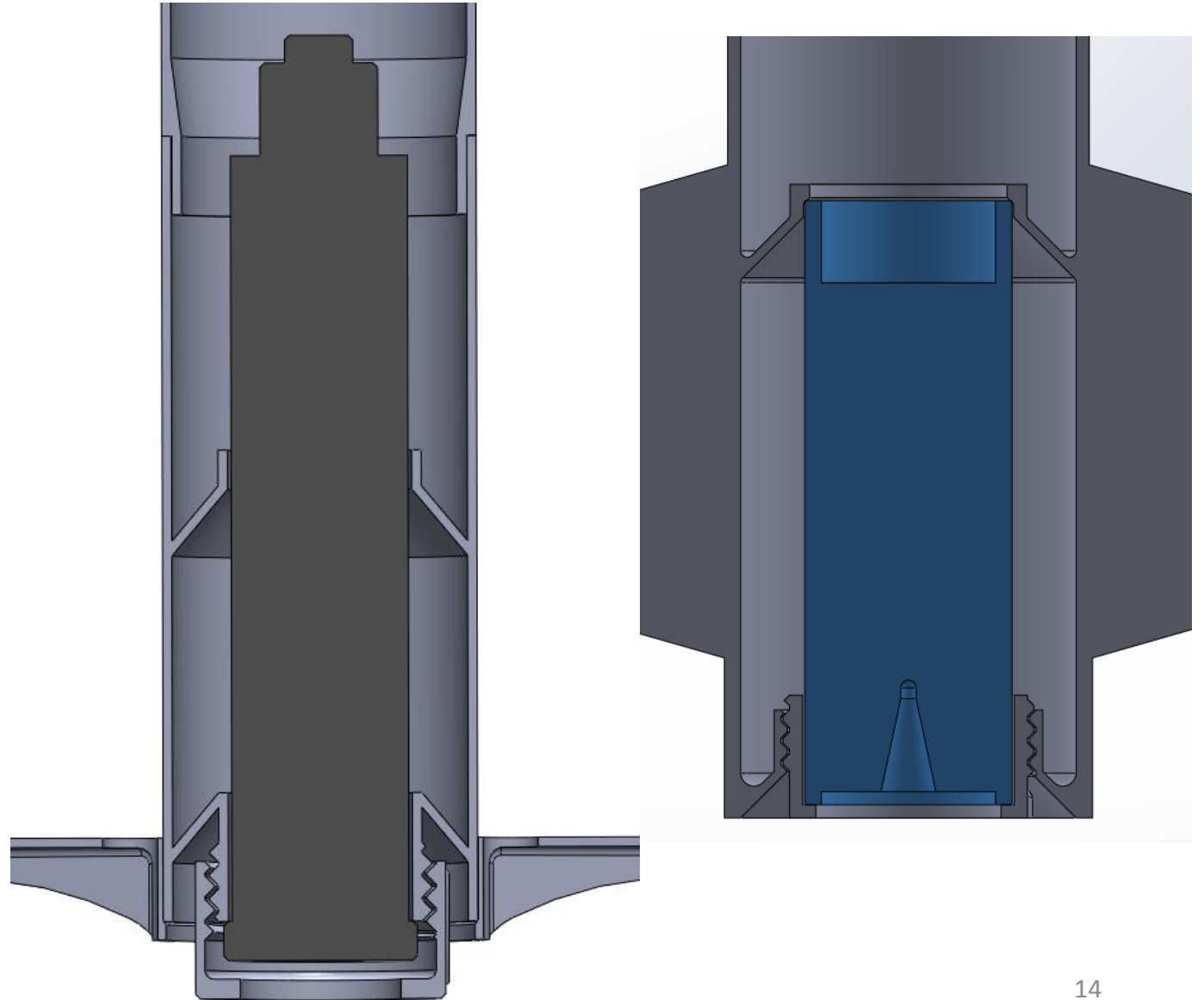
# Body Tubes

- WHY!?!
  - Custom diameter
  - Custom thickness
    - ~30 thou for low power
    - ~60 thou for mid power
    - 60 thou or greater for high power
  - Not limited to circular cross sections
  - Could add reinforcement (ribs and stringers)
    - I haven't, but it is theoretically possible
  - And most importantly: Because I can
- Single tube length is limited to printer height
  - Can join multiple sections
- Can do weird stuff
  - Strut interstages (Soyuz and Long March)
  - Fairings and cable tunnels
- Gets stupid at large sizes



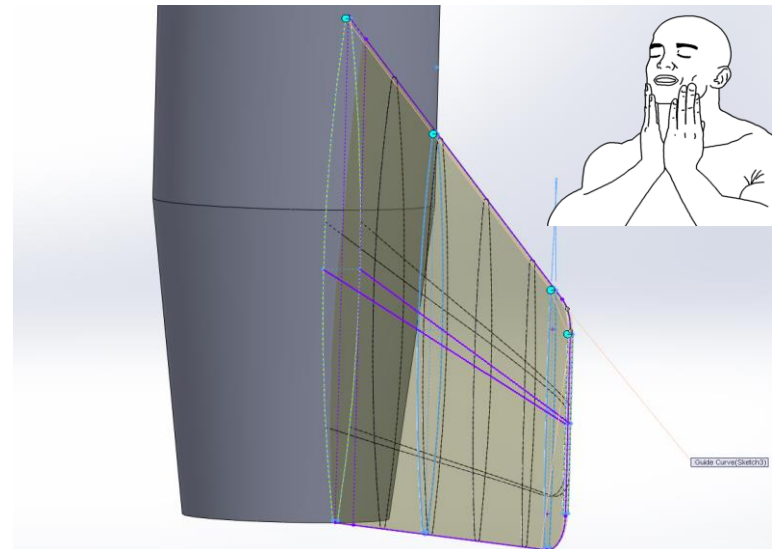
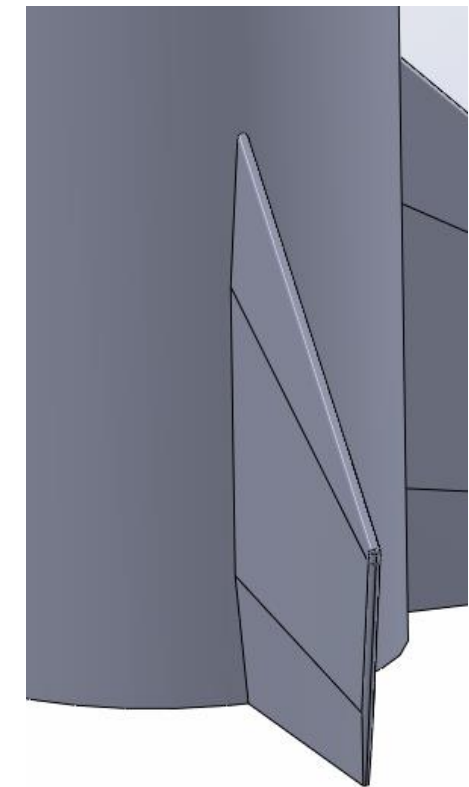
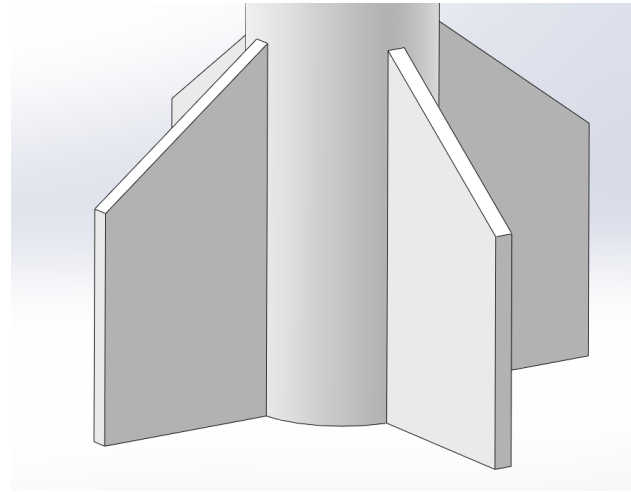
# Motor Mounts

- You could print a tube and centering rings and glue them together....
- ... but that's ~~stupid~~ not optimal
- Use 45° or greater to avoid supports
  - Centering “cones” instead of centering “rings”
- Traditional “tubes” are not needed, just enough material to:
  - Prevent radial motion
  - Prevent axial motion
- Threaded motor retainers are easy to add



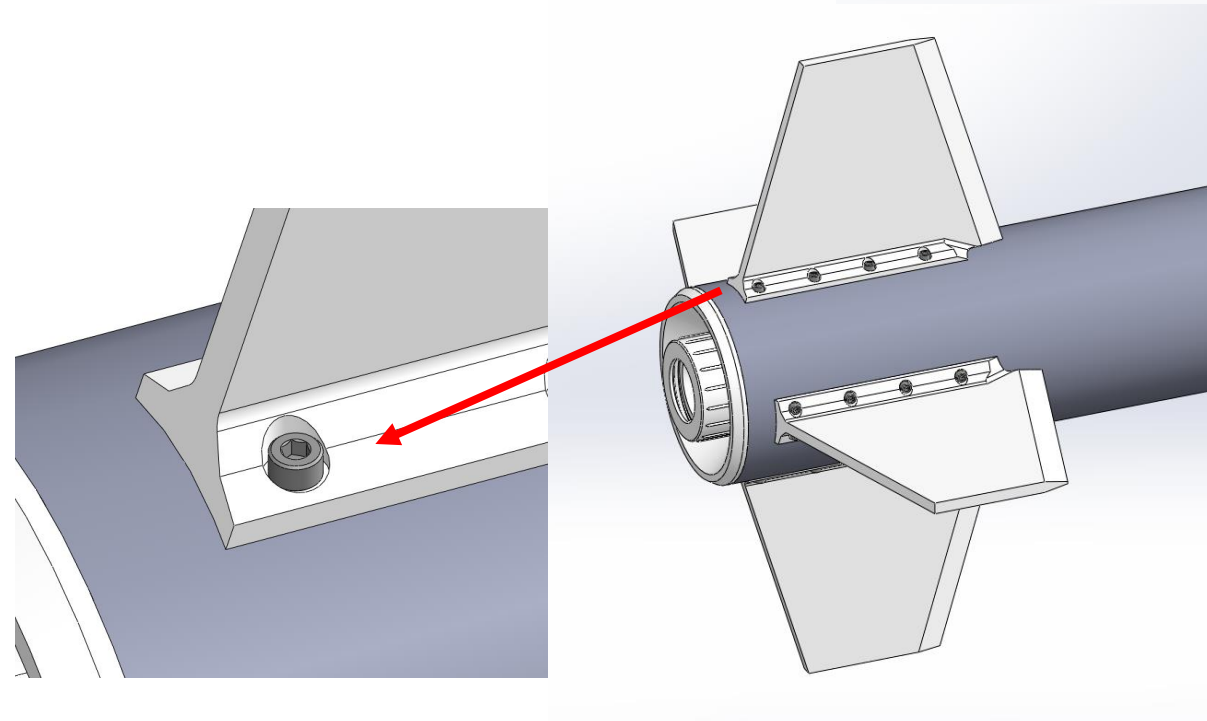
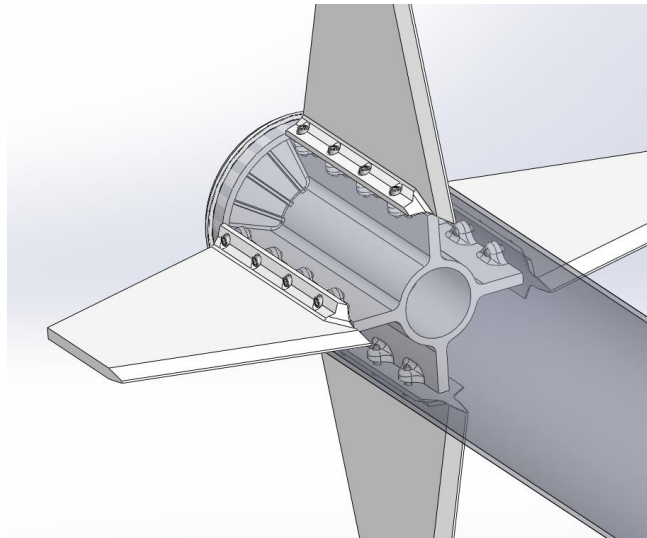
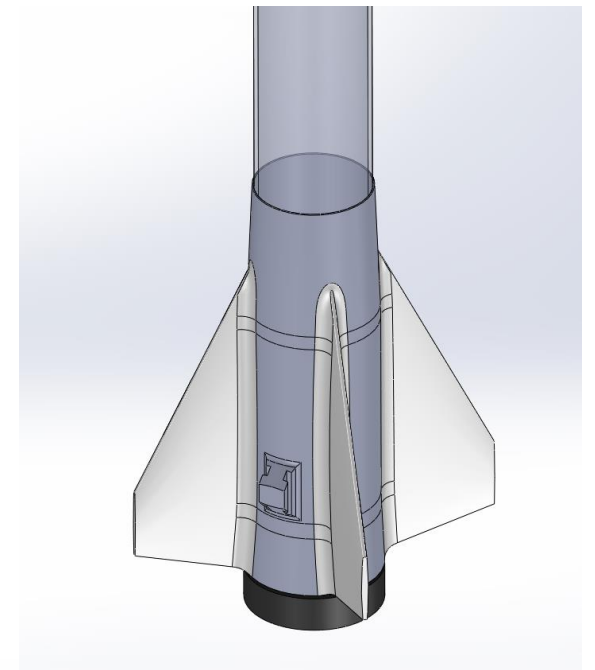
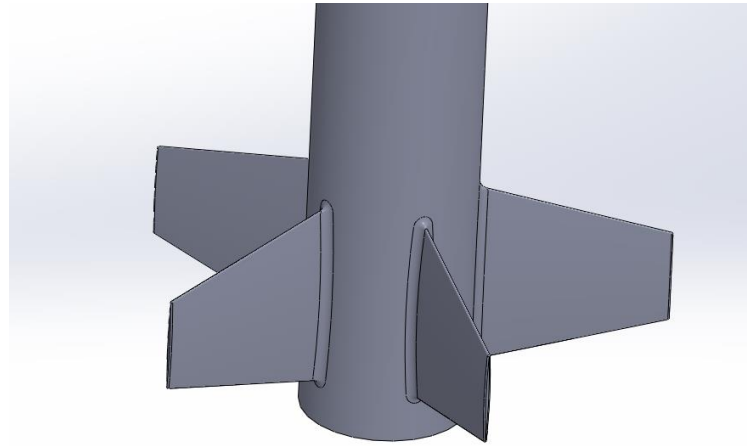
# Fin Cross Sections

- Baby's first fin
  - Rectangular extrusion
  - Simple
  - Lots of drag
- Look mom, I made an airfoil
  - Use chamfers to taper fin
  - Use fillets to round edges
- Biconvex
  - Scale profile (WAC Corporal, Aerobee, etc)
  - Loft tool can be "fun"
- Other types, but these are what I have used
- Note: Plastic not as strong
  - Make fins thicker to compensate
  - Airfoil can help reduce drag



# Fin Attachment

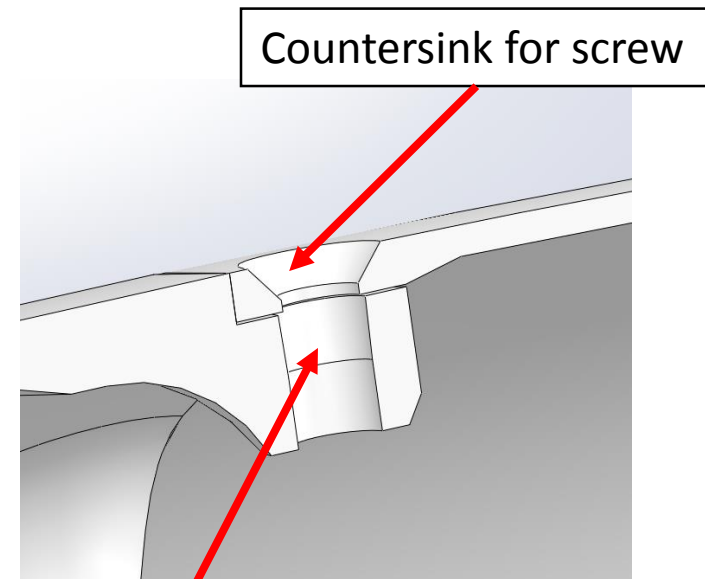
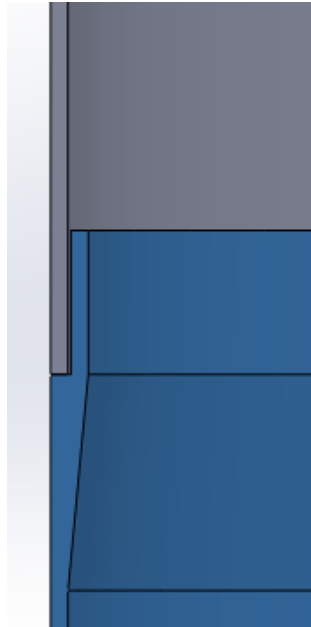
- Integrated
  - Best on small models
  - Fillets can be printed in
- Glue-on fin can
  - Fin span limited by printer bed size
- Bolt on
  - Can have much larger fin spans



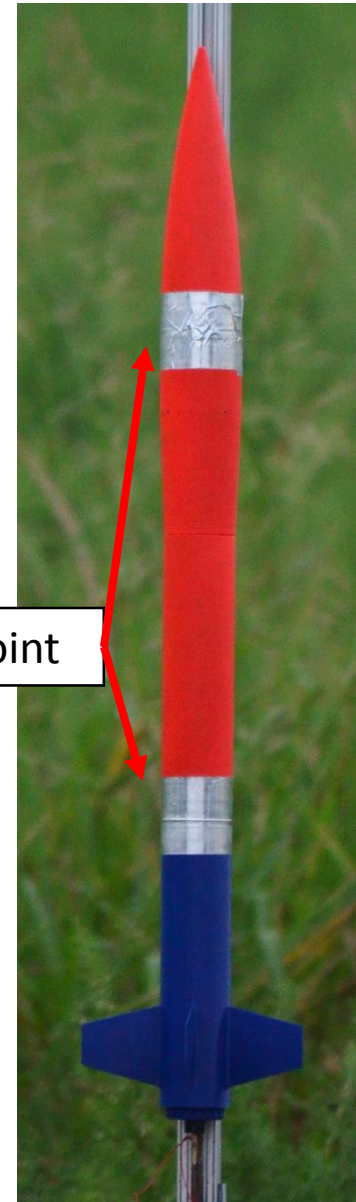
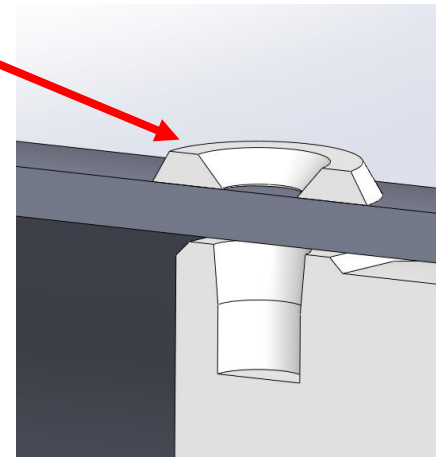


# Joining Methods

- Glue
  - Use a “printed in” coupler
  - CA and epoxy work for PETG
- Fasteners
  - #4-40 for mid power
  - #6-32 for L1
  - Heat-Set Inserts
    - <https://www.mcmaster.com/93365a132>
  - “Fairings” for countersunk screws
- Threads
  - Nose cones
  - Body tubes
  - Motor retainers
- ~~Jank~~ Tape
  - Used when you want to:
    - \*Eventually\* use glue to hold it together
    - Also be able to take it apart
  - Great for temporary joints in development
  - I use aluminum tape from the hardware store
    - It looks cool
    - I had it already



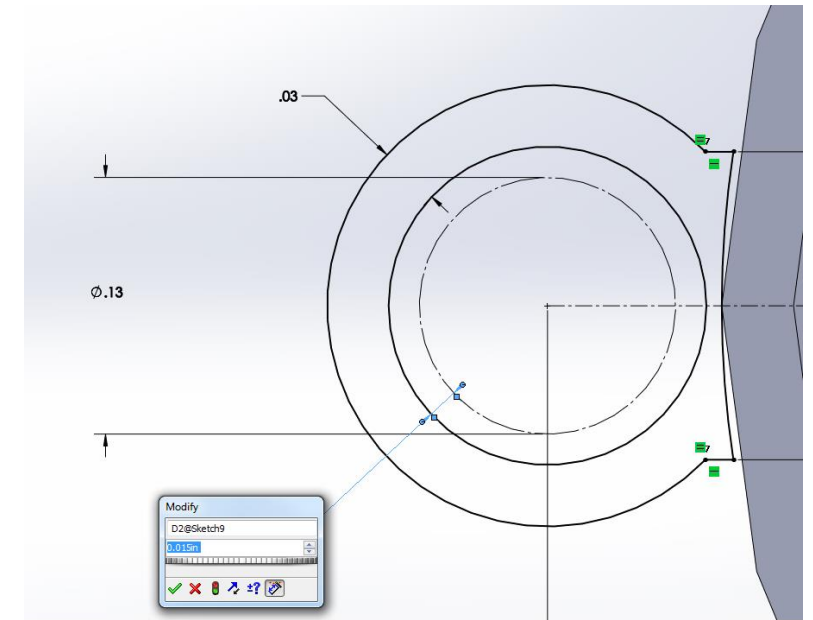
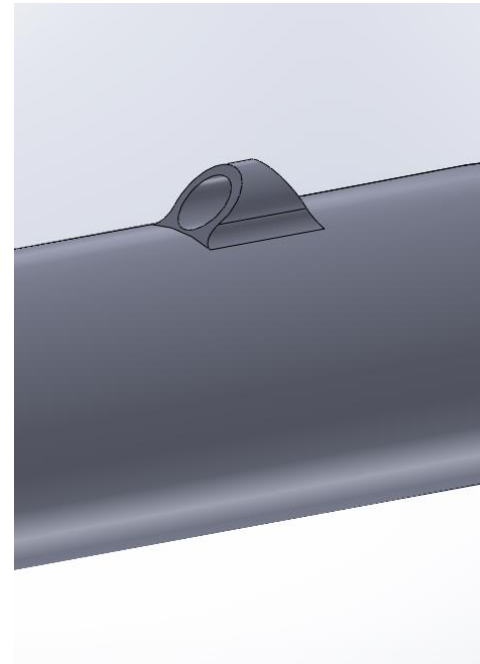
Temporary tape joint



# Launch

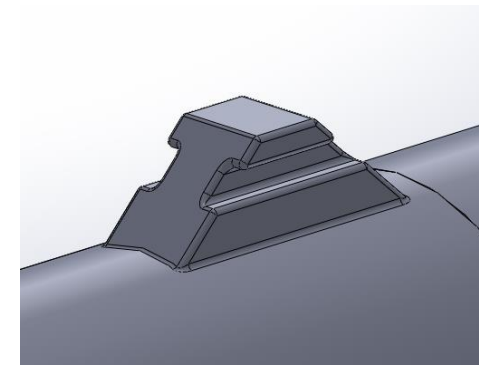
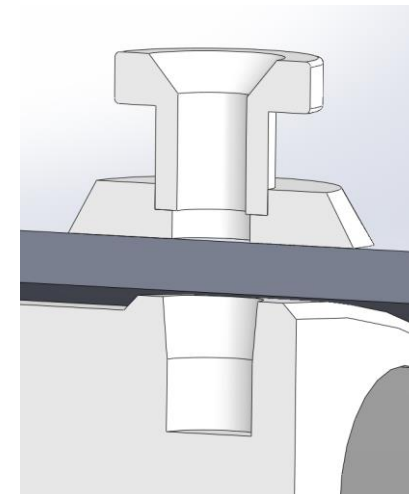
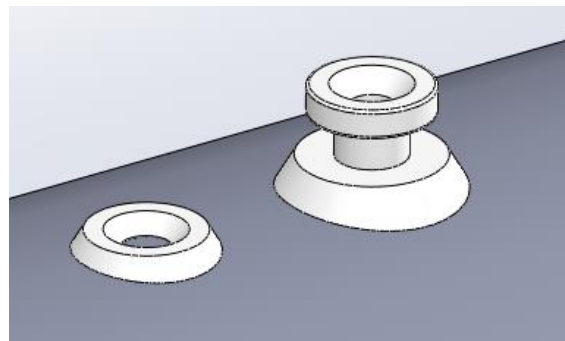
- Launch Lugs

- Printed onto body tube
- Could print separate glue/bolt on versions
- Make ID larger than rod size
  - I use 15 thou for 1/8<sup>th</sup> inch rod
  - Your printer may vary



- Rail Buttons

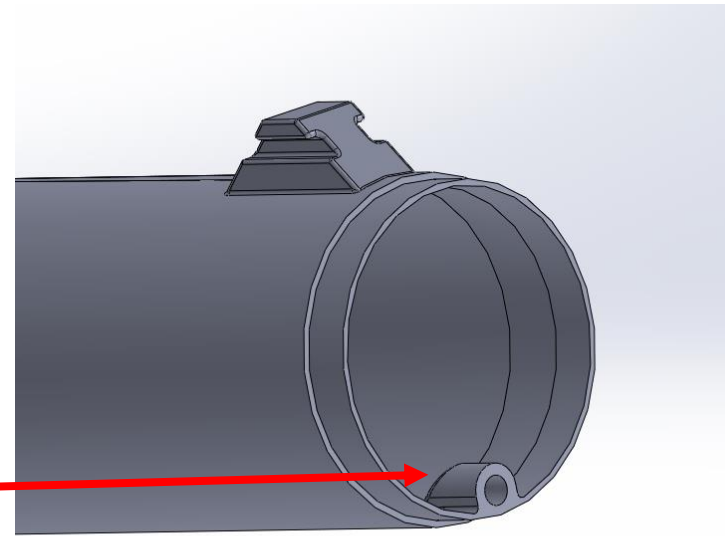
- I use two-piece to avoid support material
- Can also print on like launch lug
- Tolerance found by trial and error
- Bolts to internal structure



# Recovery

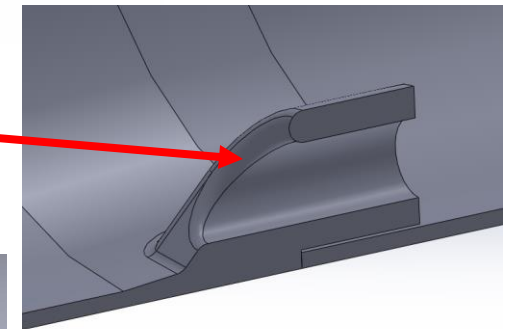
- Small Rockets

- Print a “launch lug” on the inside
- Tie shock cord to it
- Add fillets to avoid cutting



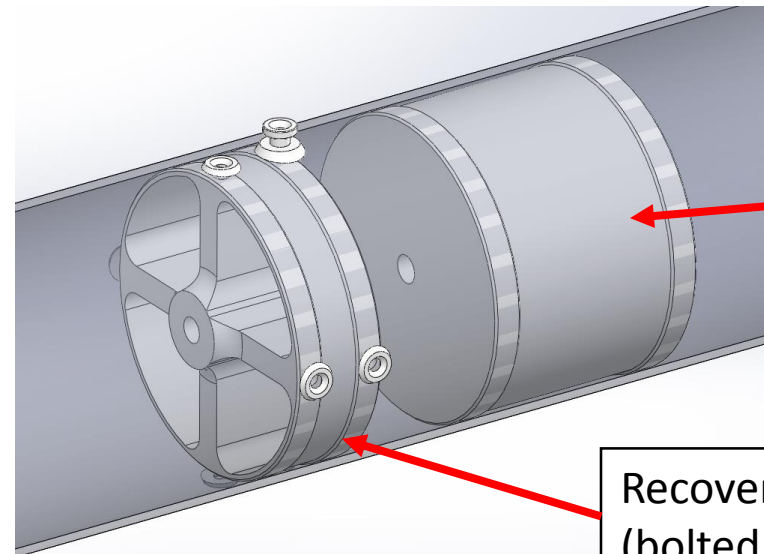
- Big Rockets

- Add hard points to structure
  - Can be part of motor mount
  - Can be separate pieces



- Can also print PML style recovery pistons

- No wadding required
- Not recommended for small models

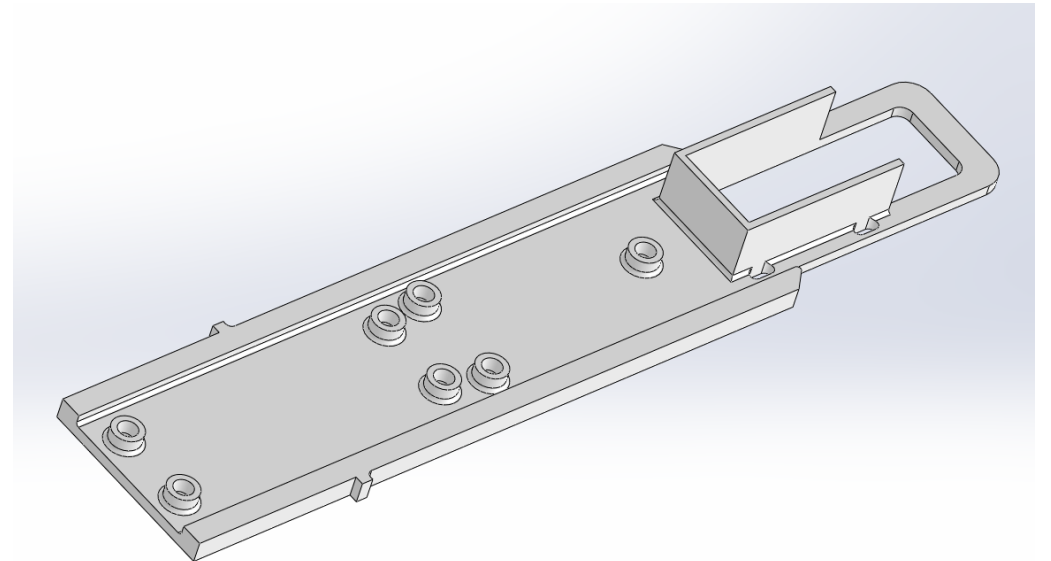
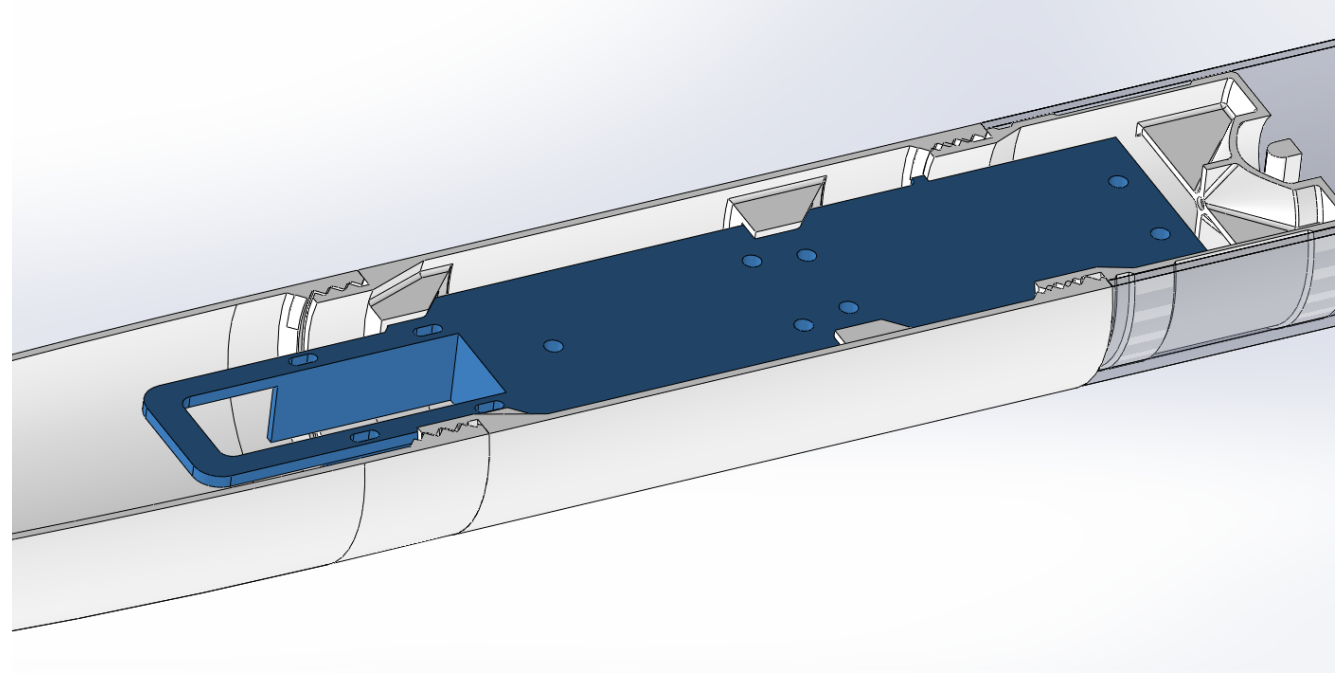


Piston

Recovery hardpoint  
(bolted to airframe)

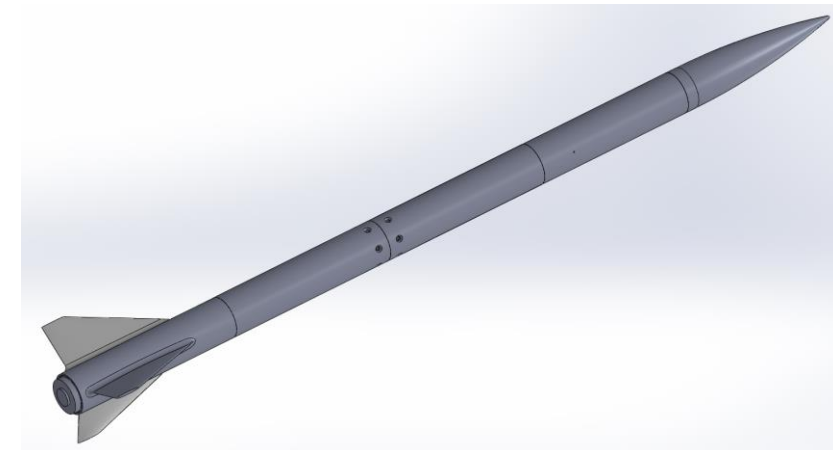
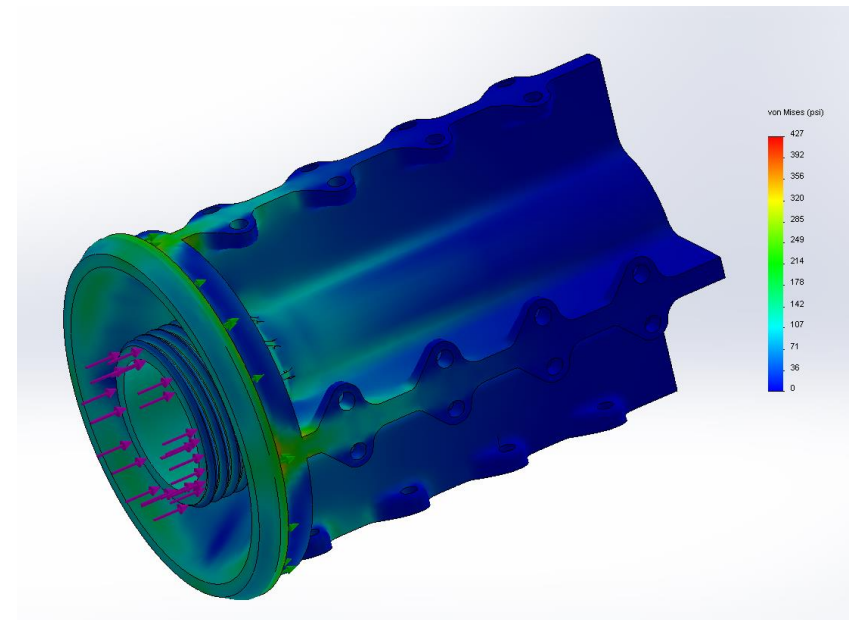
# Misc

- Altimeter sleds
  - Can print custom mounting for your electronics and battery
    - Heat-Set inserts are handy here
  - Print guides into the side of the payload bay to hold sled
  - Many other methods
- Camera fairings
  - I haven't made one (electrical tape for the win)
  - Others have made them, lots of pictures online



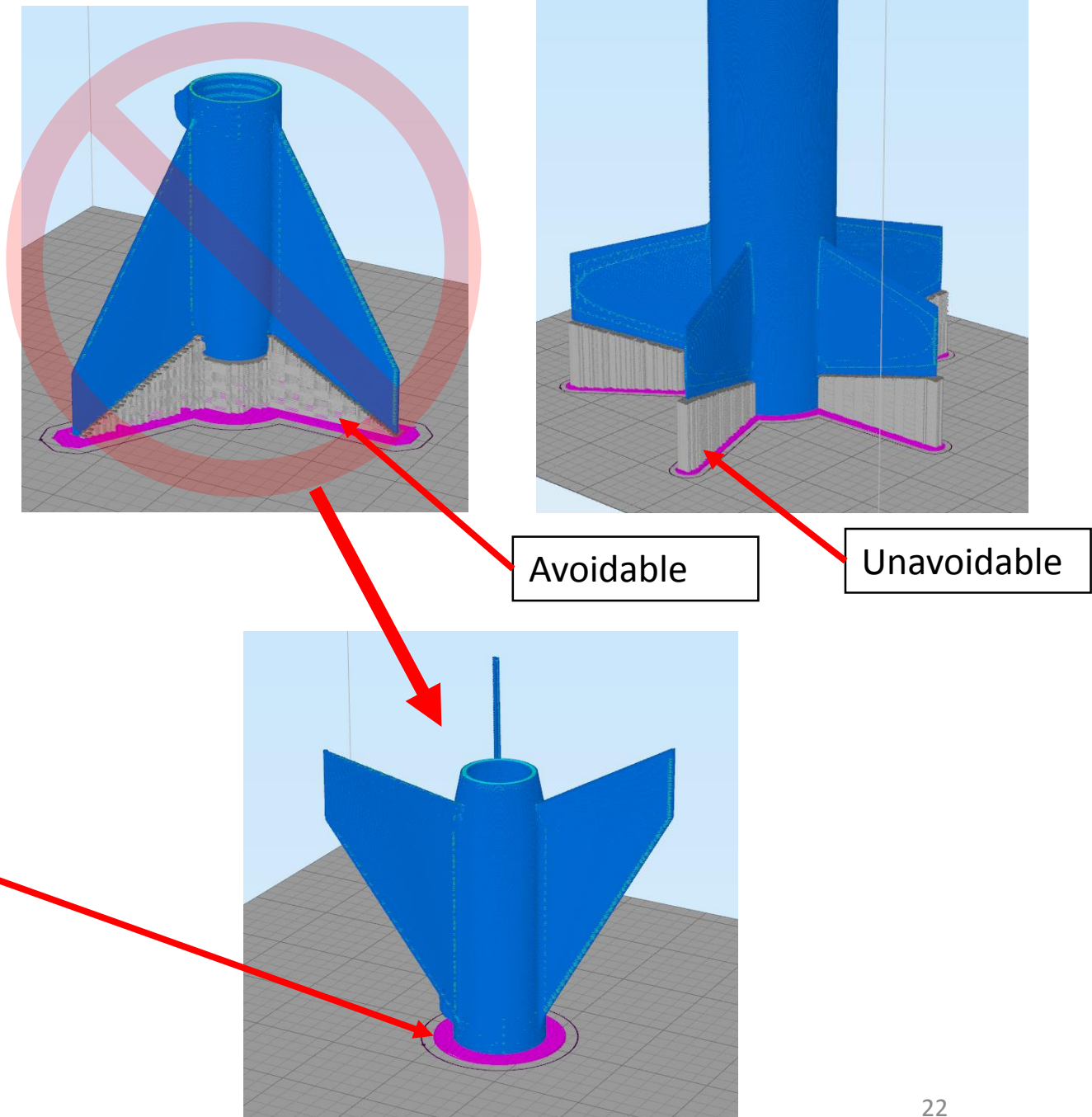
# High Power Considerations

- Hand calcs and/or FEA is basically required
  - Forces and energies involved start to get real
  - Material is at 1 to 2 ksi after safety factors and printing factors are added
- Check flutter
  - <https://www.apogeerockets.com/education/downloads/Newsletter291.pdf>
  - Shear modulus is hard to find
  - Based on flight data, it is at least 23.4 ksi (for PETG, on my printer [450 mph flight])
- Some people have used motor mounts with no thermal liners (and they worked)
  - I've been adding a tube for thermal until I can do a static test to measure case temperature
  - Thick motor mounts add thermal mass (which helps with heating)
- Aero heating is unknown
  - Model Rocketeers: "you will melt over mach 1"
  - Aerodynamicists: "good luck finding references, nobody cares under mach 2"
  - Truth probably somewhere in the middle, need experiments to find the limits (carefully)



# Printing

- Materials
  - Don't use PLA
  - PETG is great
- Direction
  - Some parts can be printed without support
  - Will be unavoidable on some parts
  - Treat the layers like wood grain
    - The layer bonds are usually weaker
    - Avoid having layers parallel to airflow
- Rafts
  - Use for parts with low-contact area
  - Can help tall parts from tipping over



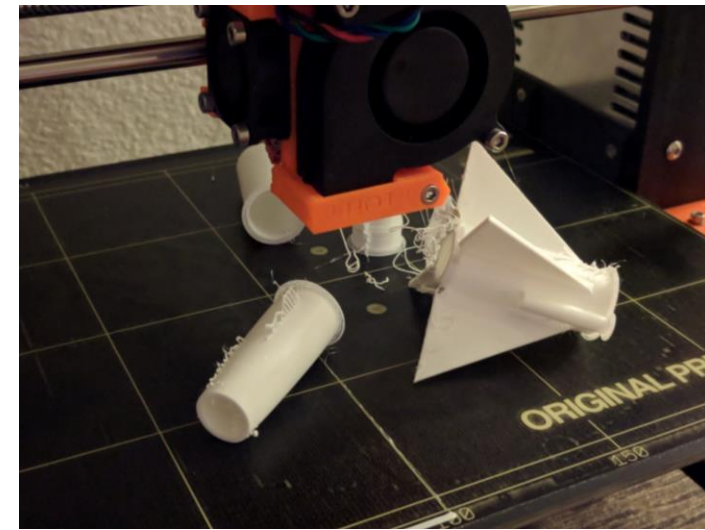
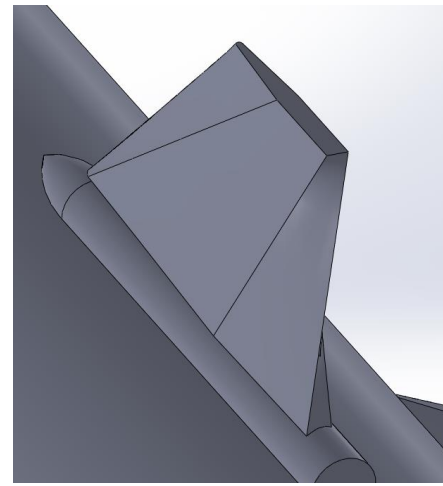
# Flying and Finishing

- Avoid dark colors
  - They will absorb sunlight and heat the model
  - Mostly a PLA problem (PLA will slump in the sun)
- Paint (if you want)
  - I've had good luck with wet sanding and spray paint/primer for plastic
  - Multiple primer and wet sanding steps can help fill print imperfections
- ALL THE WADDING
  - I've noticed that I need to use more than normal amounts of wadding to stop printed tubes from melting



# Conclusions

- Make test pieces
- Don't be afraid to experiment
- Don't print if you are optimizing for maximum performance
  - Not as strong
  - Not a light
  - But....
- **RULE OF COOL**
  - I optimize for combination of cost, lazy and stupid
  - Having fun is important (otherwise what is the point?)
  - Do what you enjoy (within reason, don't be *that guy*)

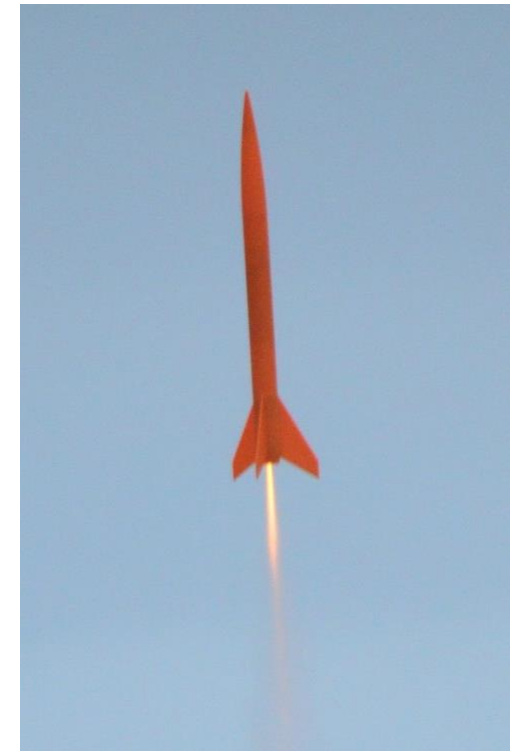
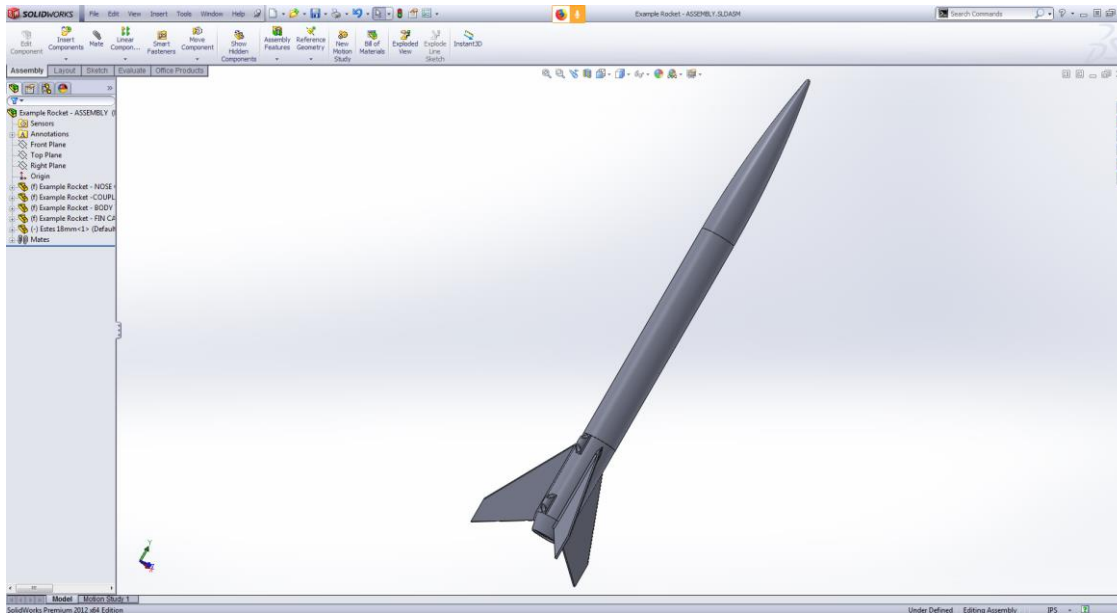


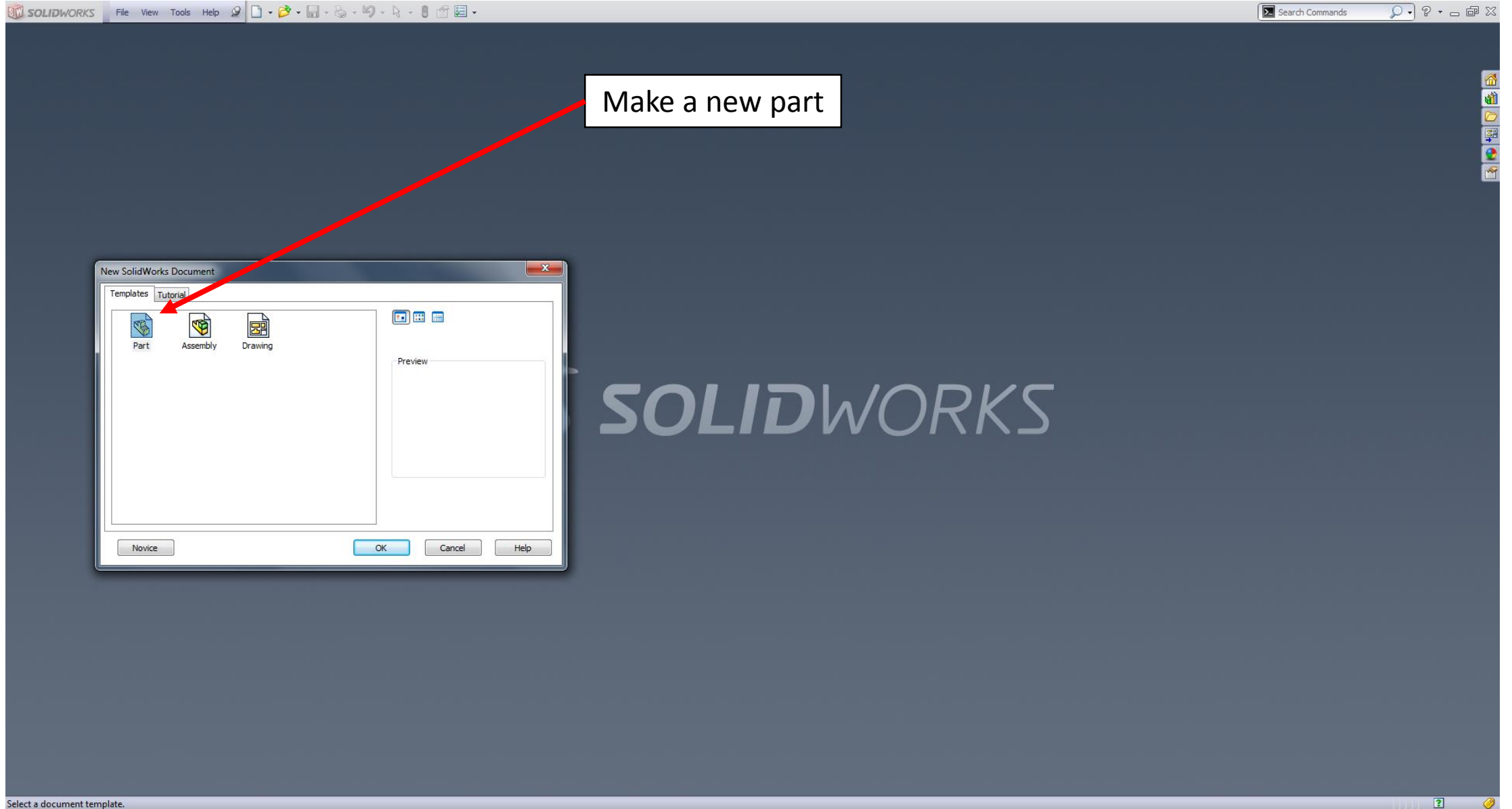


# Example Rocket

(it's over 120 slides, I'm not talking about it)

- Step-by-step unintelligible brain vomit of how I CAD
- 18mm Motors
- Estes Alpha-ish (have fun with those fins [use a raft])
- Threaded fin can stolen from Peanut (<https://www.thingiverse.com/thing:2854353>)

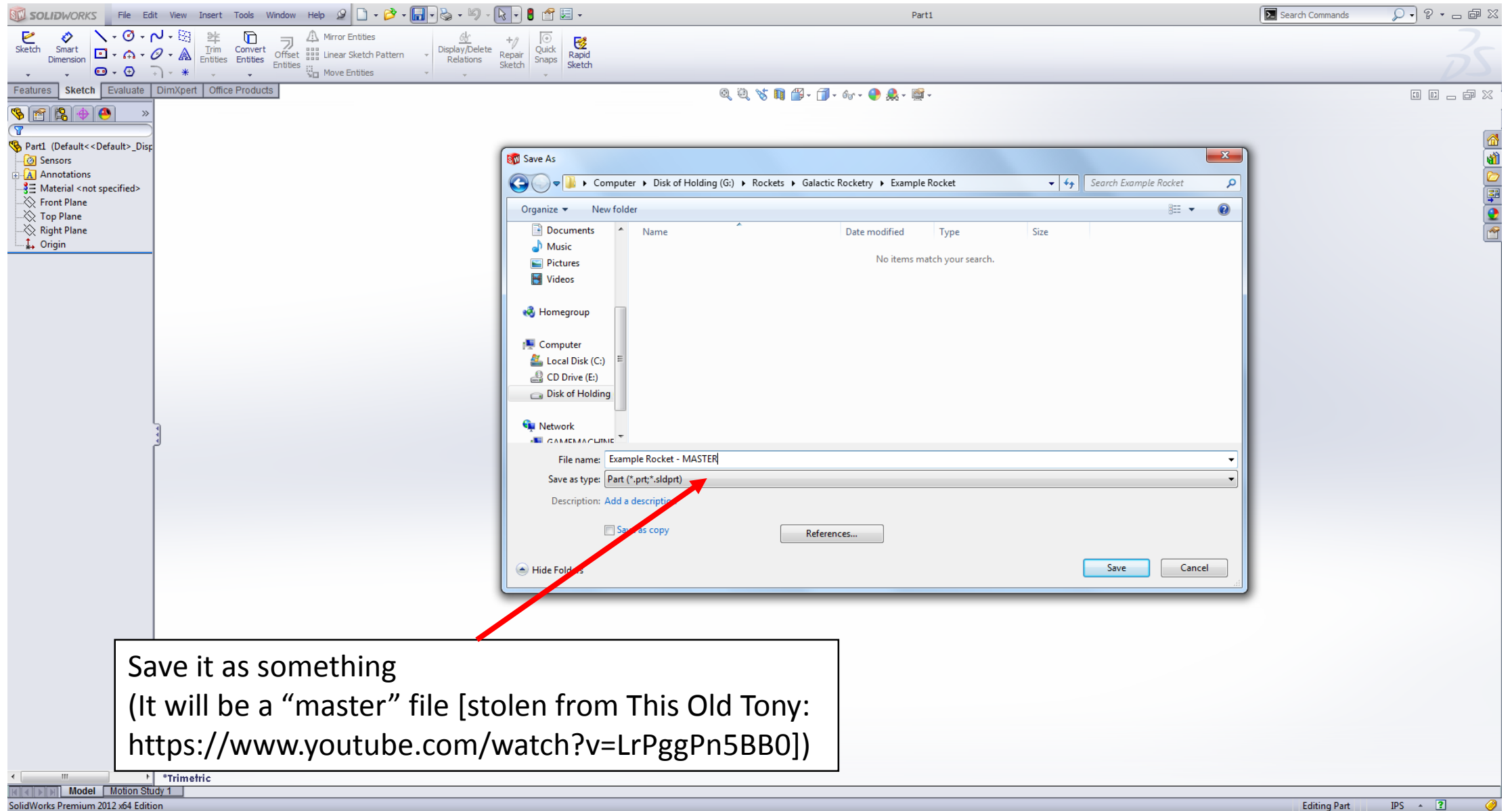




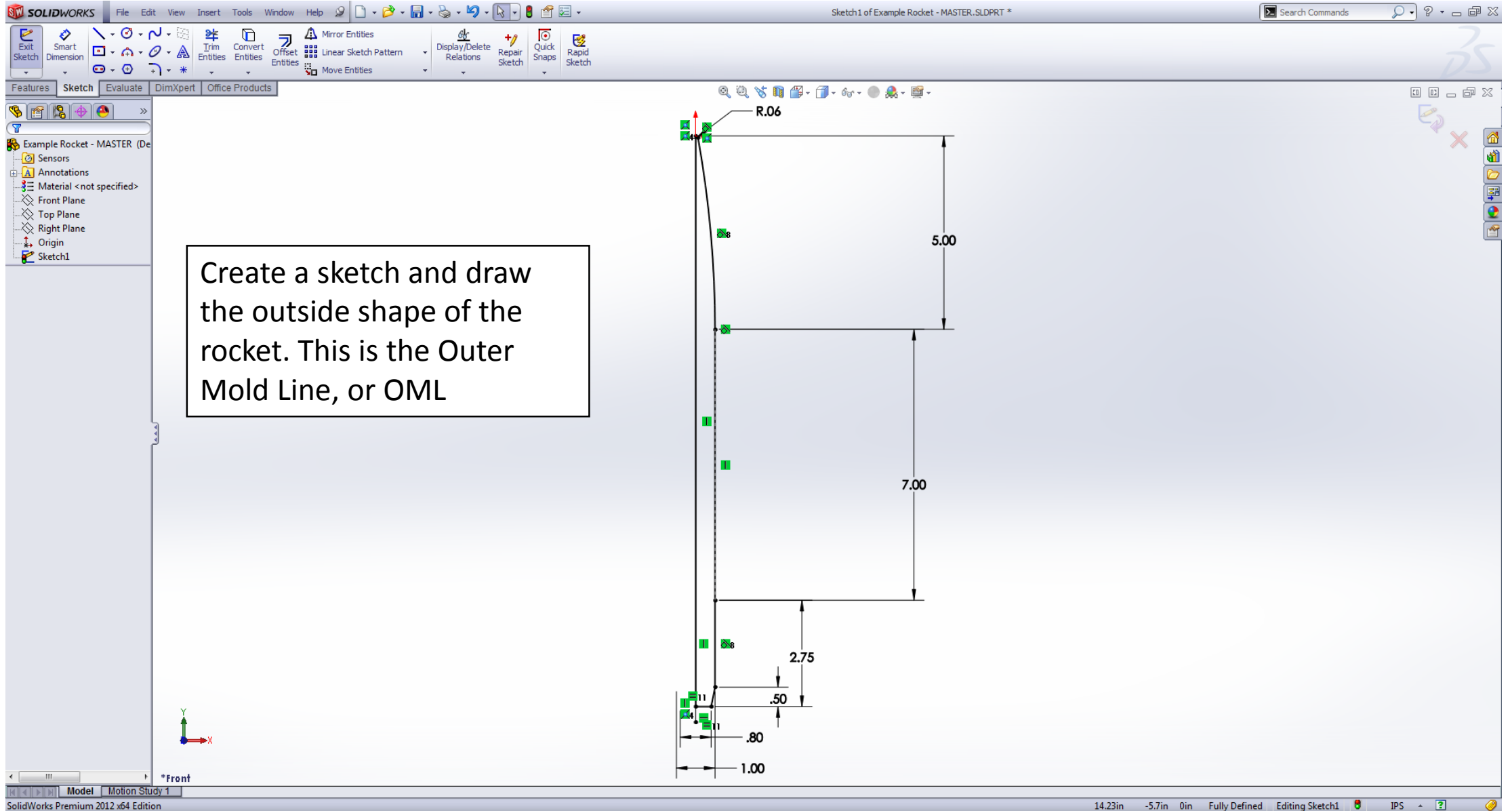
Make a new part

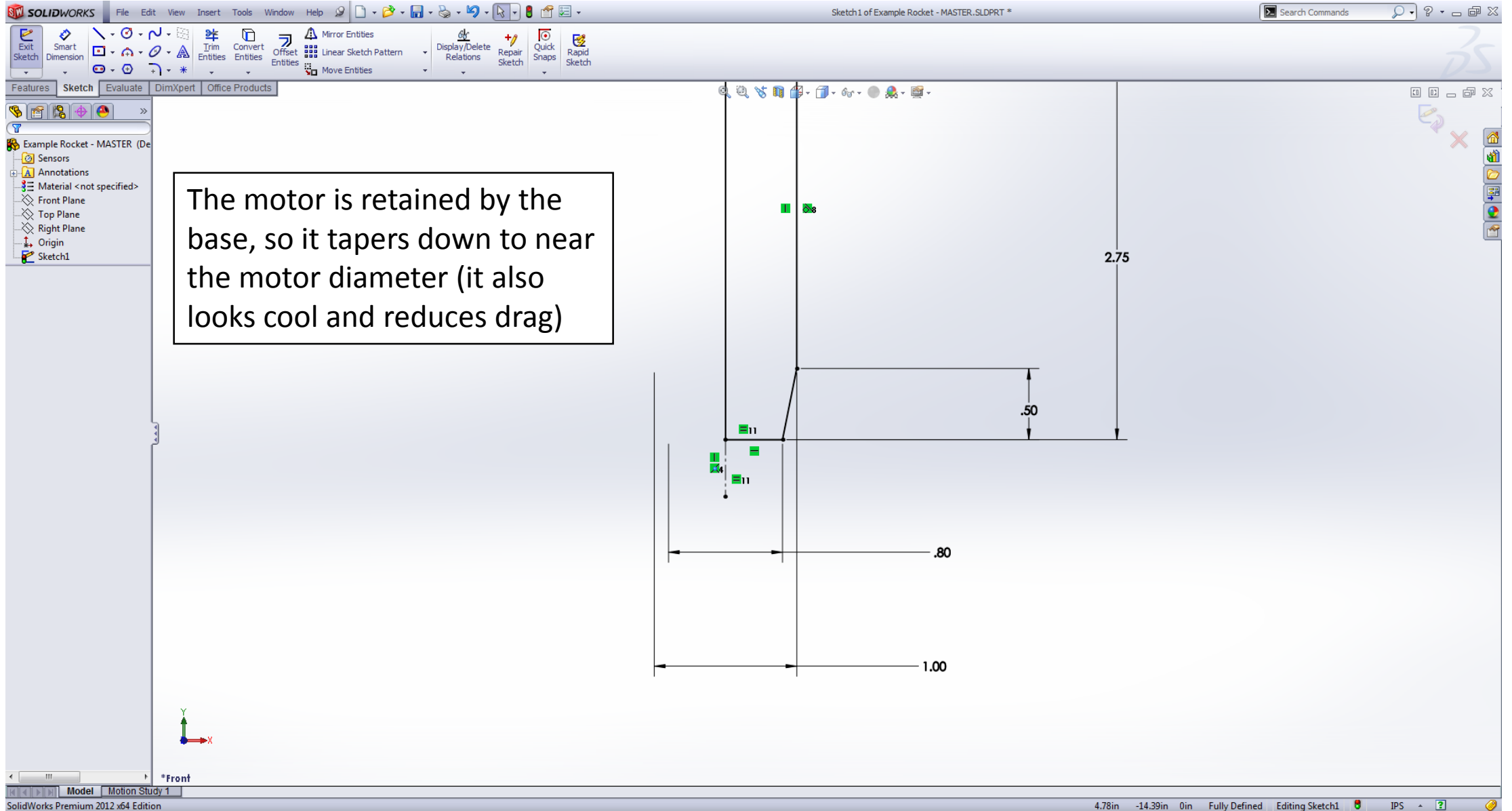
SOLIDWORKS

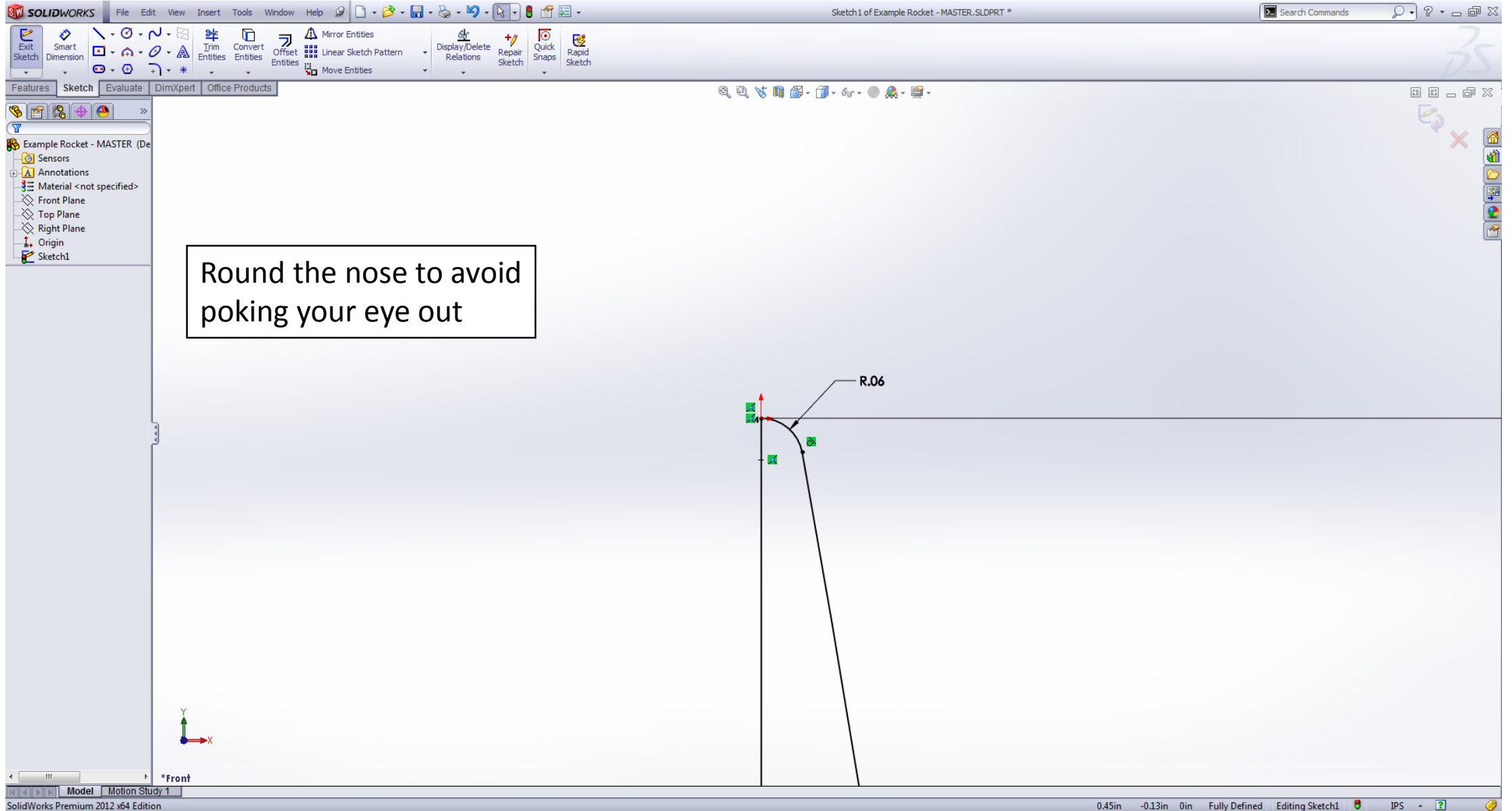
Select a document template.

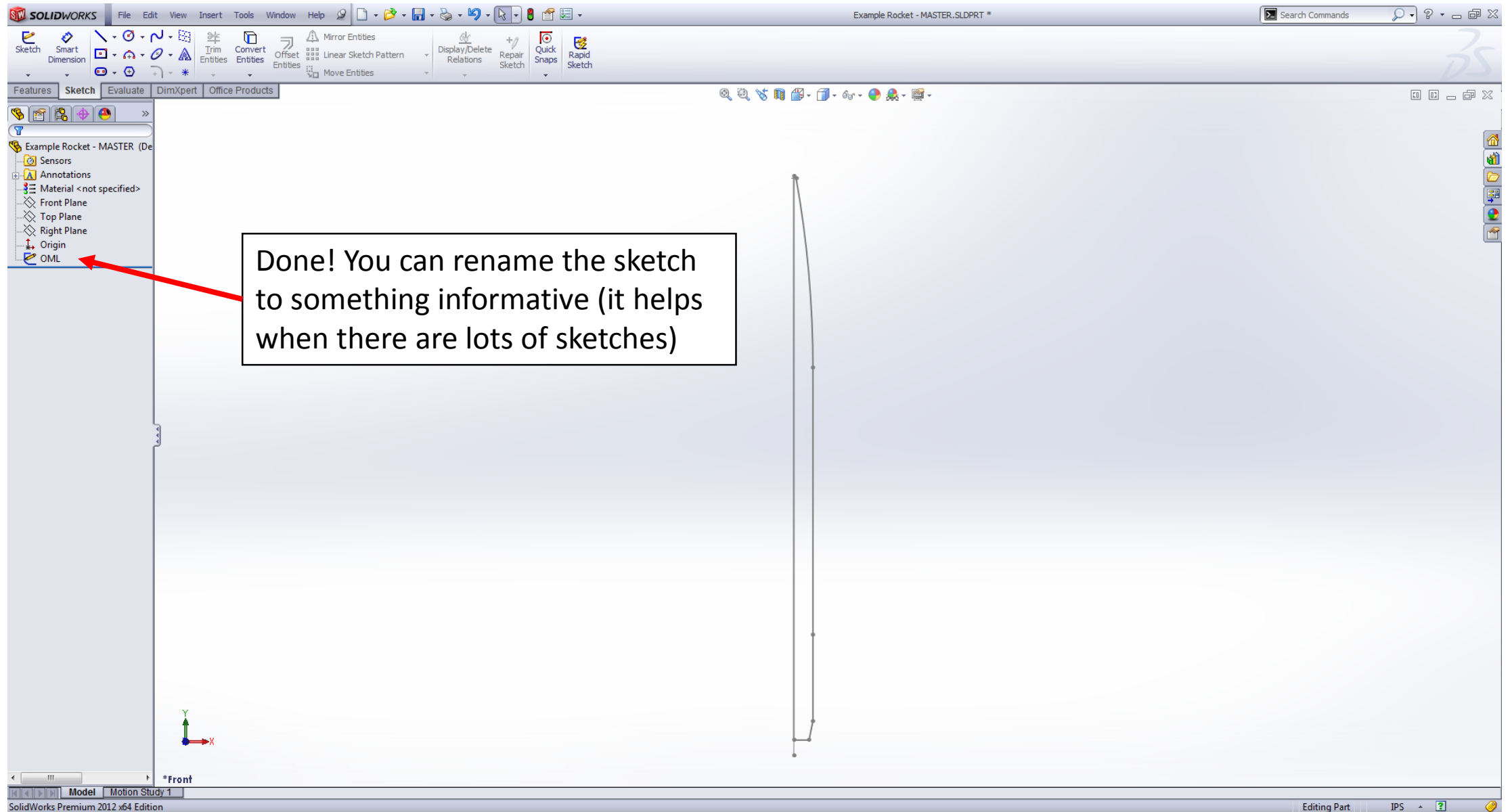


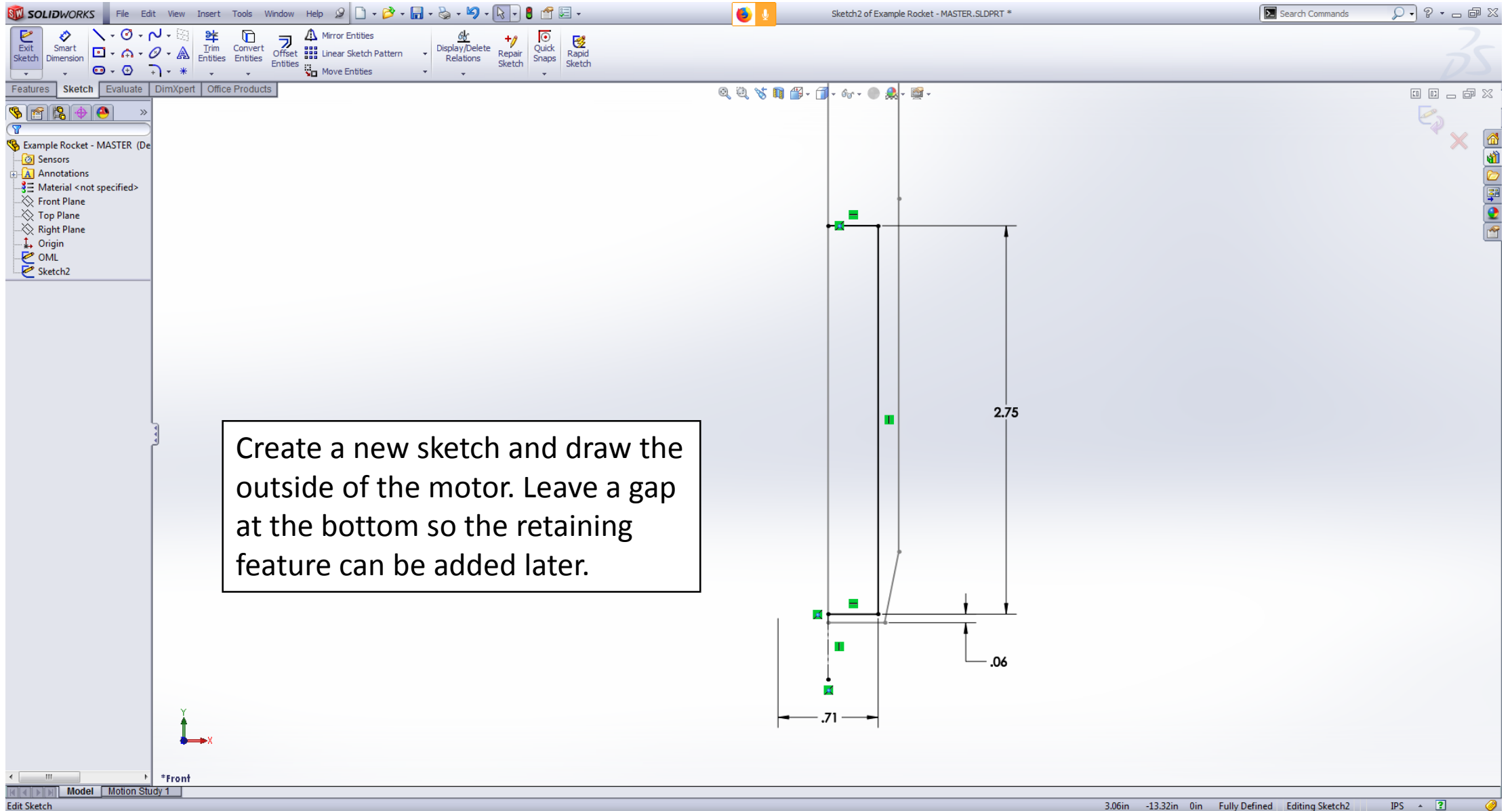
Save it as something  
(It will be a “master” file [stolen from This Old Tony:  
<https://www.youtube.com/watch?v=LrPggPn5BB0>])



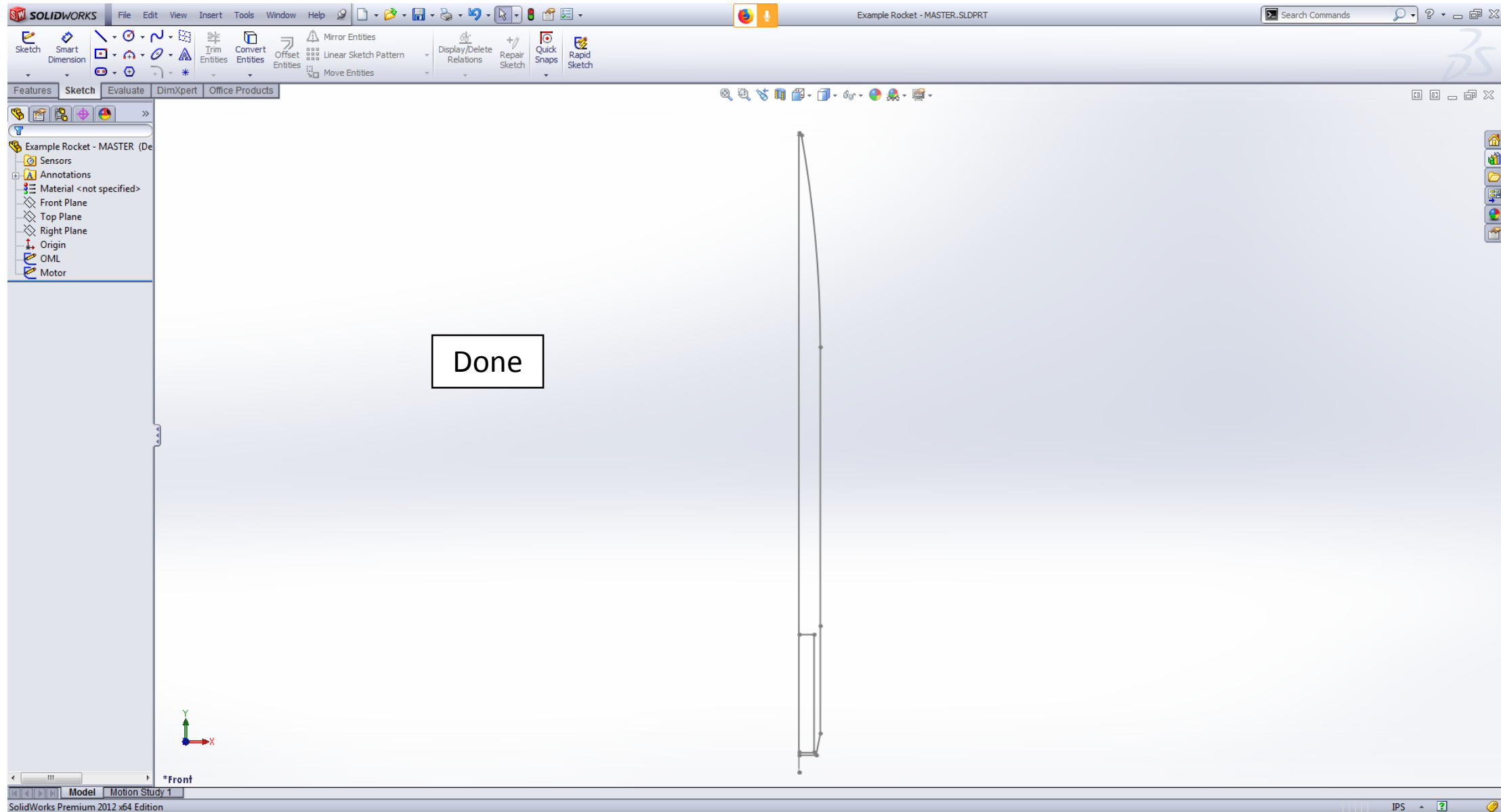


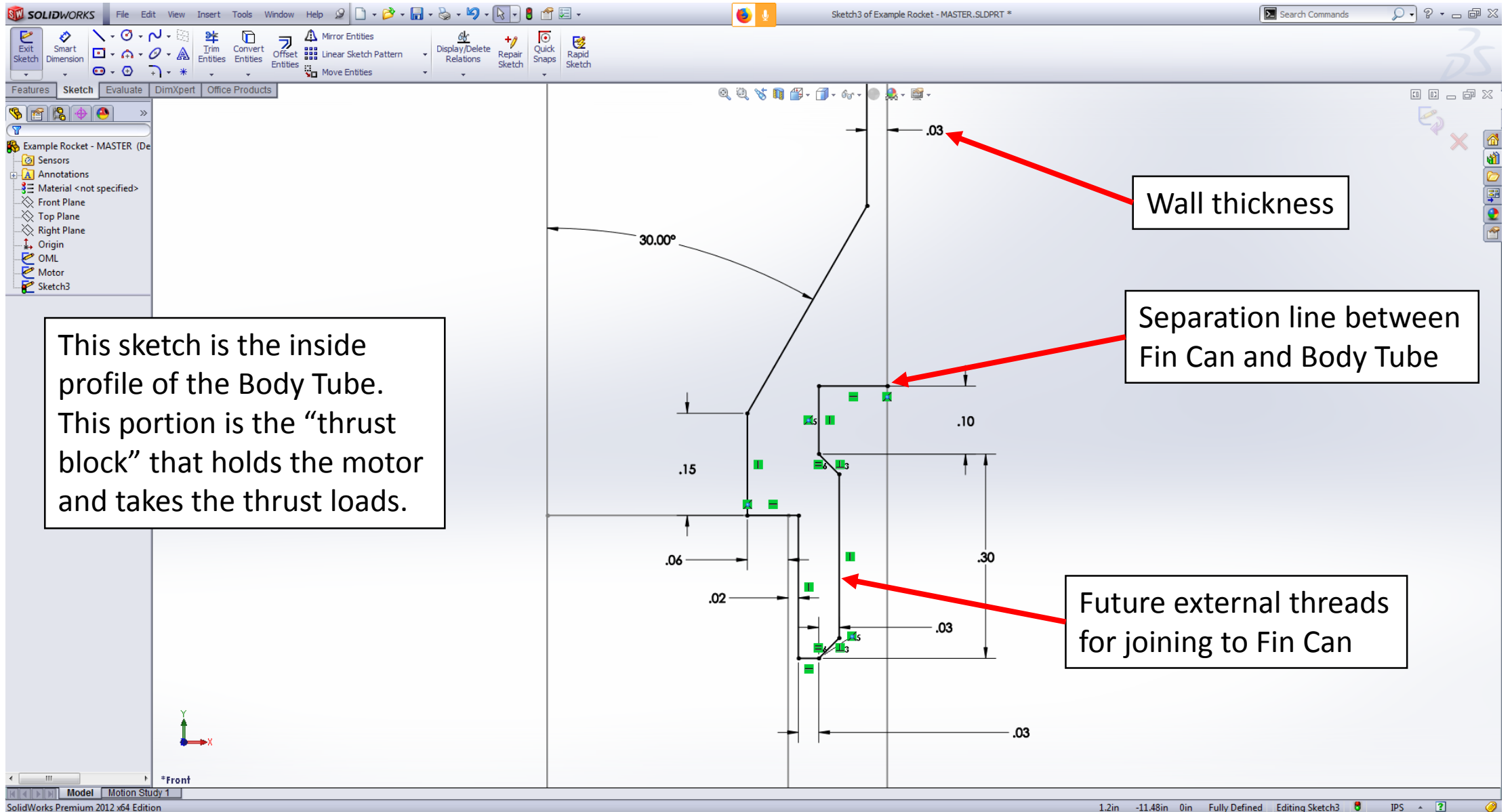


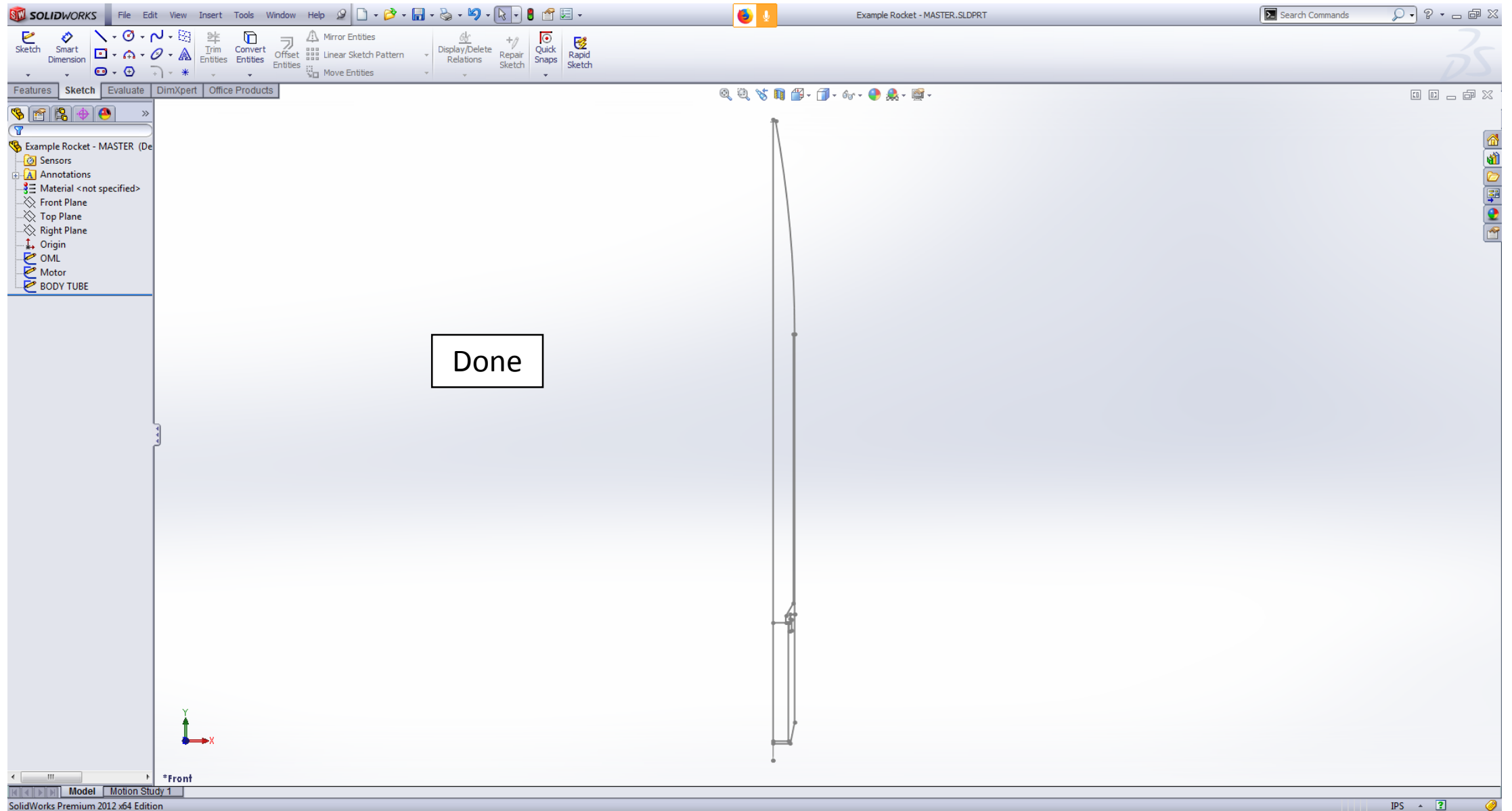




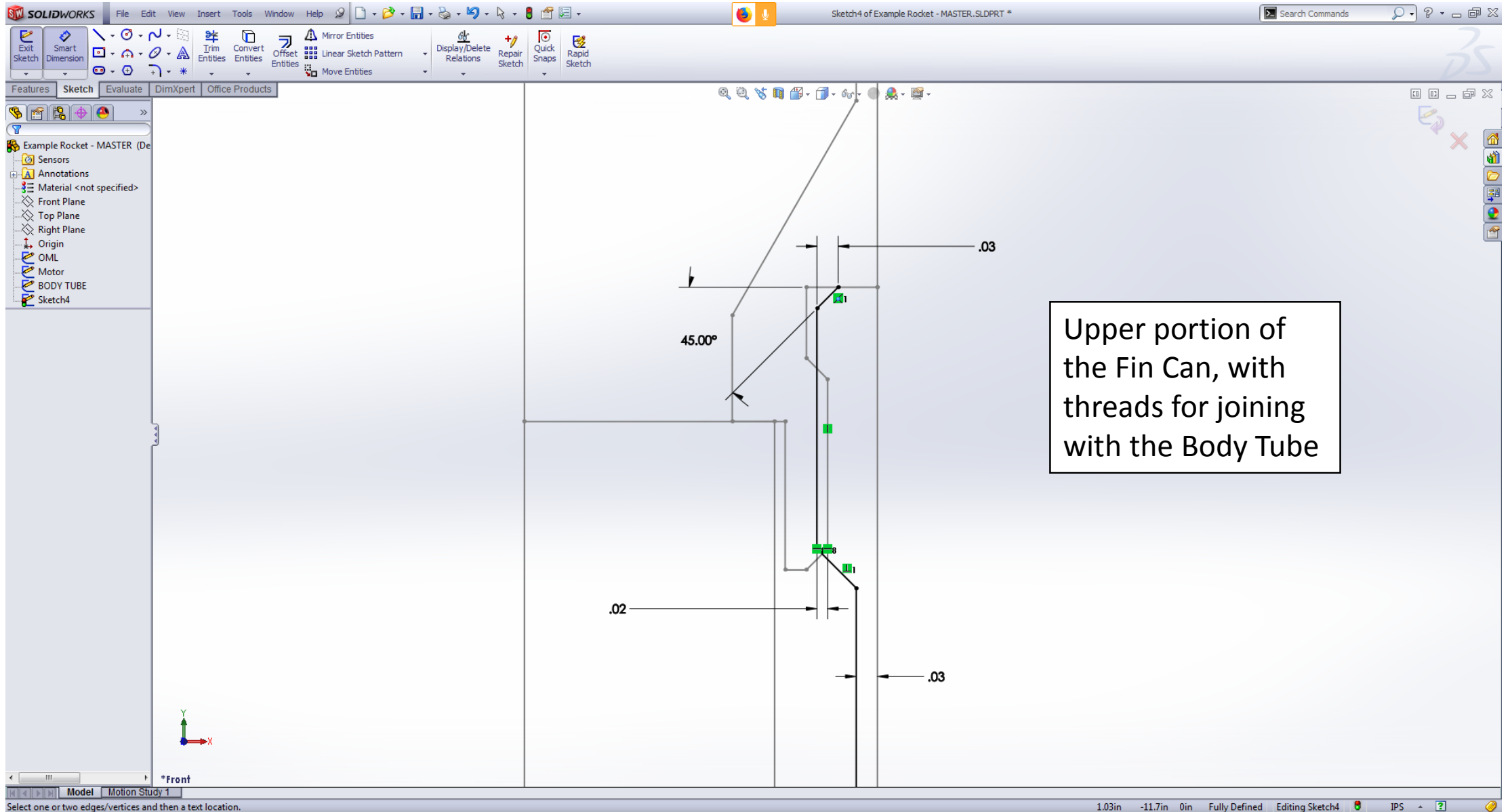


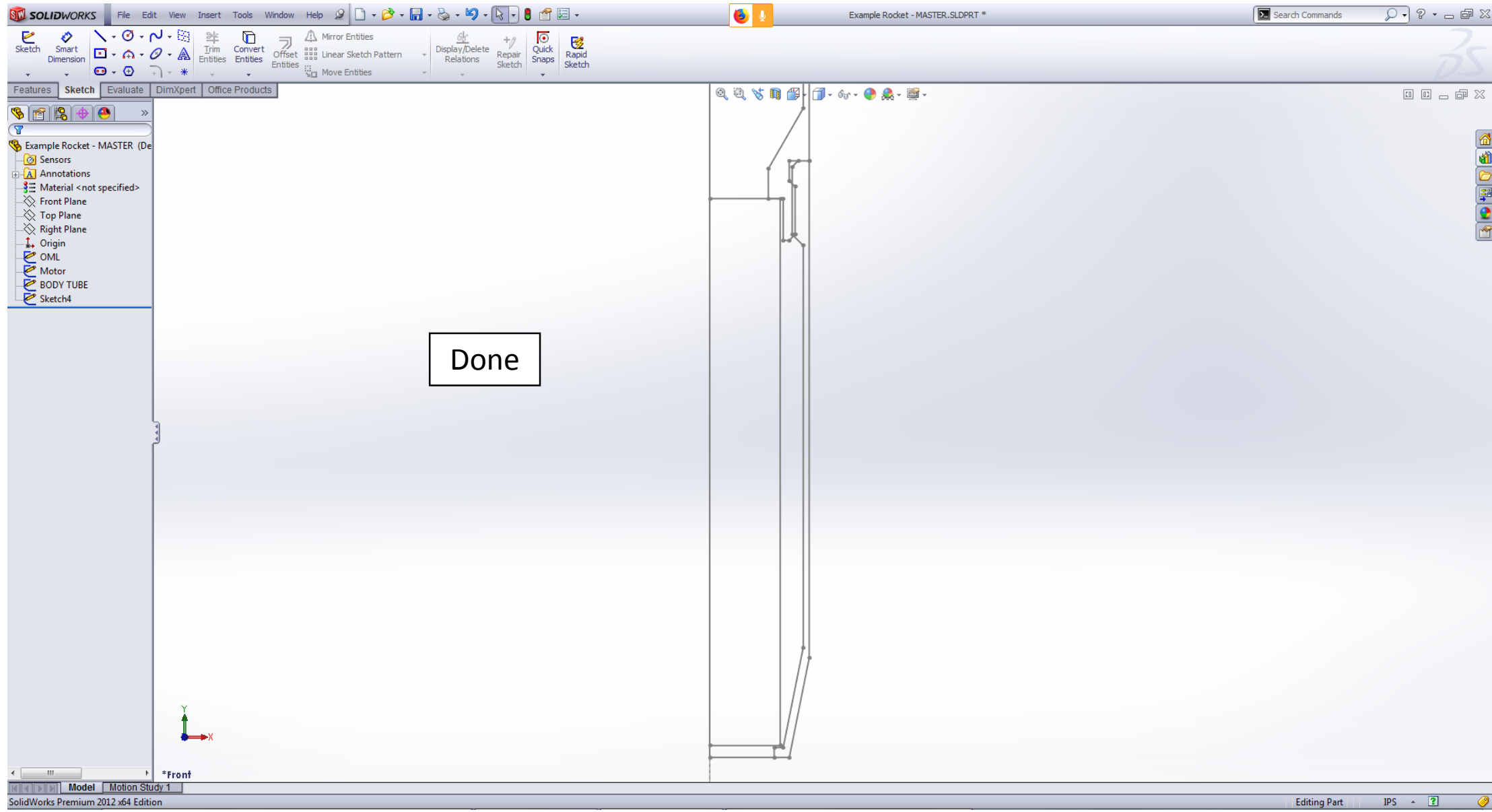


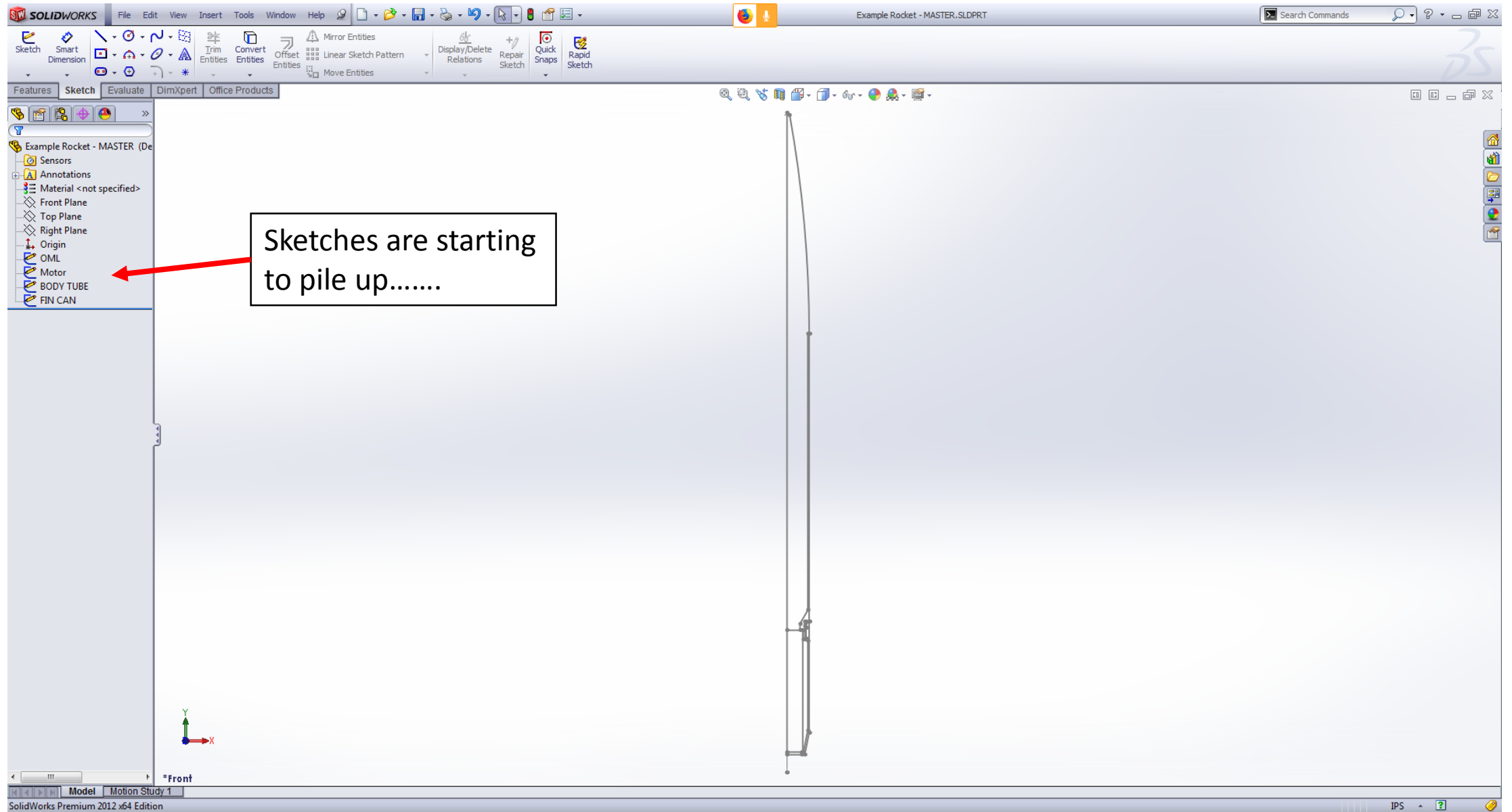


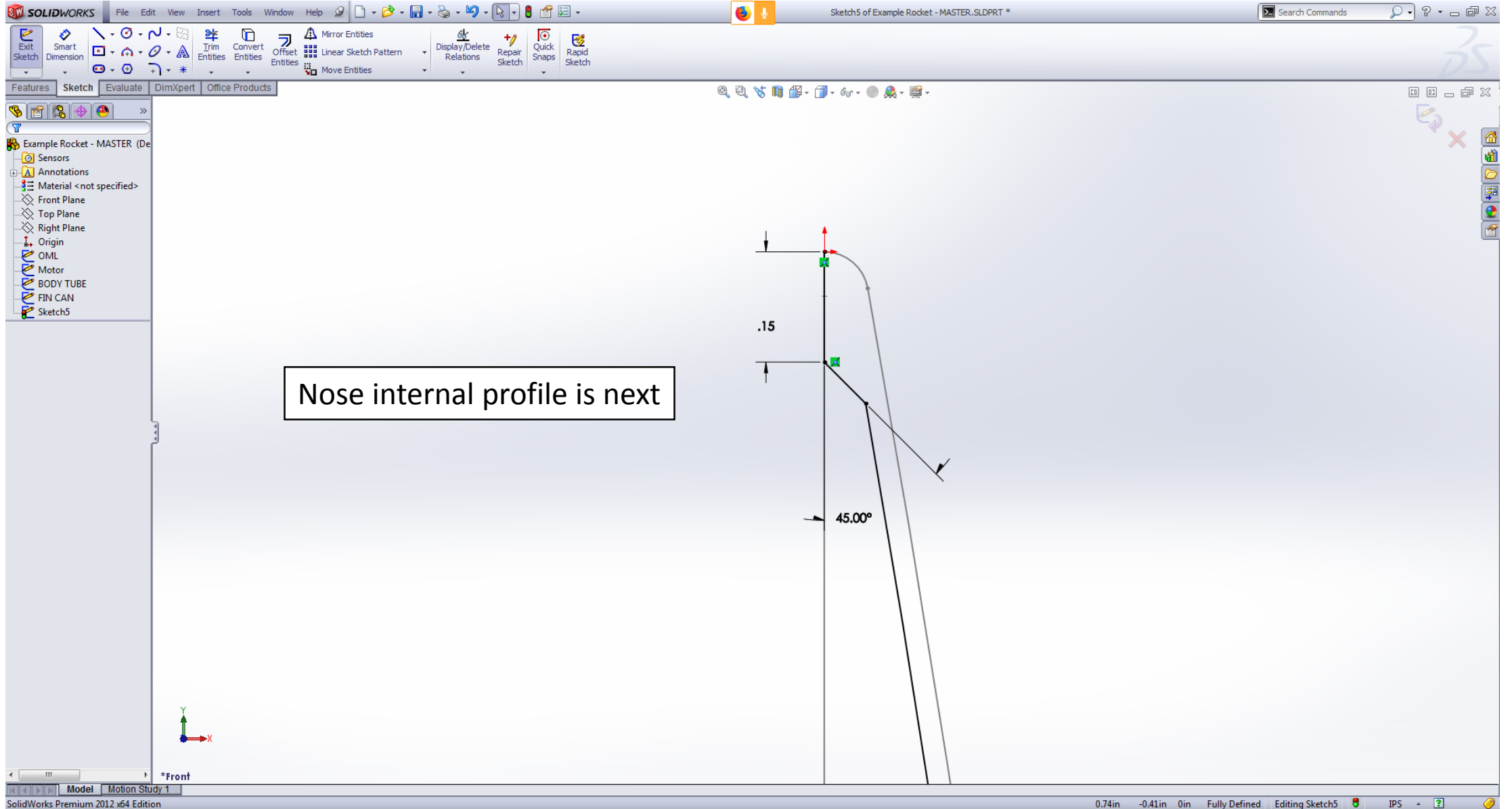


The image shows a SolidWorks interface with a sketch of a rocket fin can. A dimension of 0.015in is being modified. The software interface includes a menu bar (File, Edit, View, Insert, Tools, Window, Help), a ribbon with various sketching tools, and a left-hand panel with dimensioning options. A 'Modify' dialog box is open, showing the dimension value '0.015in'. A text box on the right contains the instruction: 'Draw the Fin Can internal profile next. This is the lower motor retention feature.' The sketch shows a profile with dimensions .01 and .03. The status bar at the bottom indicates 'Fully Defined' and 'Editing Sketch4'.

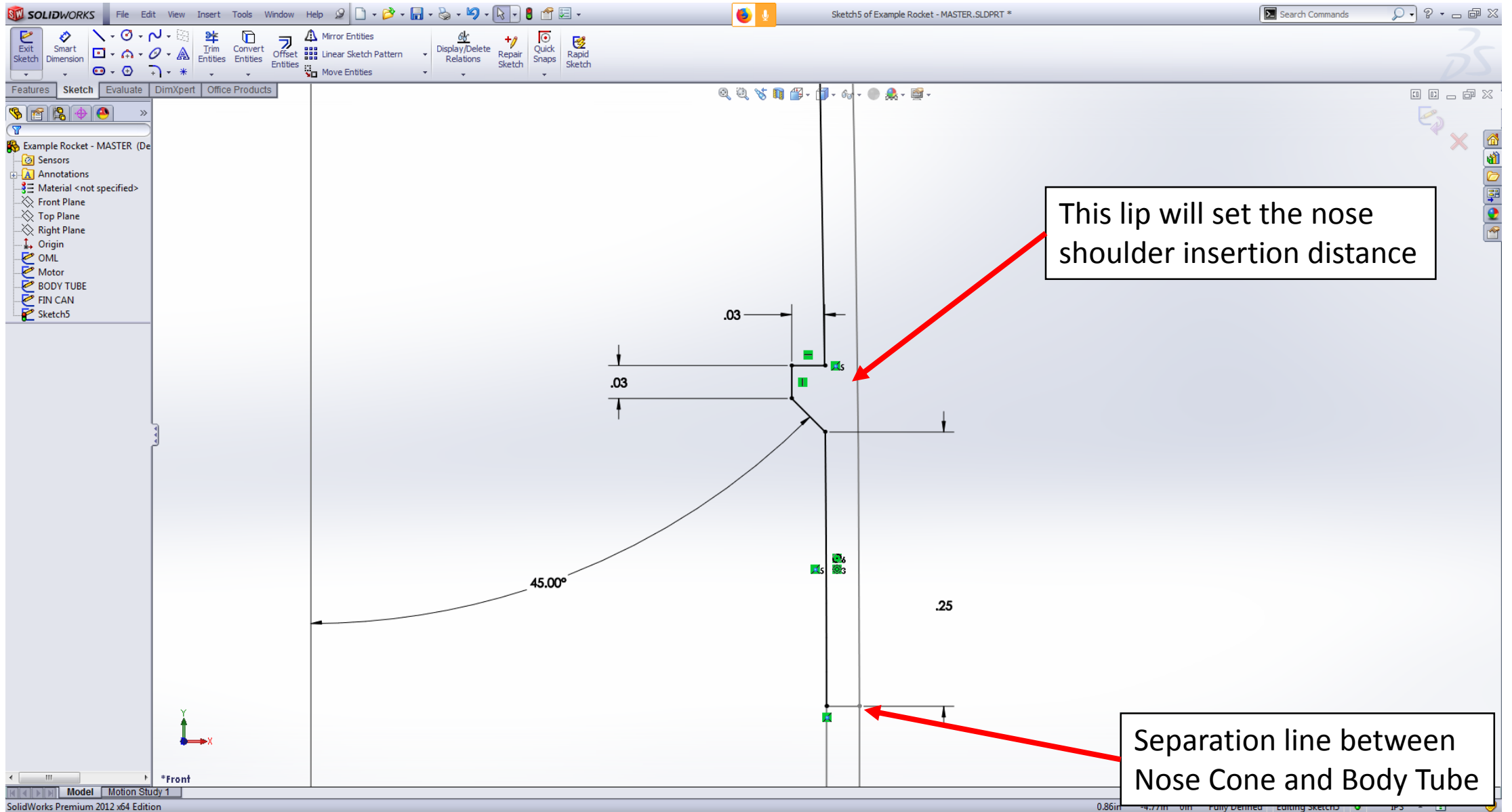


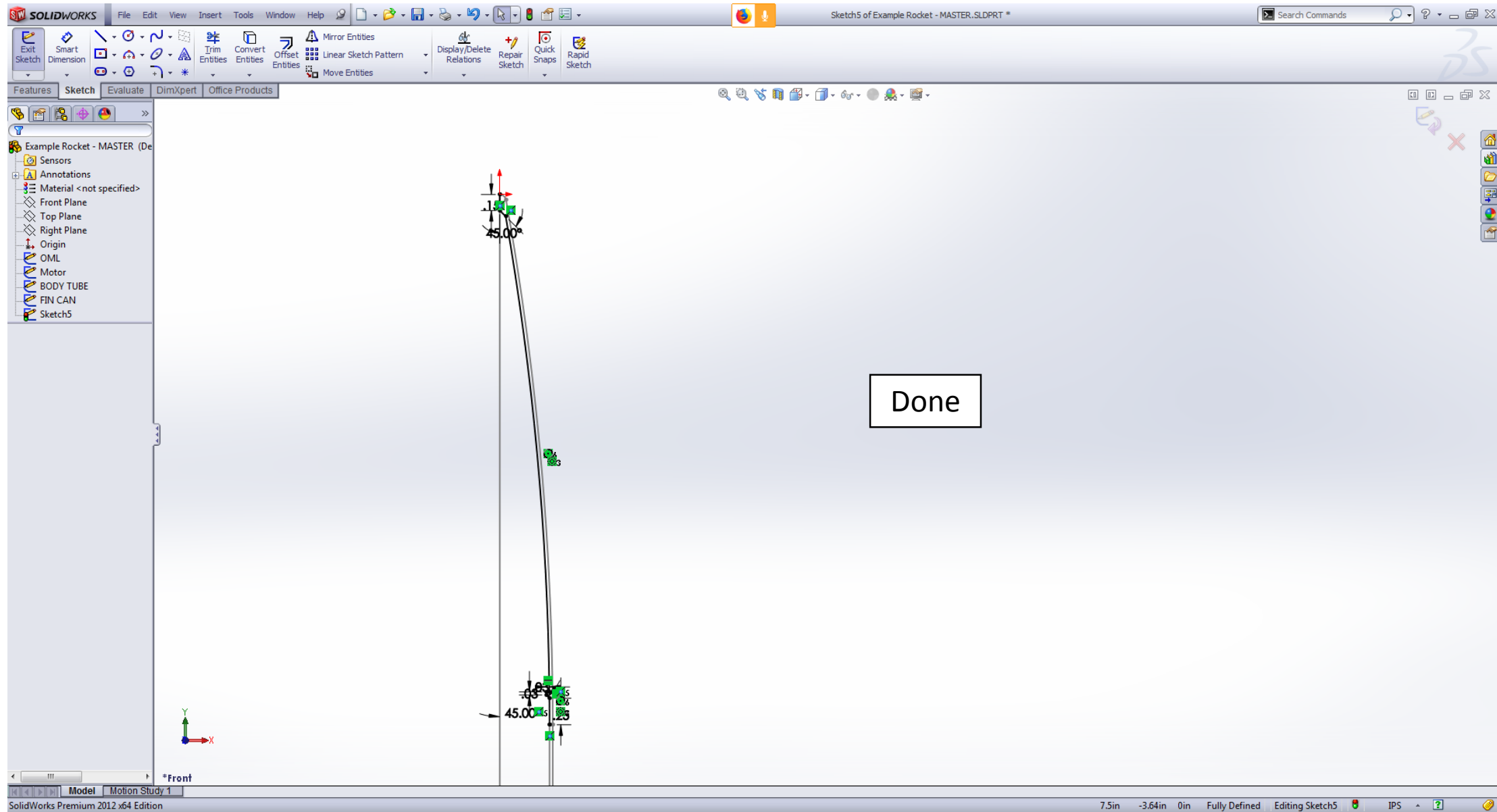












SOLIDWORKS File Edit View Insert Tools Window Help

Sketch6 of Example Rocket - MASTER.SLDPRT \* Search Commands

Exit Sketch Smart Dimension Trim Entities Convert Entities Offset Entities Mirror Entities Linear Sketch Pattern Display/Delete Relations Repair Sketch Quick Snaps Rapid Sketch

Features Sketch Evaluate DimXpert Office Products

Example Rocket - MASTER (De)  
 Sensors  
 Annotations  
 Material <not specified>  
 Front Plane  
 Top Plane  
 Right Plane  
 Origin  
 OML  
 Motor  
 BODY TUBE IML  
 FIN CAN IML  
 NOSE IML  
 Sketch6

$V = \frac{1}{3} \pi r^2 \cdot h$

$y = ax^2 + bx + c$   
 $(x, x_2) = \frac{-b \pm \sqrt{b^2 - 4ac}}{2a}$

$\sin$   
 $\cos$   
 $\tan$   
 $\frac{a}{b} = \frac{c}{d}$   
 $\frac{a}{\sin A} = \frac{b}{\sin B} = \frac{c}{\sin C}$   
 $a^2 = b^2 + c^2 - 2bc \cos A$

It's the Nose Shoulder. I only drew the outer profile to demonstrate the "Thin Revolve" feature later.

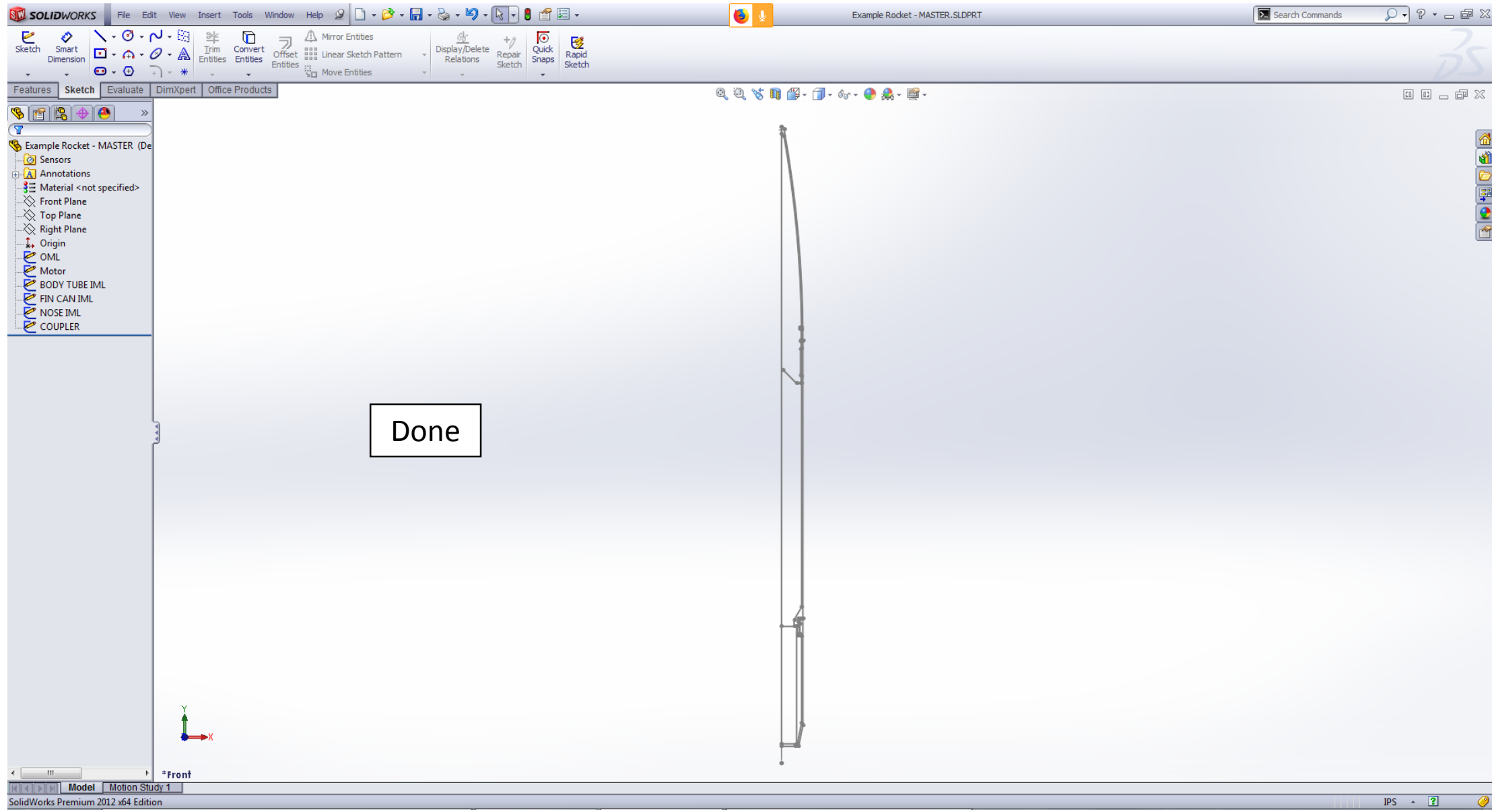
.02 .01 .02 .01 .15 1.00 .03 45.00° .35

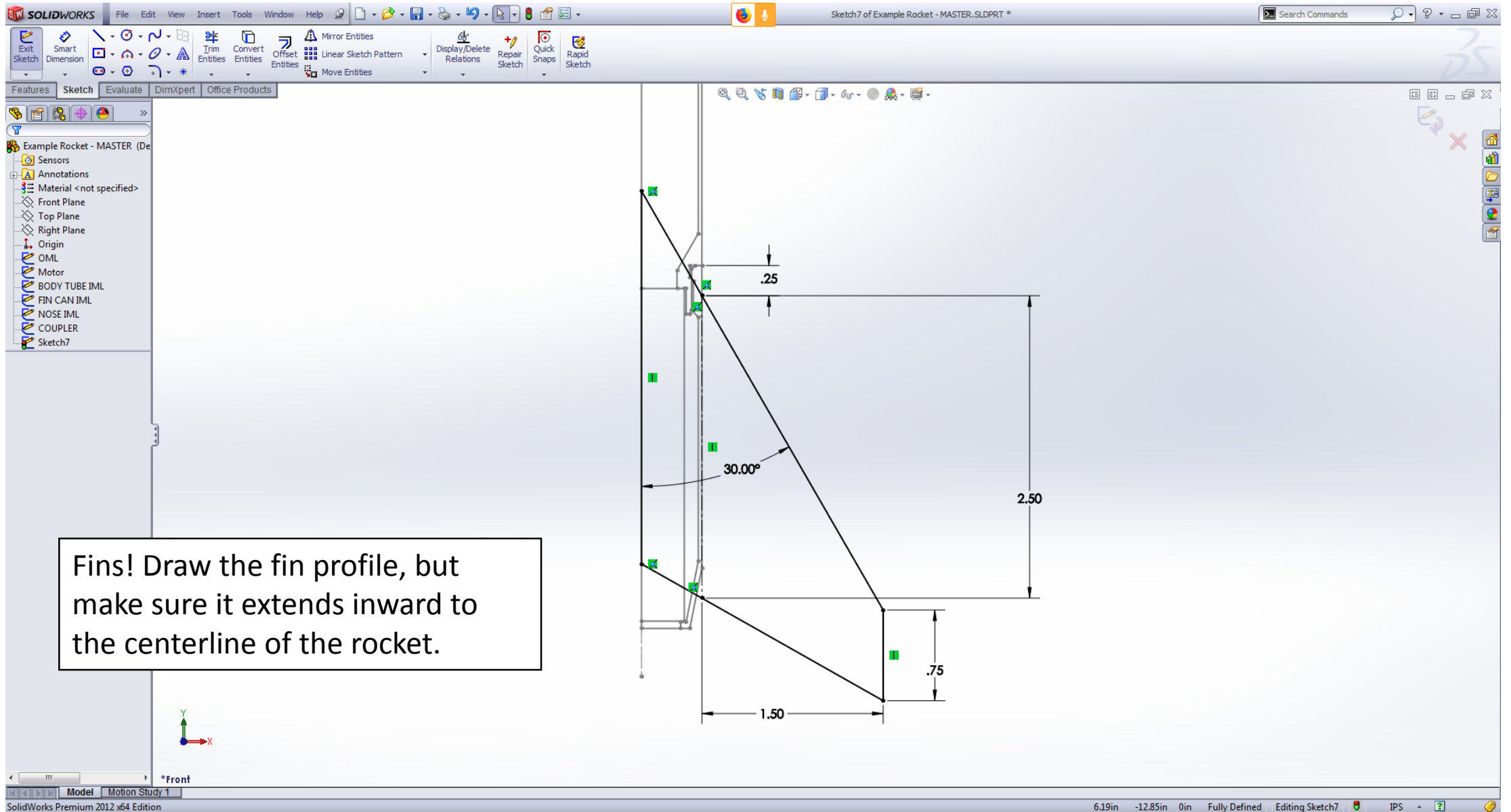
\*Front

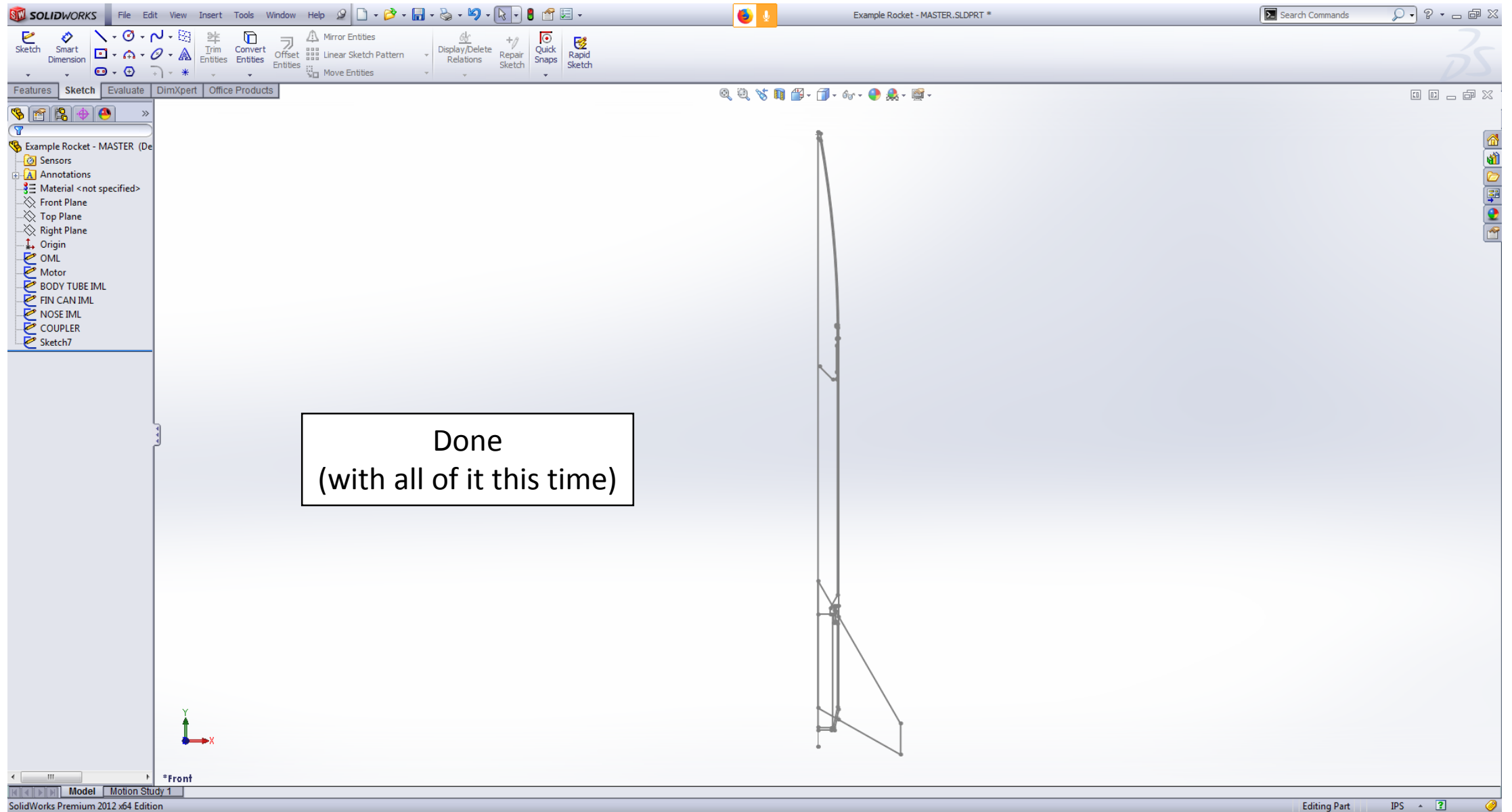
Model Motion Study 1

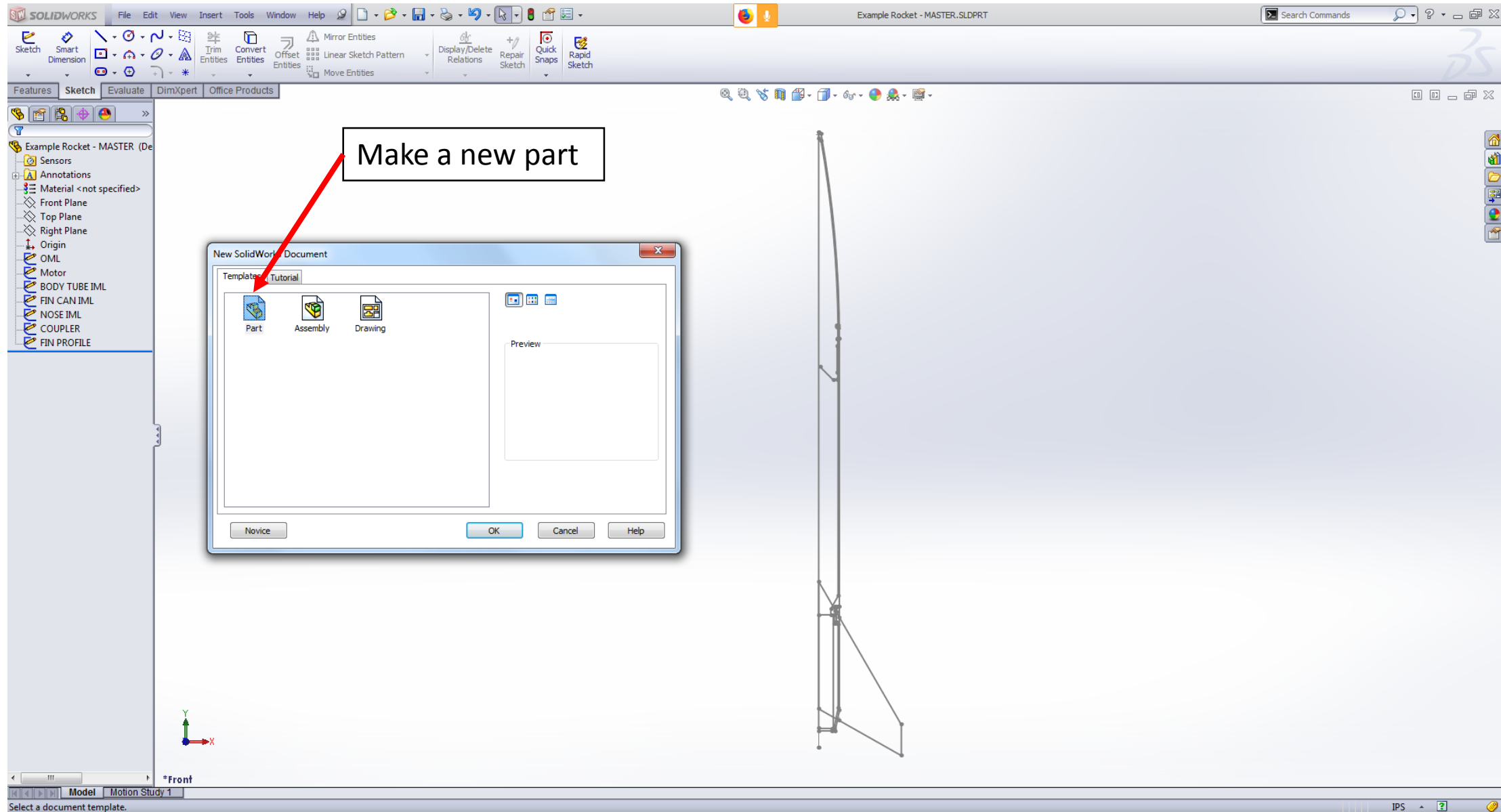
Select one or two edges/vertices and then a text location.

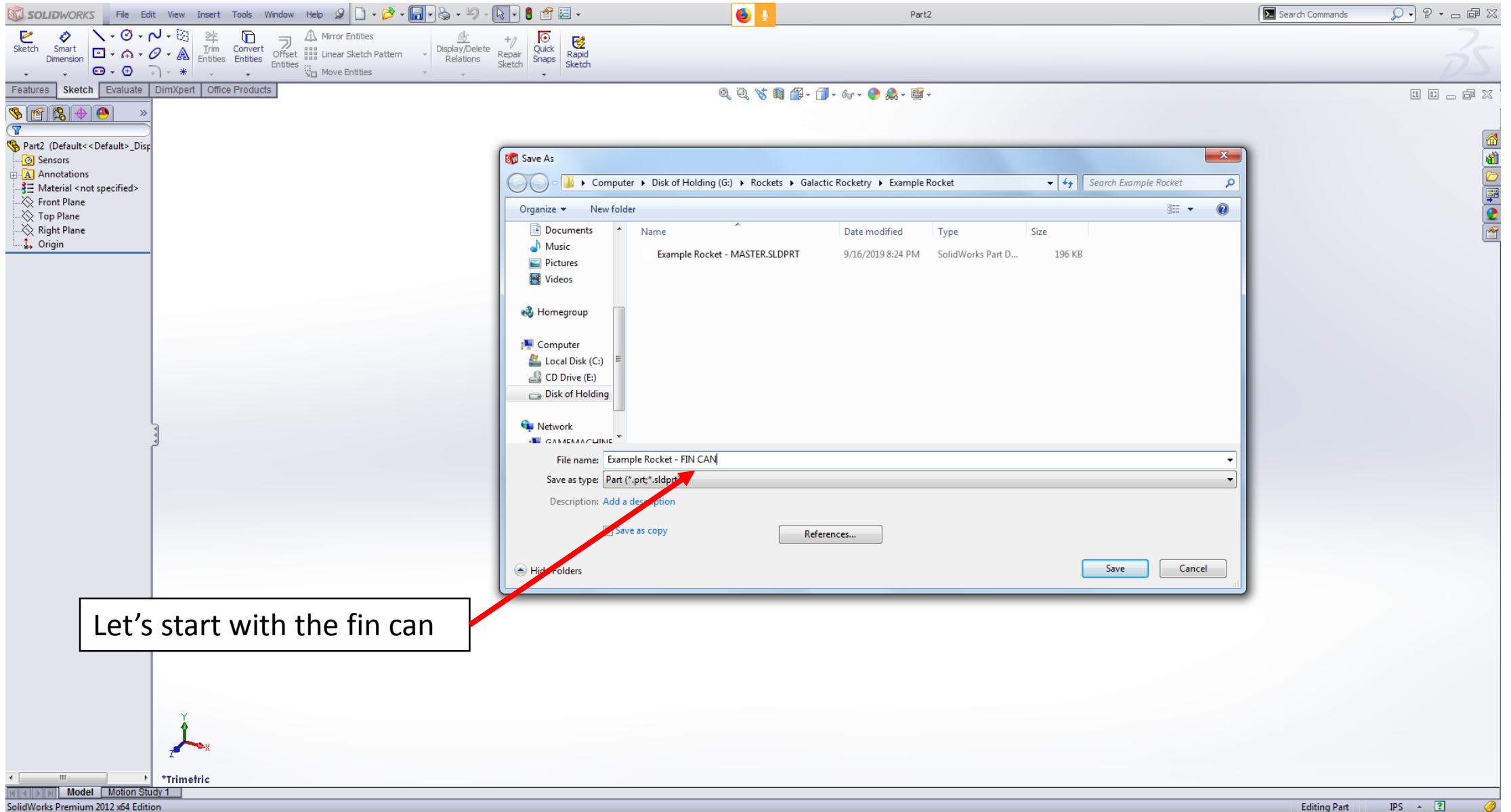
2.28in -5.73in 0in Fully Defined Editing Sketch6 IPS



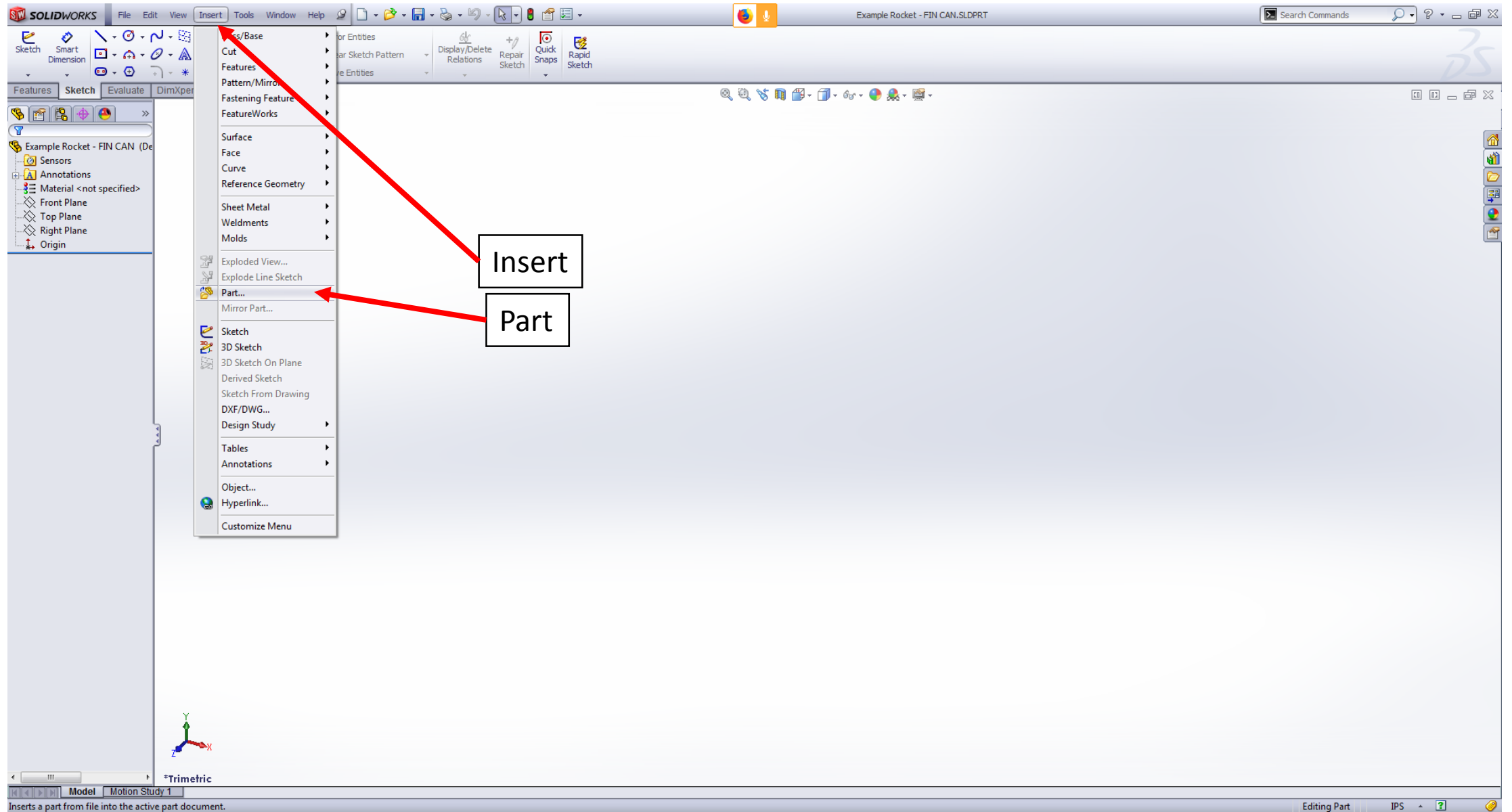












SOLIDWORKS Example Rocket - FIN CAN.SLDPRT

File Edit View Insert Tools Window Help

Sketch Smart Dimension Trim Entities Convert Entities Offset Entities Mirror Entities Linear Sketch Pattern Display/Delete Relations Repair Sketch Quick Snaps Rapid Sketch

Features Sketch Evaluate DimXpert Office Products

Example Rocket - FIN CAN (De)  
Sensors  
Annotations  
Material <not specified>  
Front Plane  
Top Plane  
Right Plane  
Origin

Open

Computer > Disk of Holding (G:) > Rockets > Galactic Rocketry > Example Rocket

Name	Date modified	Type	Size
Example Rocket - FIN CAN.SLDPRT	9/16/2019 8:25 PM	SolidWorks Part D...	61 KB
Example Rocket - MASTER.SLDPRT	9/16/2019 8:24 PM	SolidWorks Part D...	196 KB

File name: Example Rocket - MASTER.SLDPRT

Parts (\*.sldprt;\*.prt)

Open Cancel

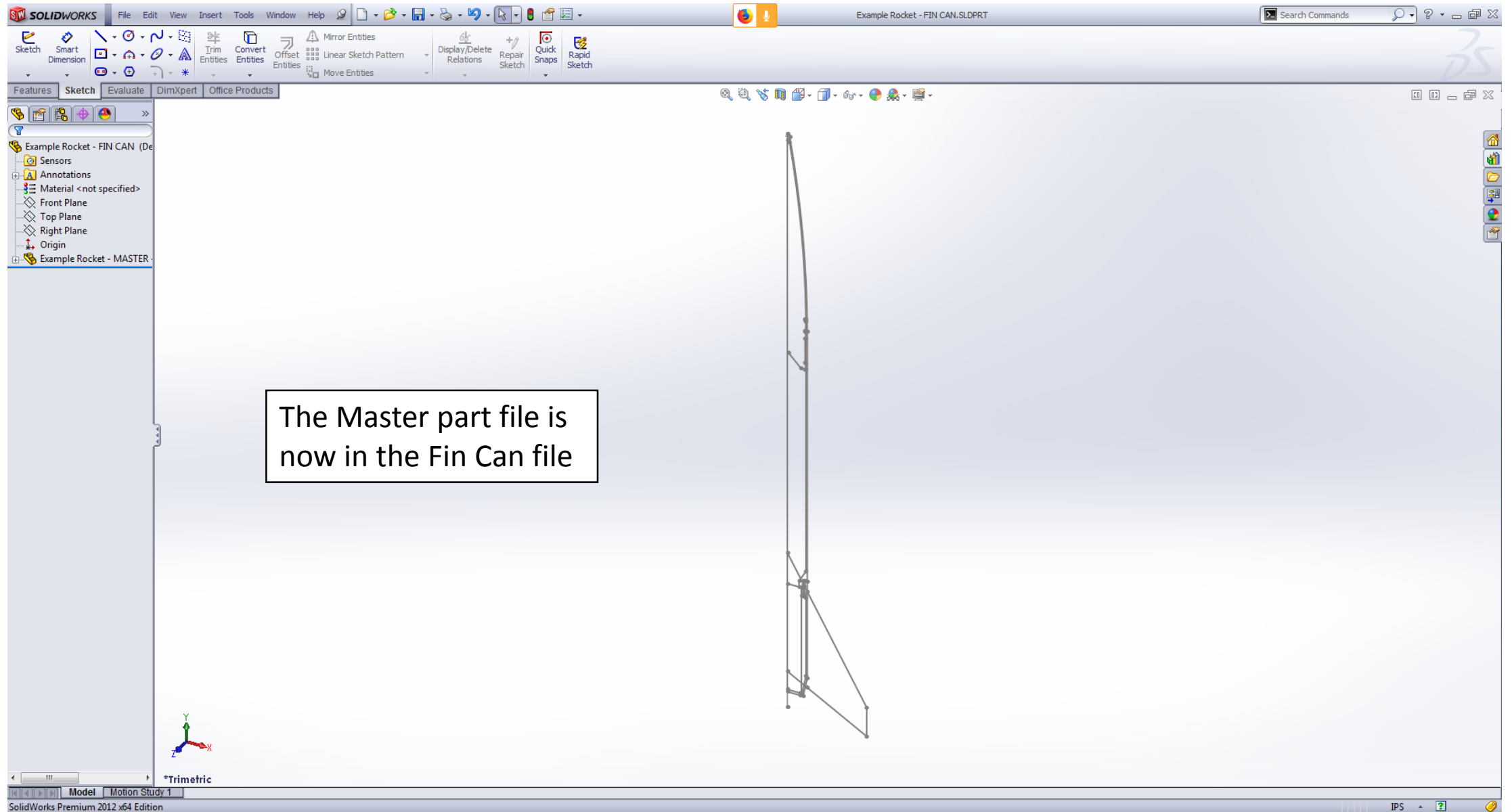
Select the Master file

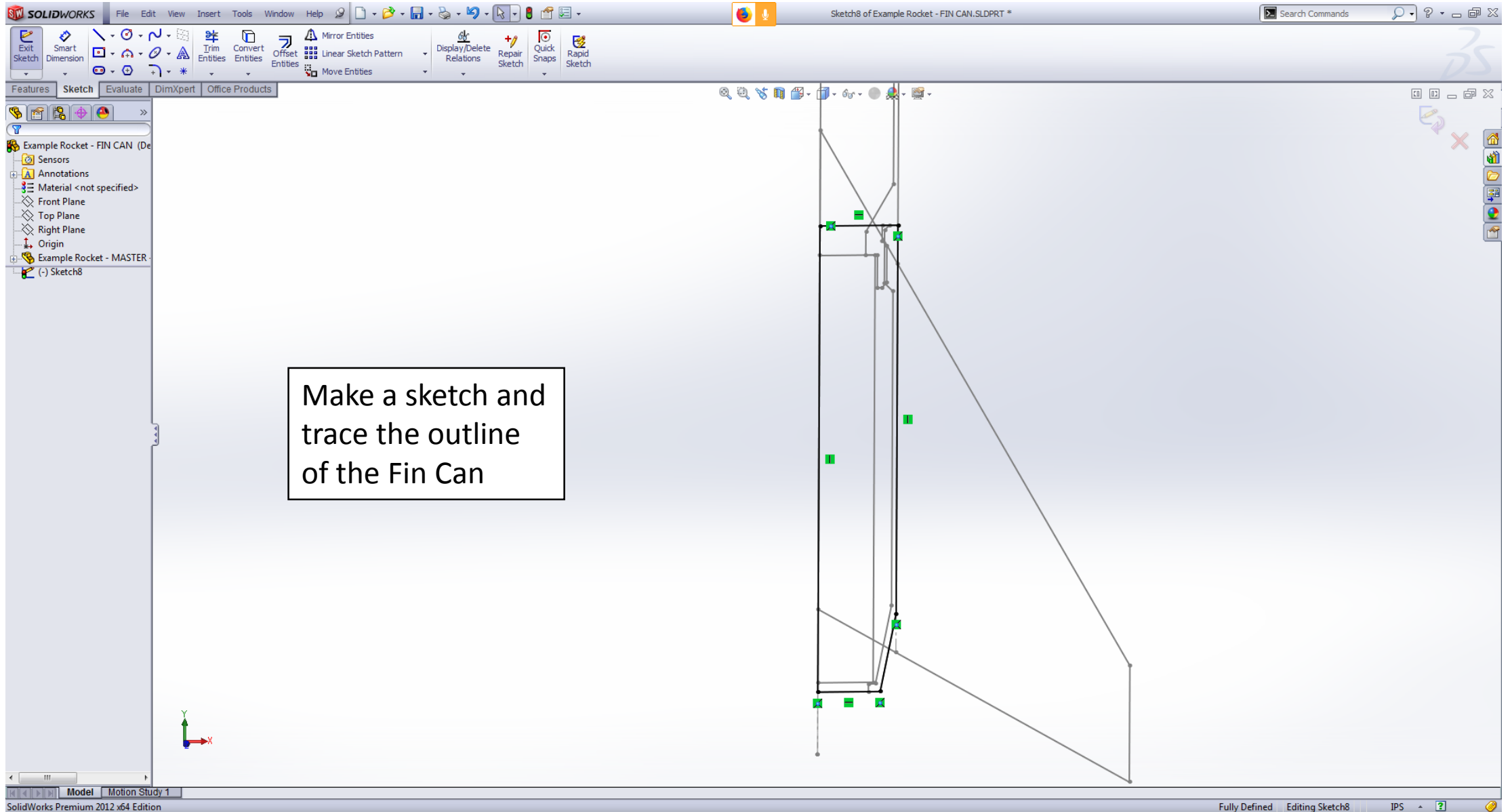
\*Trimetric

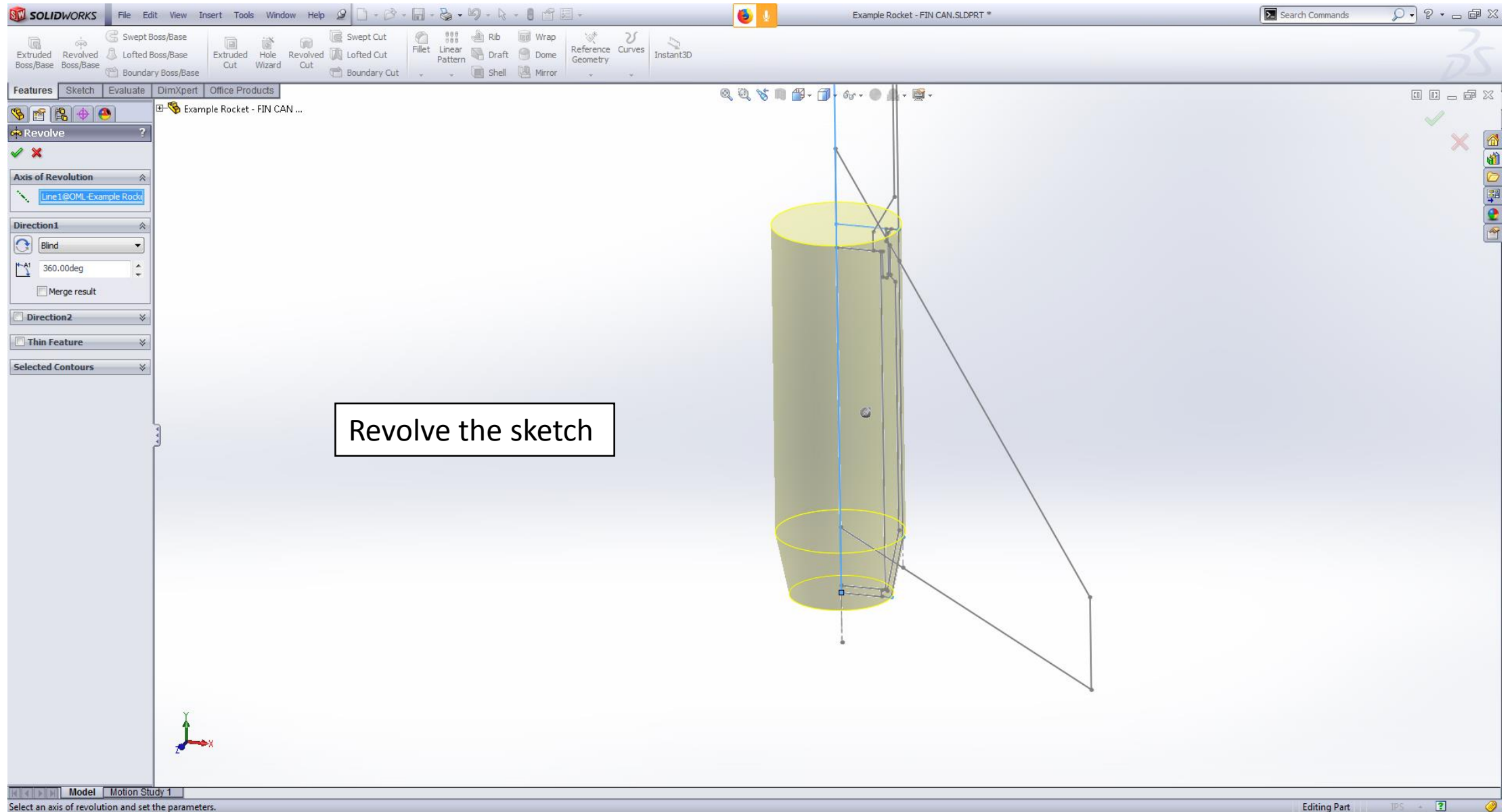
Model Motion Study 1

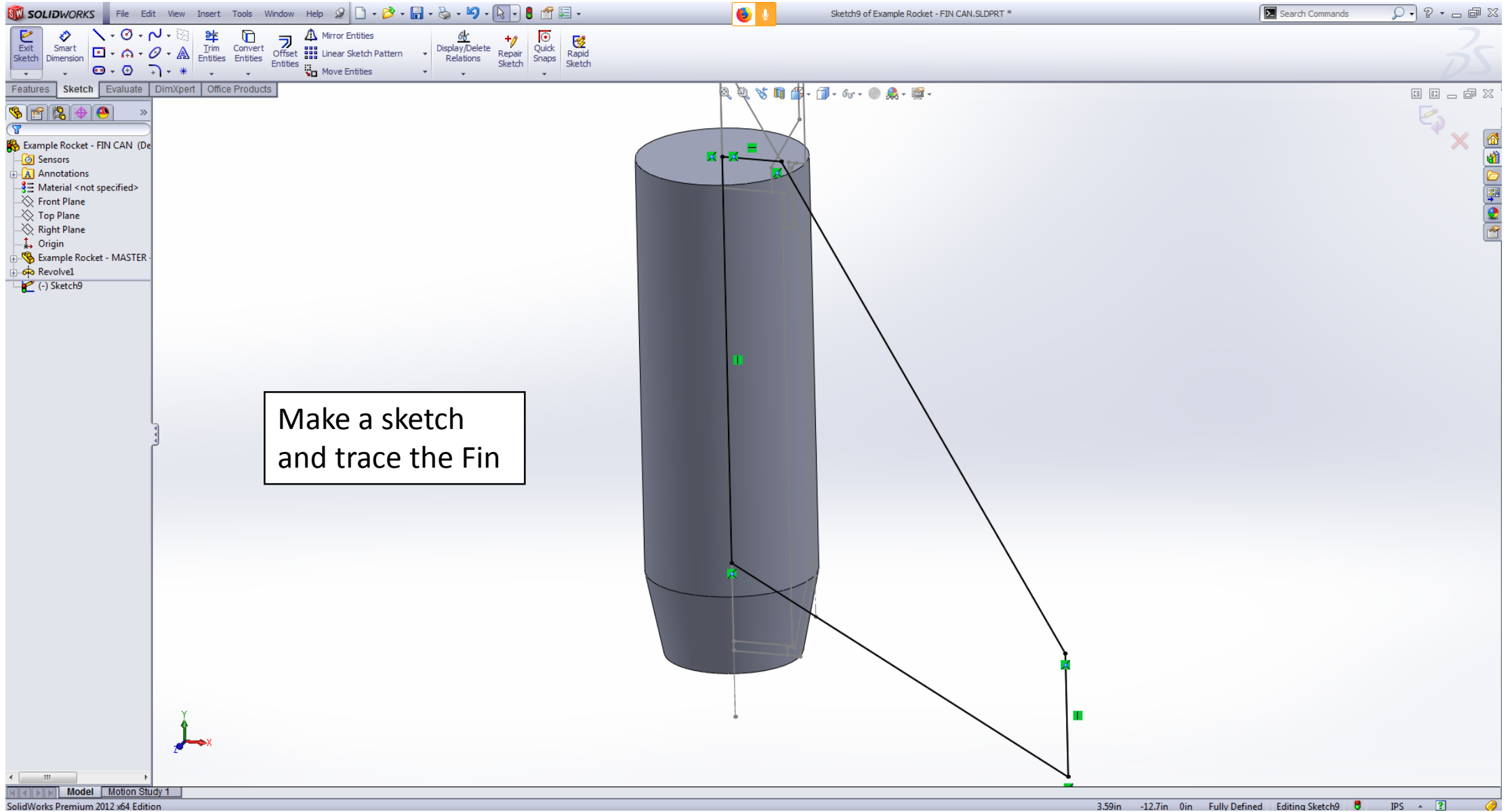
Select part to be used as a base part.

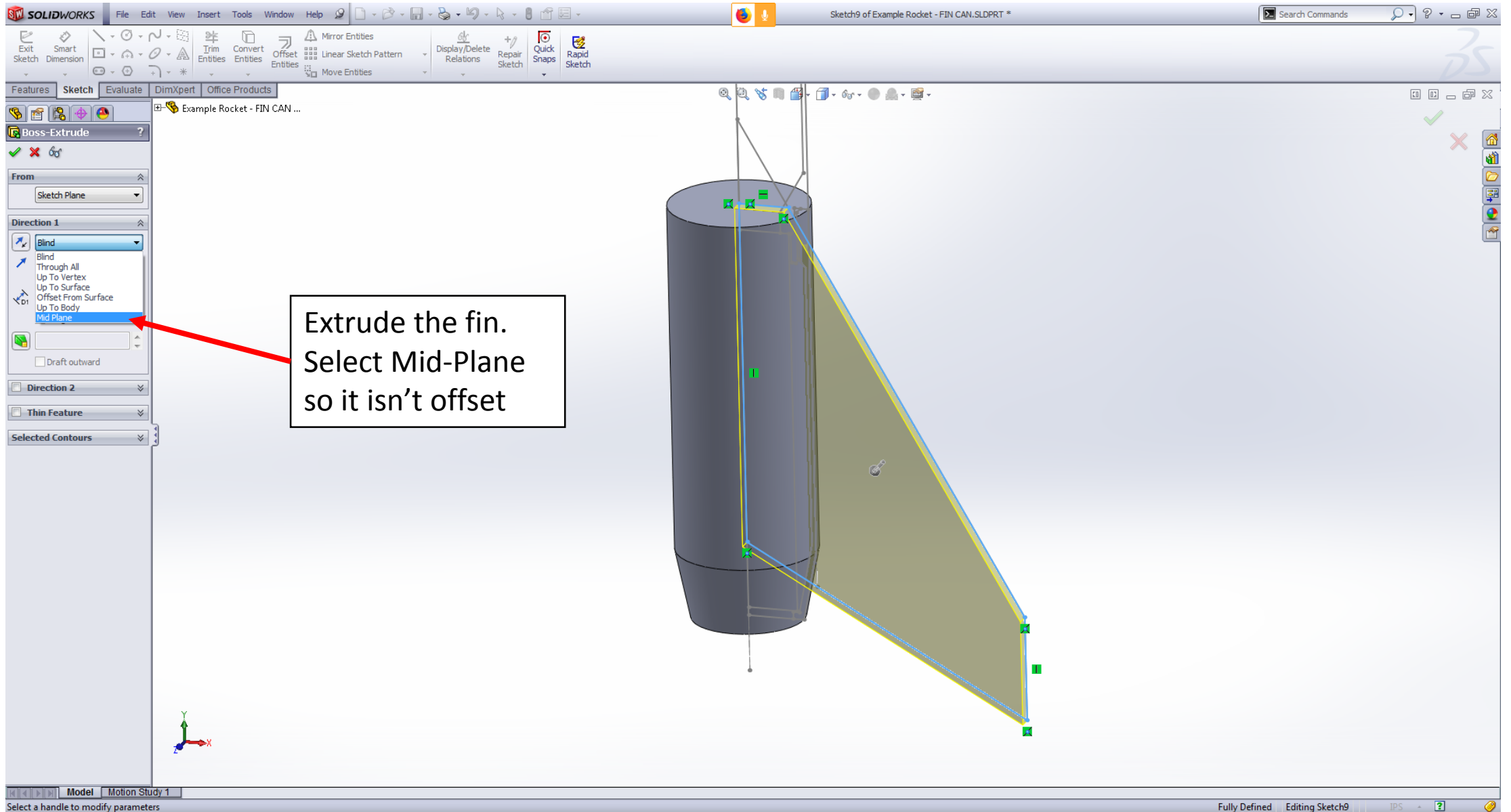
Editing Part IPS

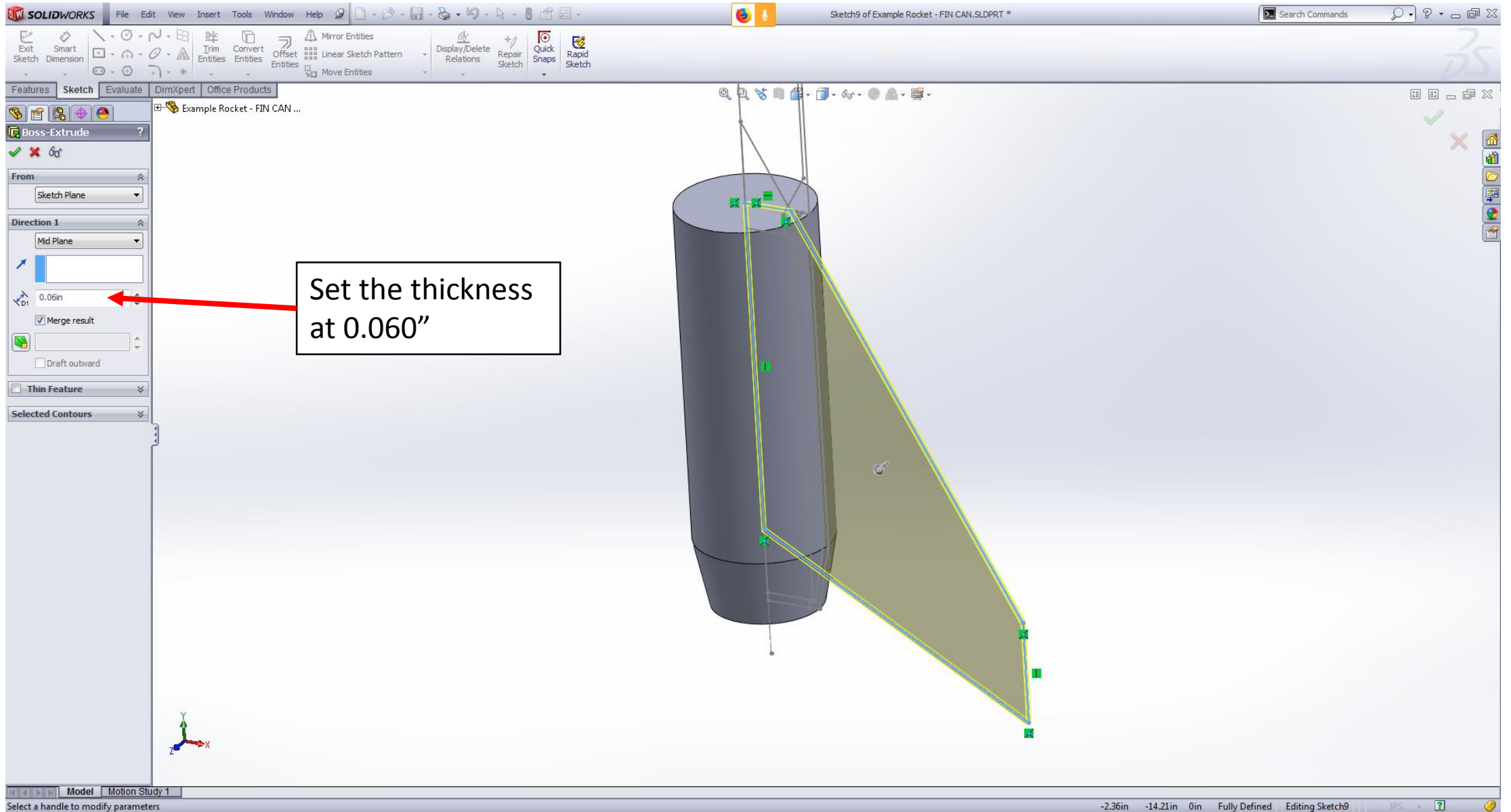




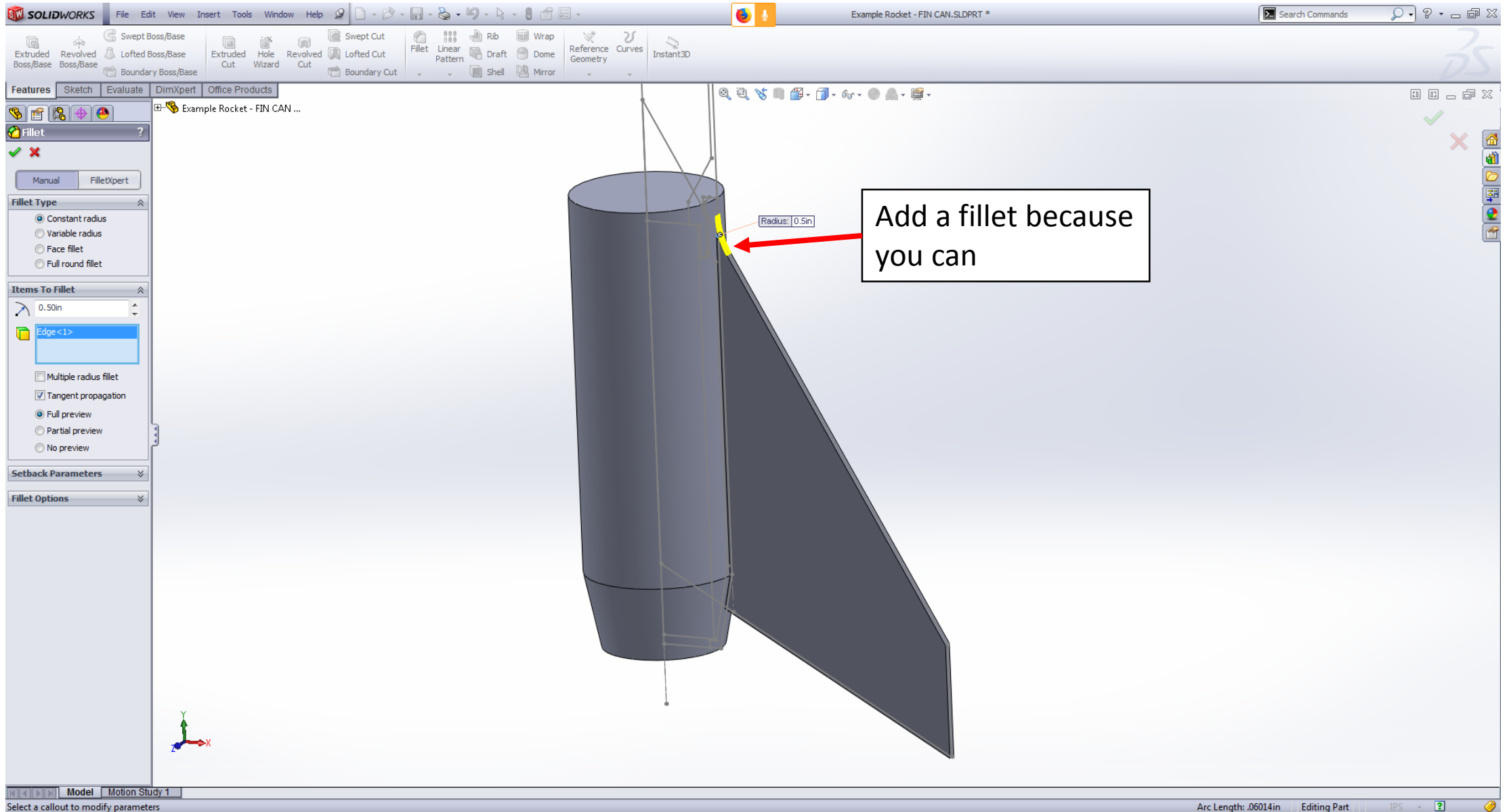


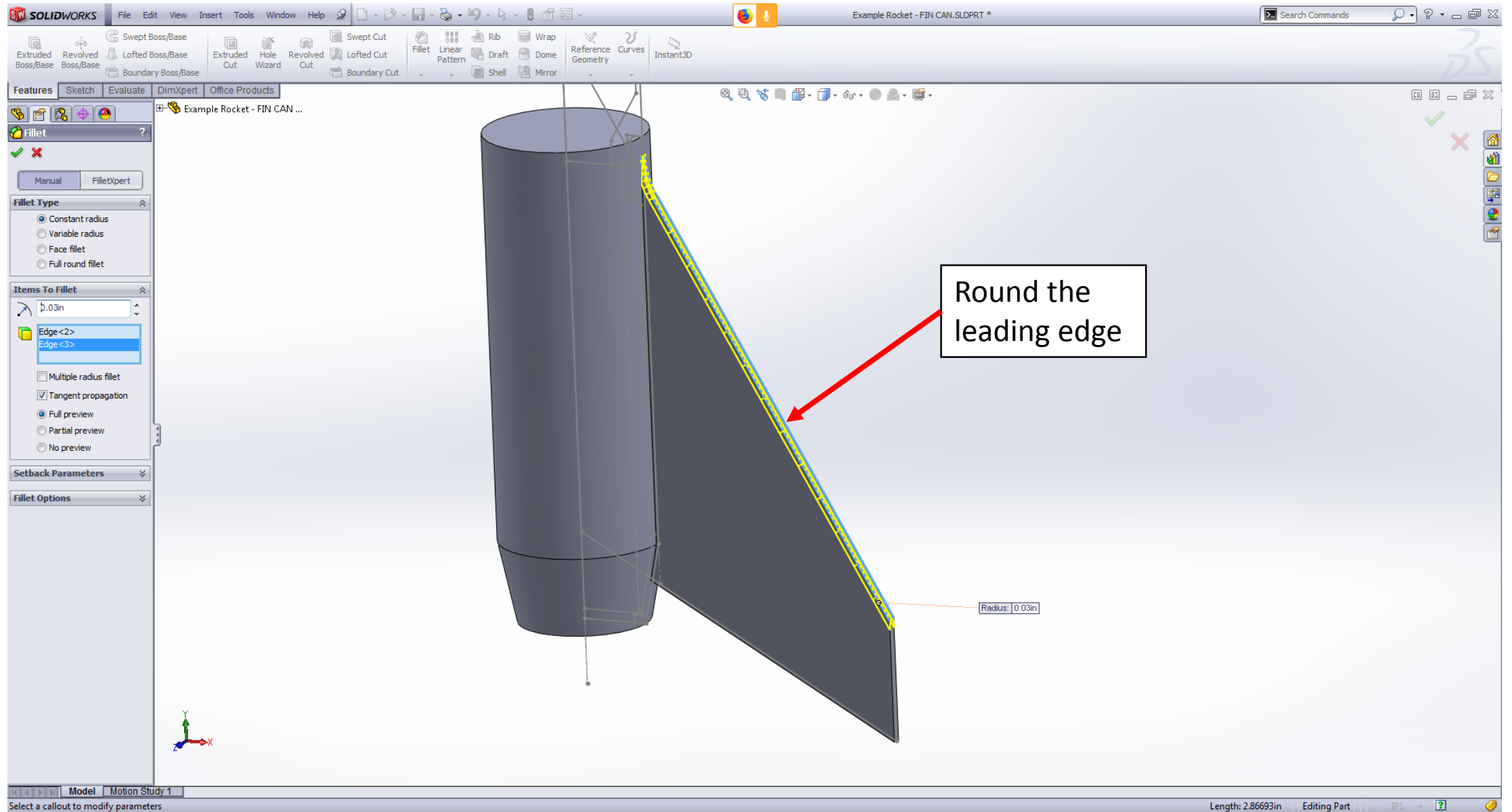


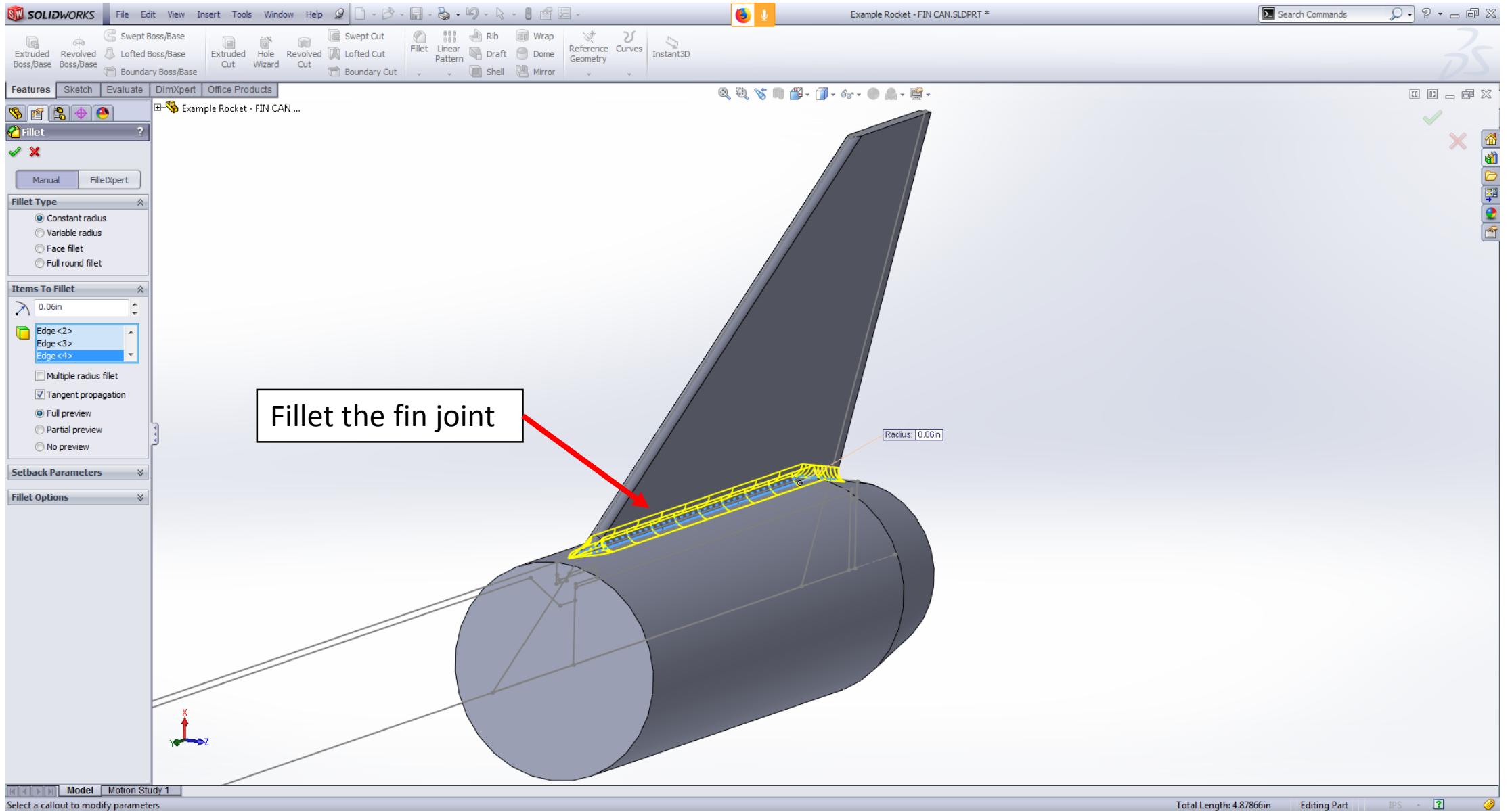


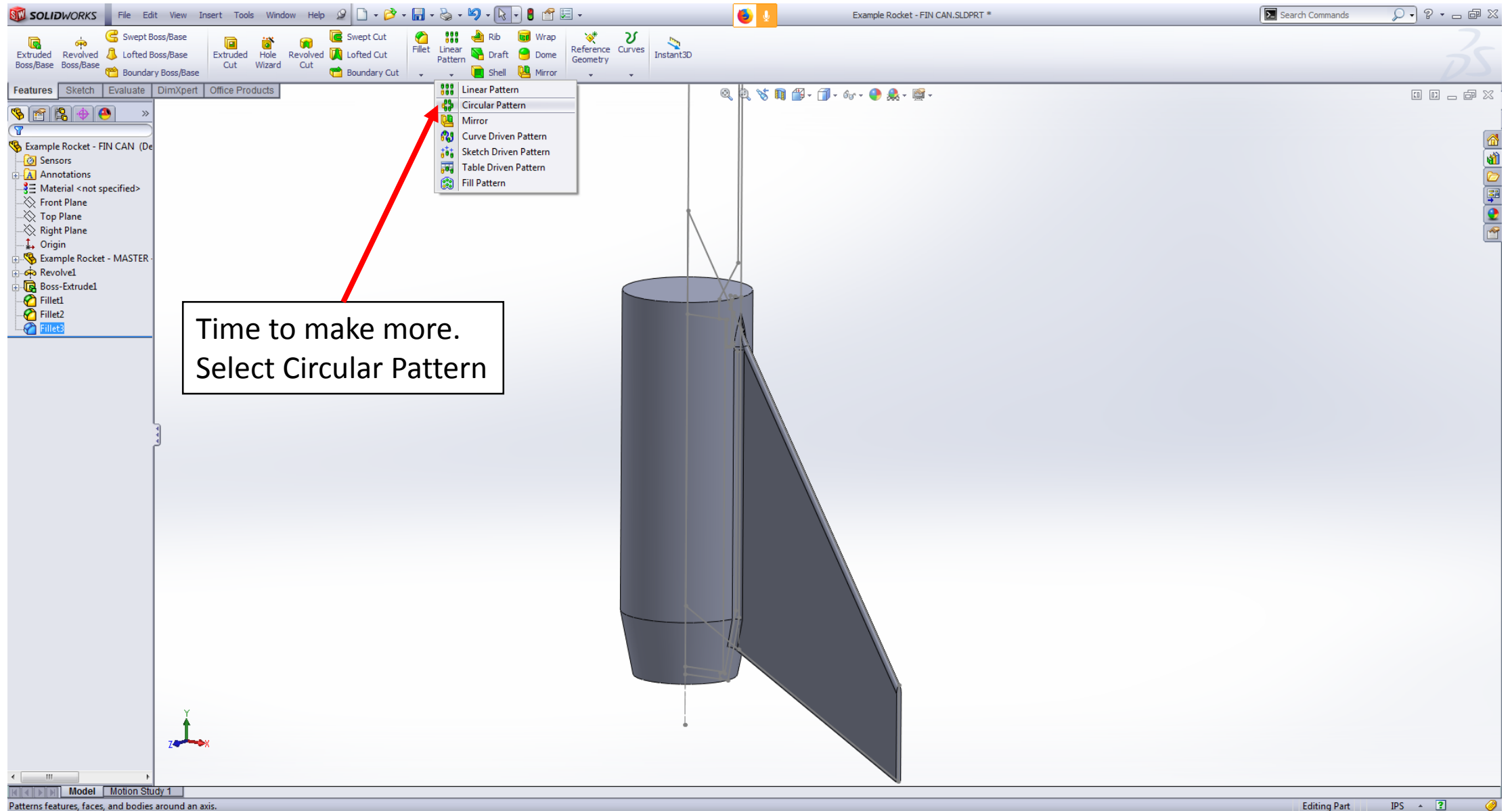




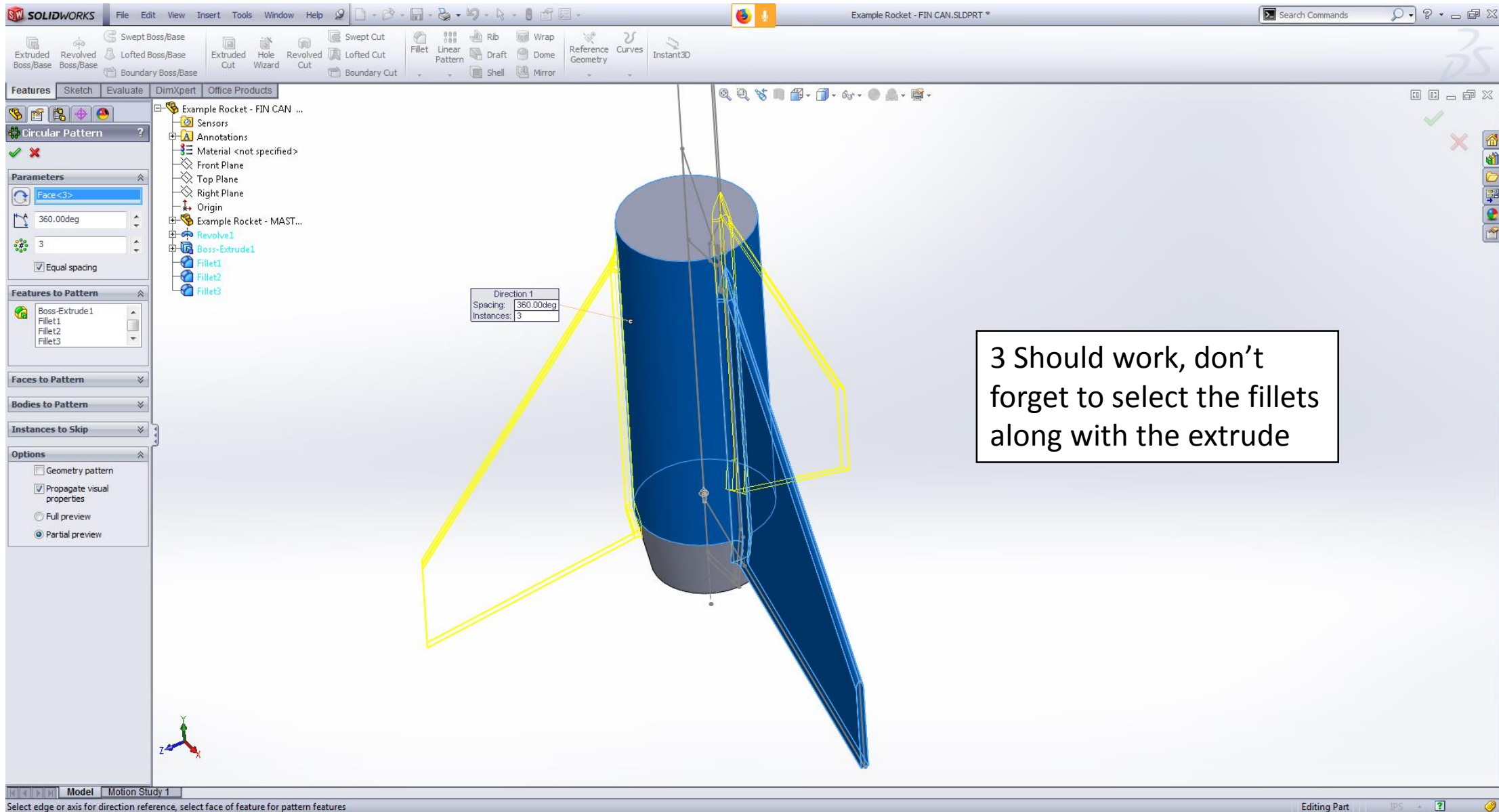




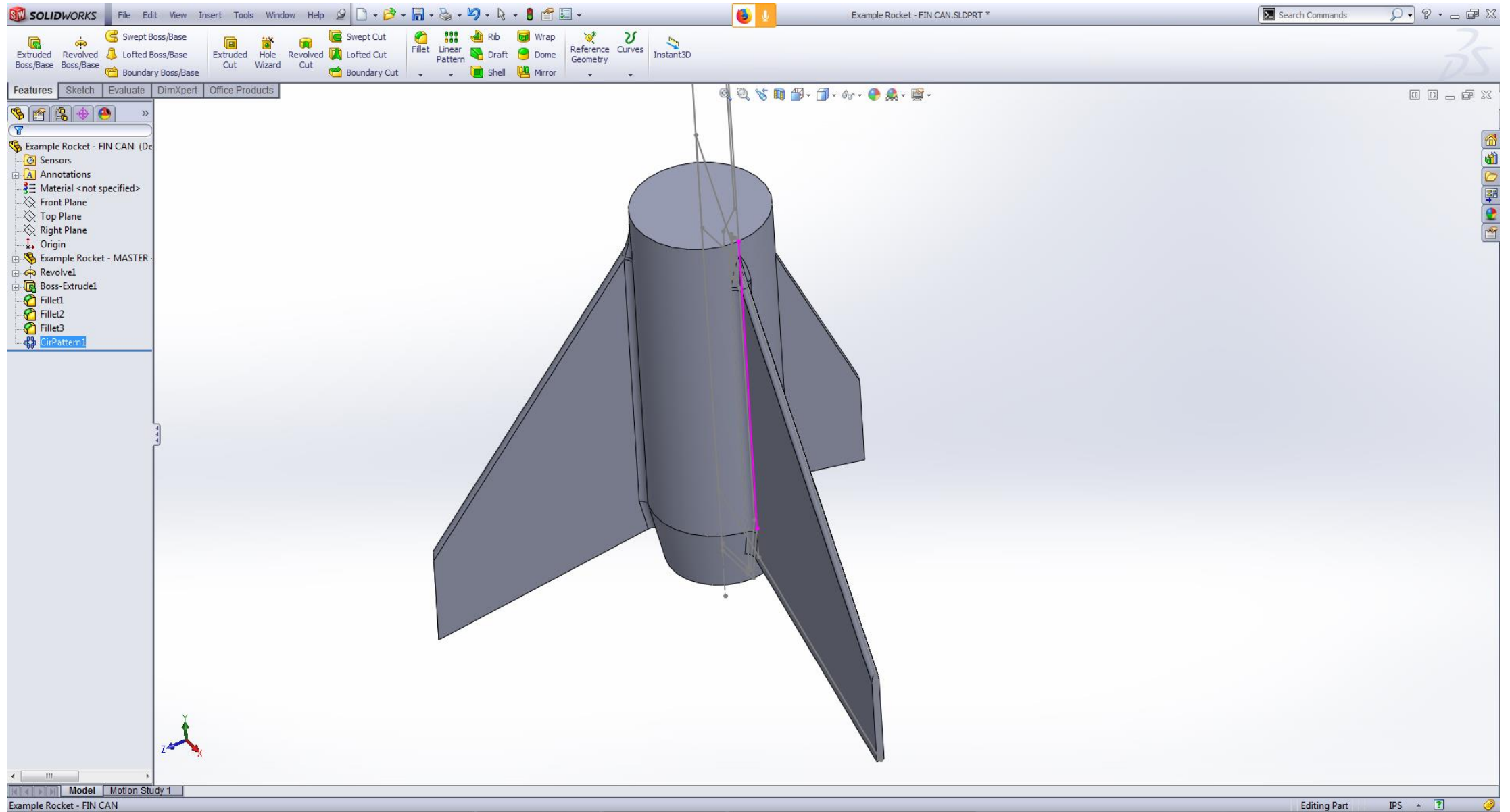


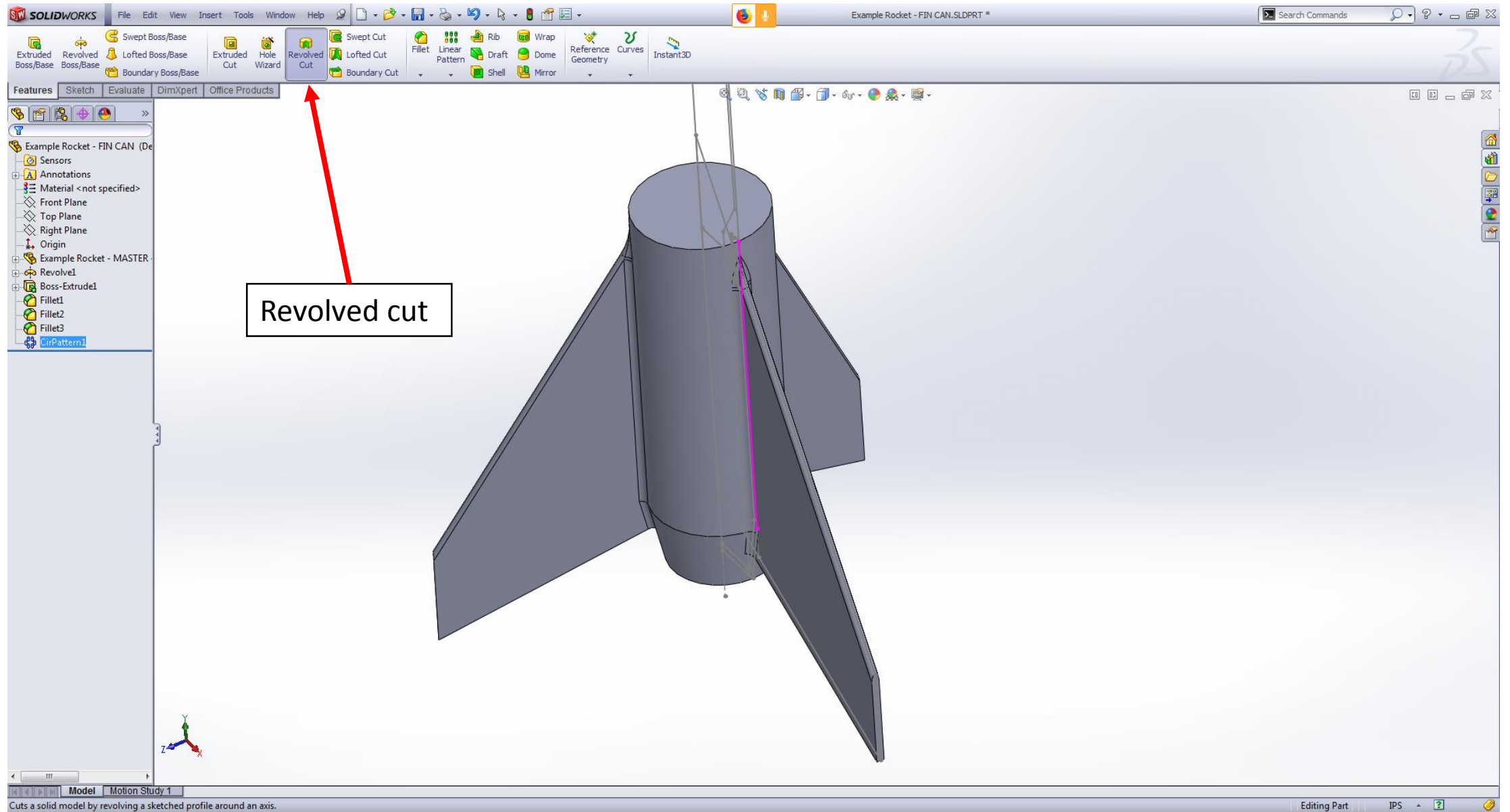


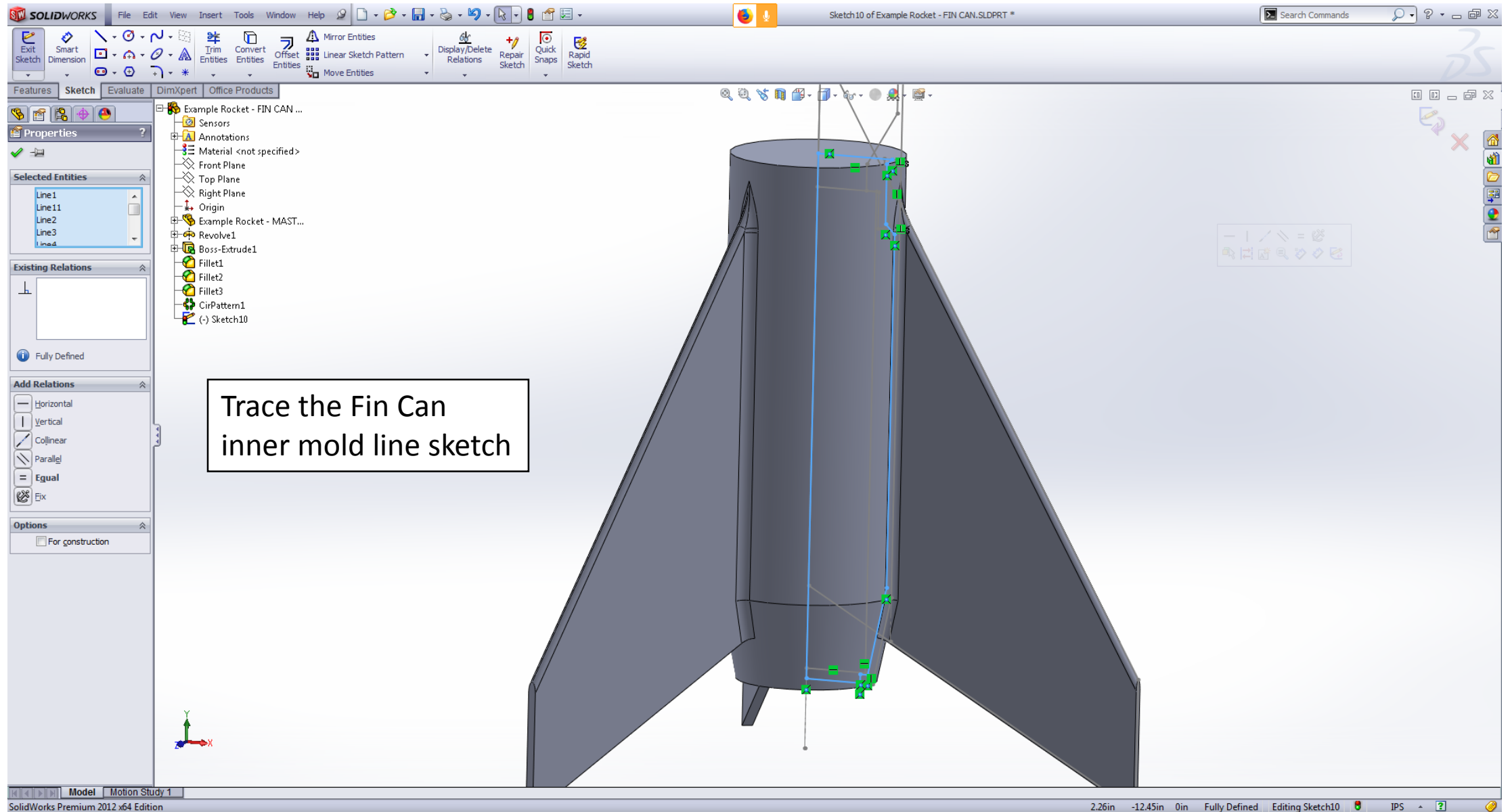
Time to make more.  
Select Circular Pattern



3 Should work, don't forget to select the fillets along with the extrude

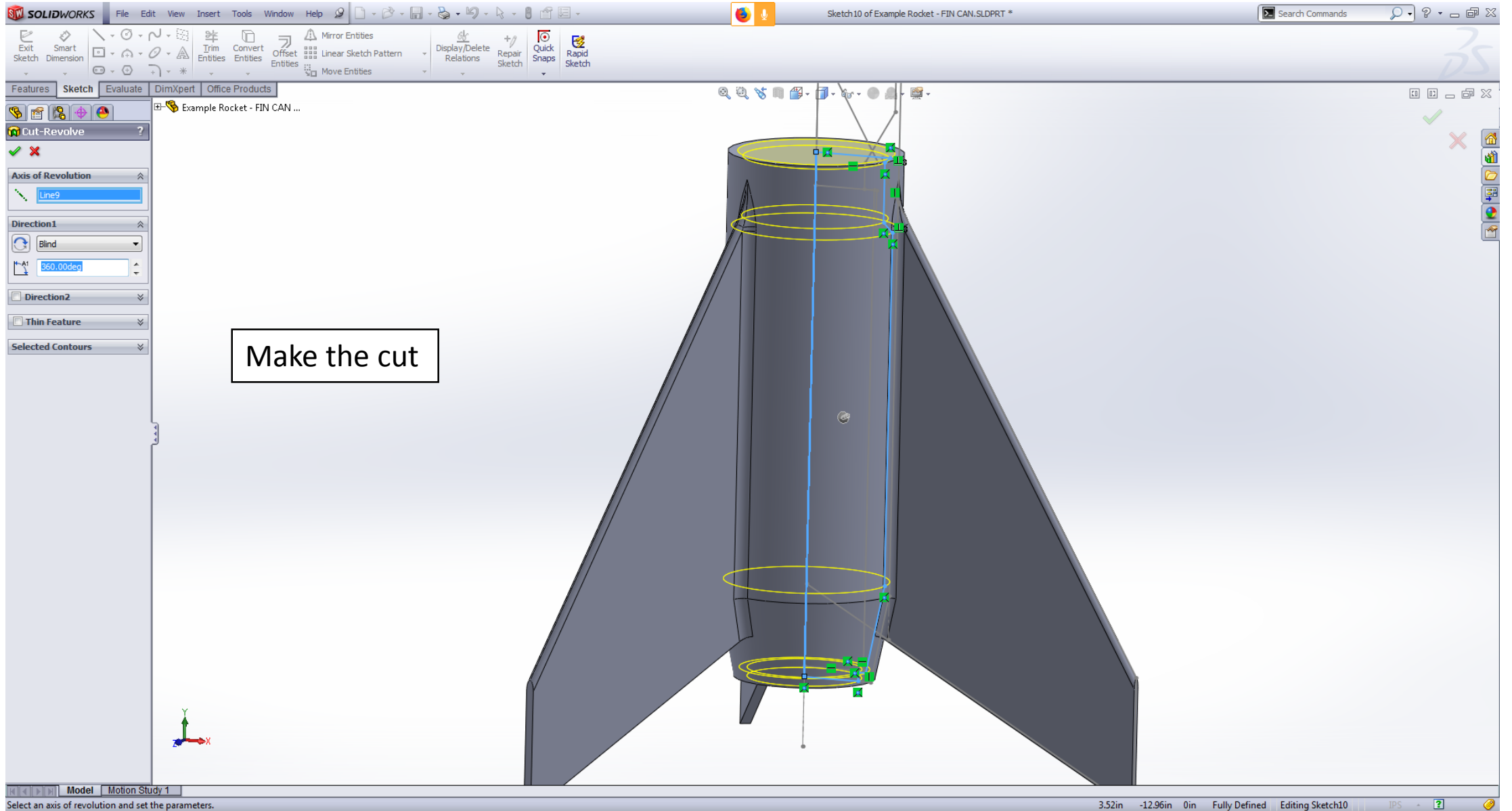


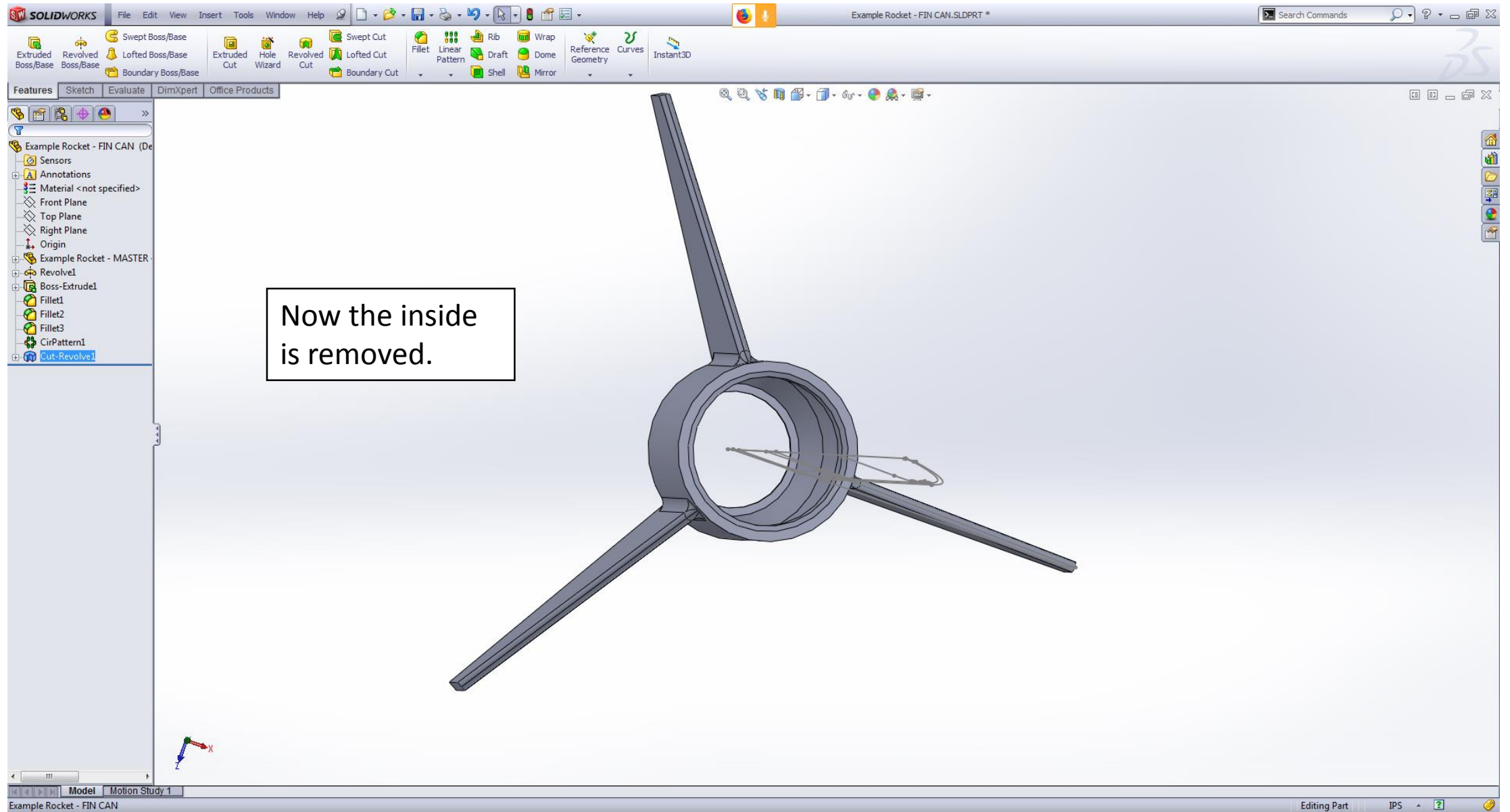




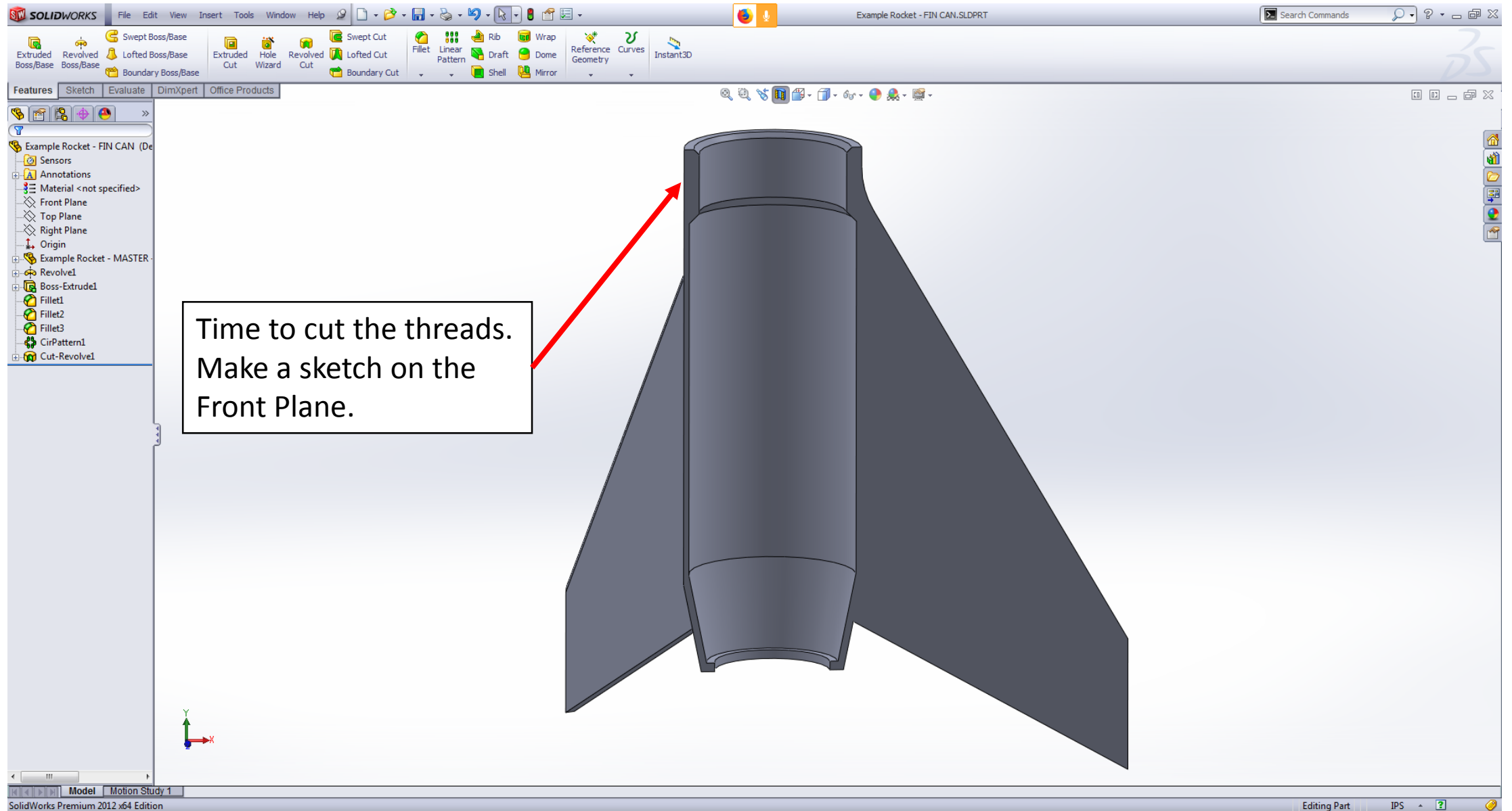
Trace the Fin Can  
inner mold line sketch

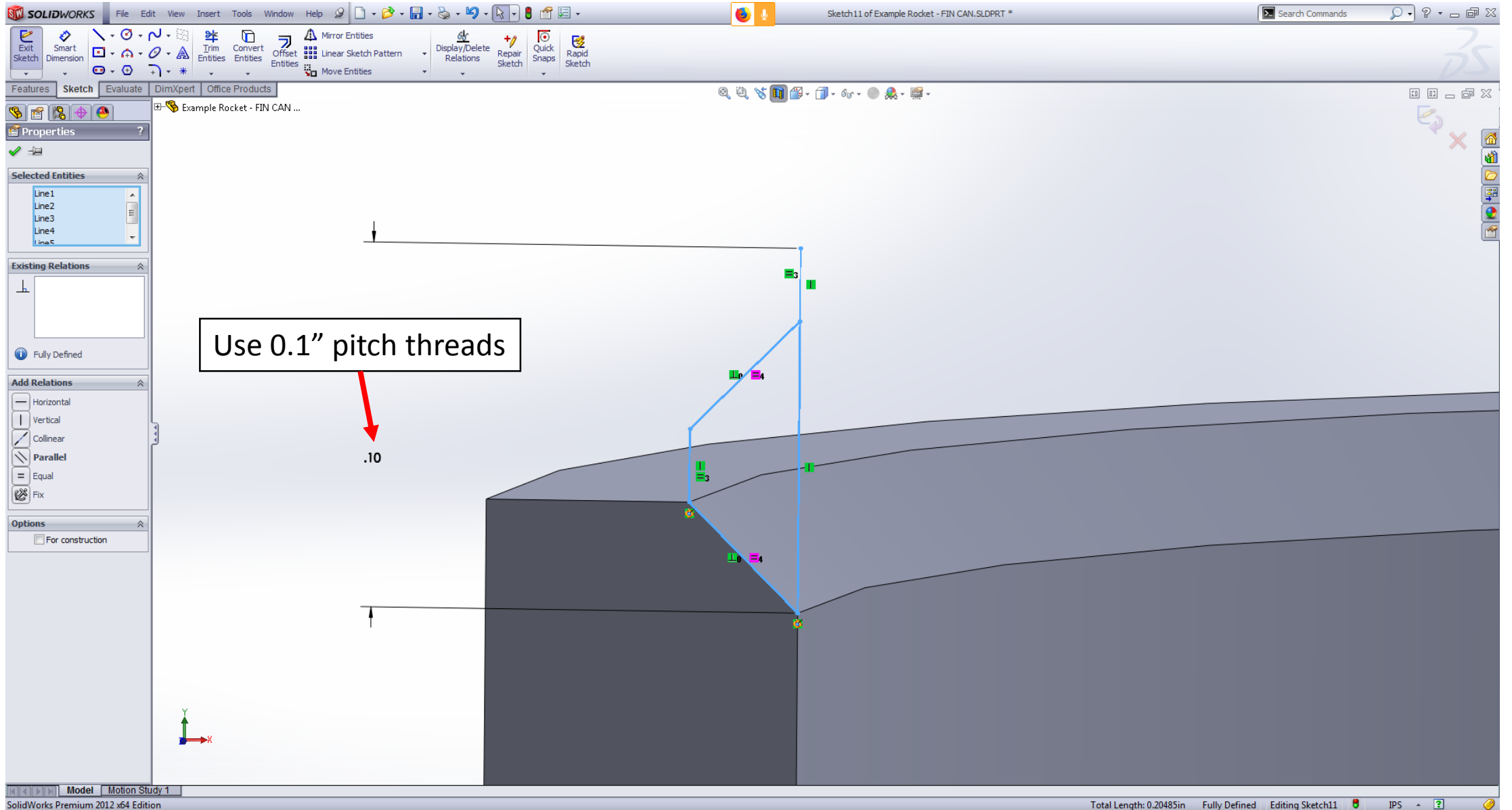


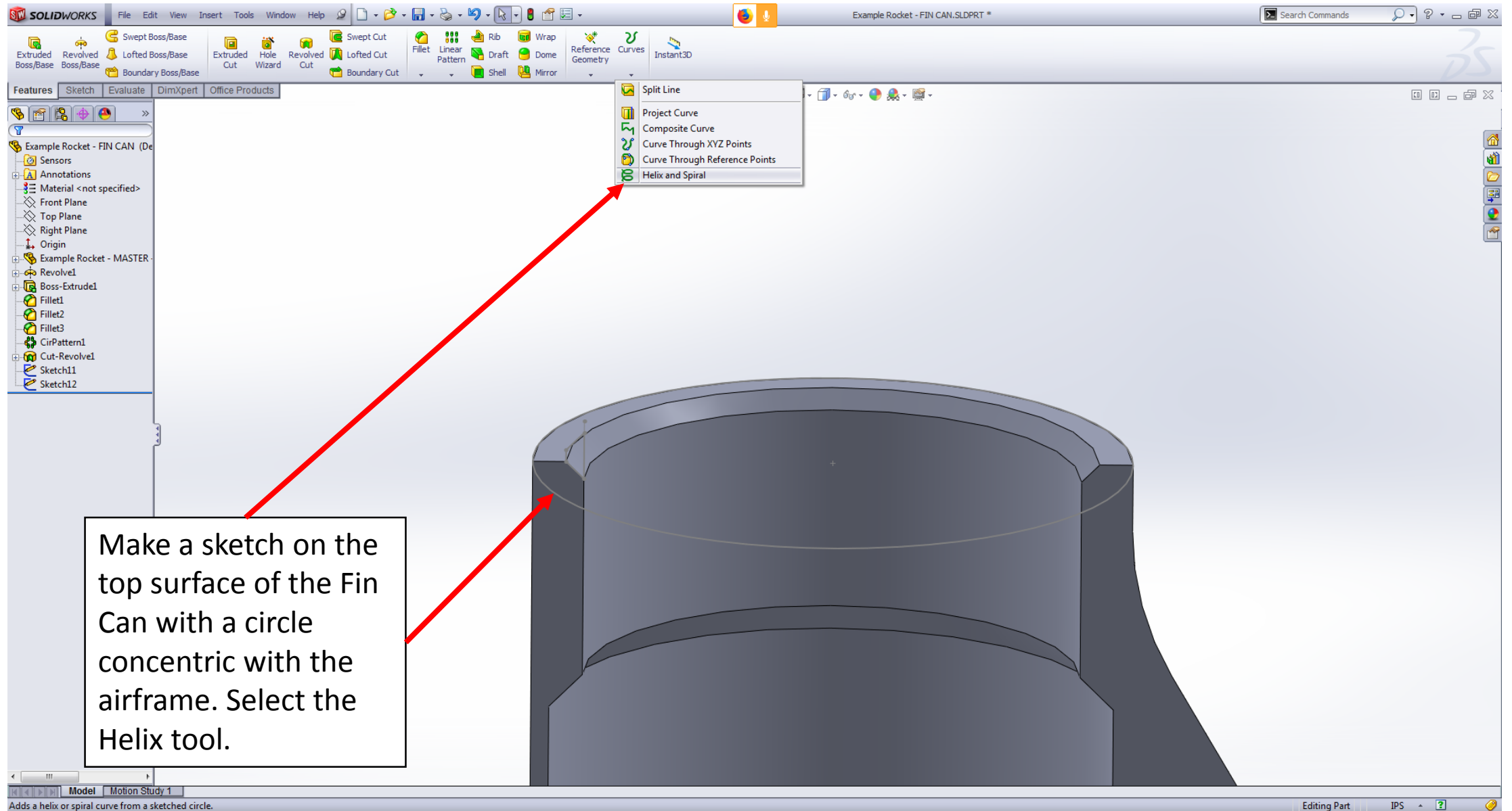




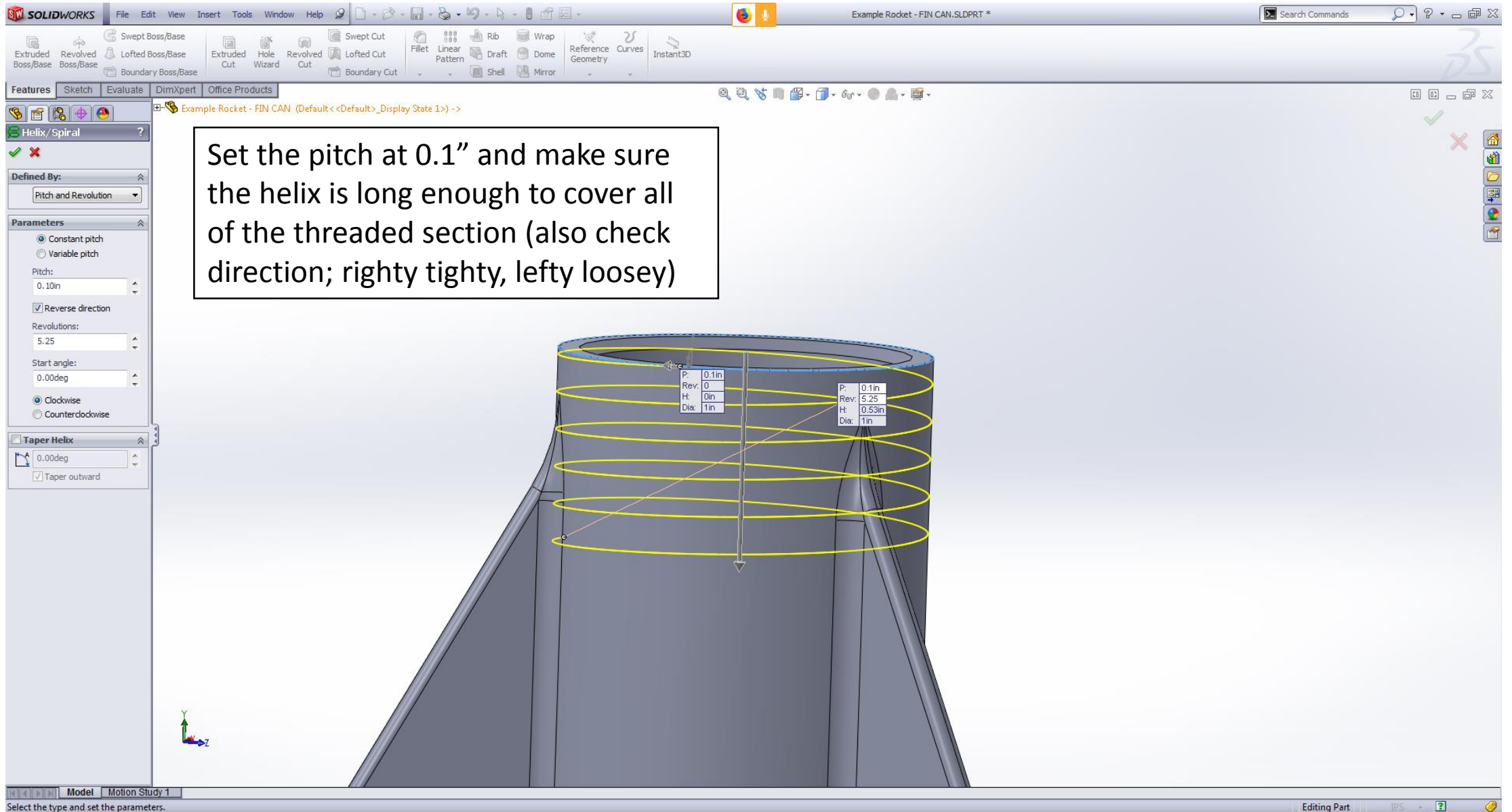
Now the inside is removed.

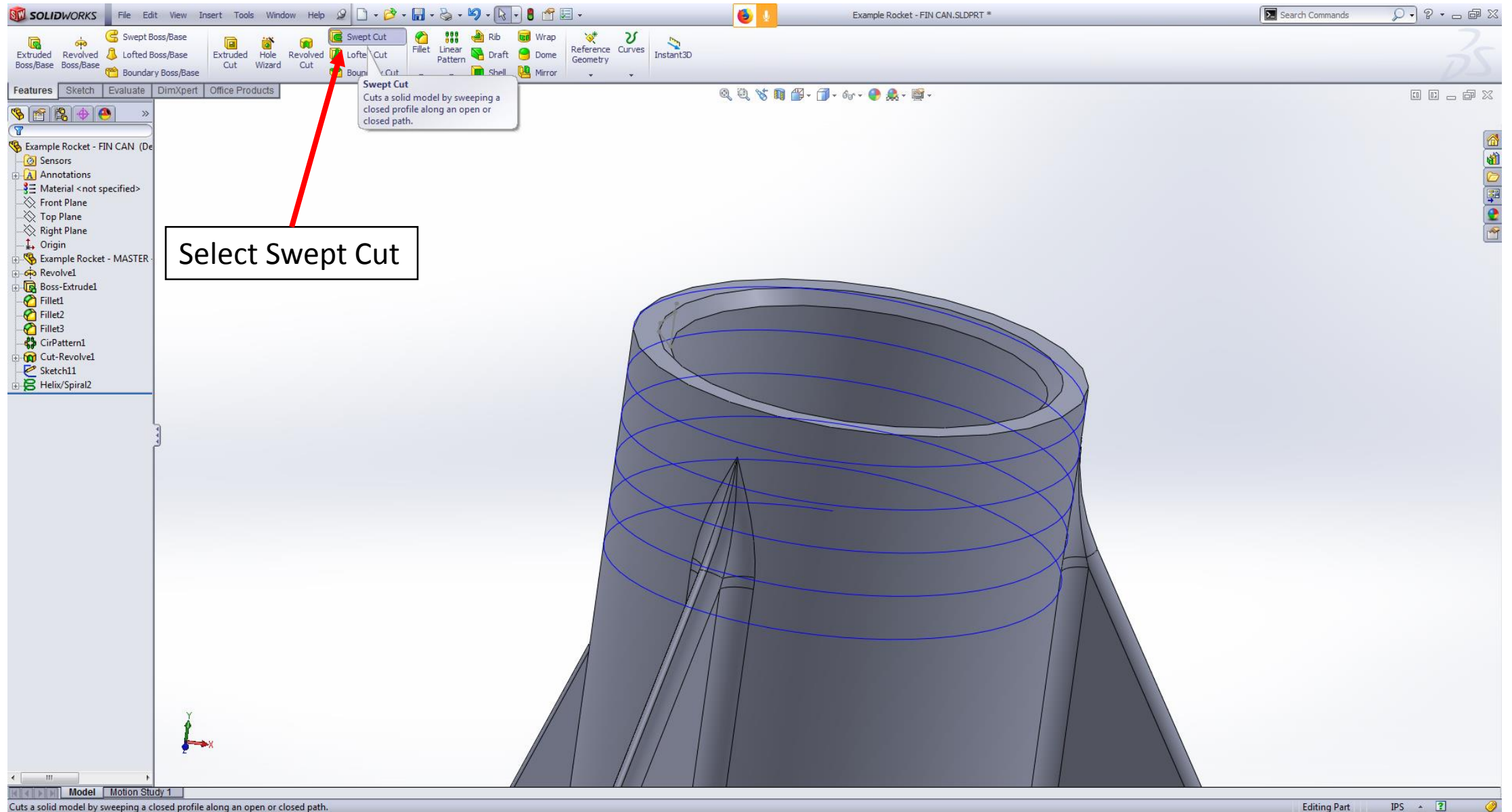


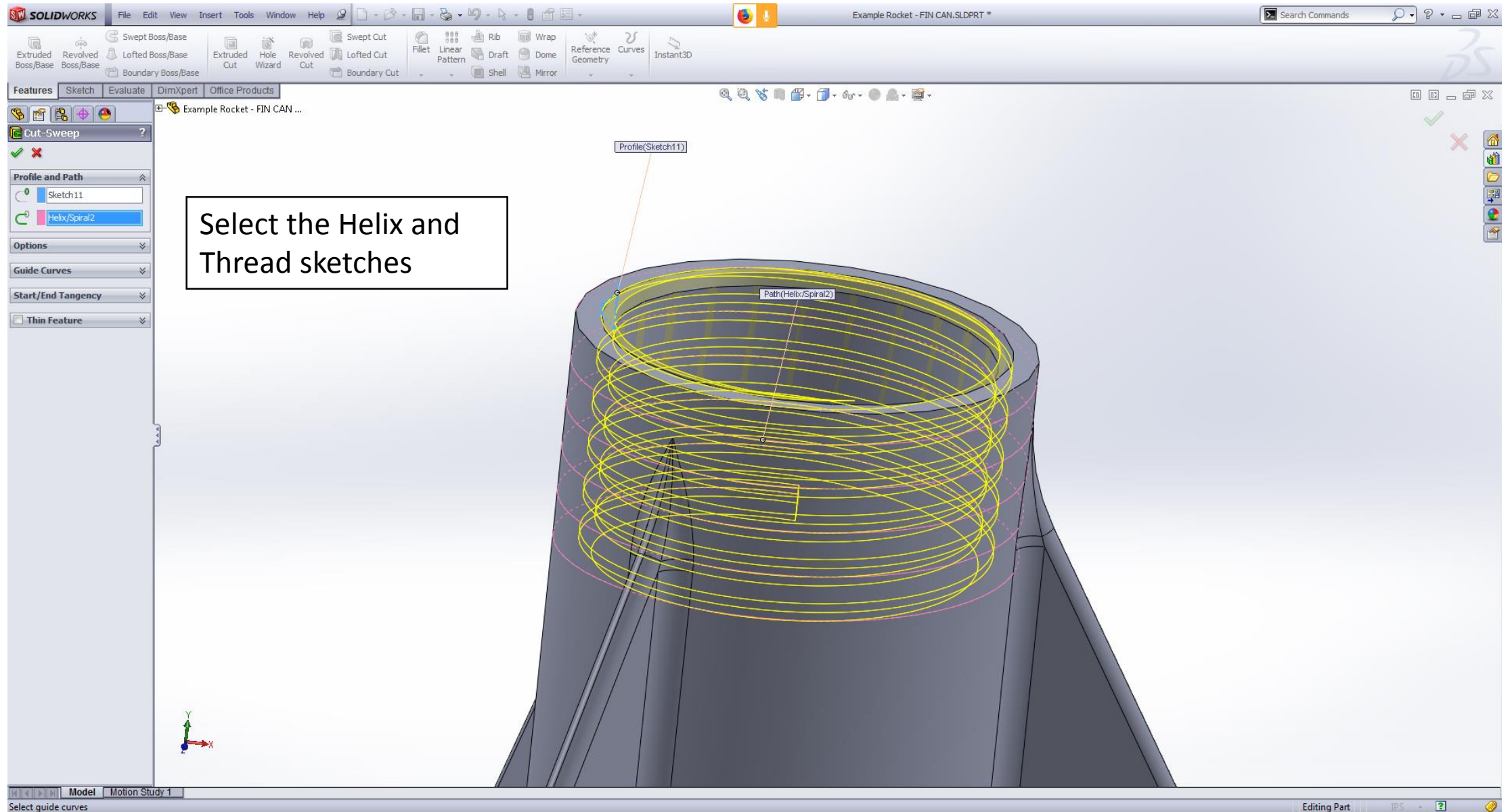




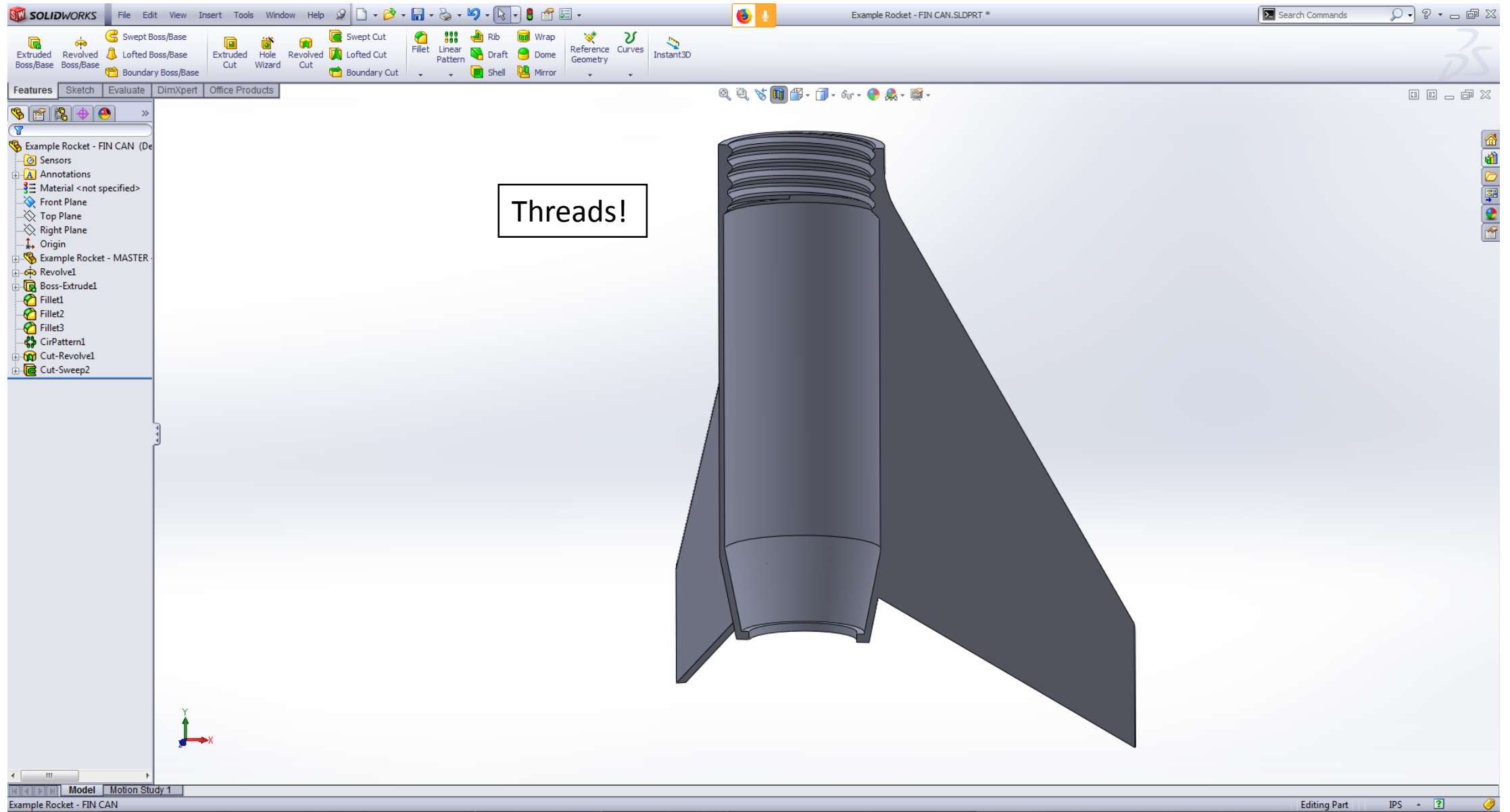
Make a sketch on the top surface of the Fin Can with a circle concentric with the airframe. Select the Helix tool.

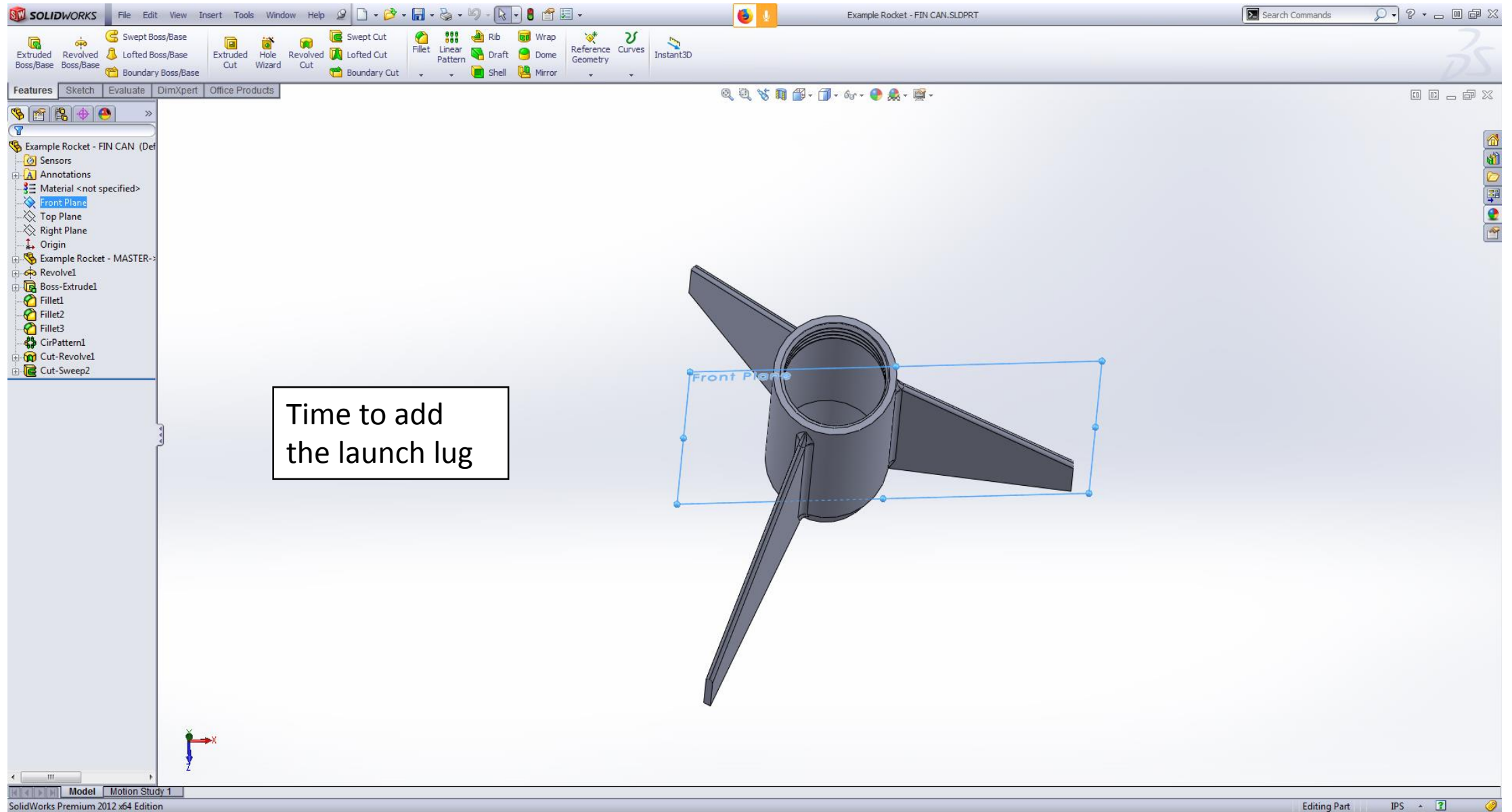








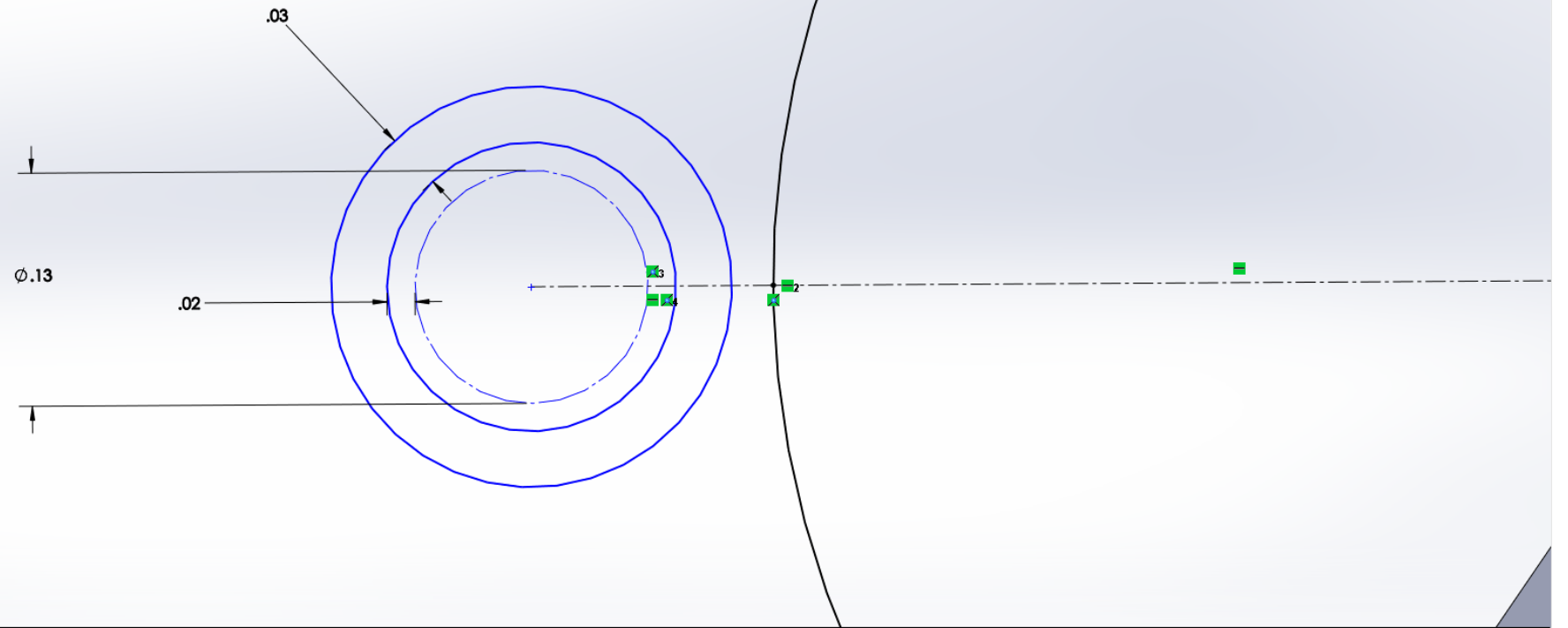




Time to add  
the launch lug

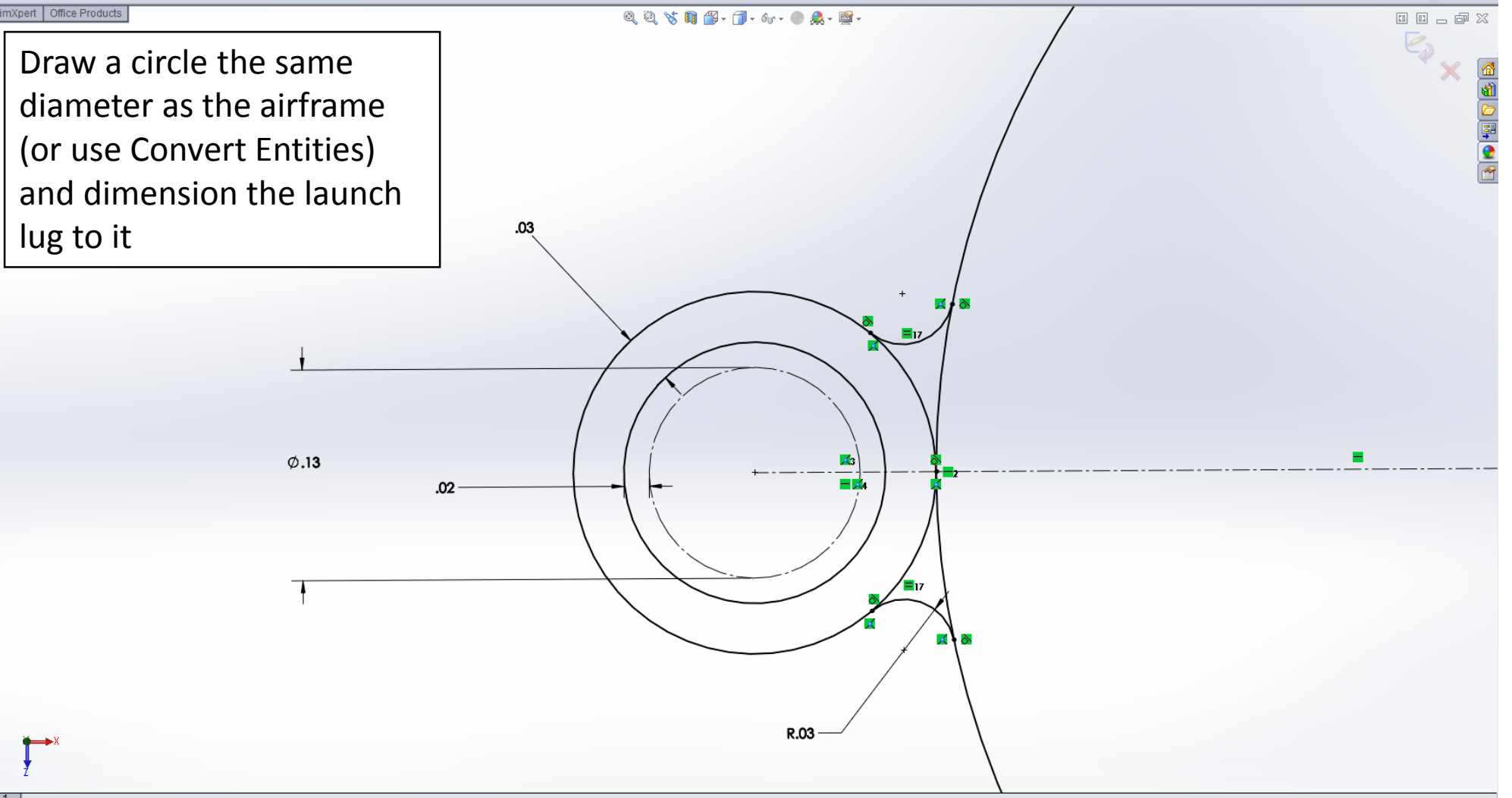
- Example Rocket - FIN CAN (Def)
- Sensors
- Annotations
- Material <not specified>
- Front Plane
- Top Plane
- Right Plane
- Origin
- Example Rocket - MASTER->
- Revolve1
- Boss-Extrude1
- Fillet1
- Fillet2
- Fillet3
- CirPattern1
- Cut-Revolve1
- Cut-Sweep2
- (-) Sketch13

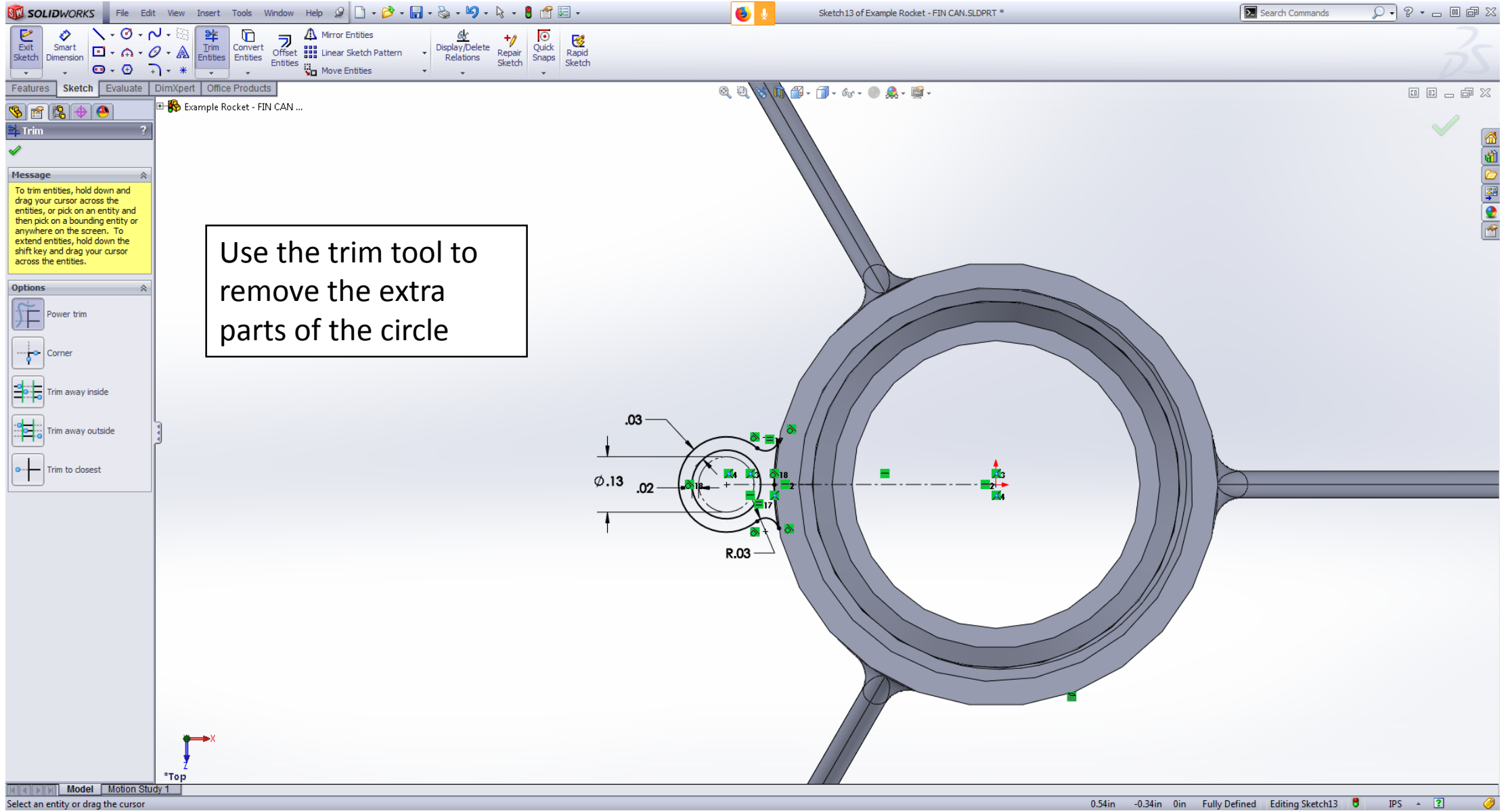
Make a sketch on the Top Plane. I leave 15 thou between the ID of the launch lug and the OD of the rod.

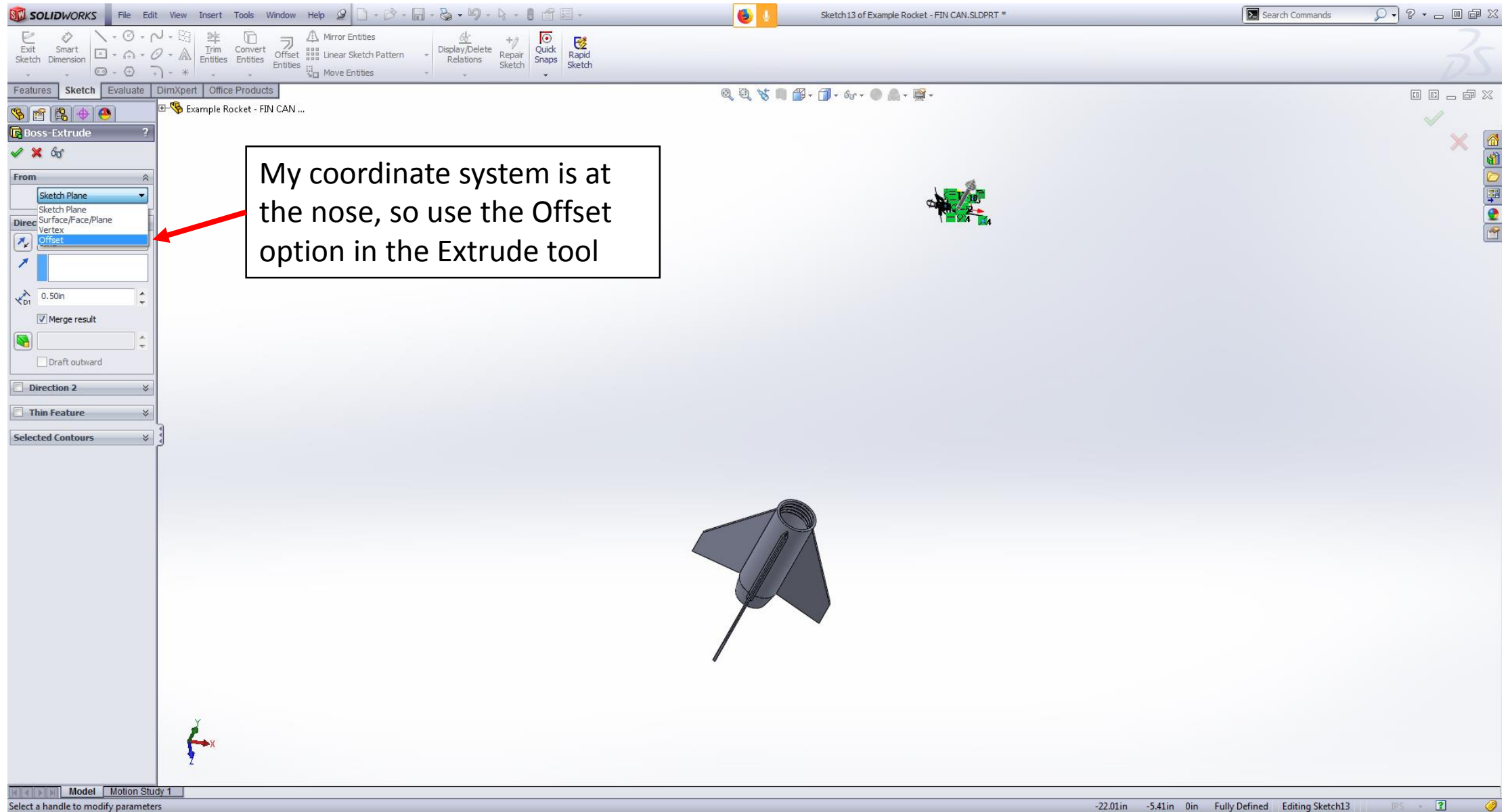


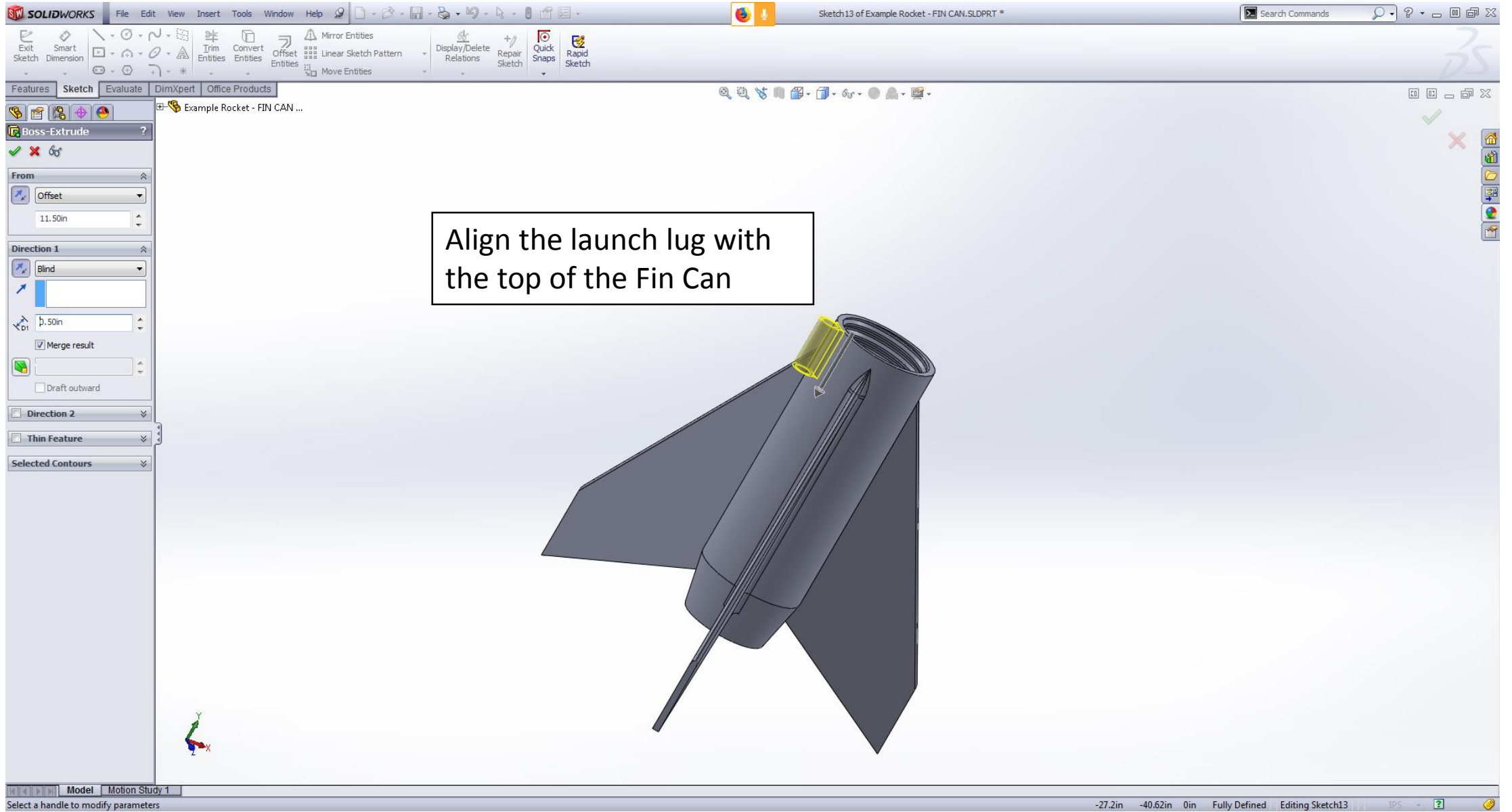
- Example Rocket - FIN CAN (Def)
- Sensors
- Annotations
- Material <not specified>
- Front Plane
- Top Plane
- Right Plane
- Origin
- Example Rocket - MASTER->
- Revolve1
- Boss-Extrude1
- Fillet1
- Fillet2
- Fillet3
- CirPattern1
- Cut-Revolve1
- Cut-Sweep2
- Sketch13

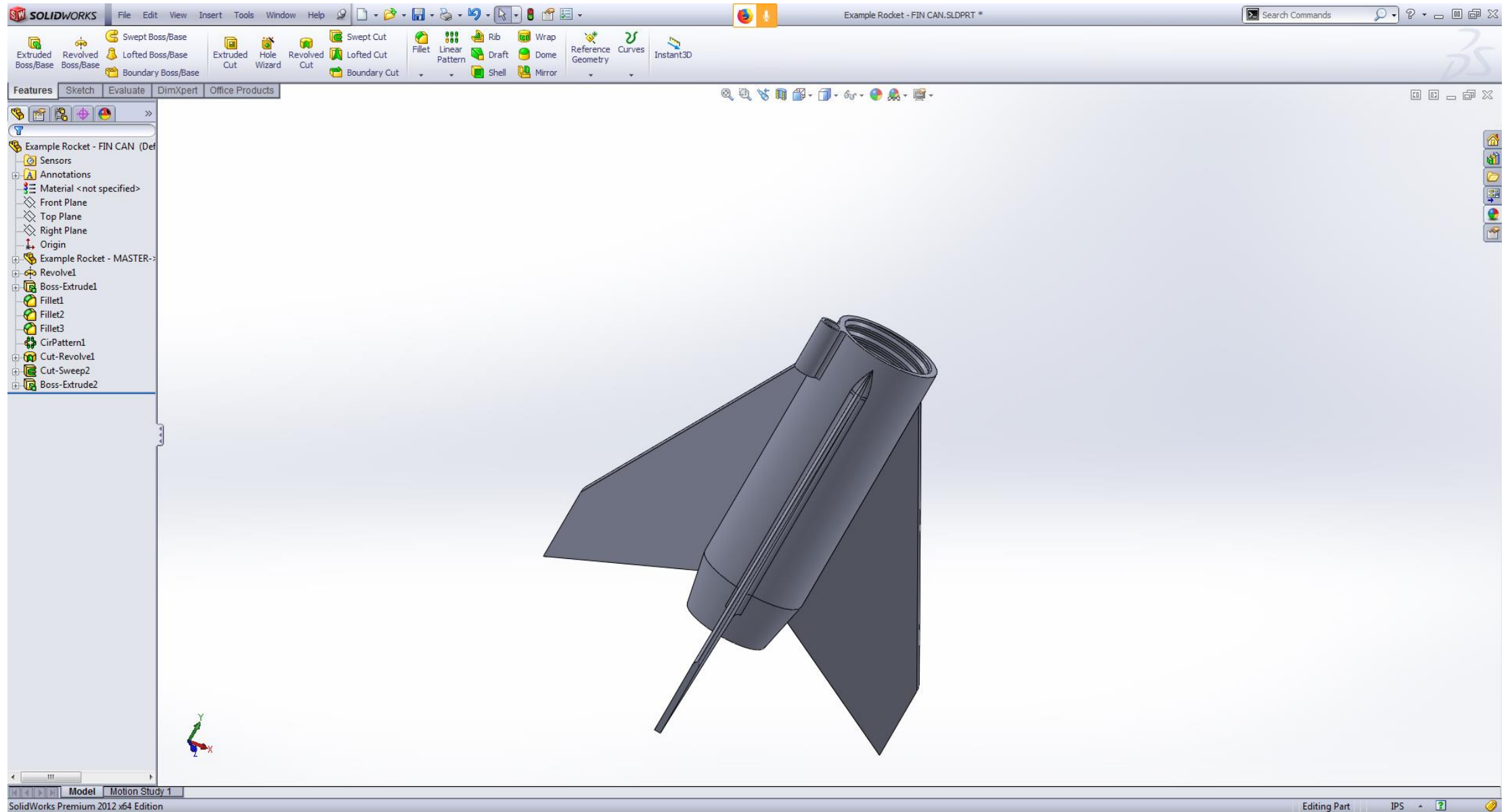
Draw a circle the same diameter as the airframe (or use Convert Entities) and dimension the launch lug to it



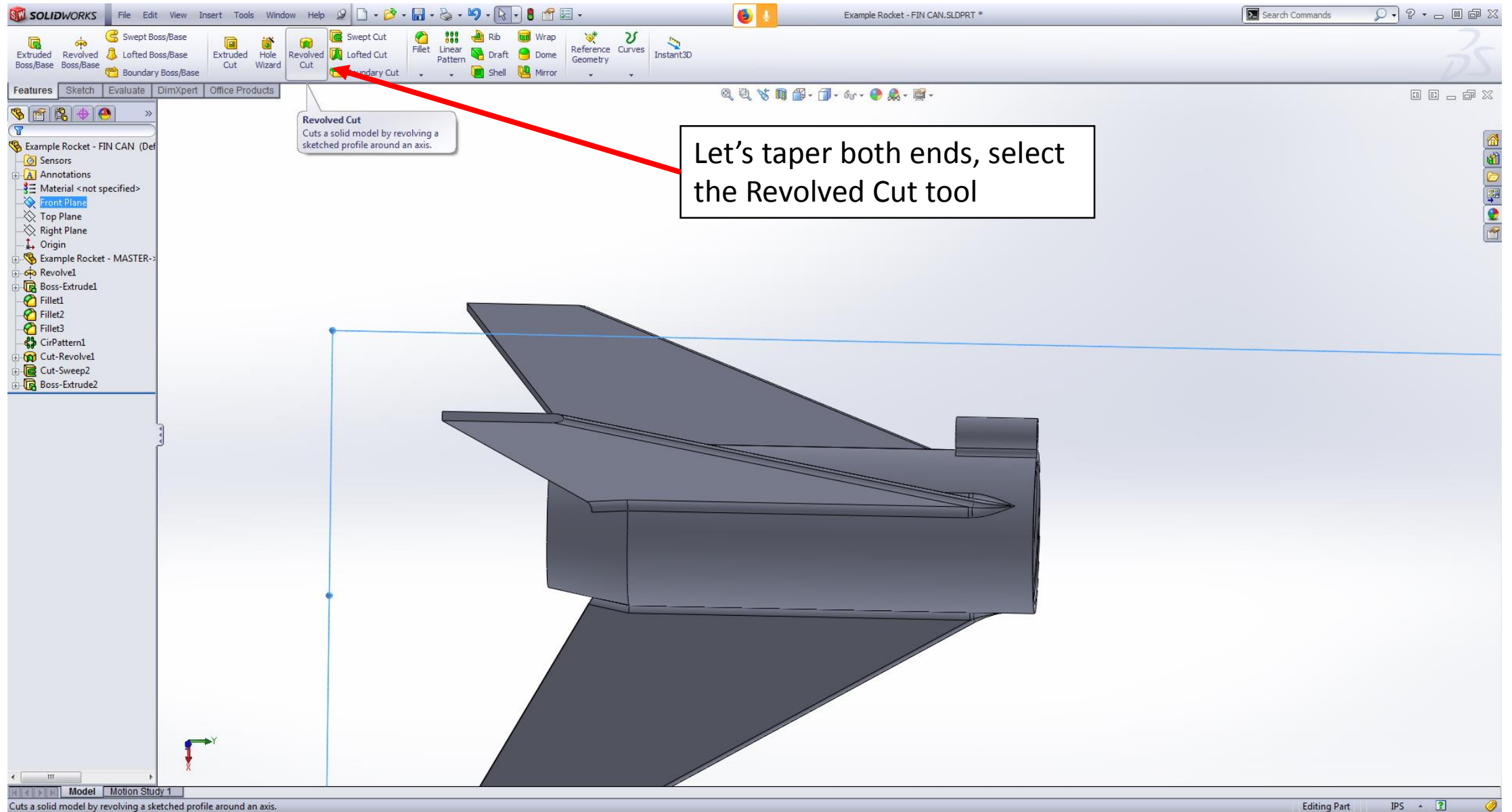




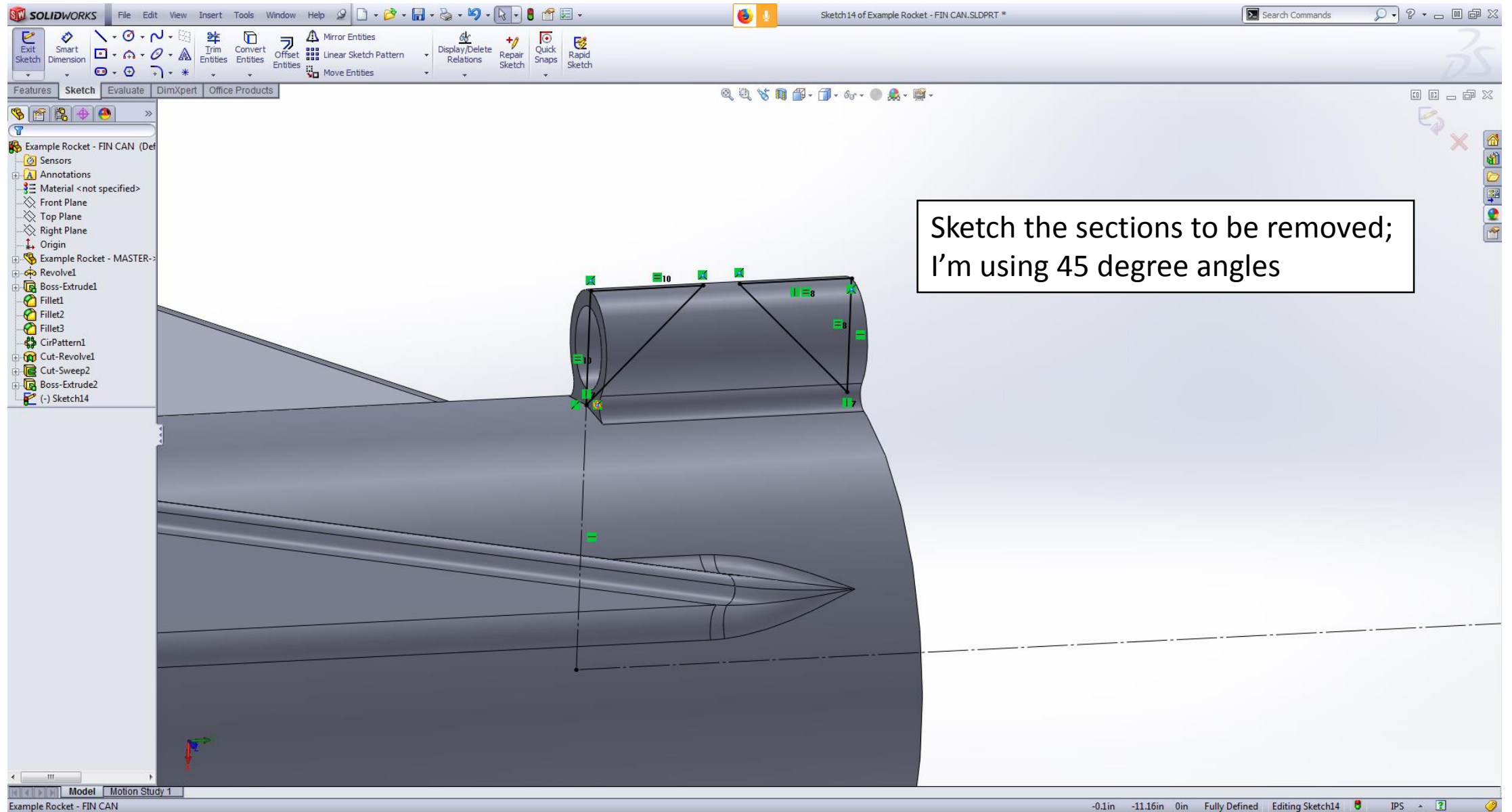




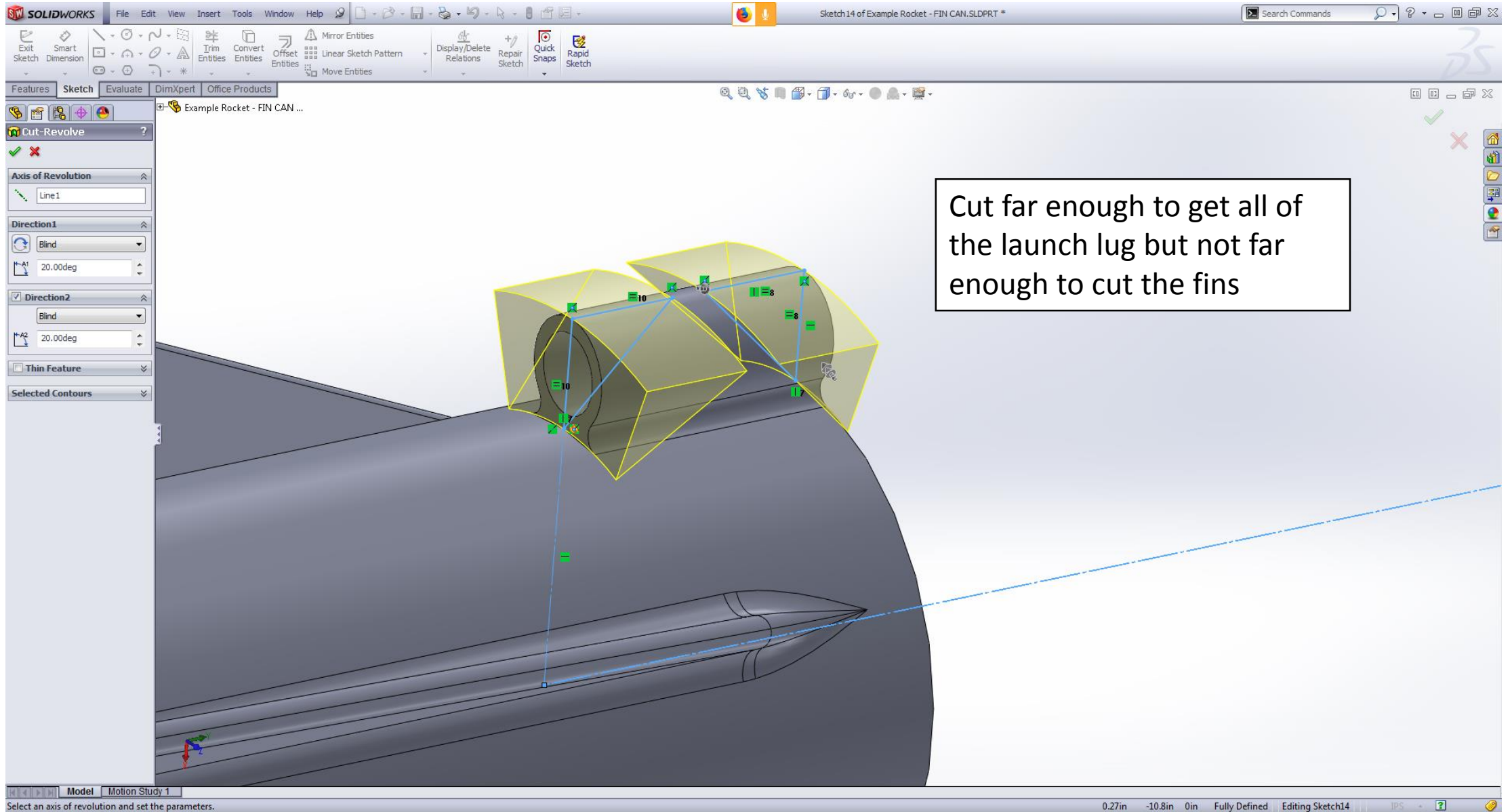




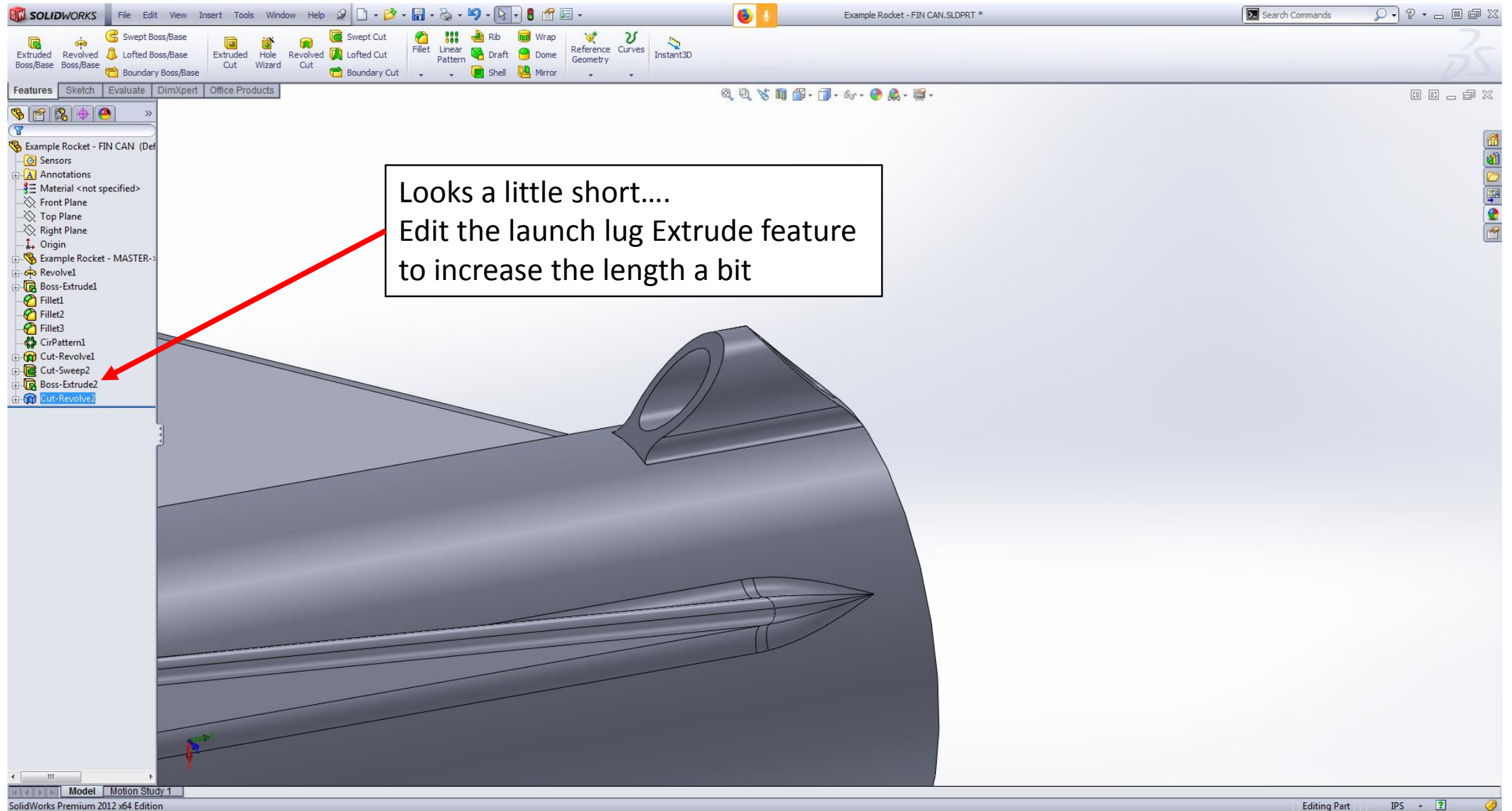
Let's taper both ends, select the Revolved Cut tool



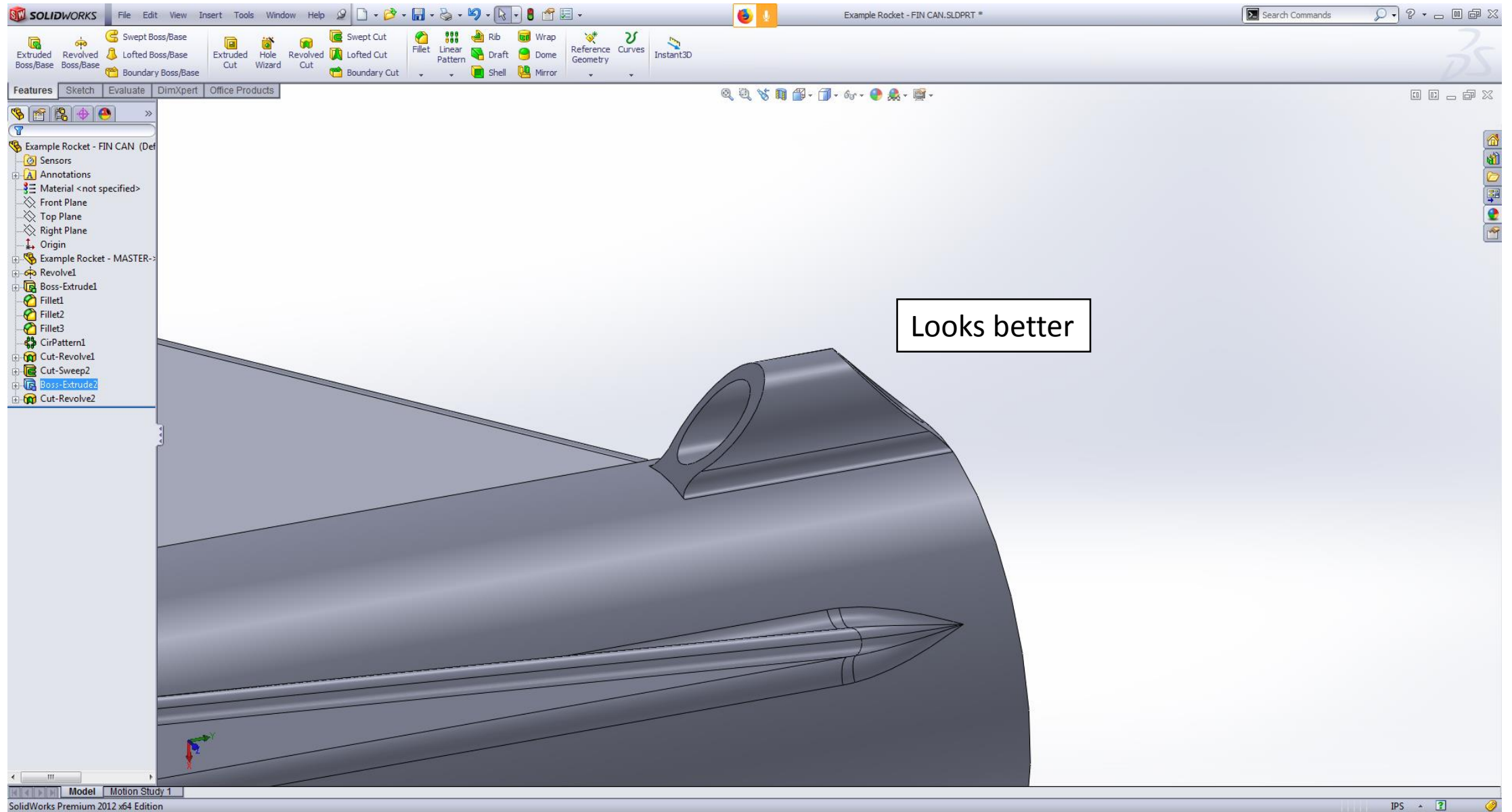
Sketch the sections to be removed;  
I'm using 45 degree angles



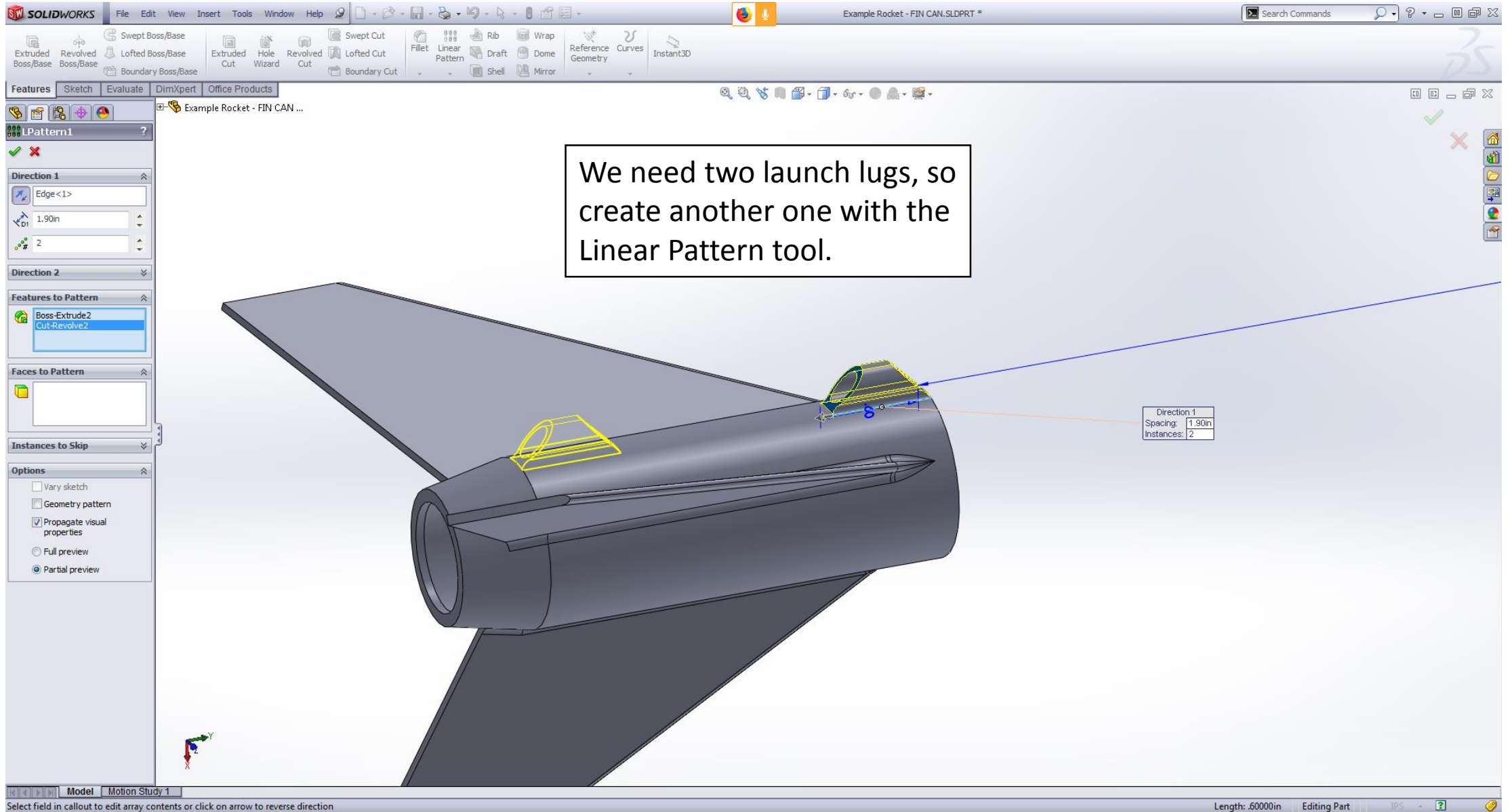
Cut far enough to get all of the launch lug but not far enough to cut the fins

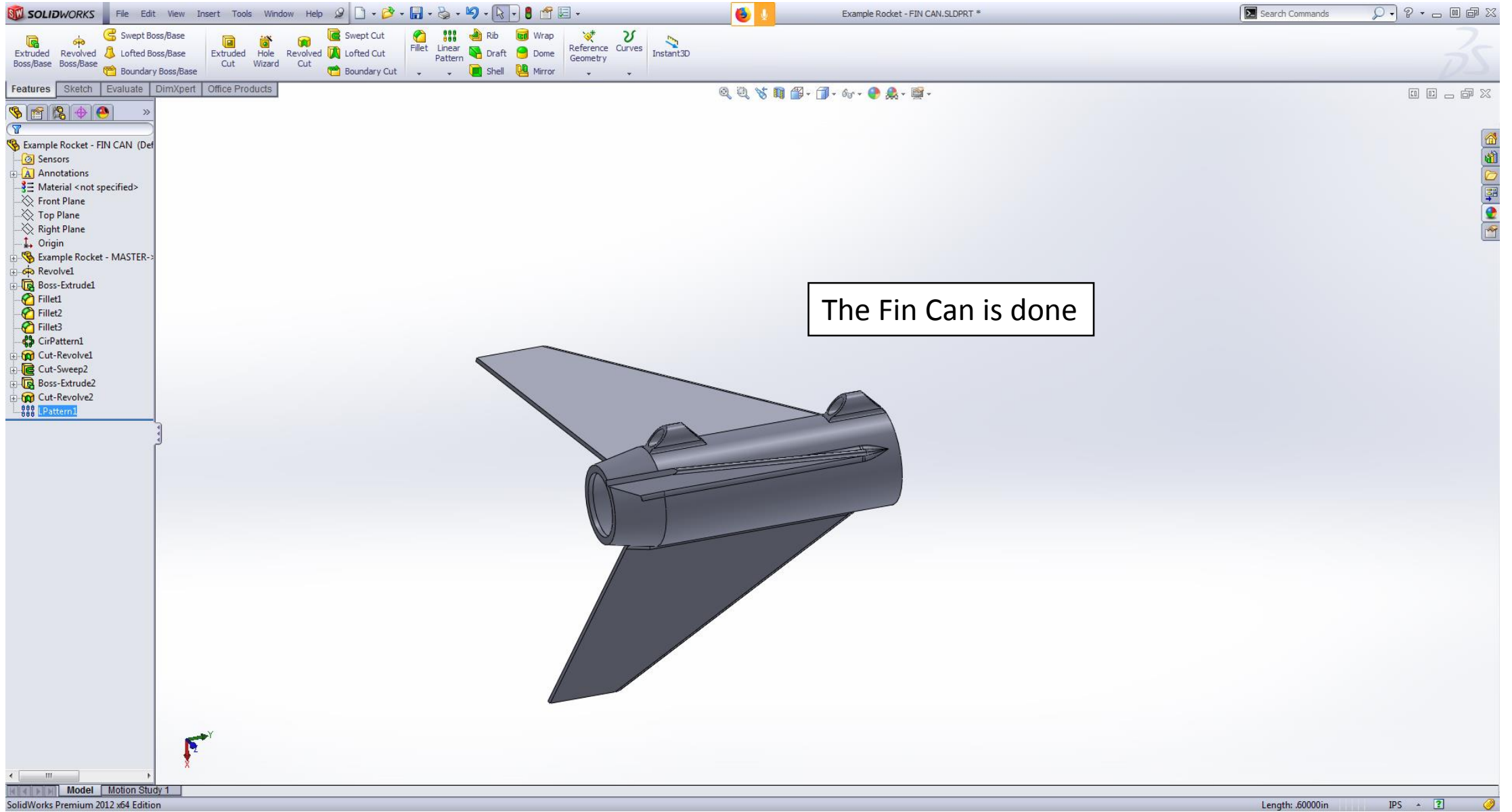


Looks a little short....  
Edit the launch lug Extrude feature  
to increase the length a bit

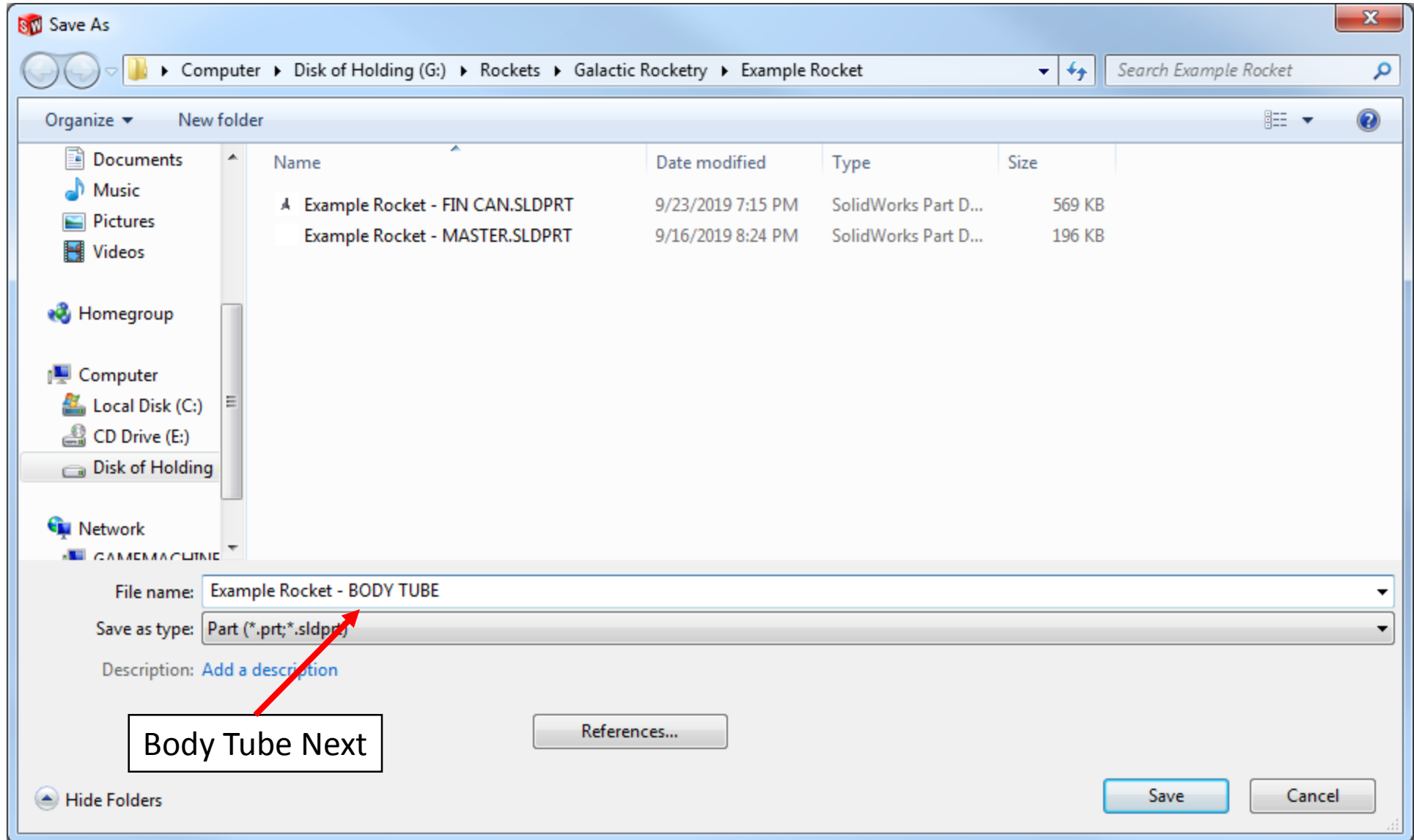


Looks better

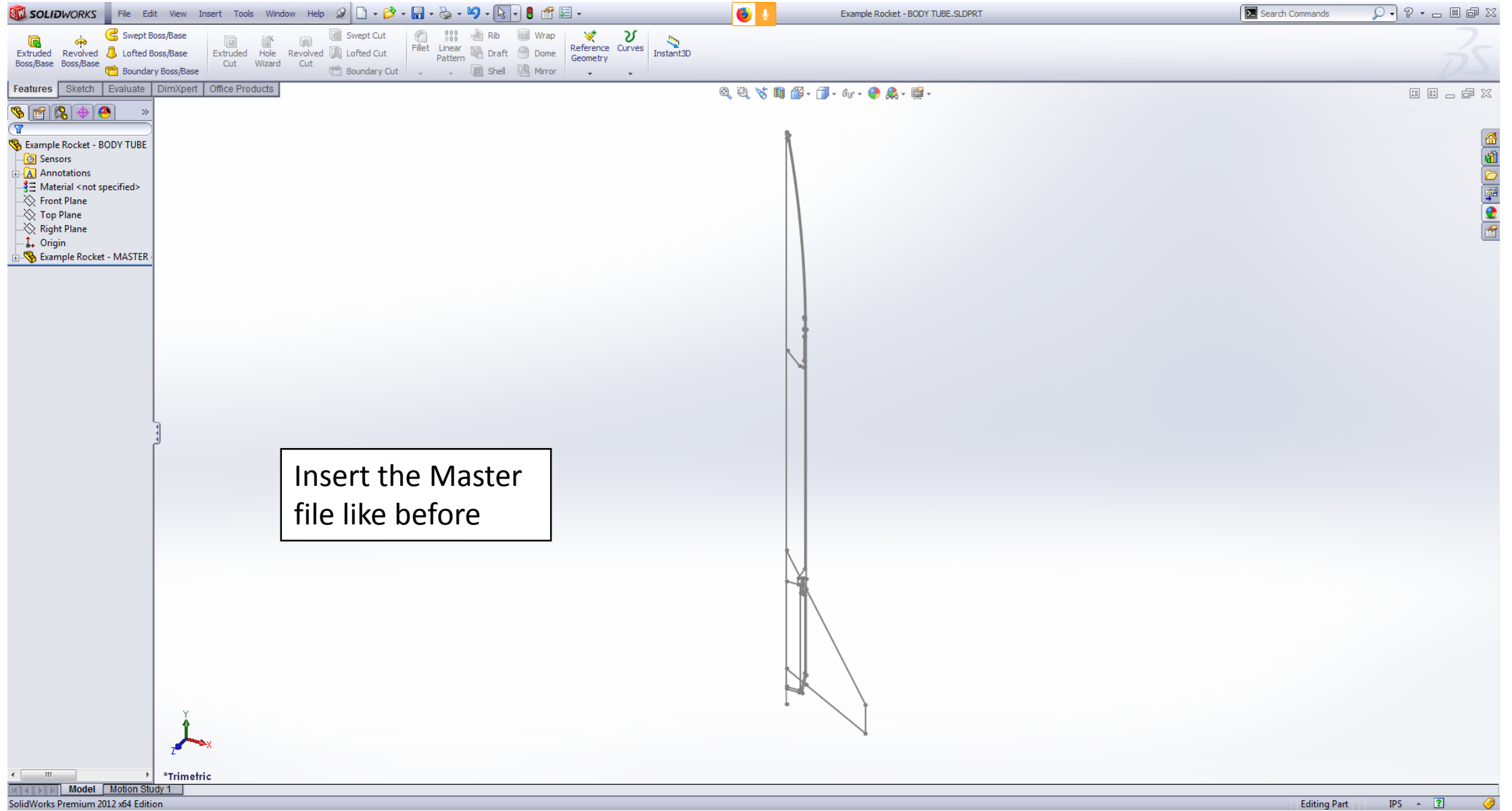




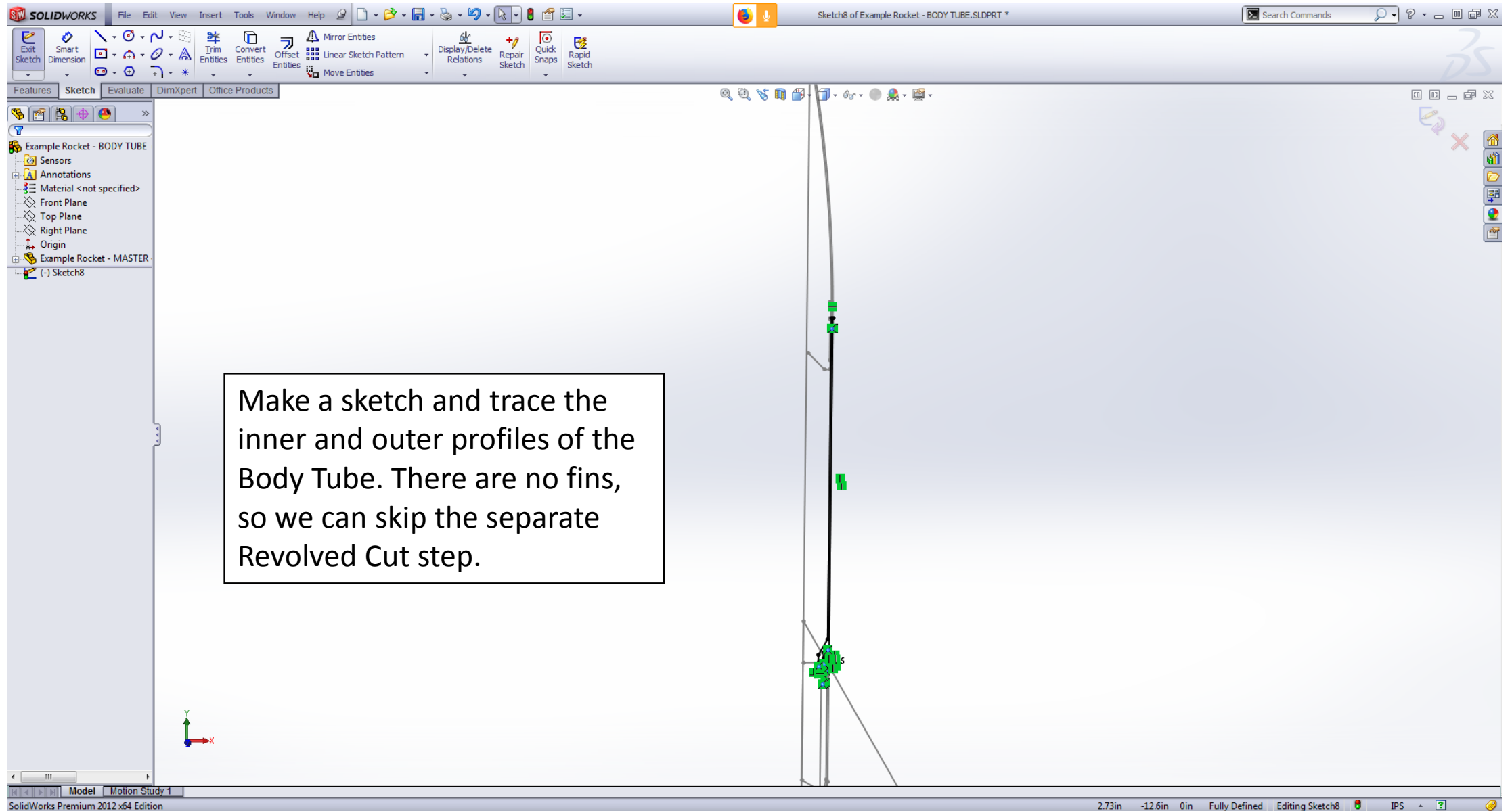
The Fin Can is done

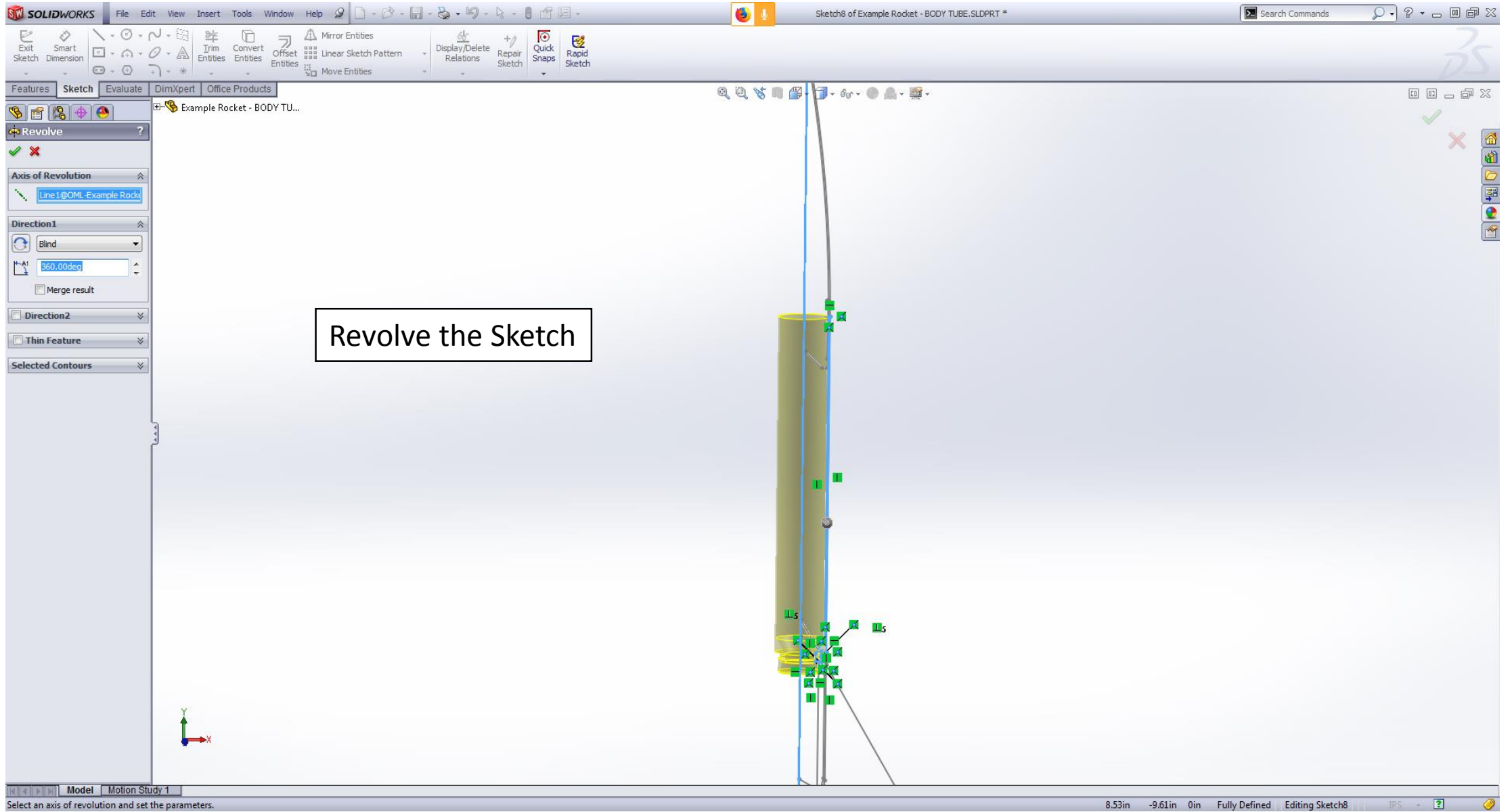


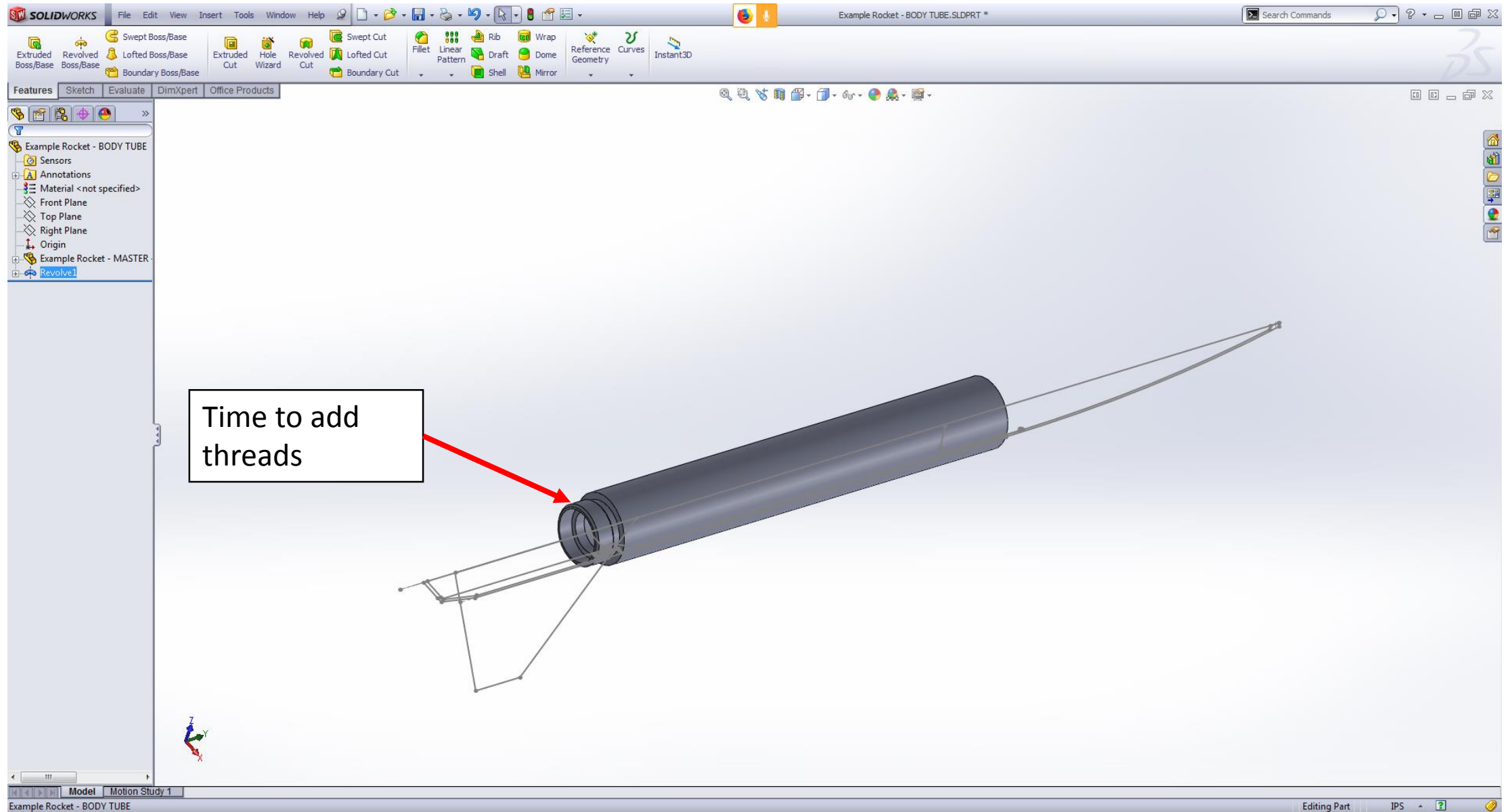


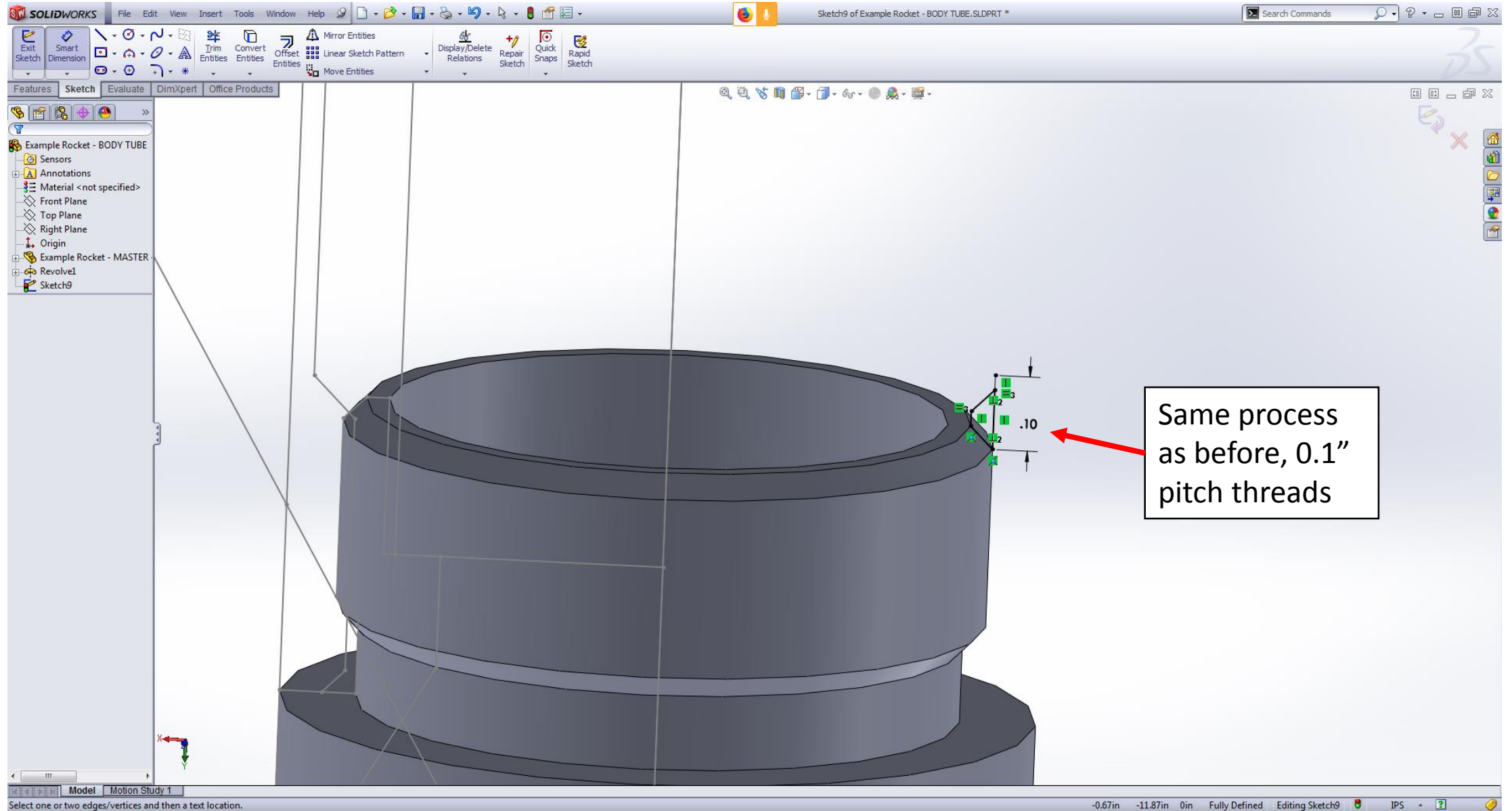


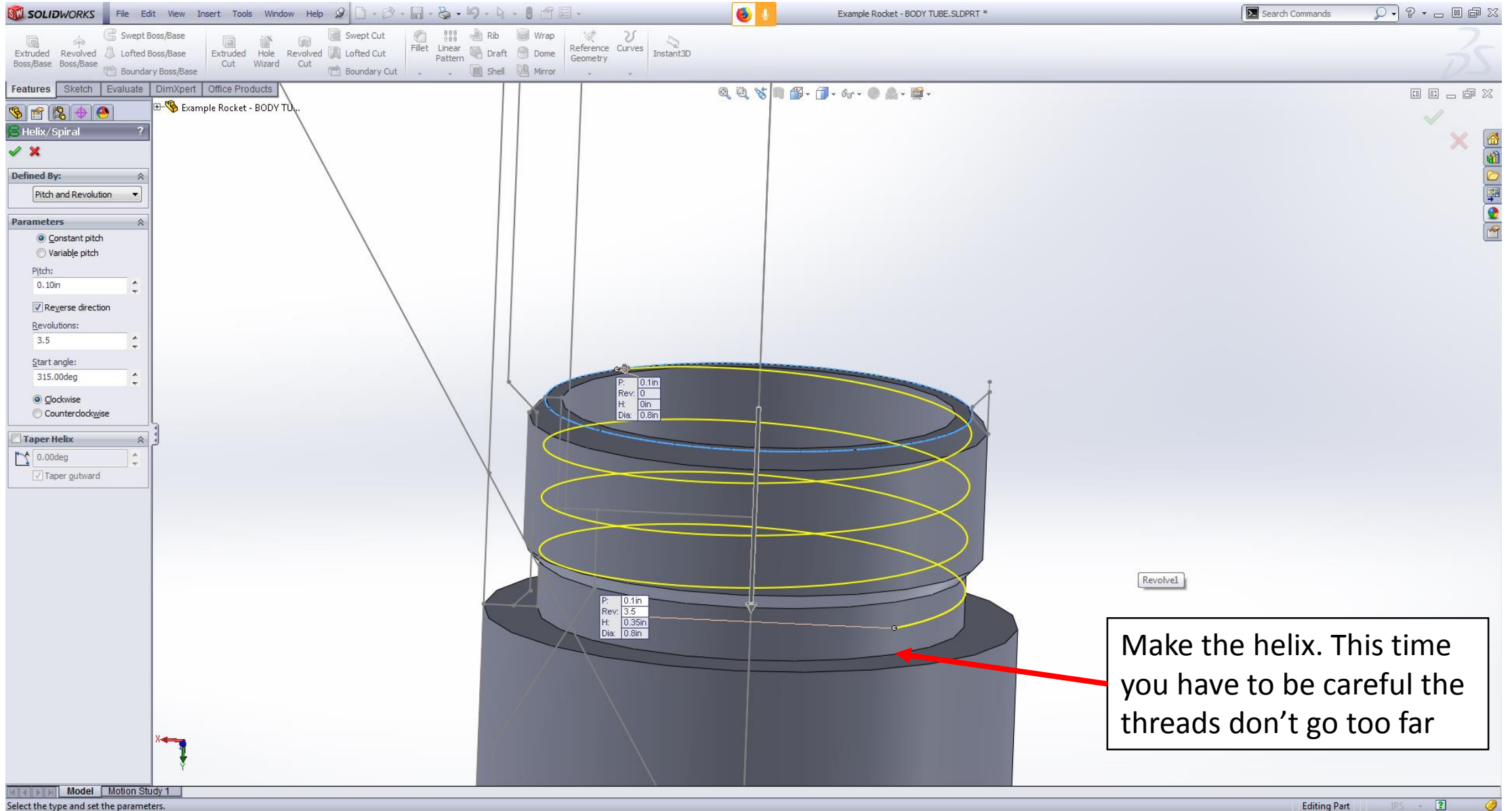
Insert the Master file like before

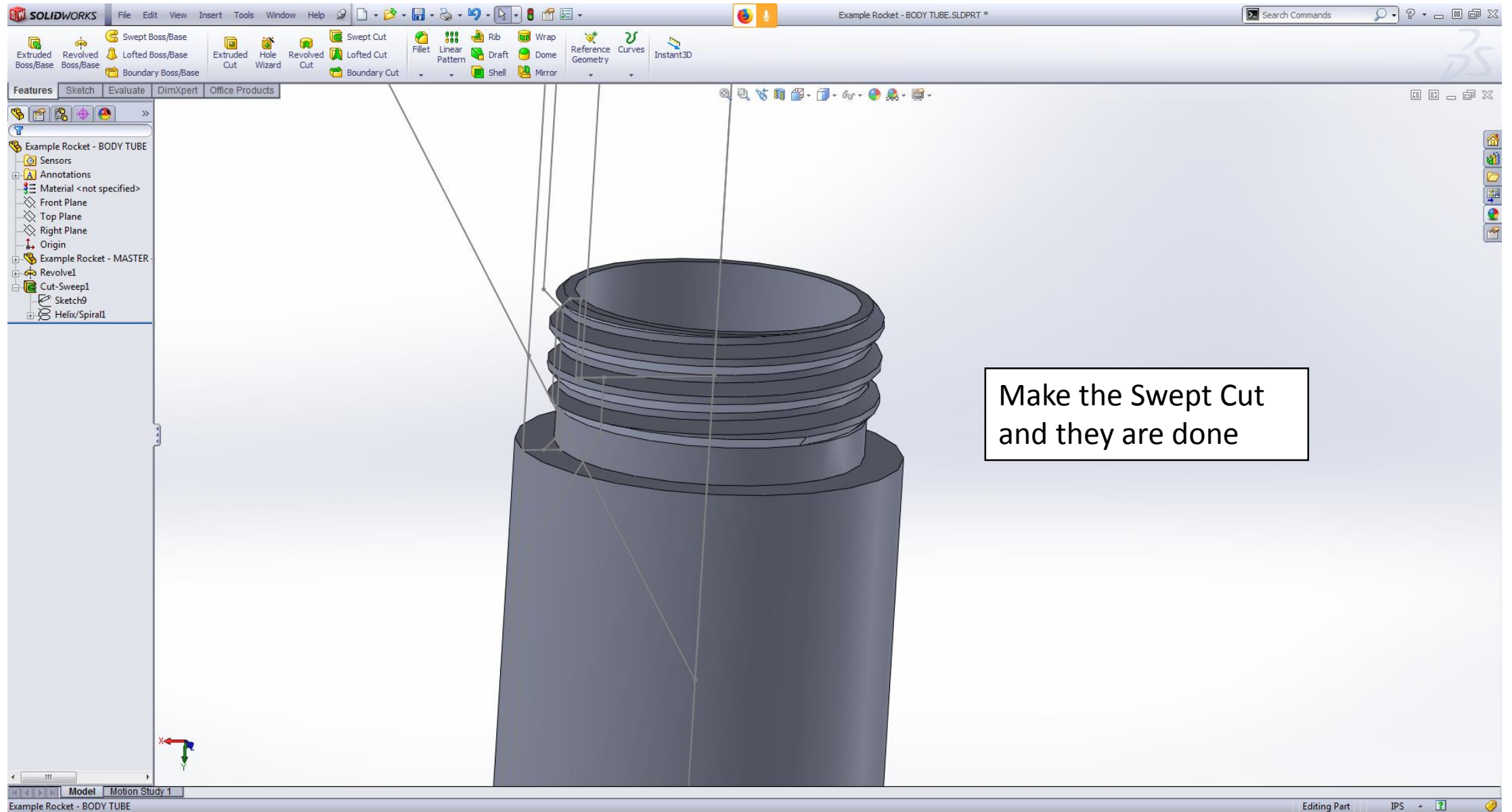


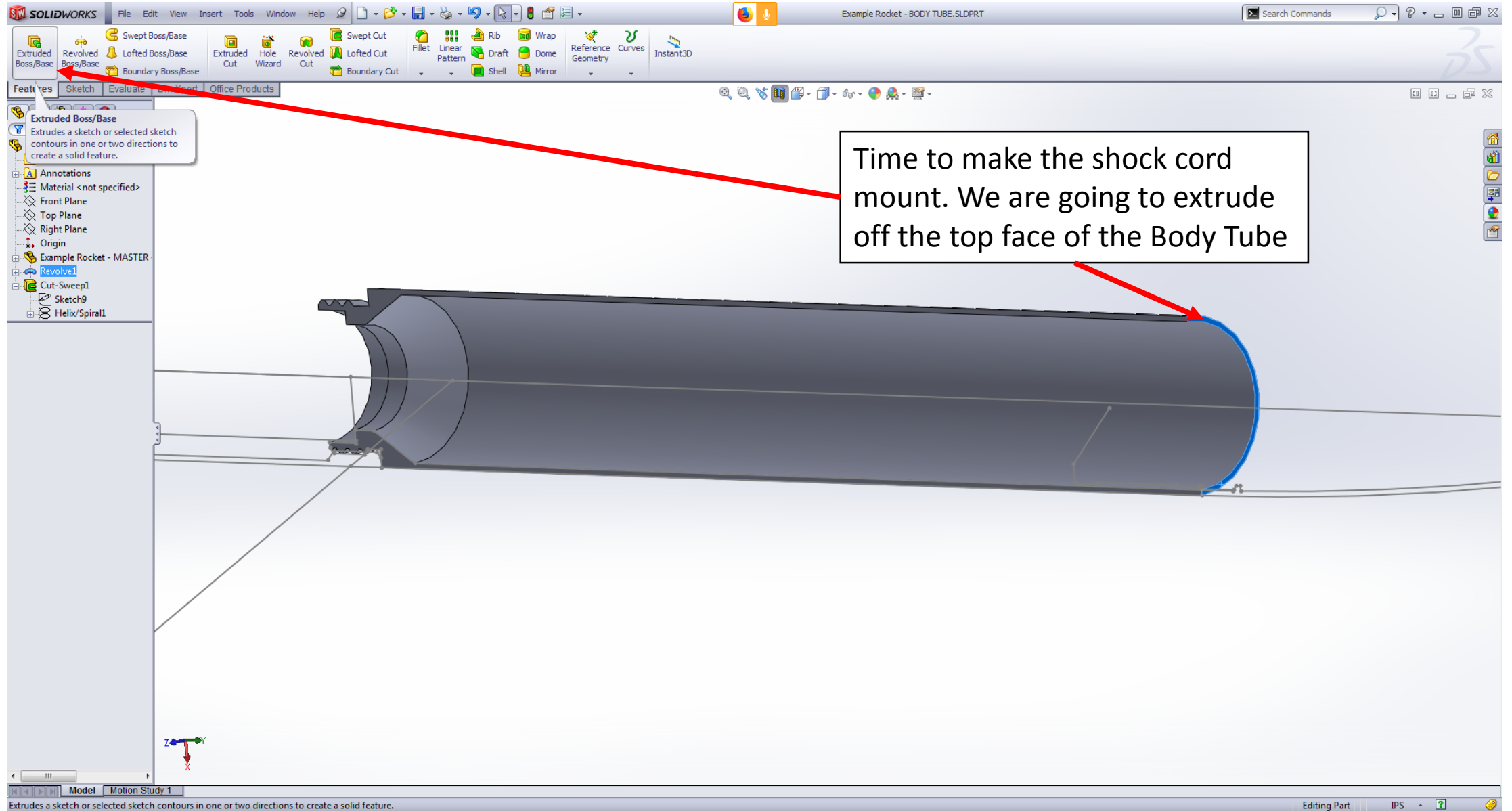






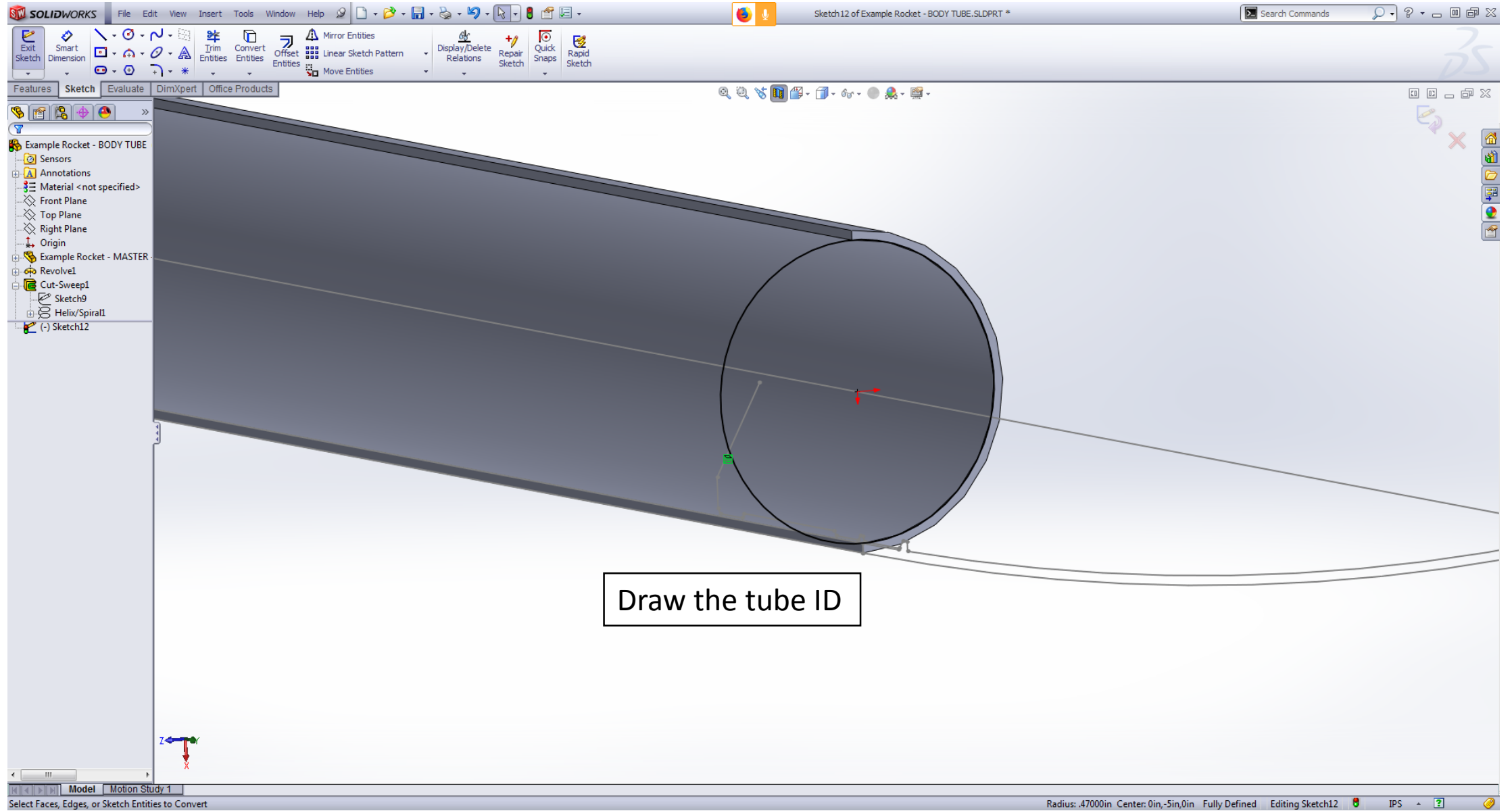


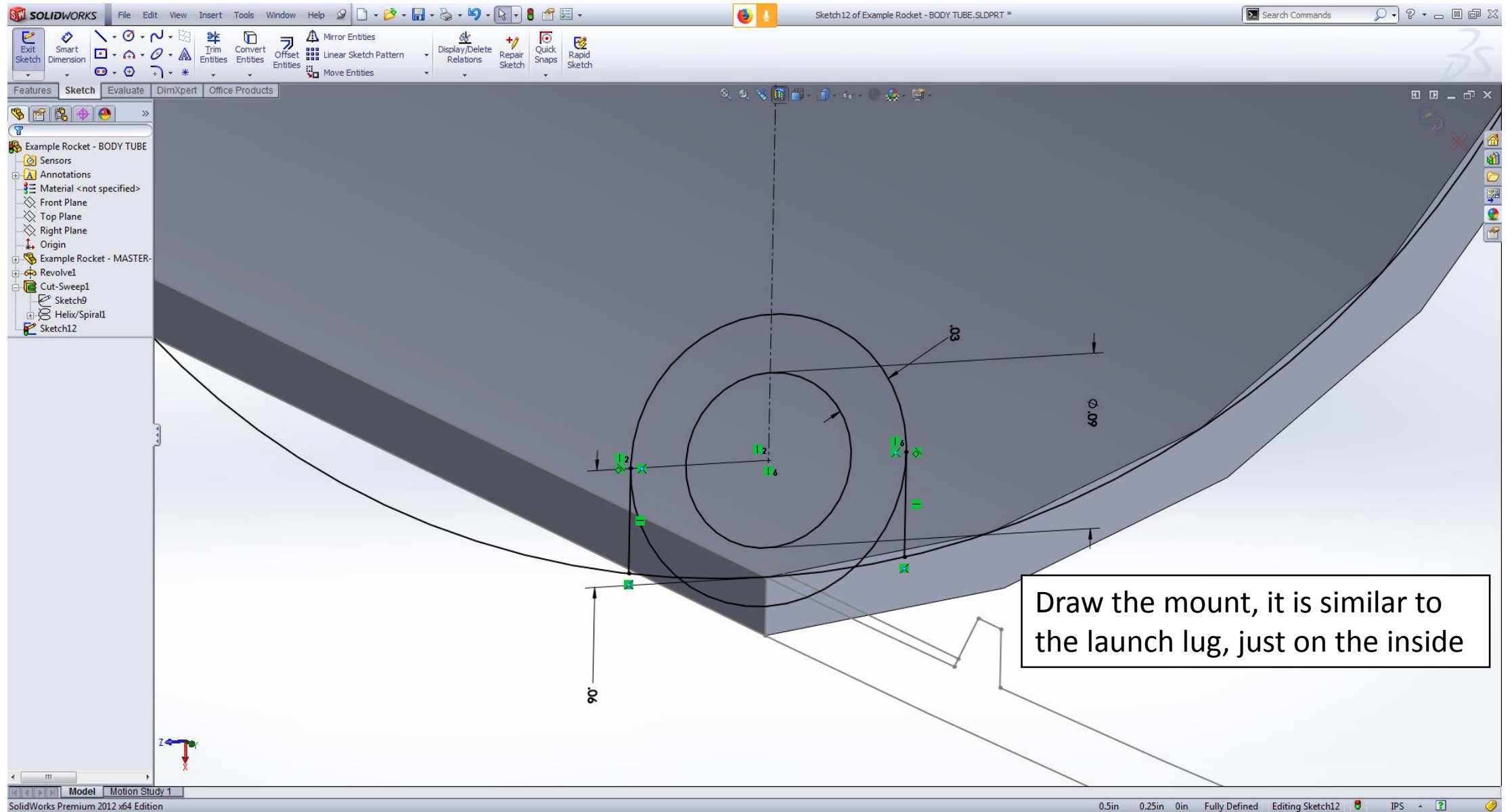


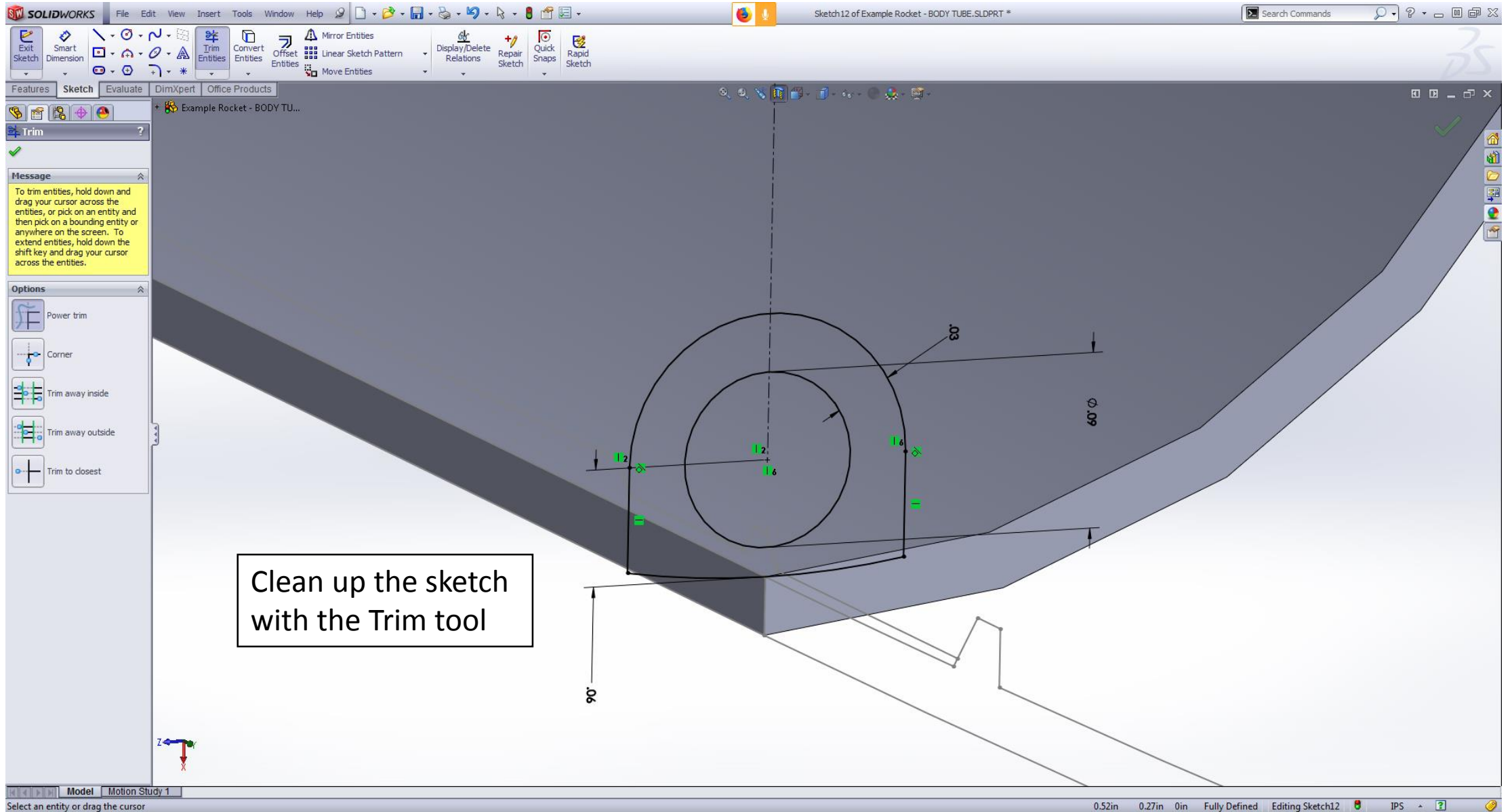


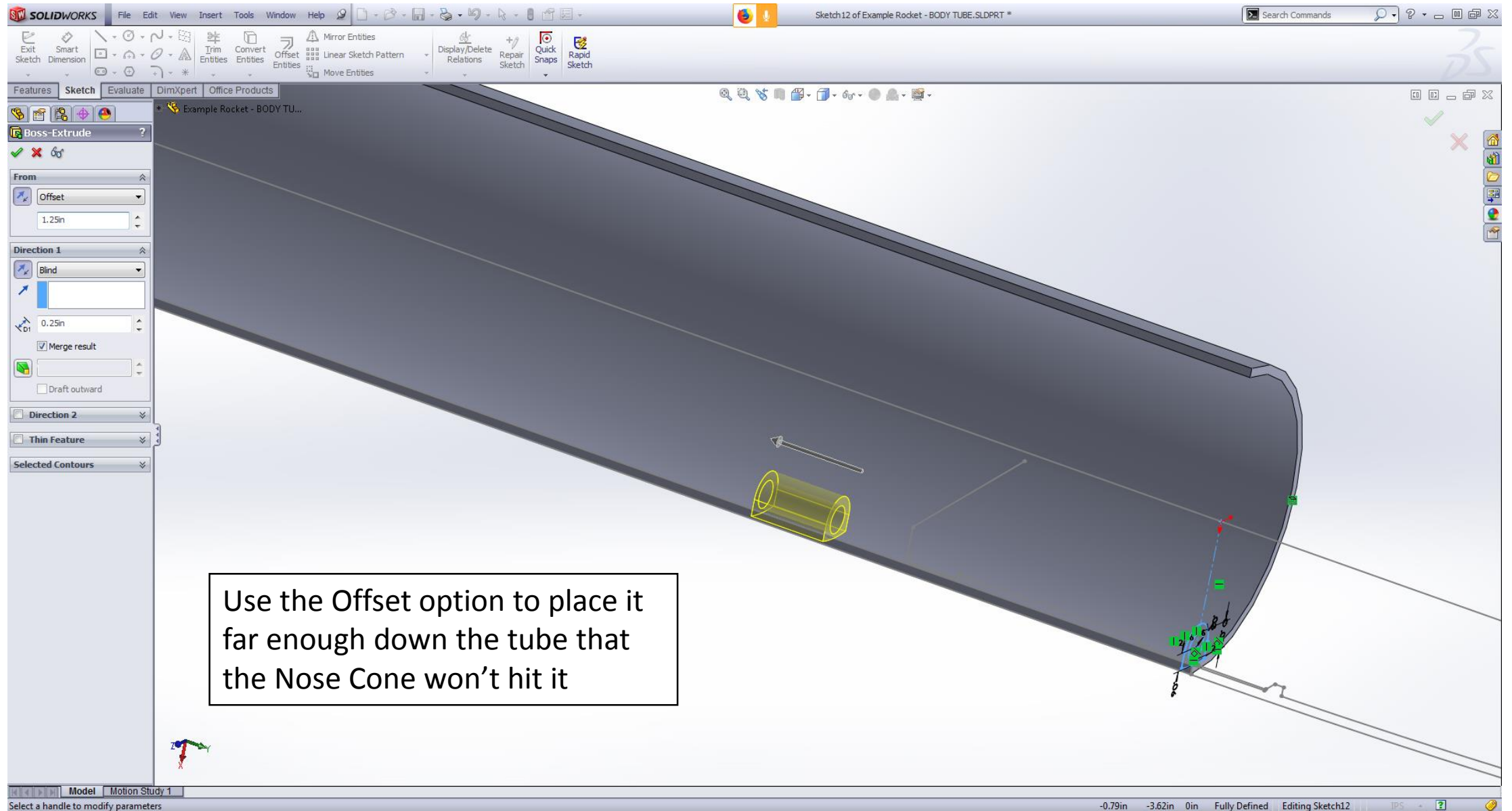
Time to make the shock cord mount. We are going to extrude off the top face of the Body Tube

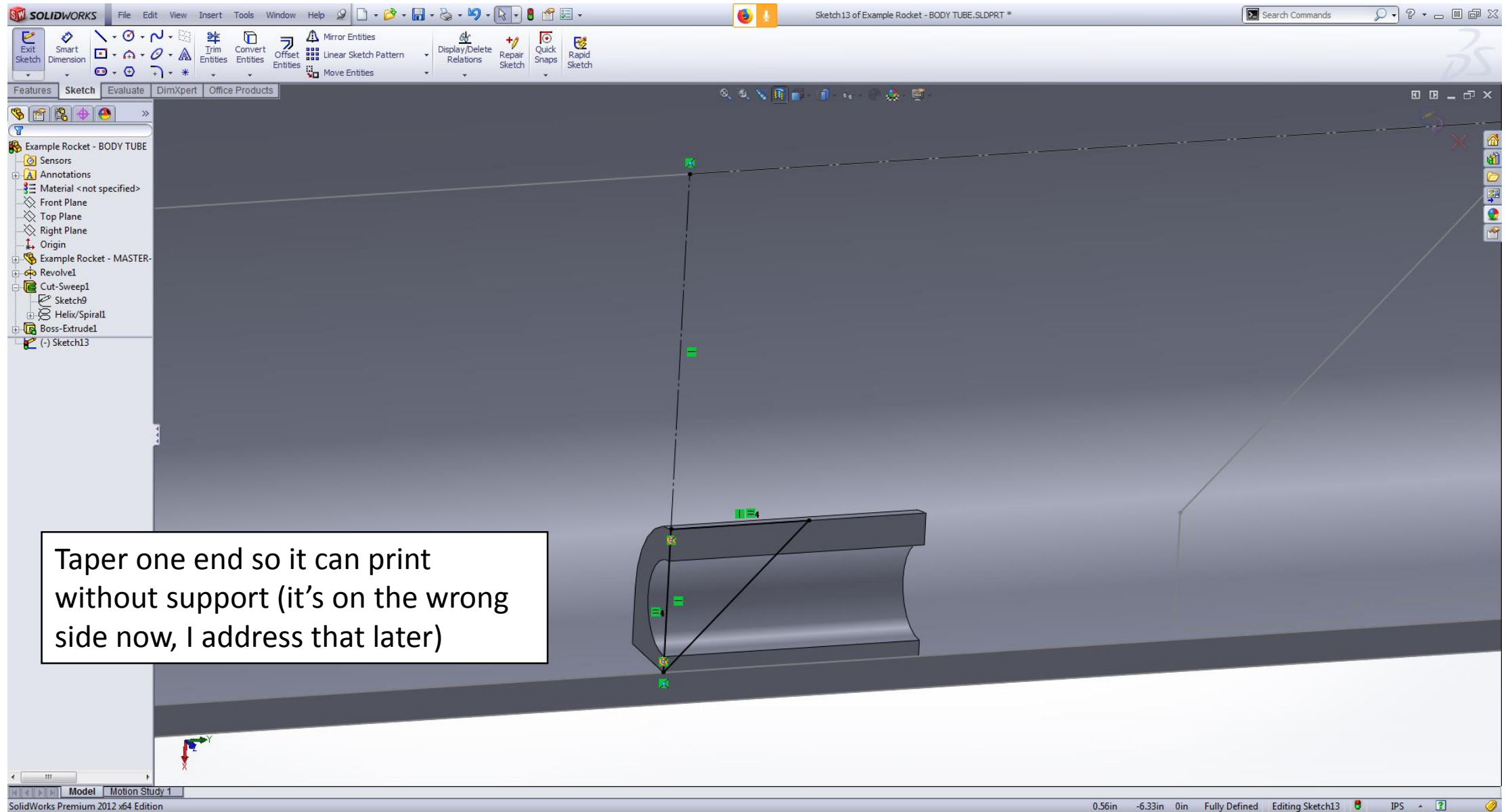




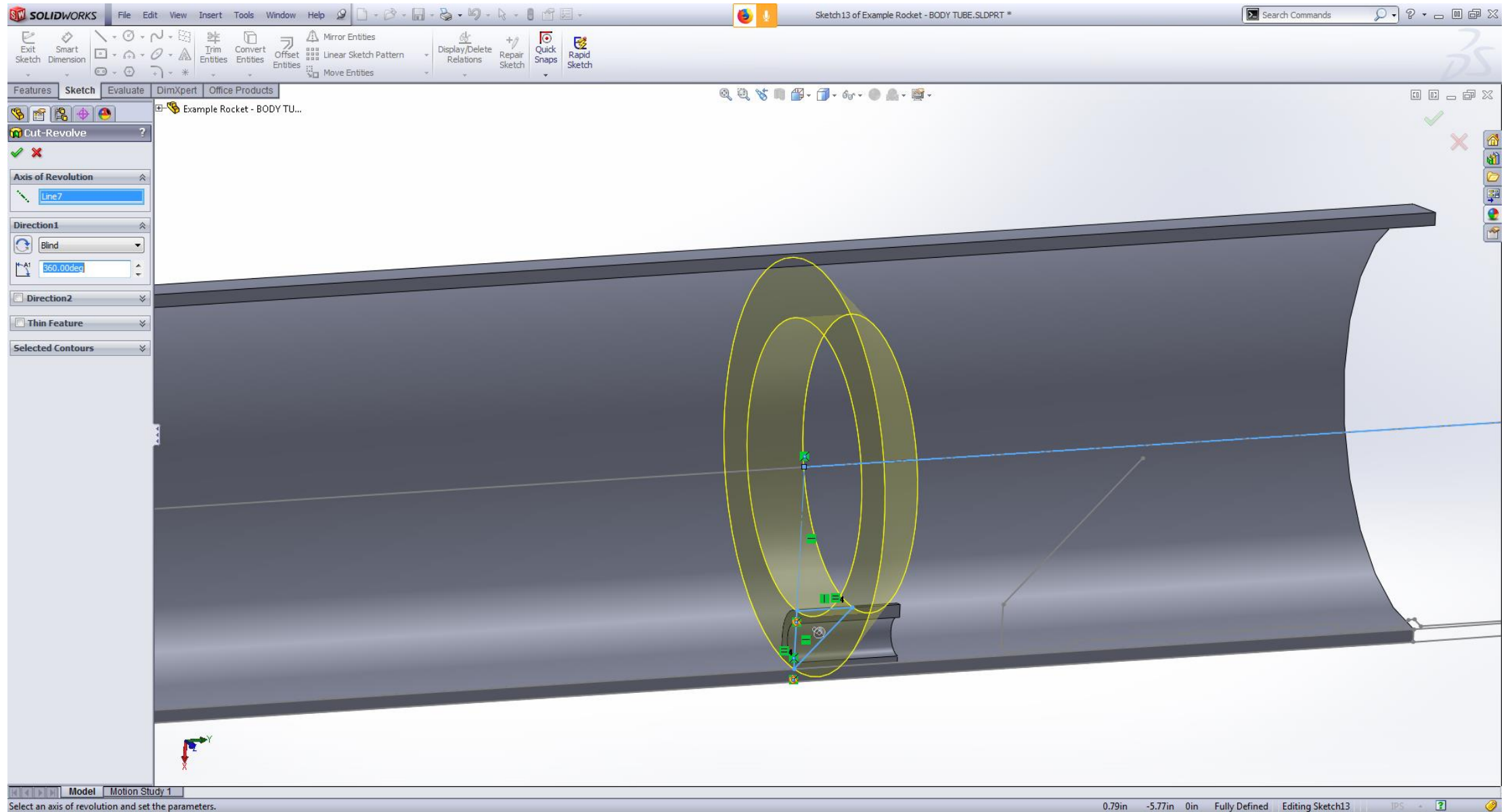


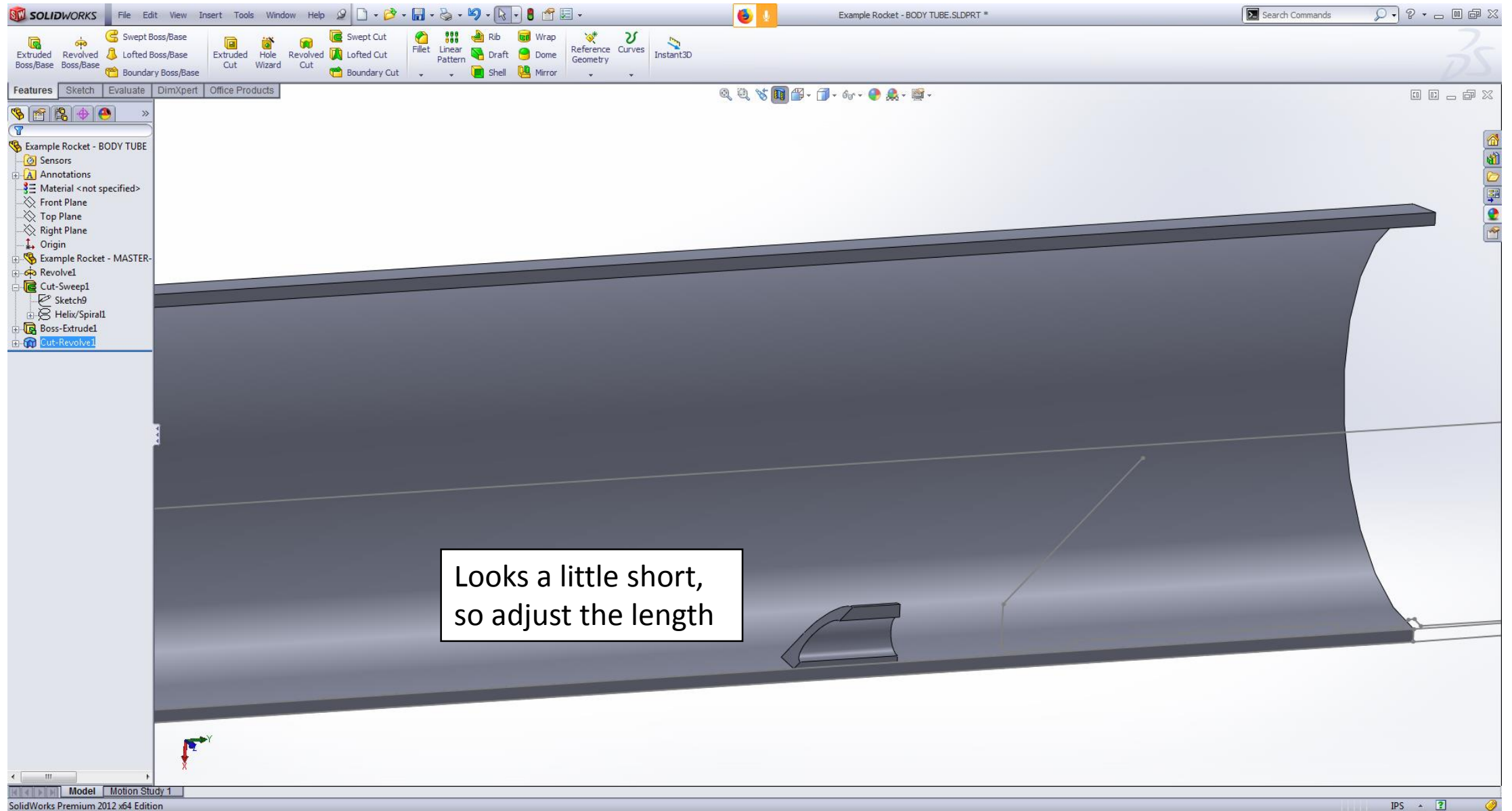


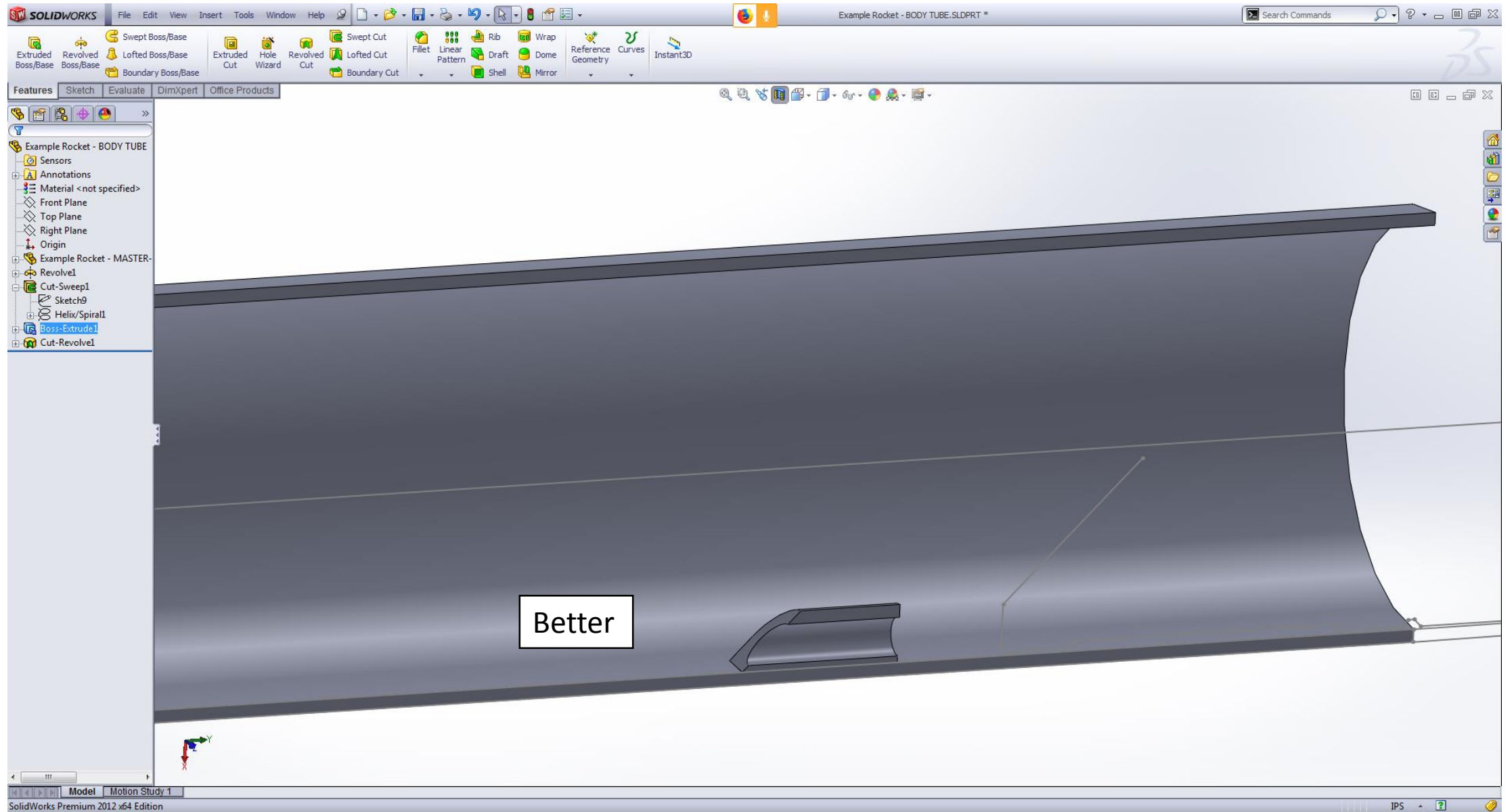




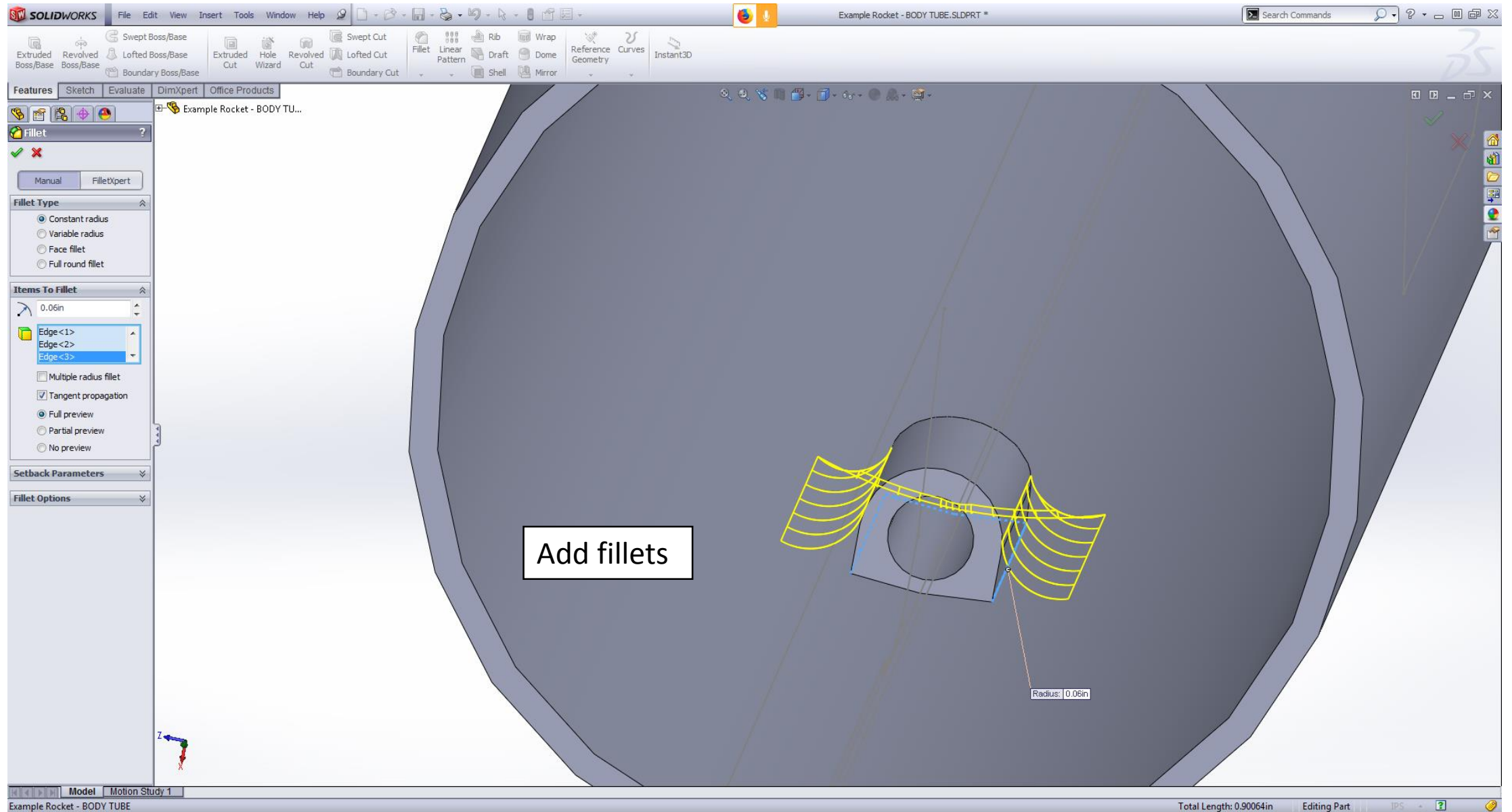
Taper one end so it can print without support (it's on the wrong side now, I address that later)

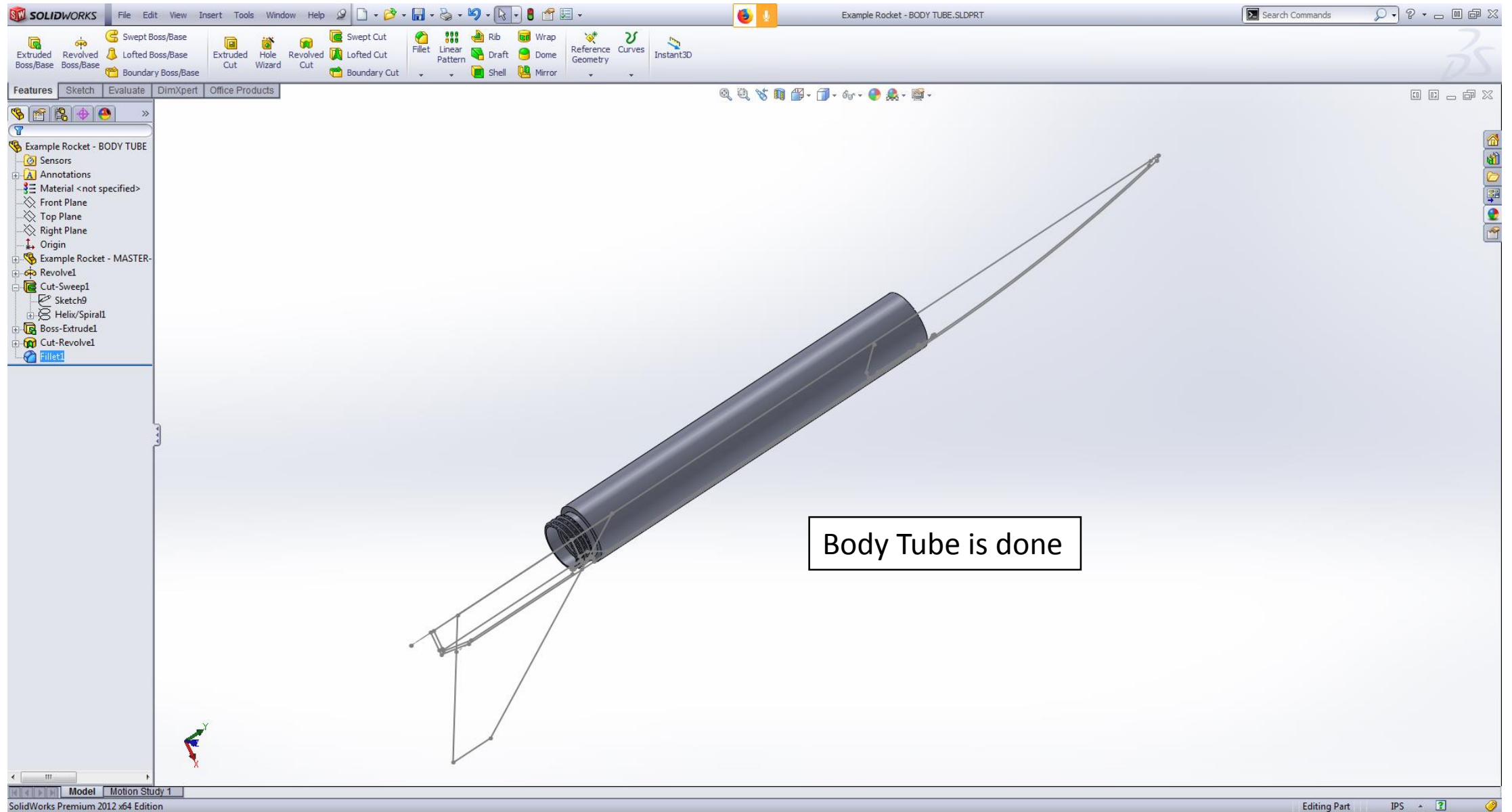


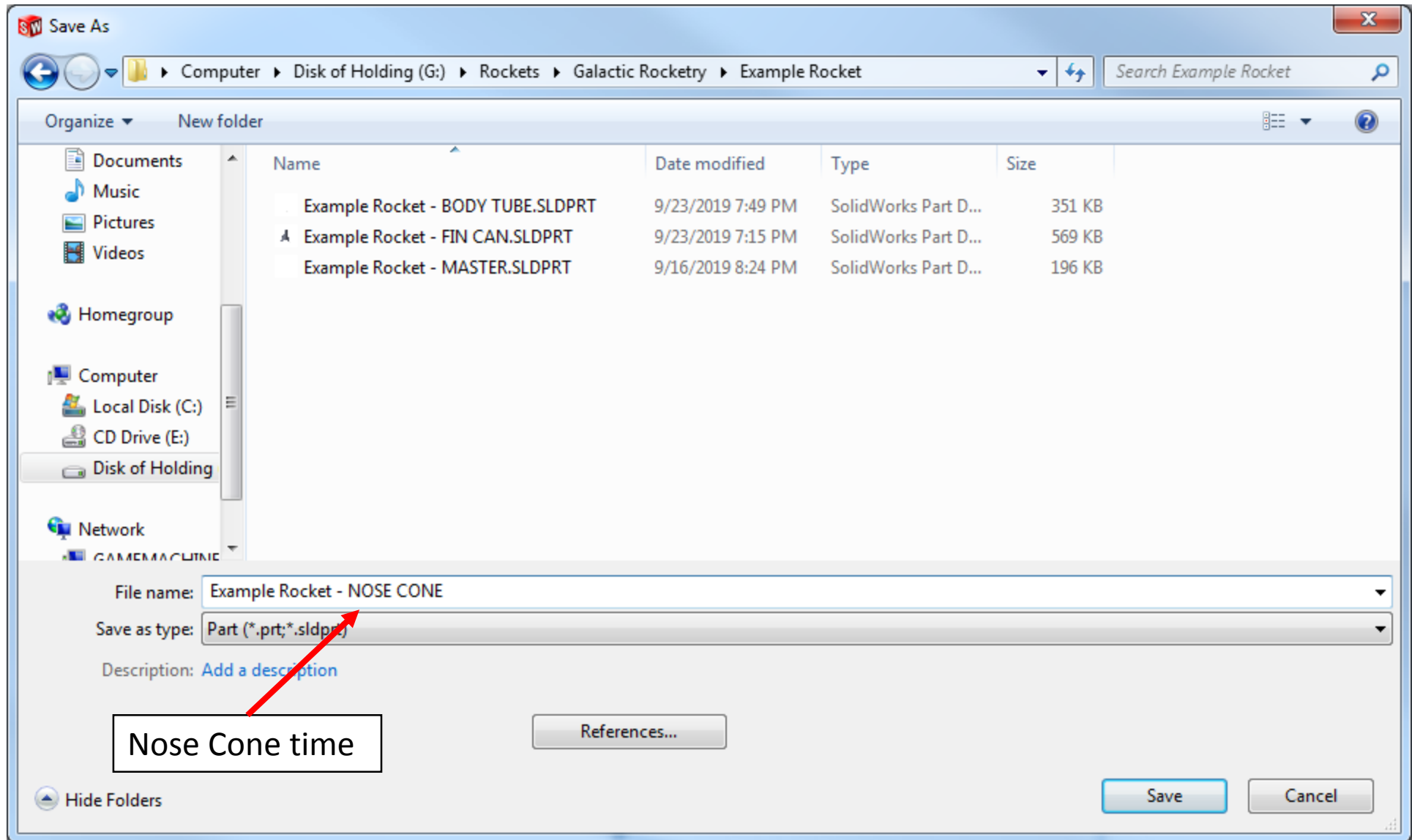


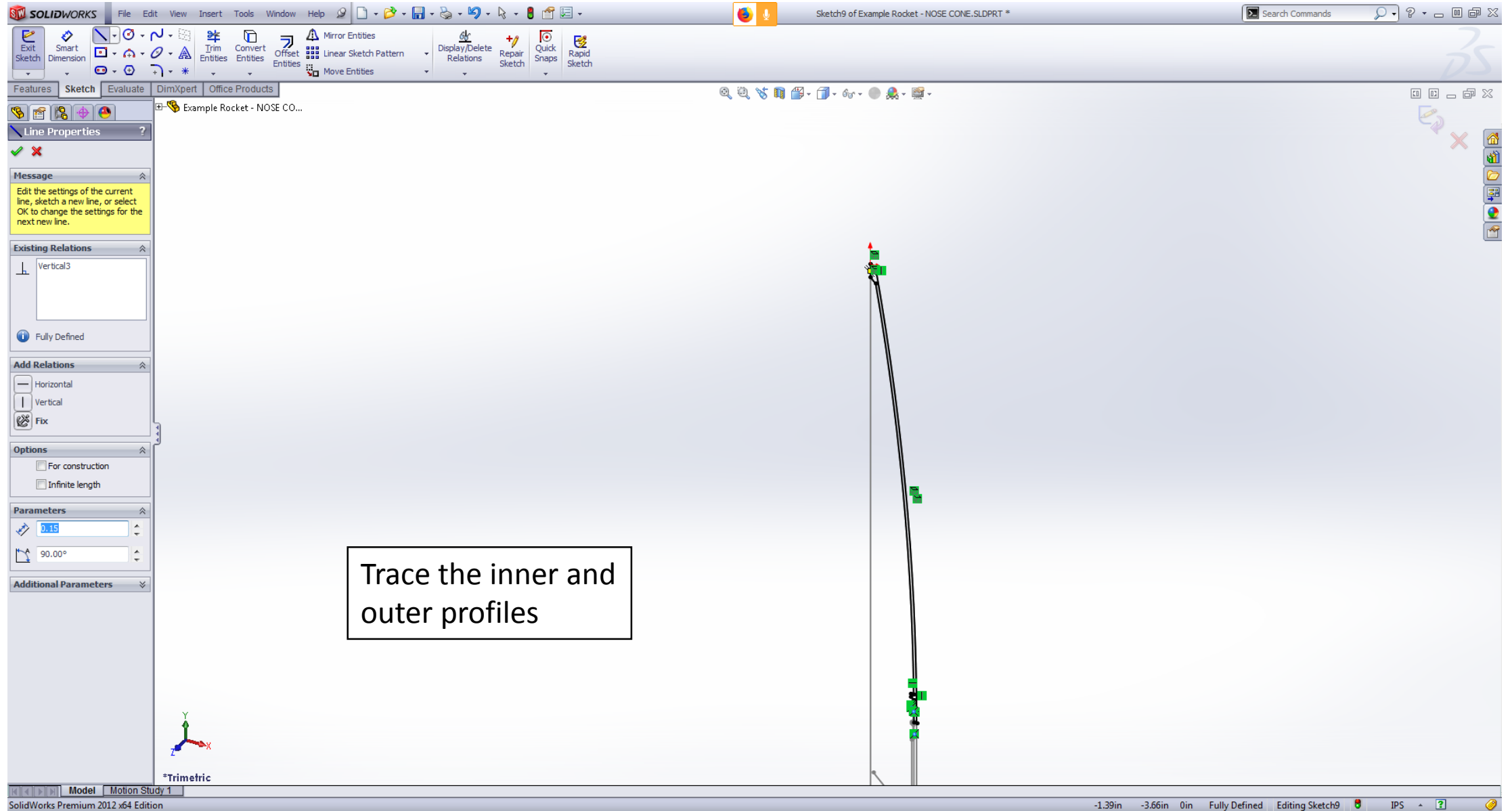












Trace the inner and outer profiles

**Revolve** ?

Axis of Revolution  
Line1@OML-Example Rockt

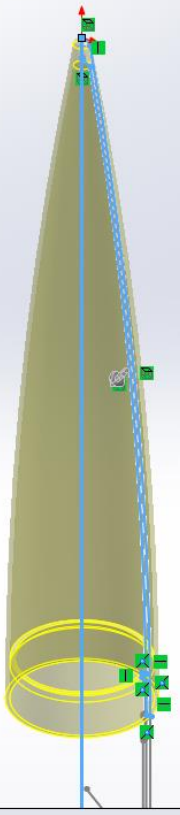
Direction1  
Blind  
360.00deg  
 Merge result

Direction2

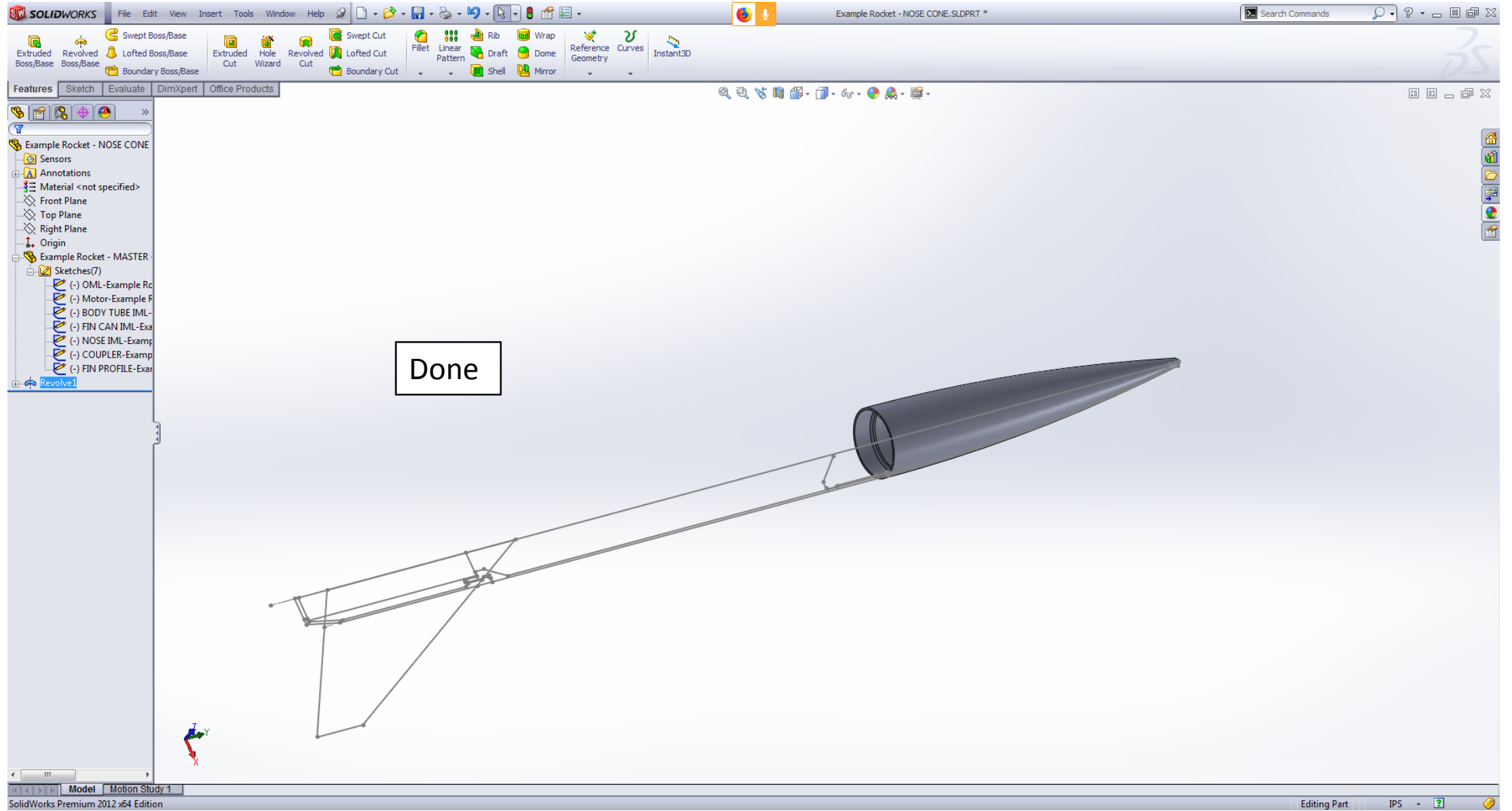
Thin Feature

Selected Contours

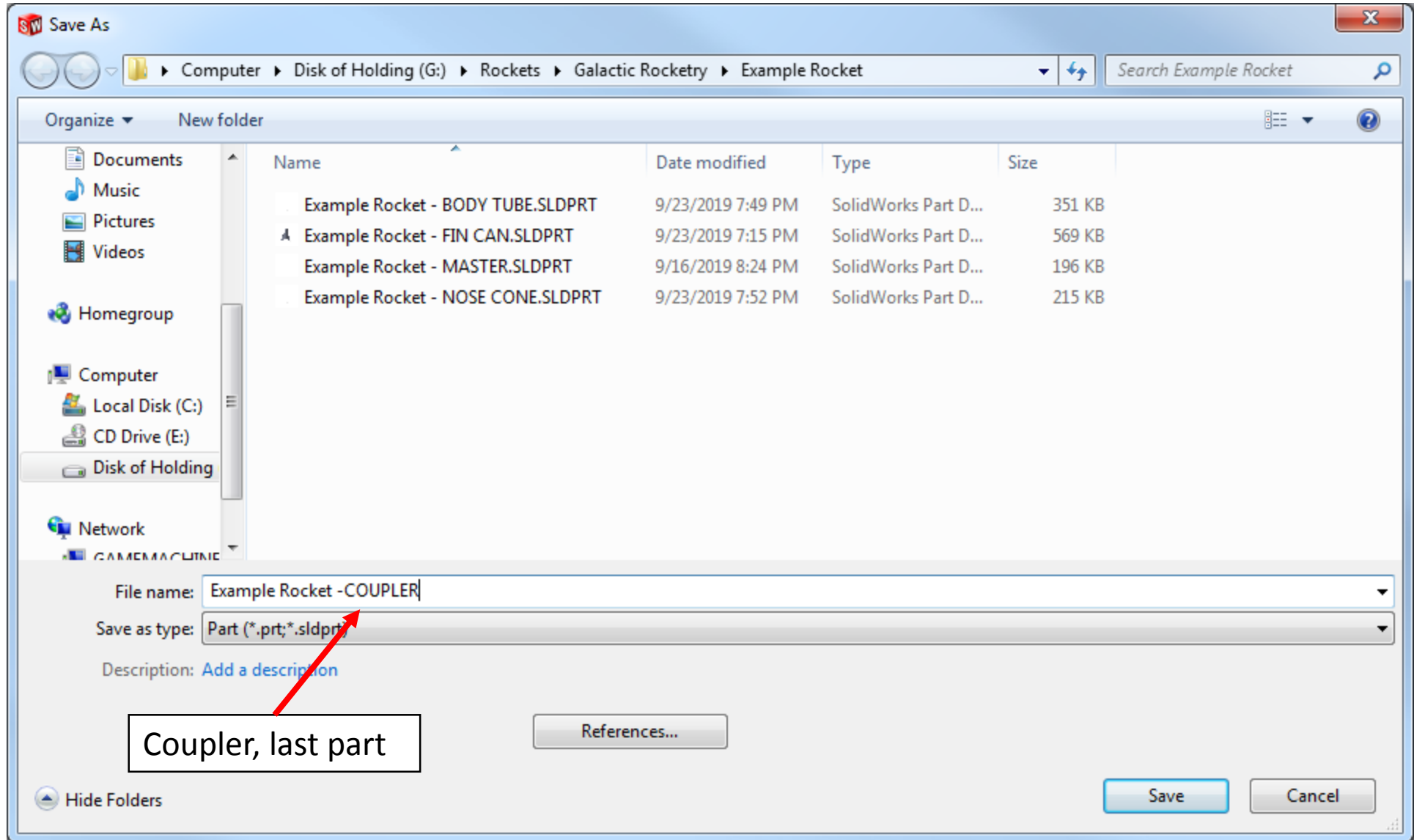
Revolve

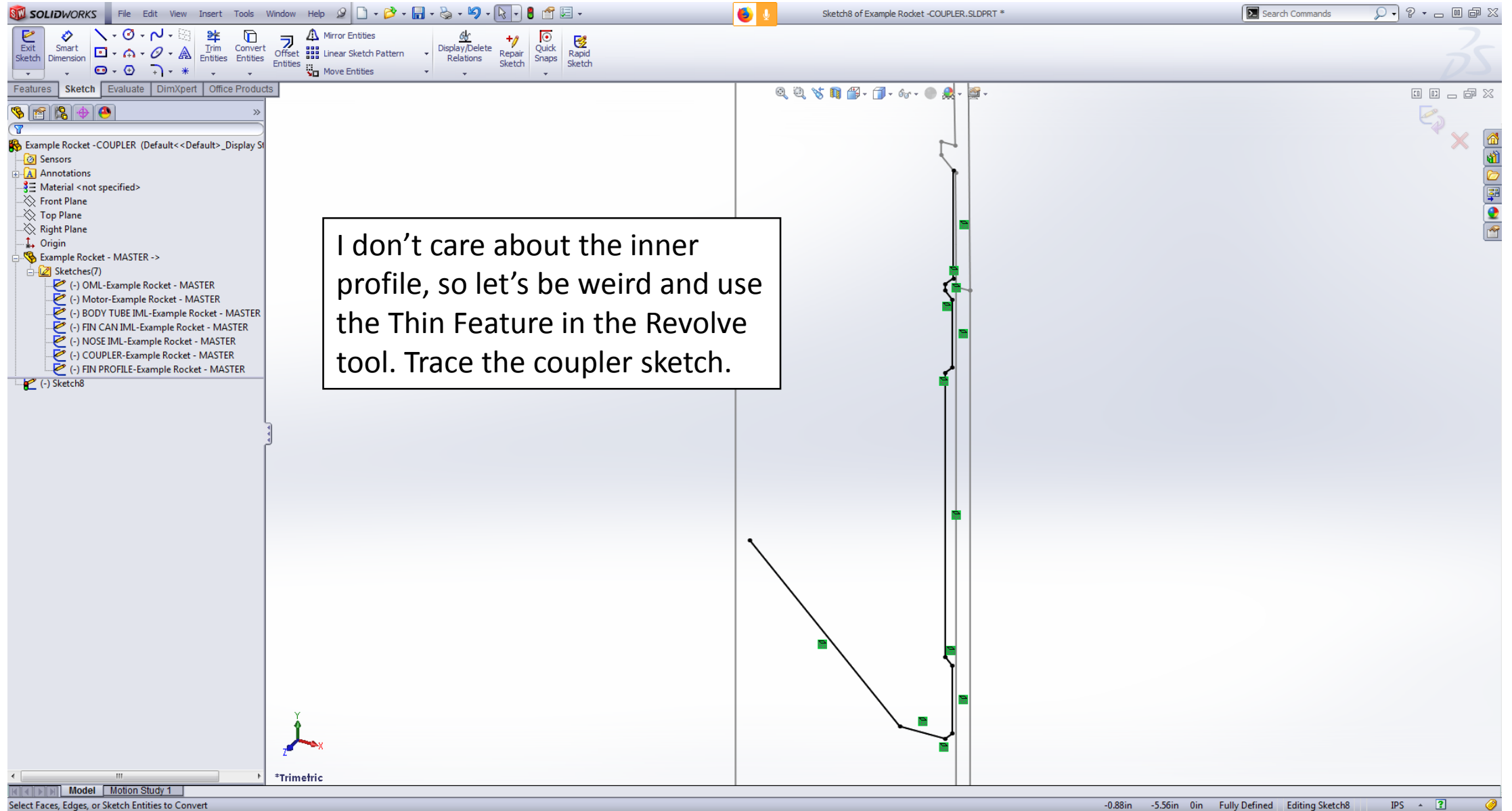


\*Trimetric



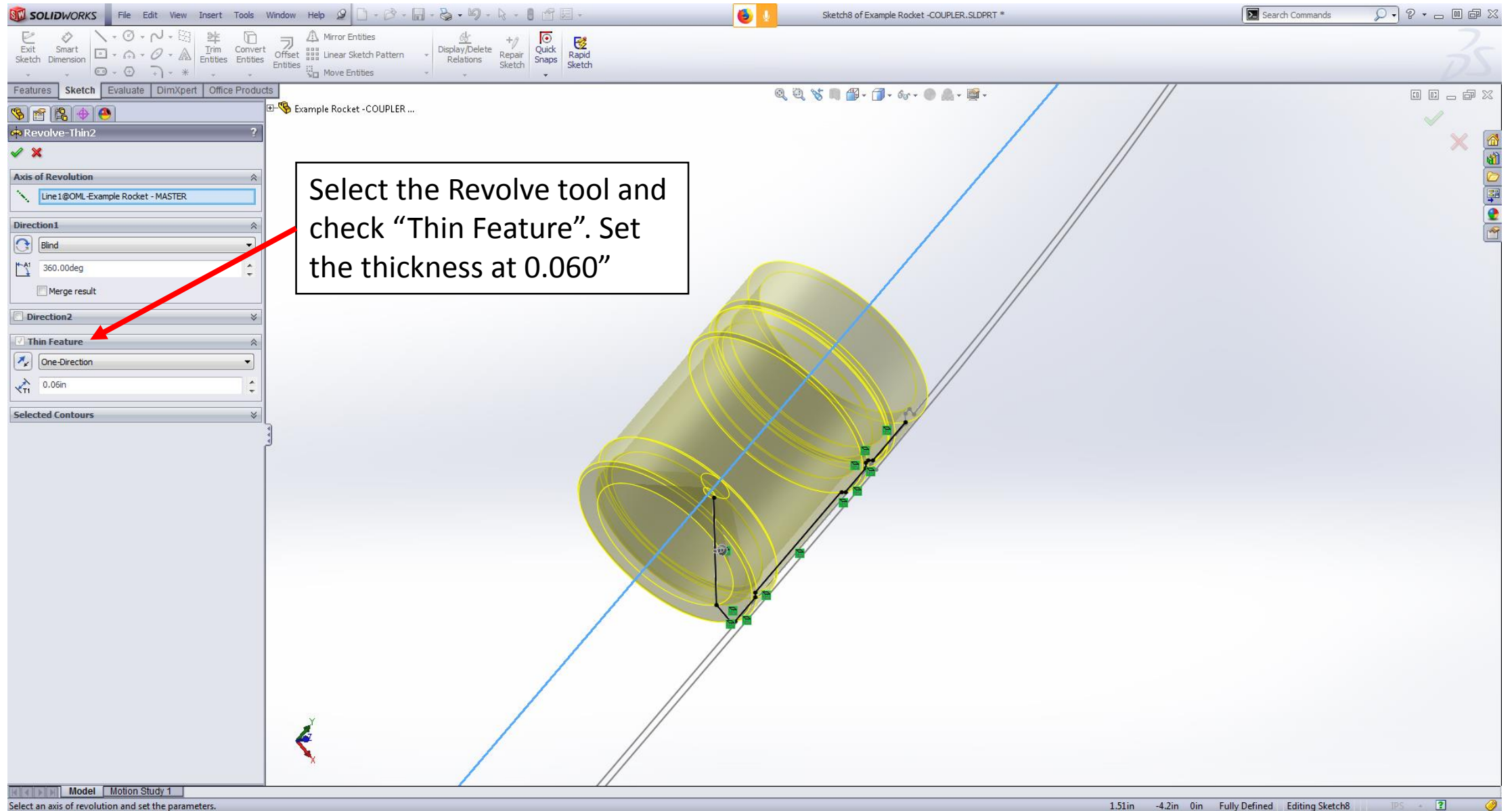
Done



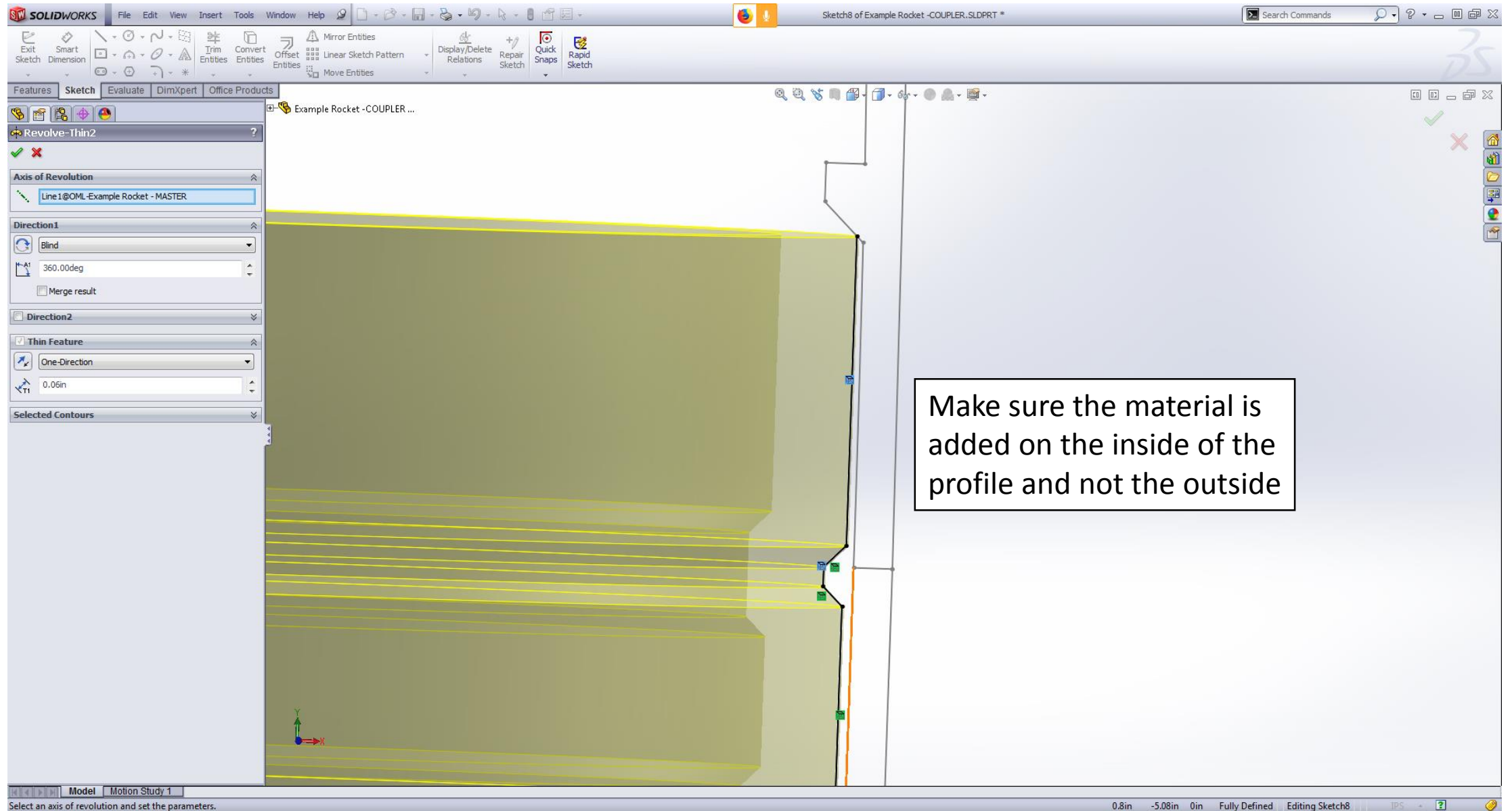


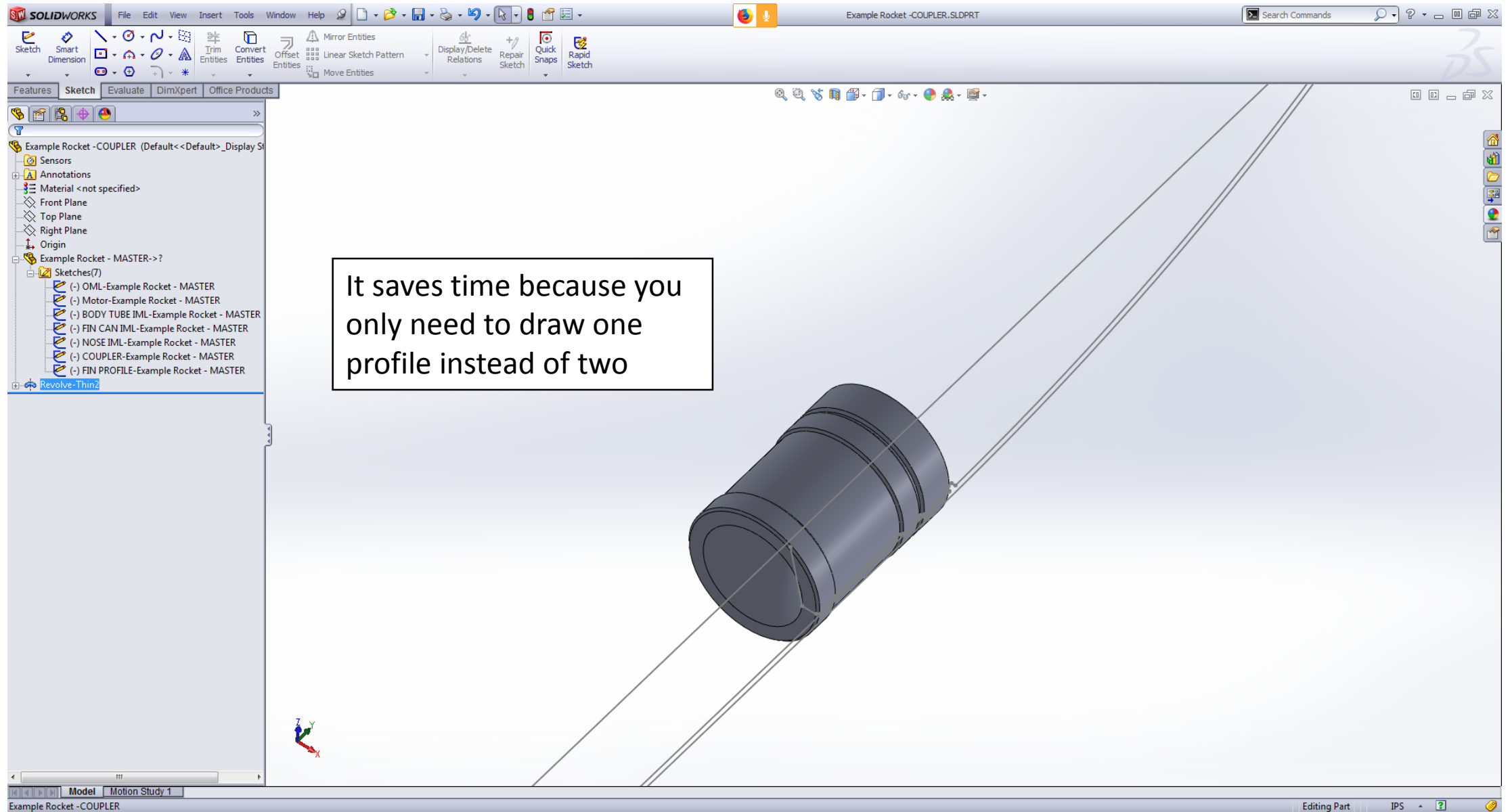
I don't care about the inner profile, so let's be weird and use the Thin Feature in the Revolve tool. Trace the coupler sketch.

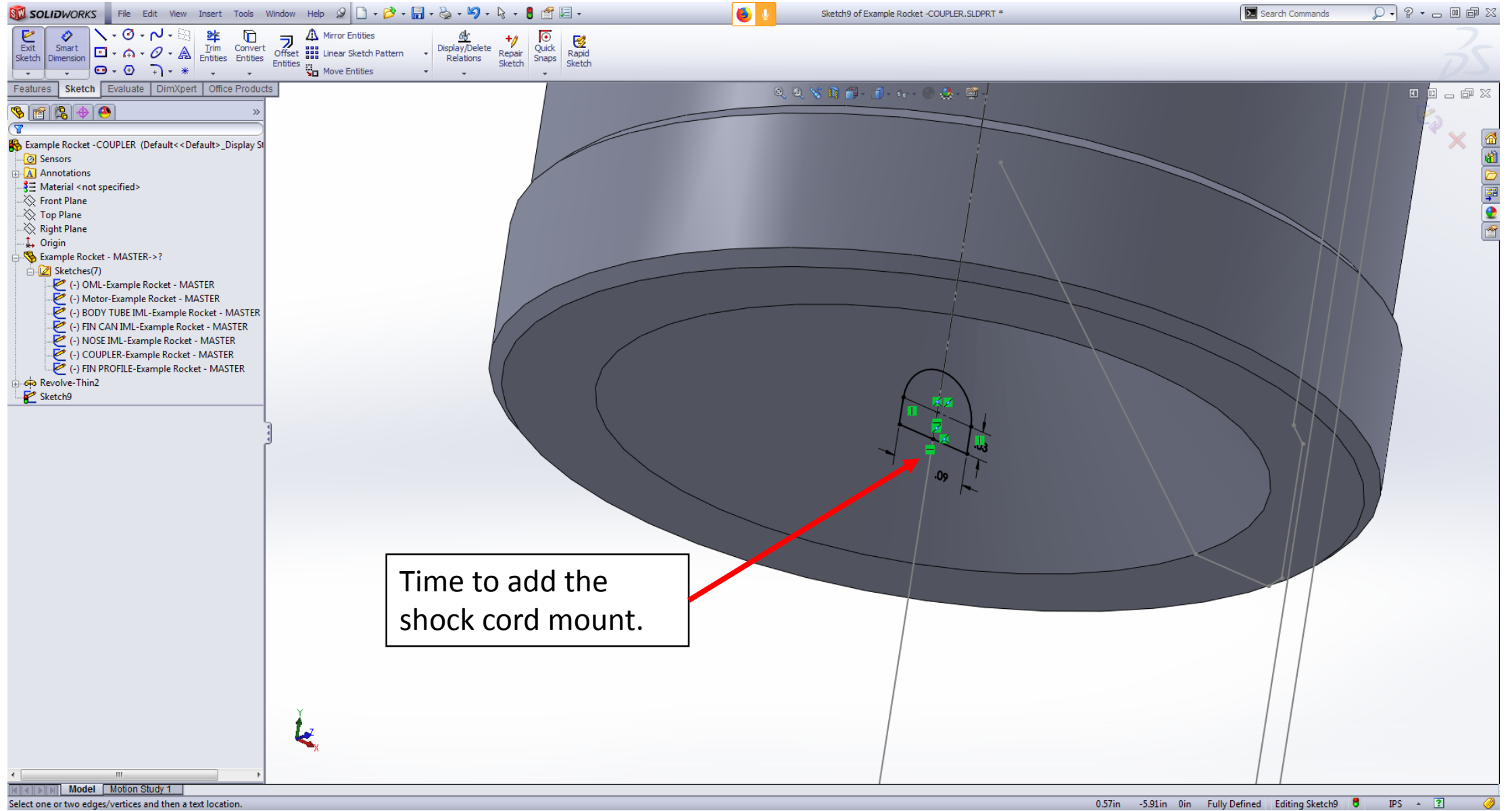




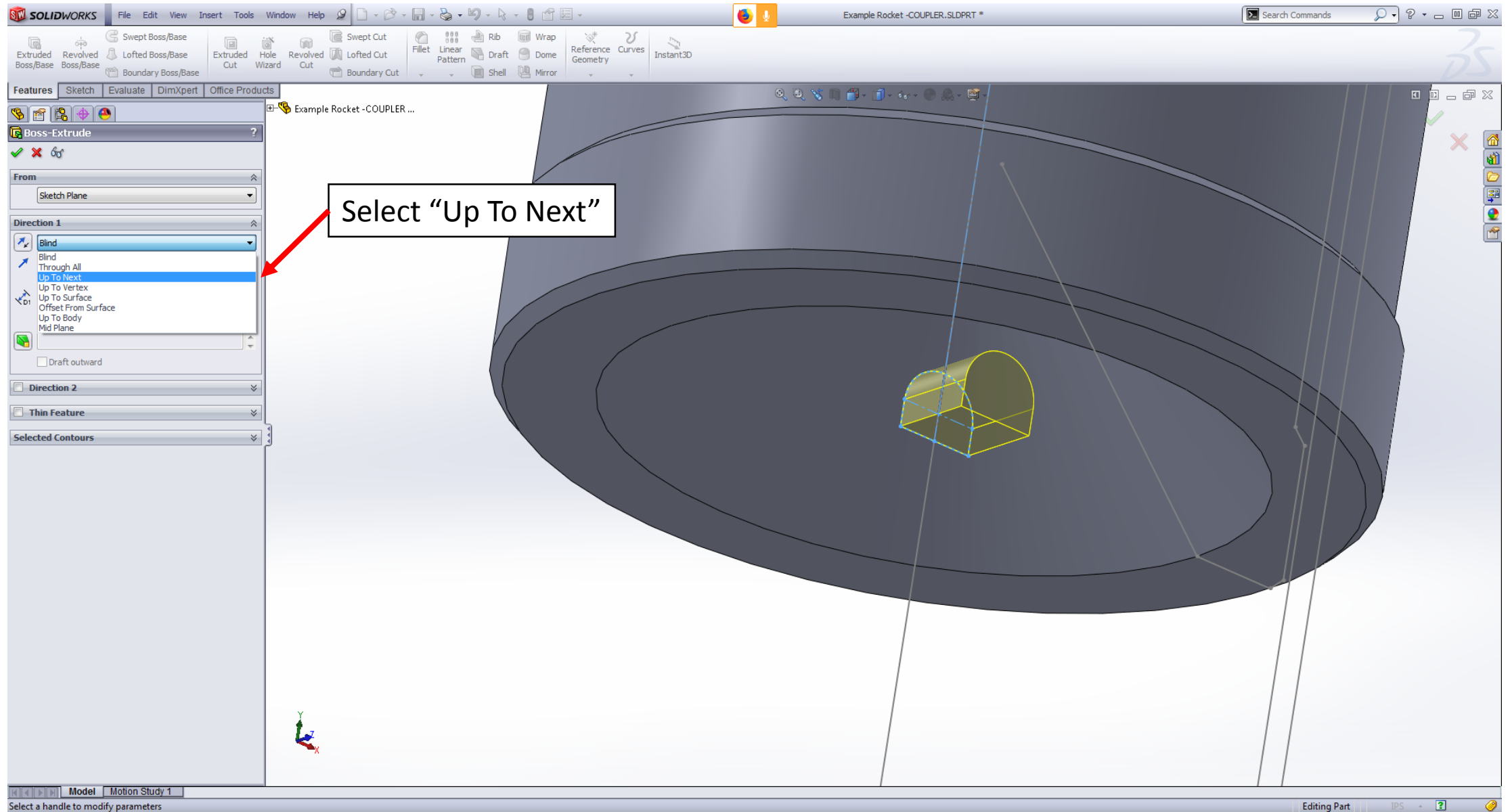
Select the Revolve tool and check "Thin Feature". Set the thickness at 0.060"



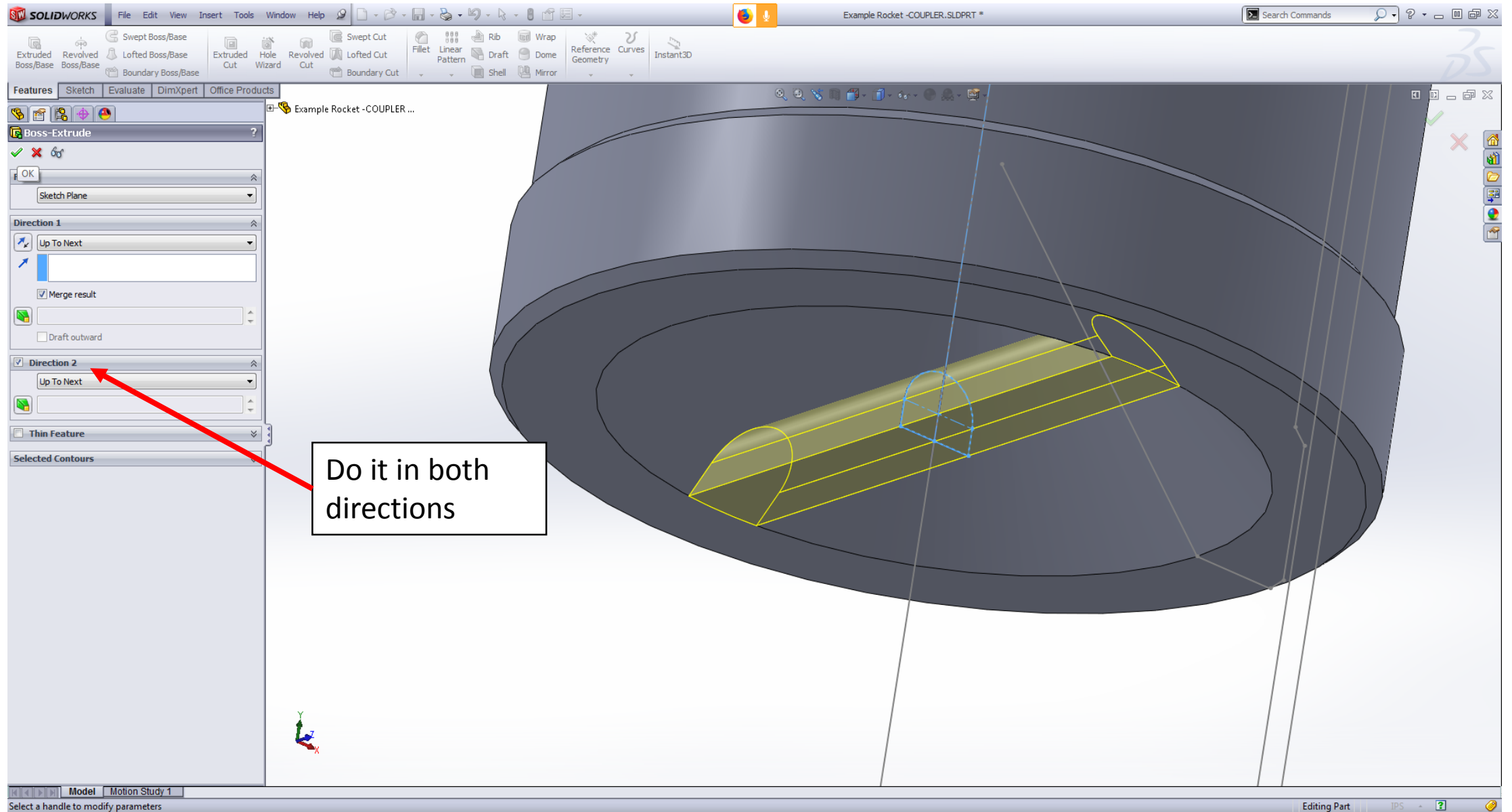


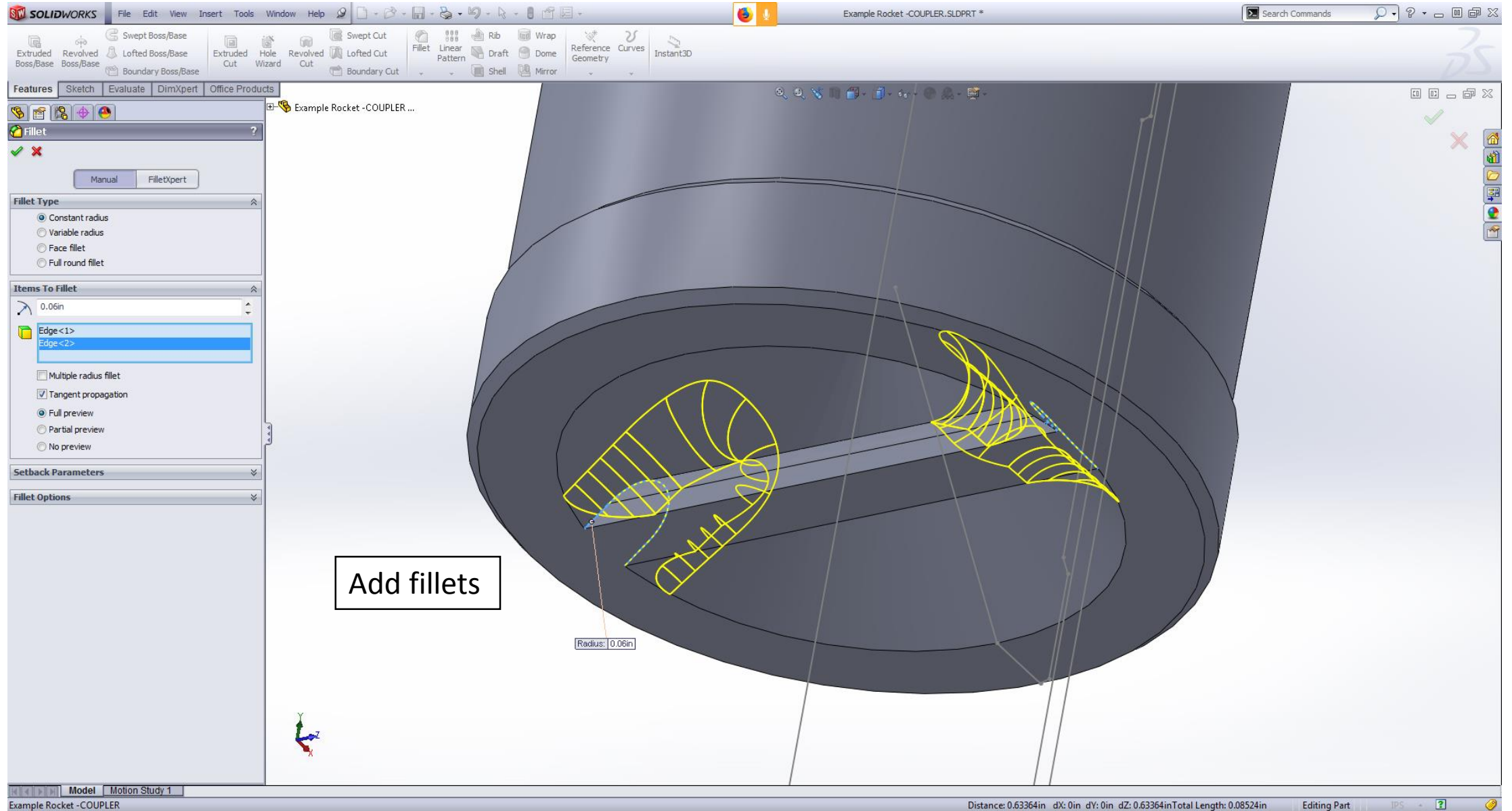


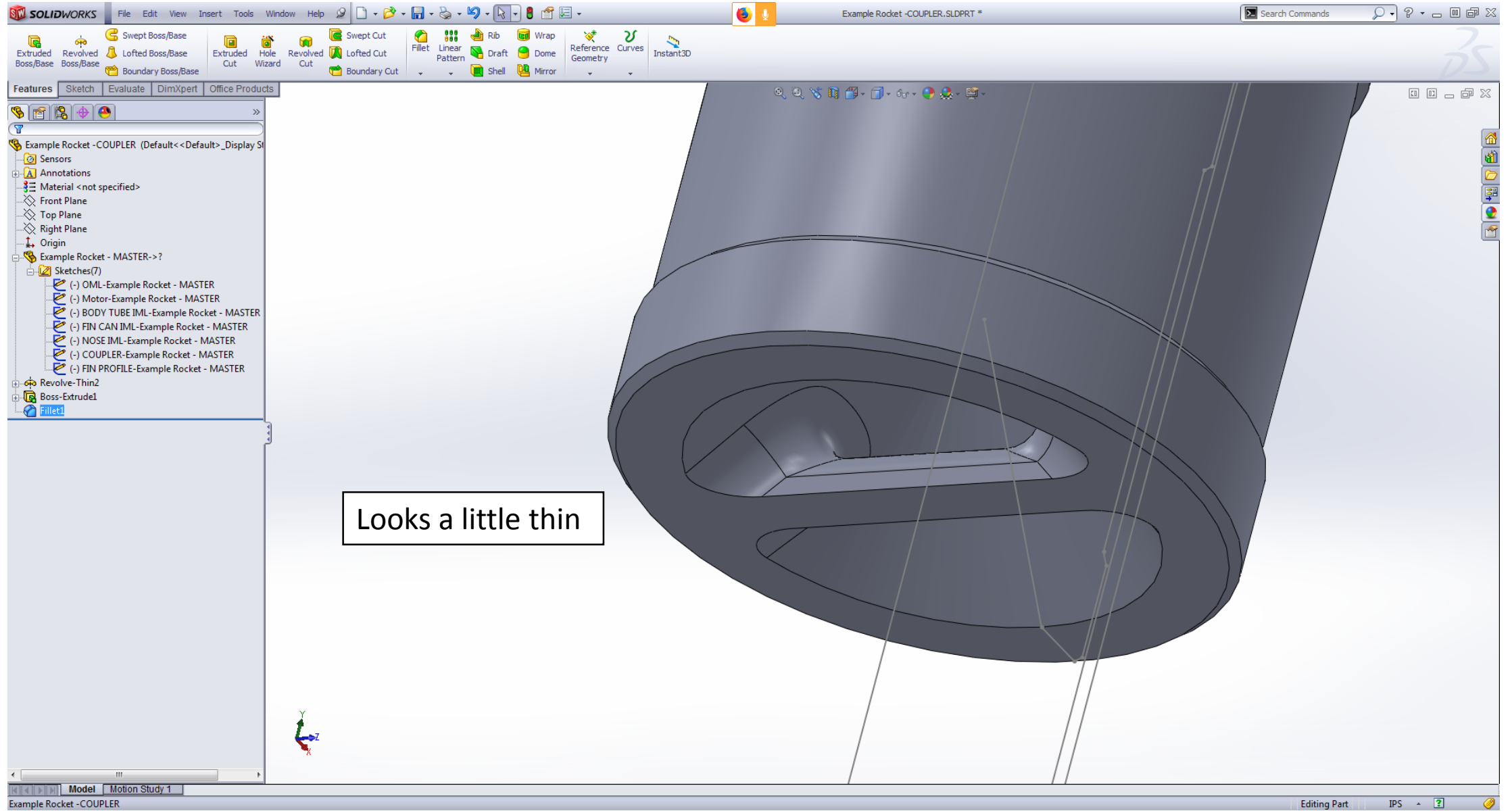
Time to add the shock cord mount.



Select "Up To Next"

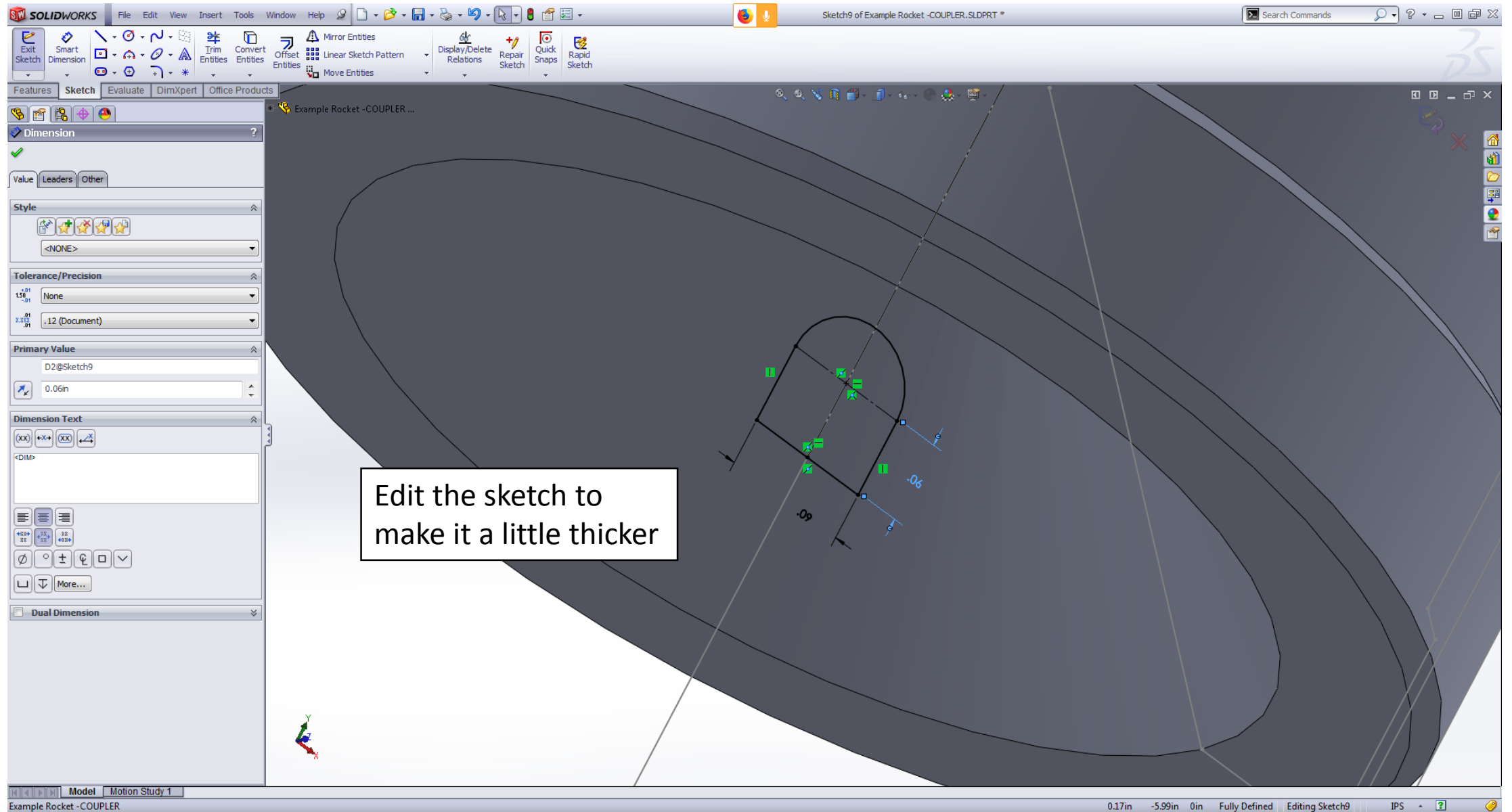


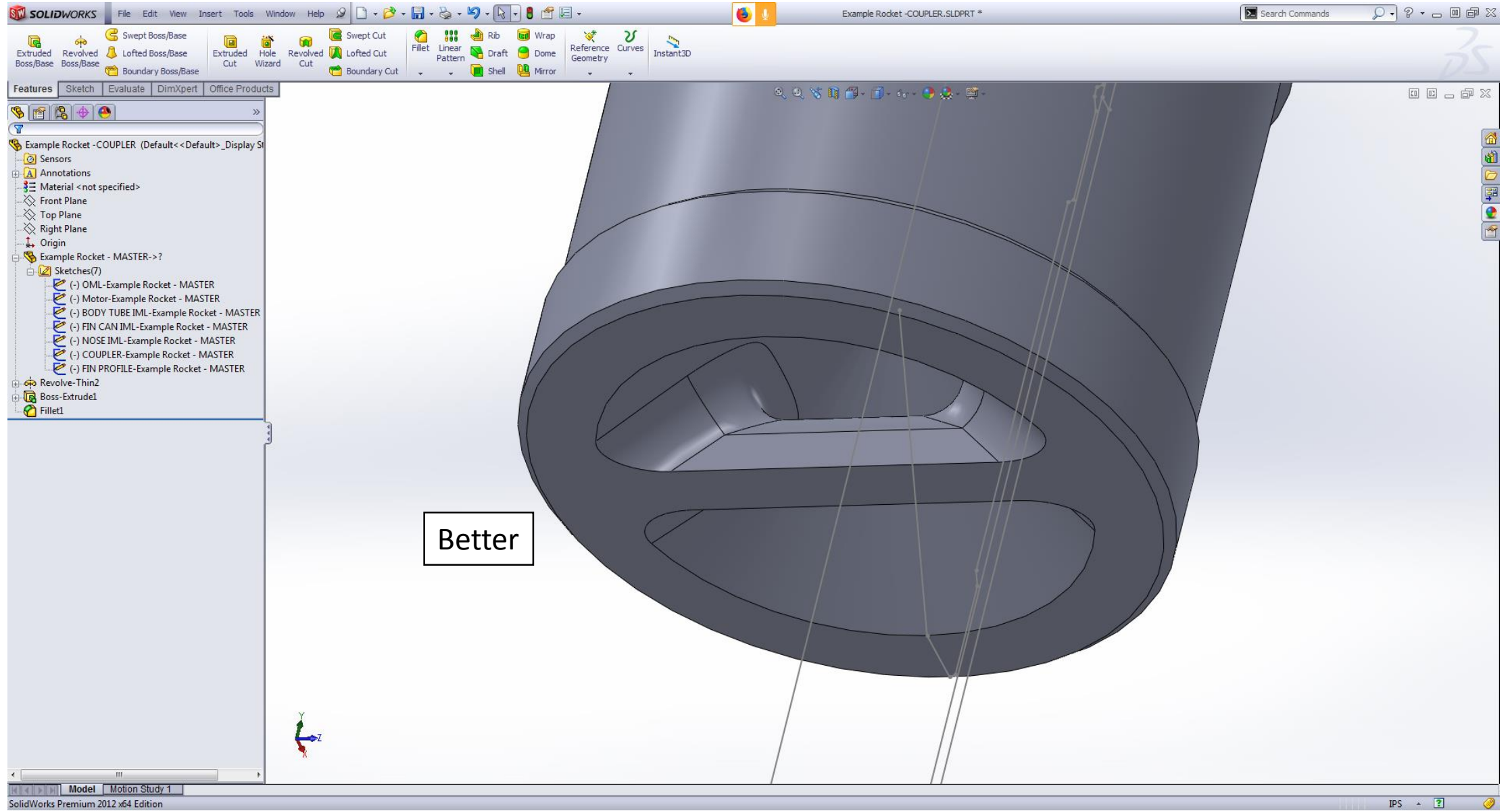




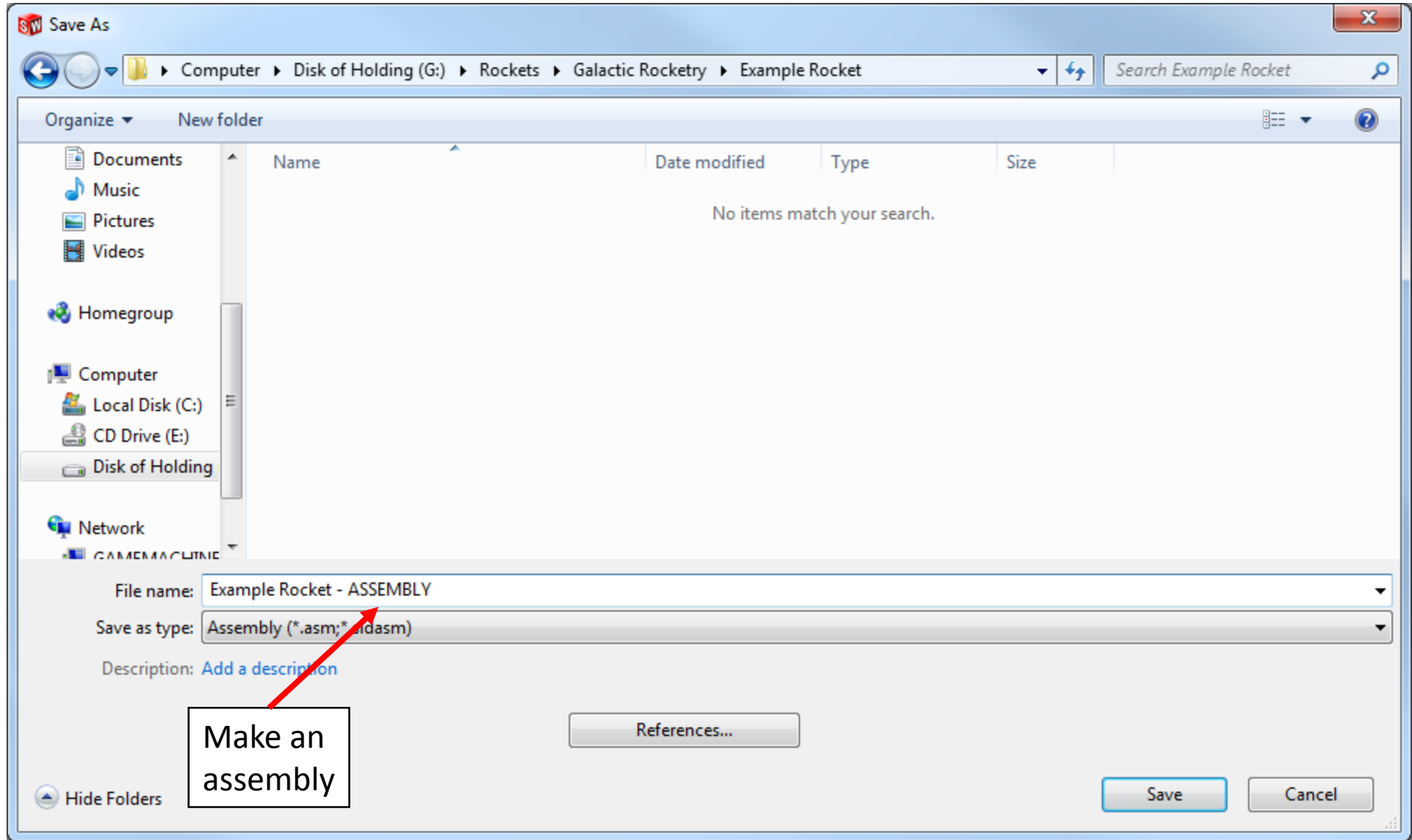
Looks a little thin

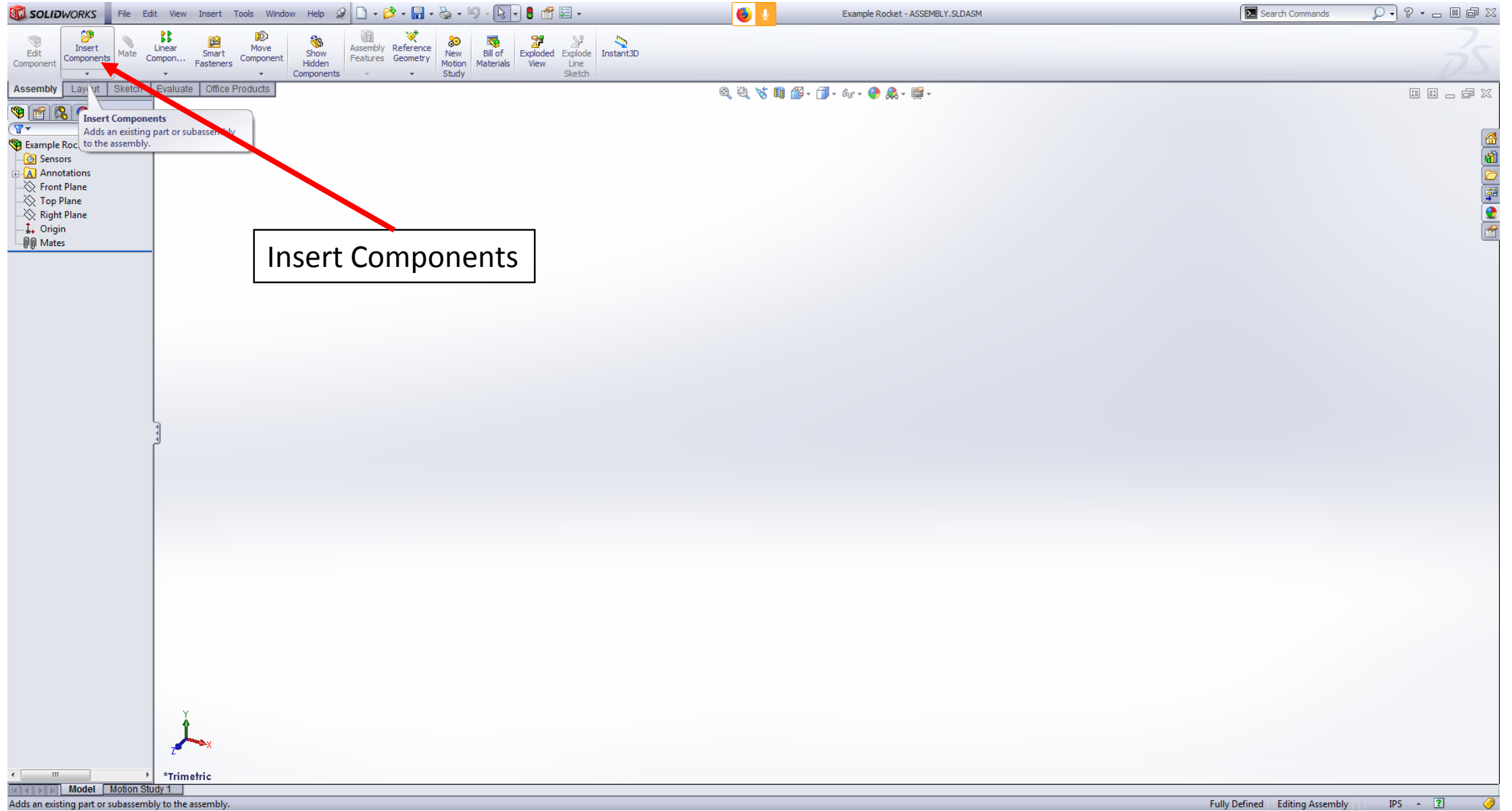




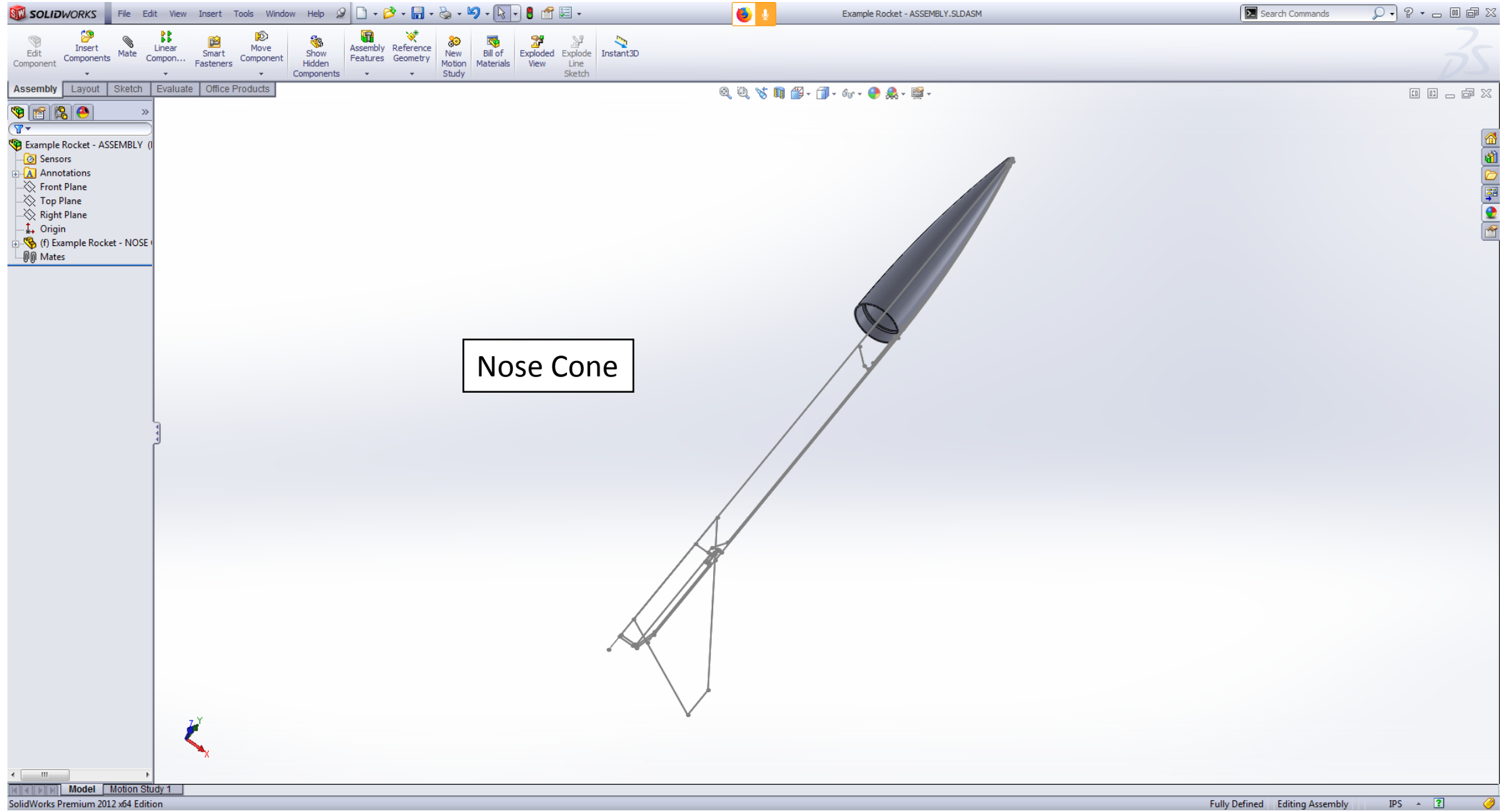


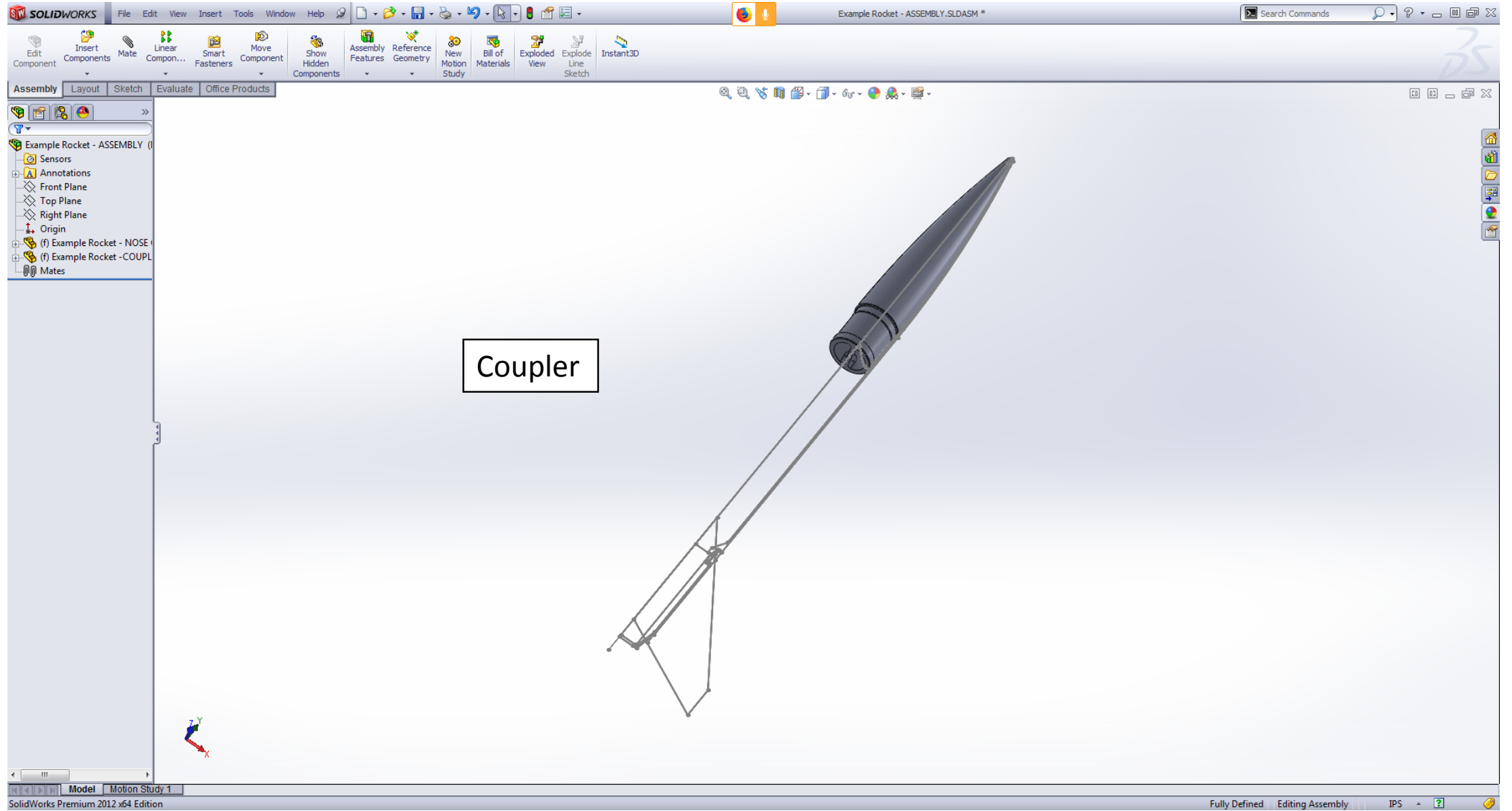
Better



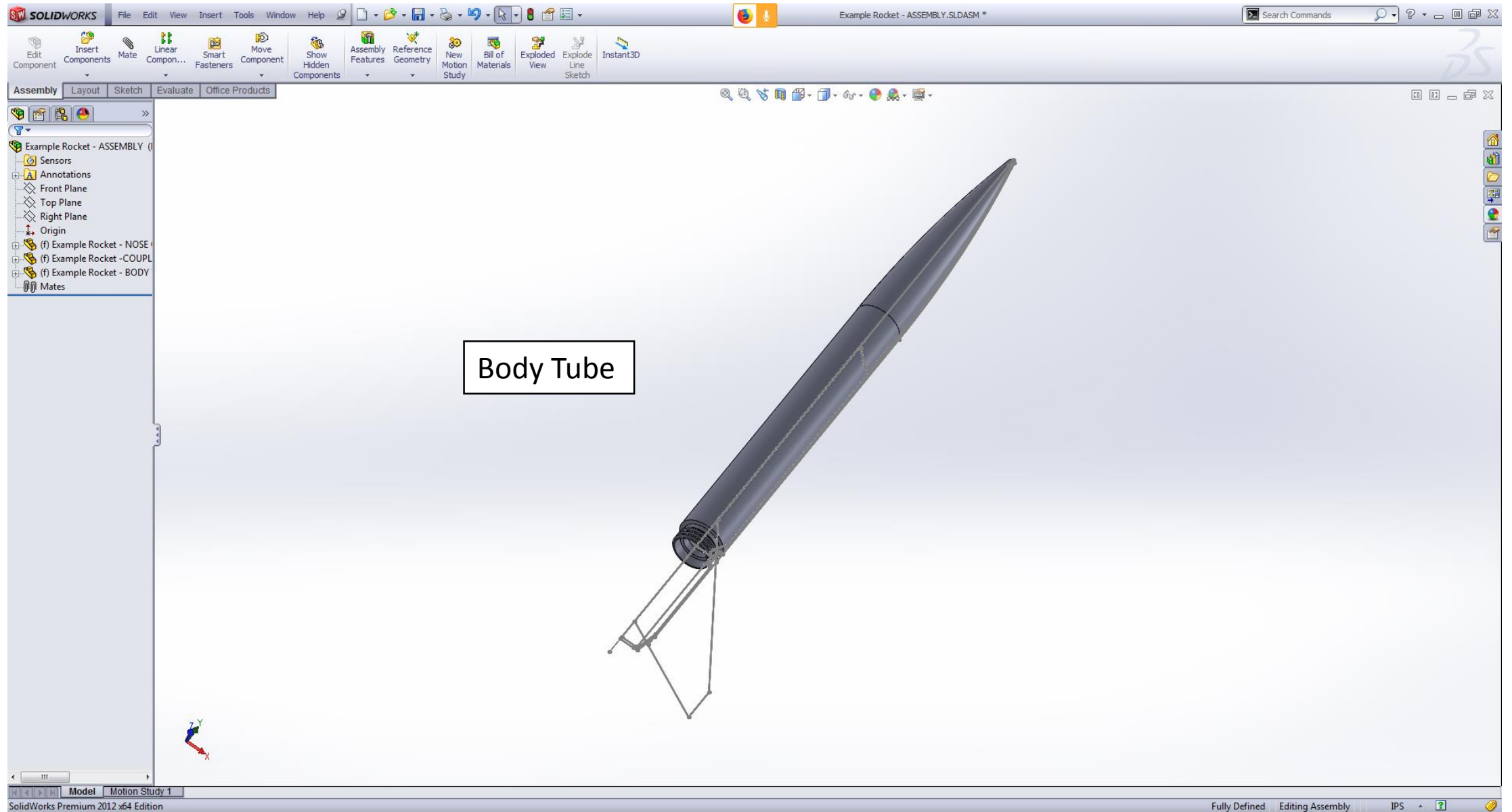


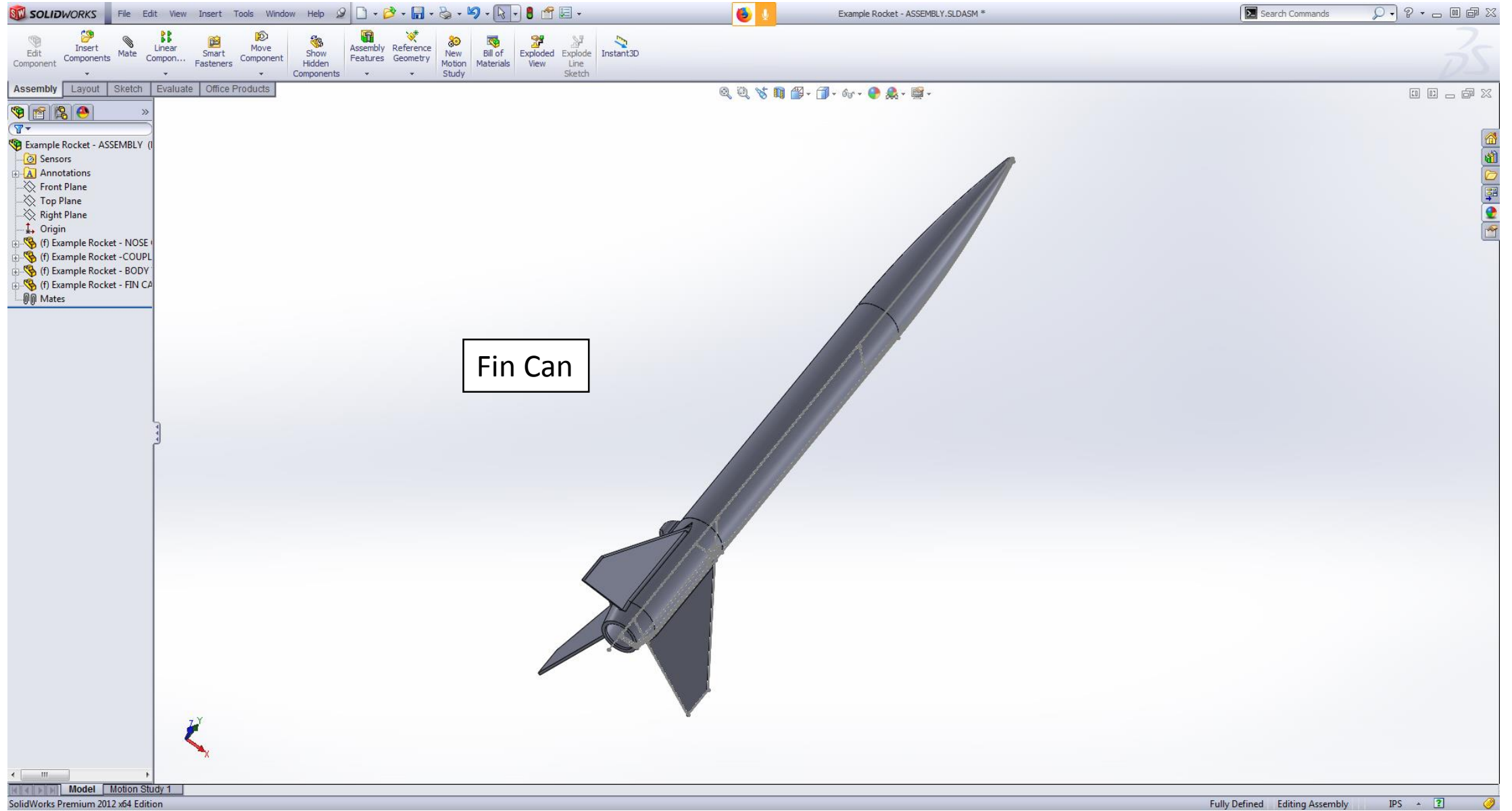
Insert Components





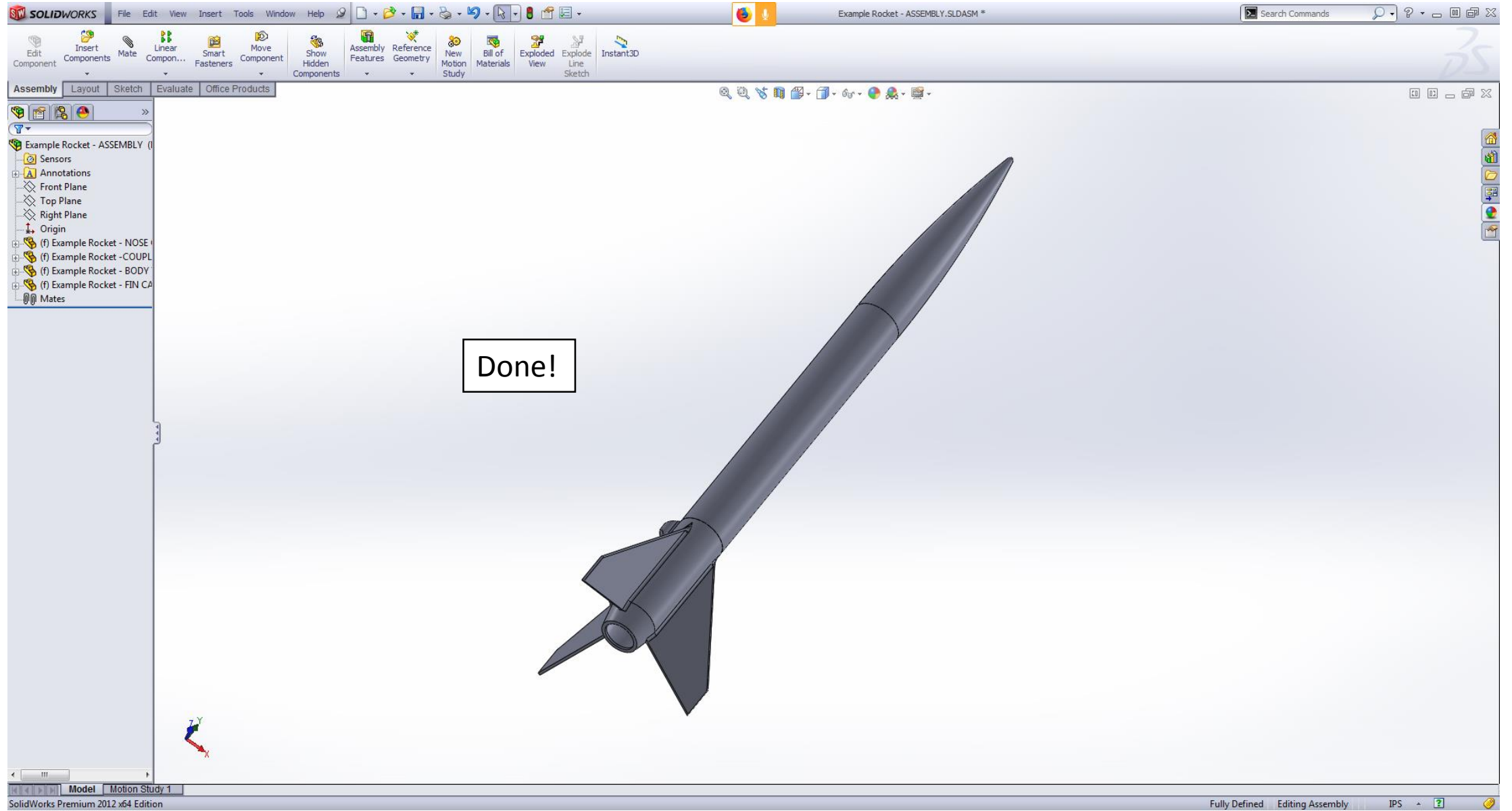
Coupler



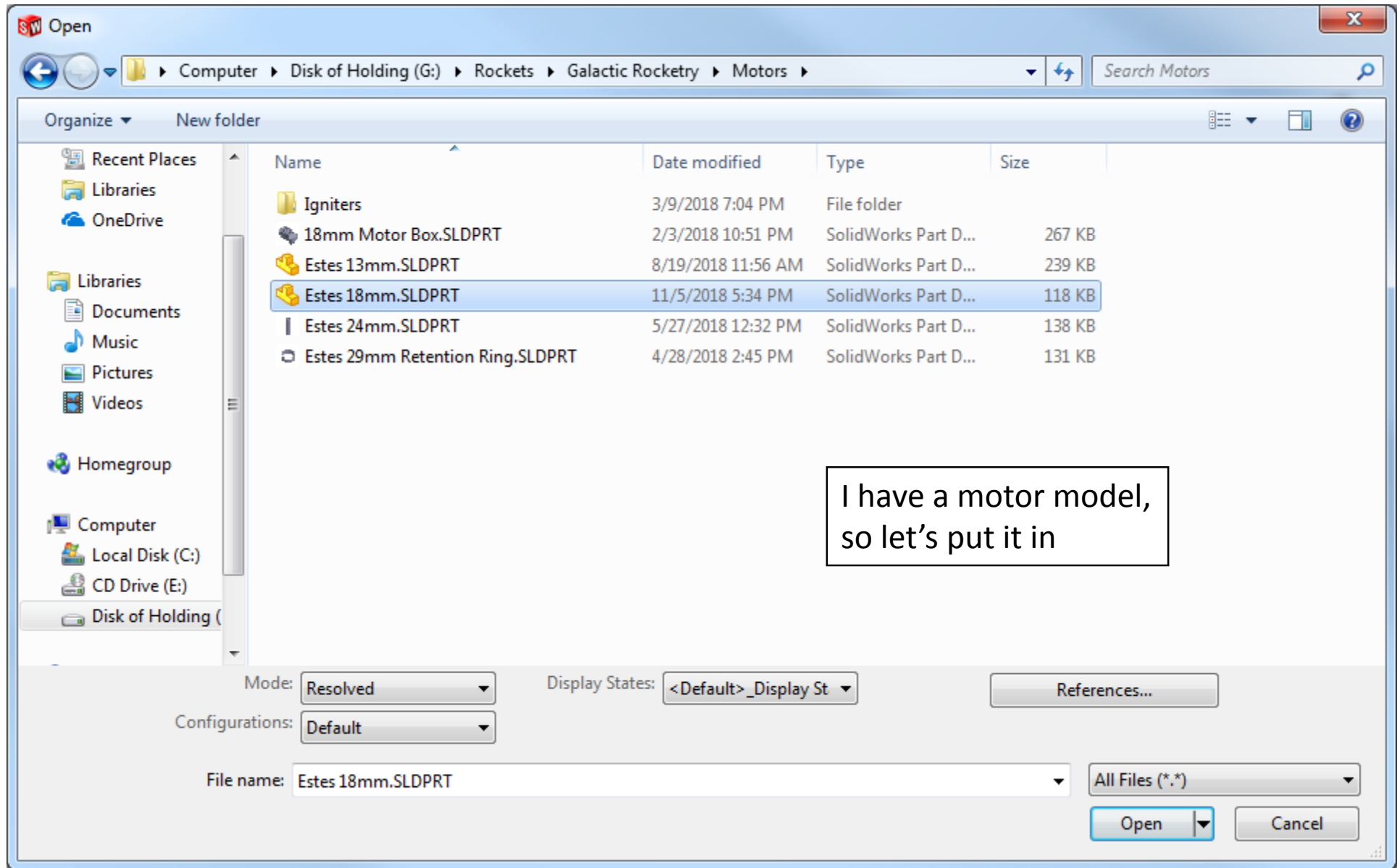


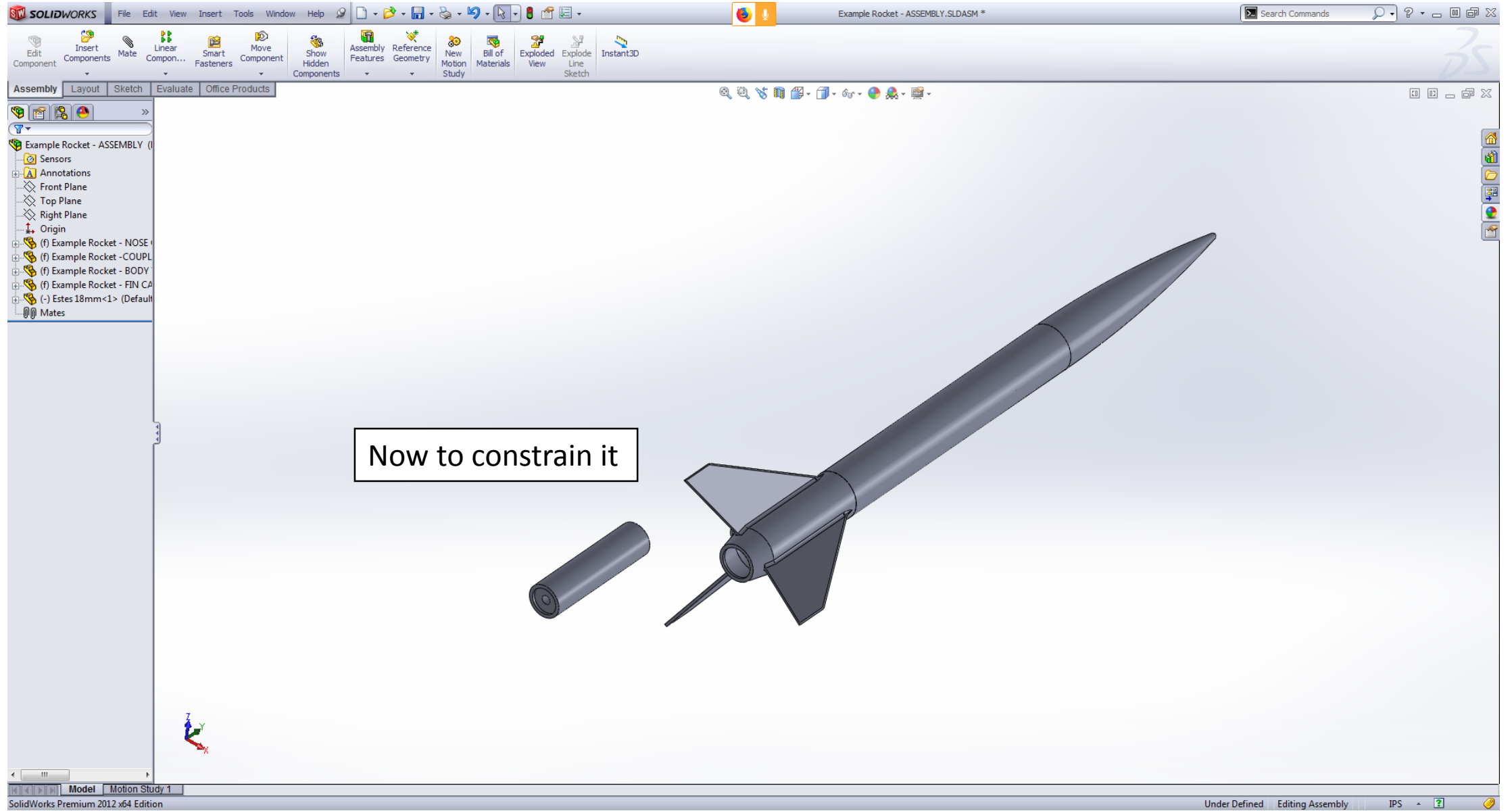
Fin Can

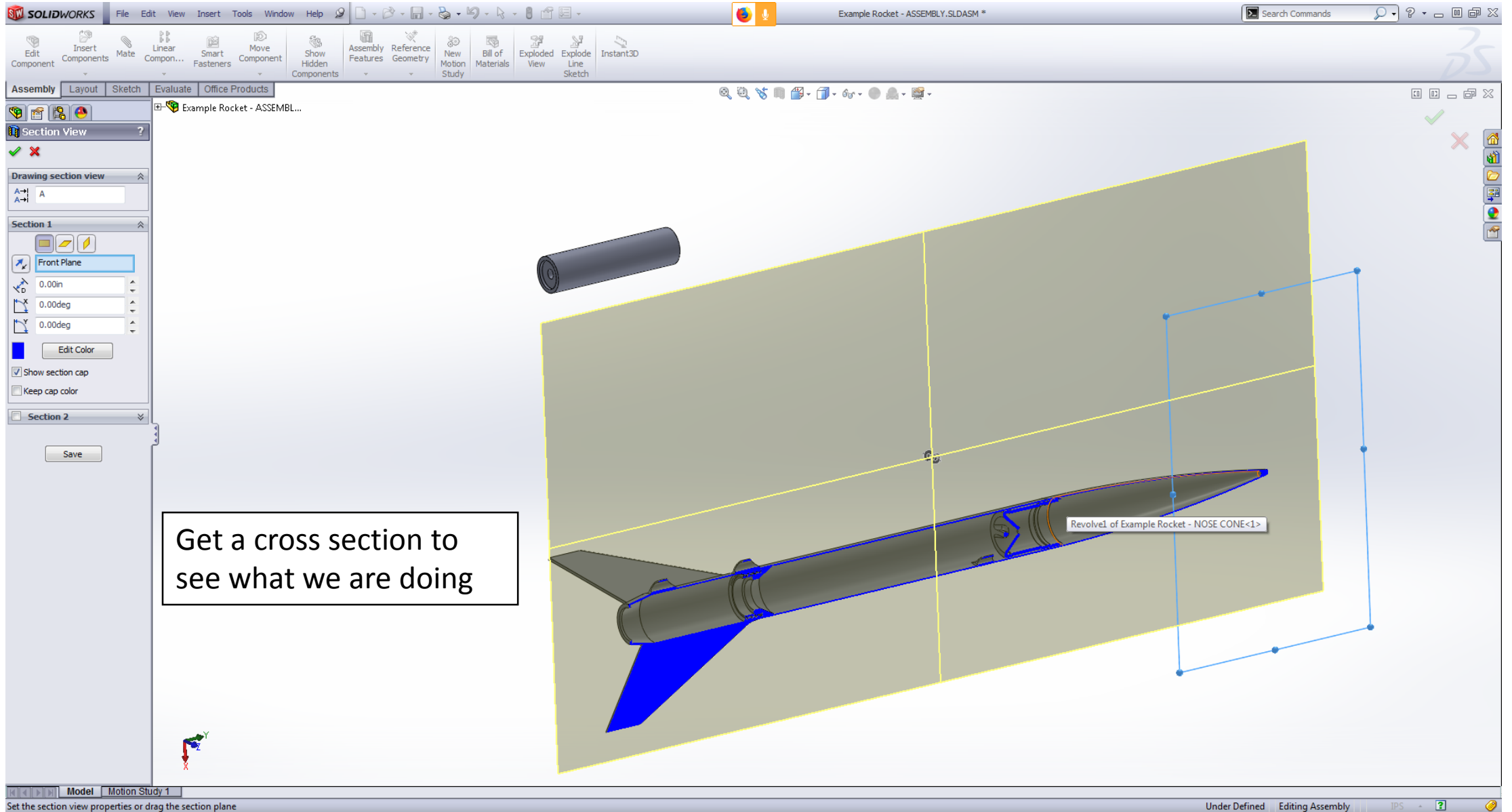


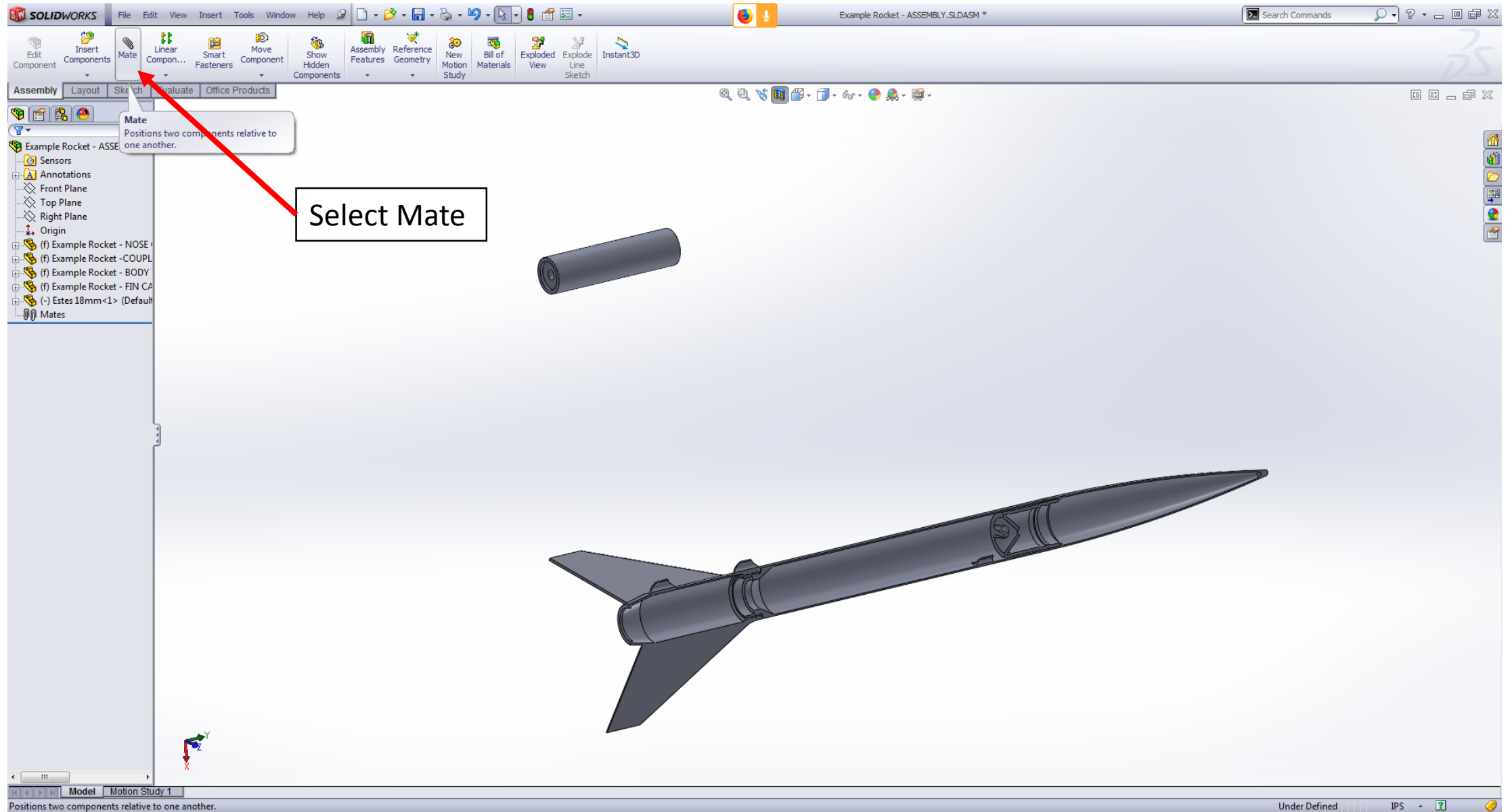


Done!

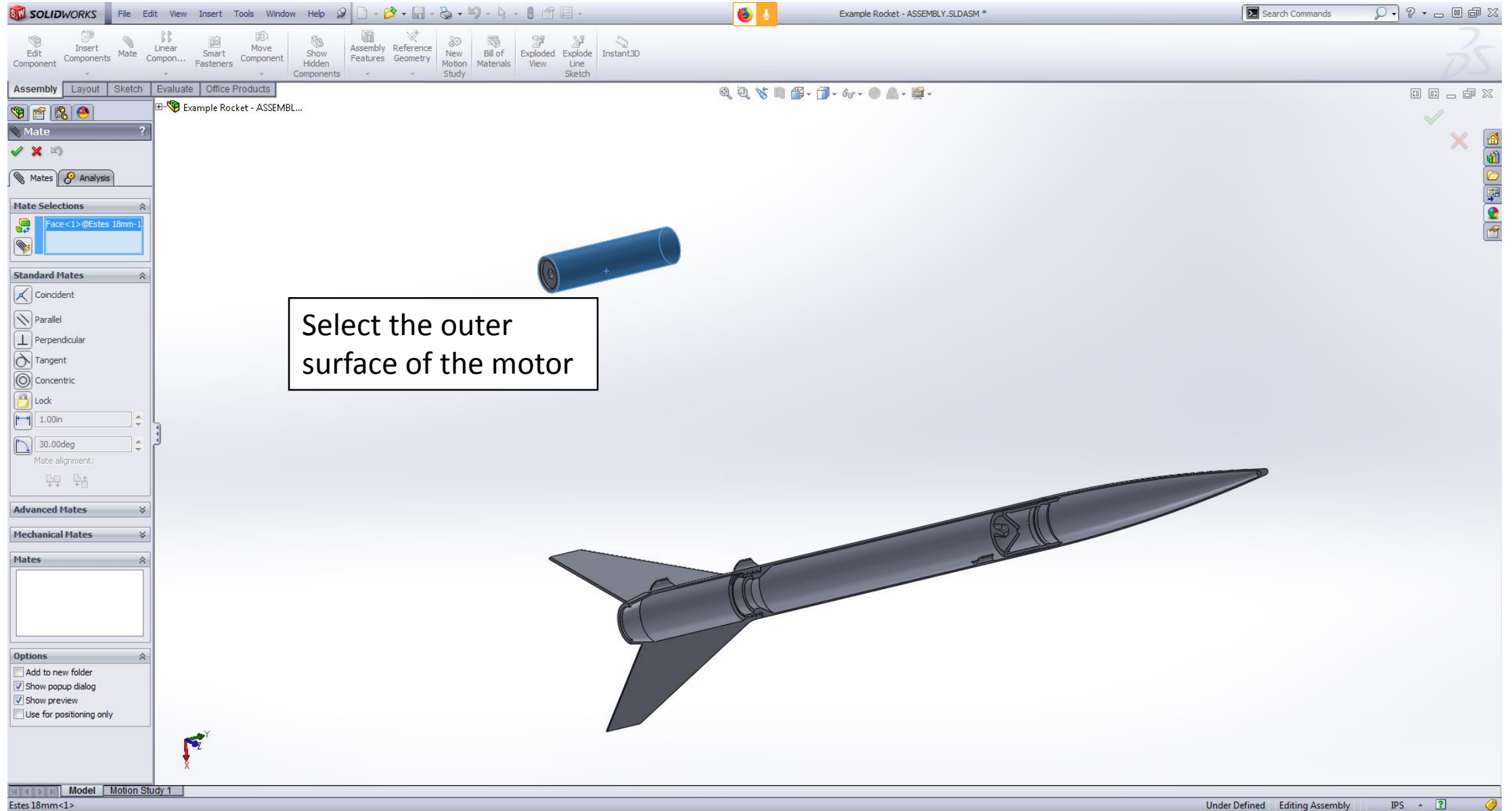


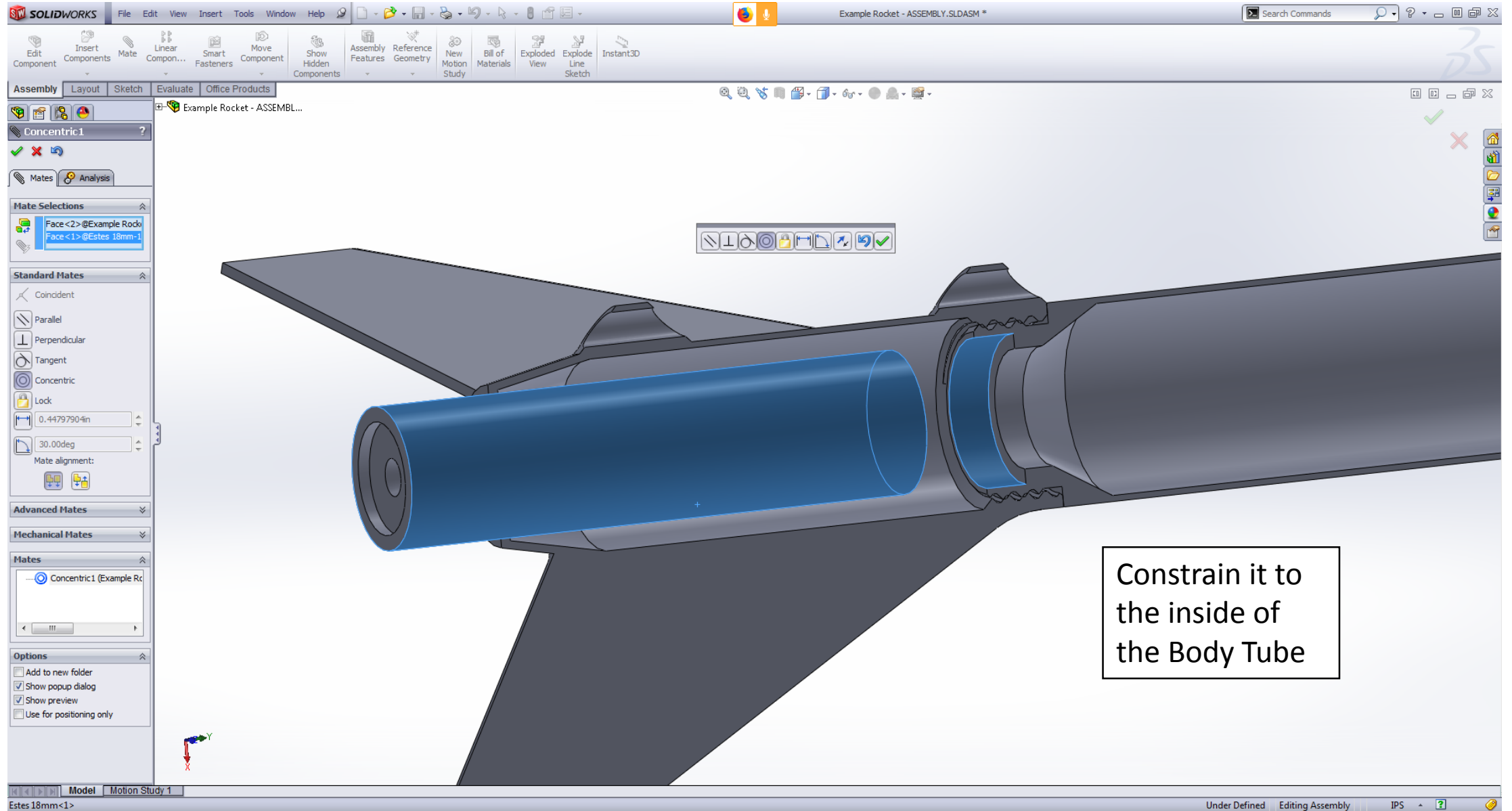




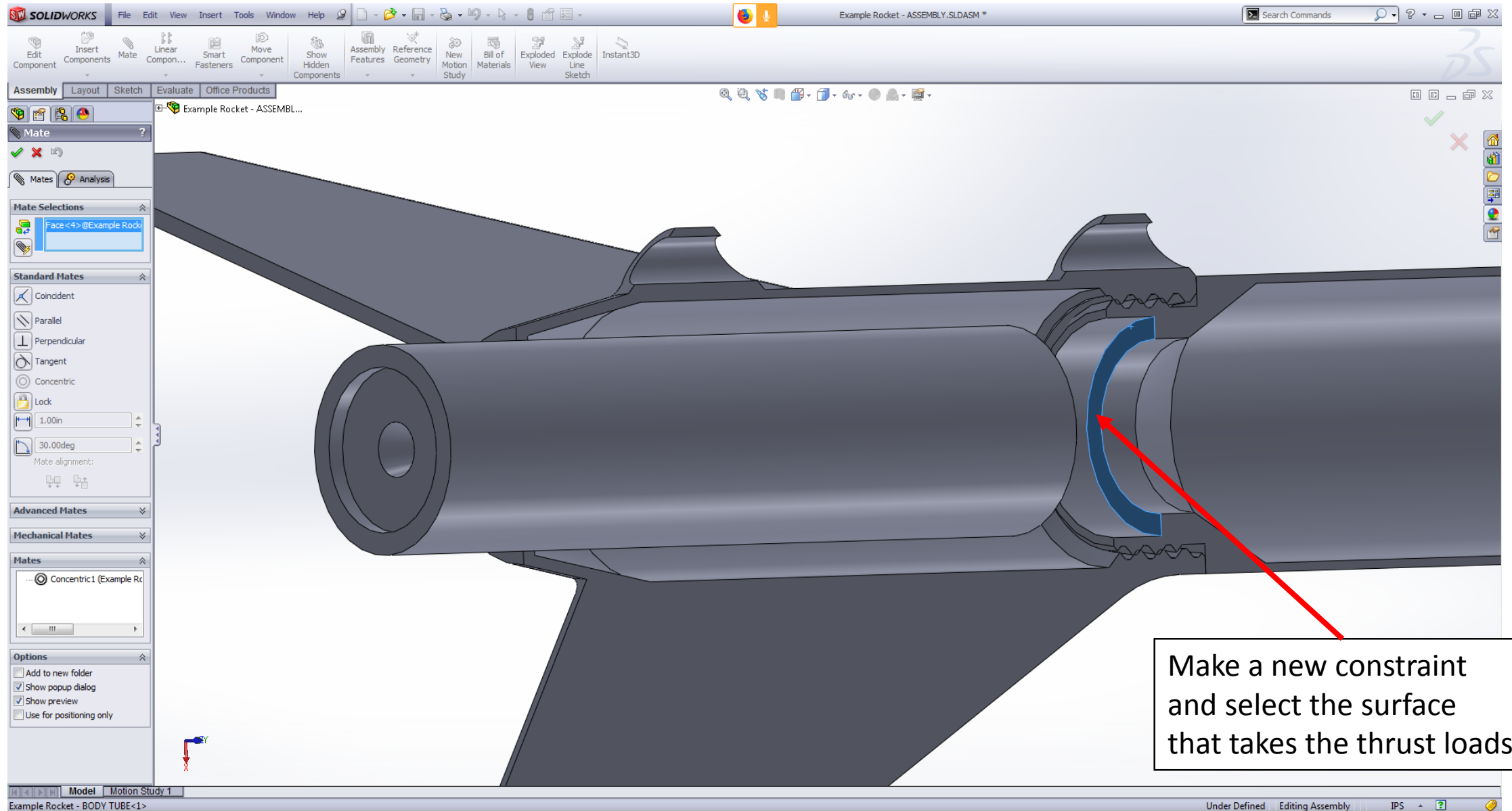


Select Mate

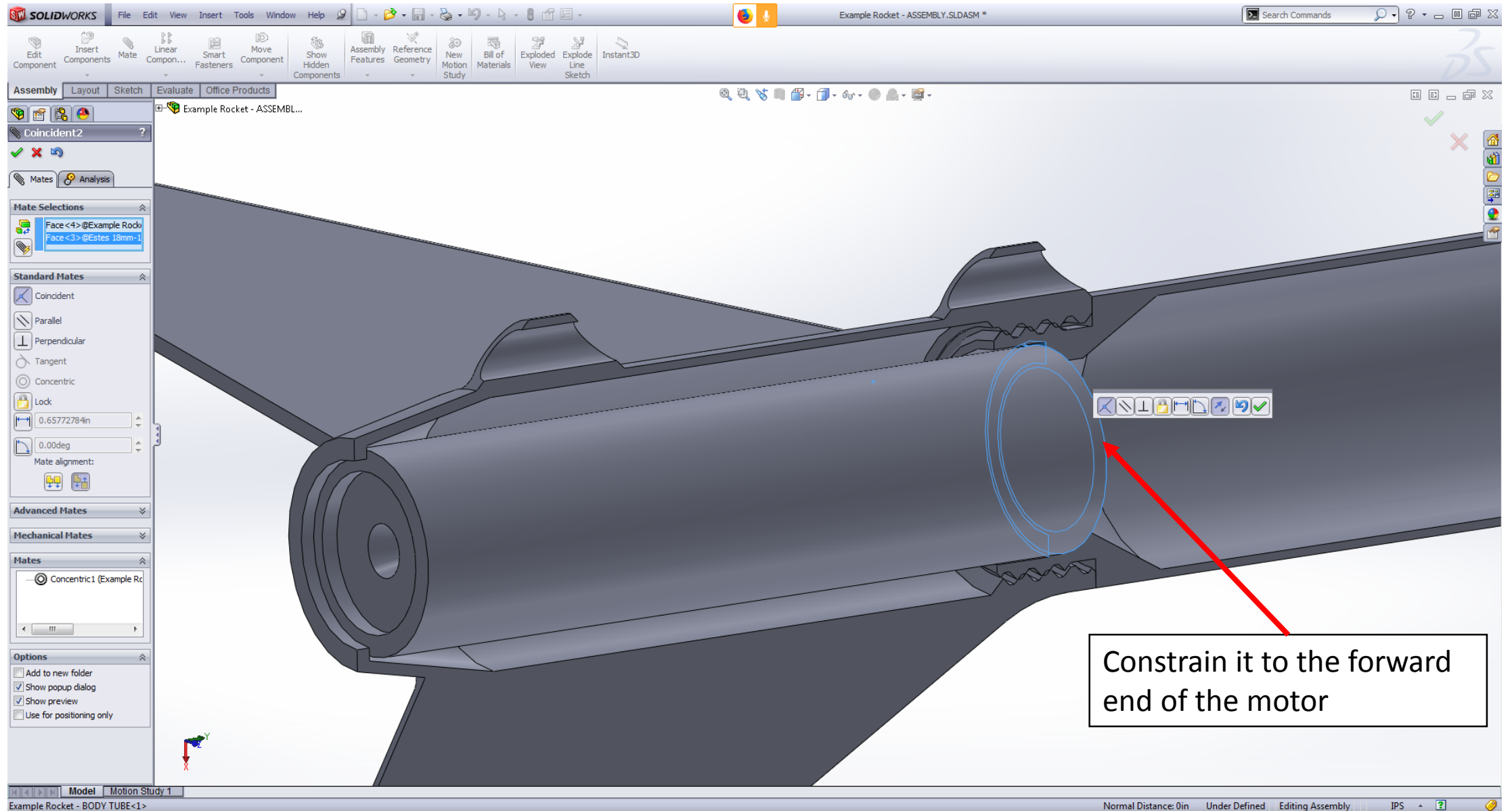




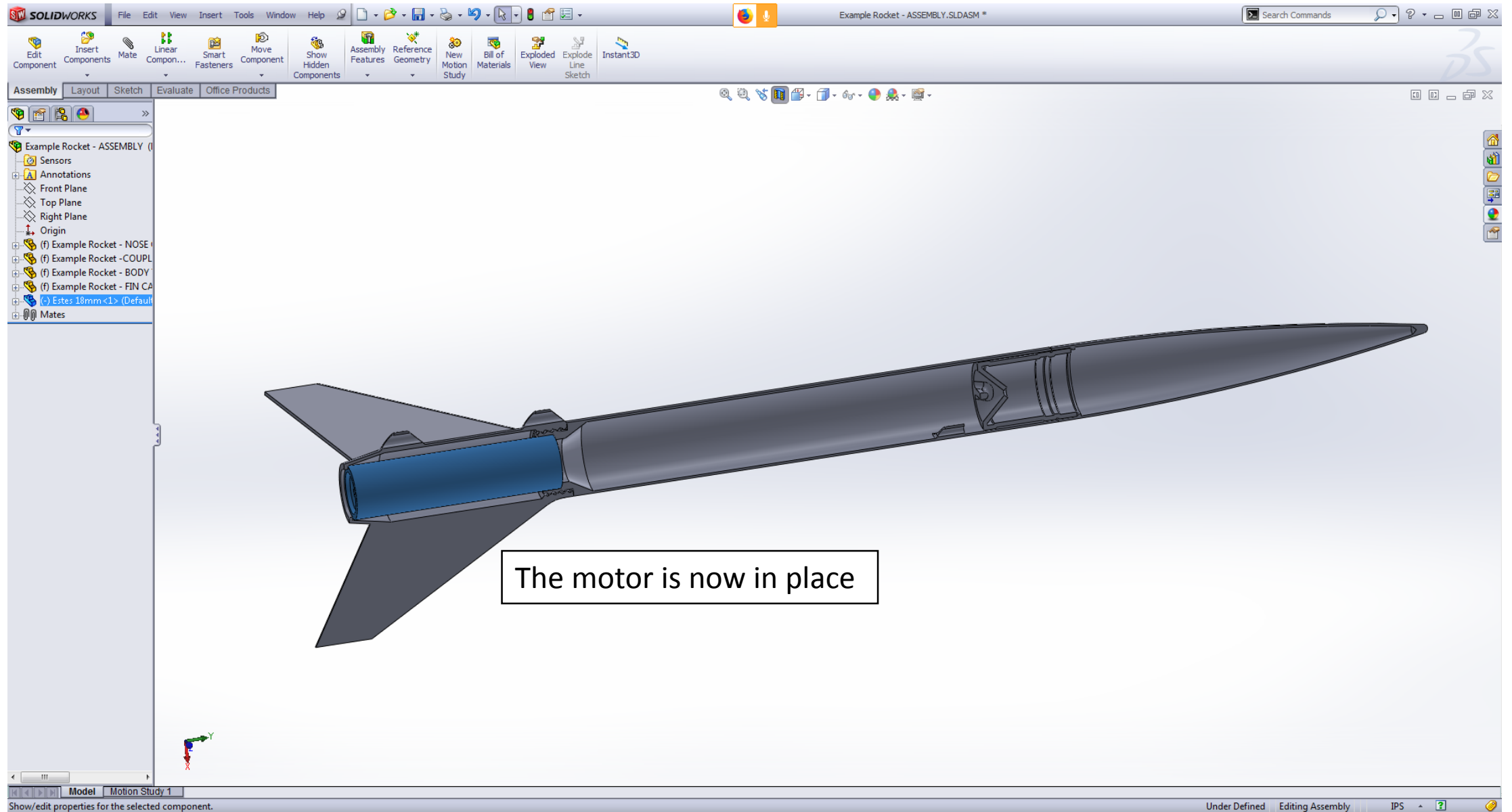
Constrain it to  
the inside of  
the Body Tube



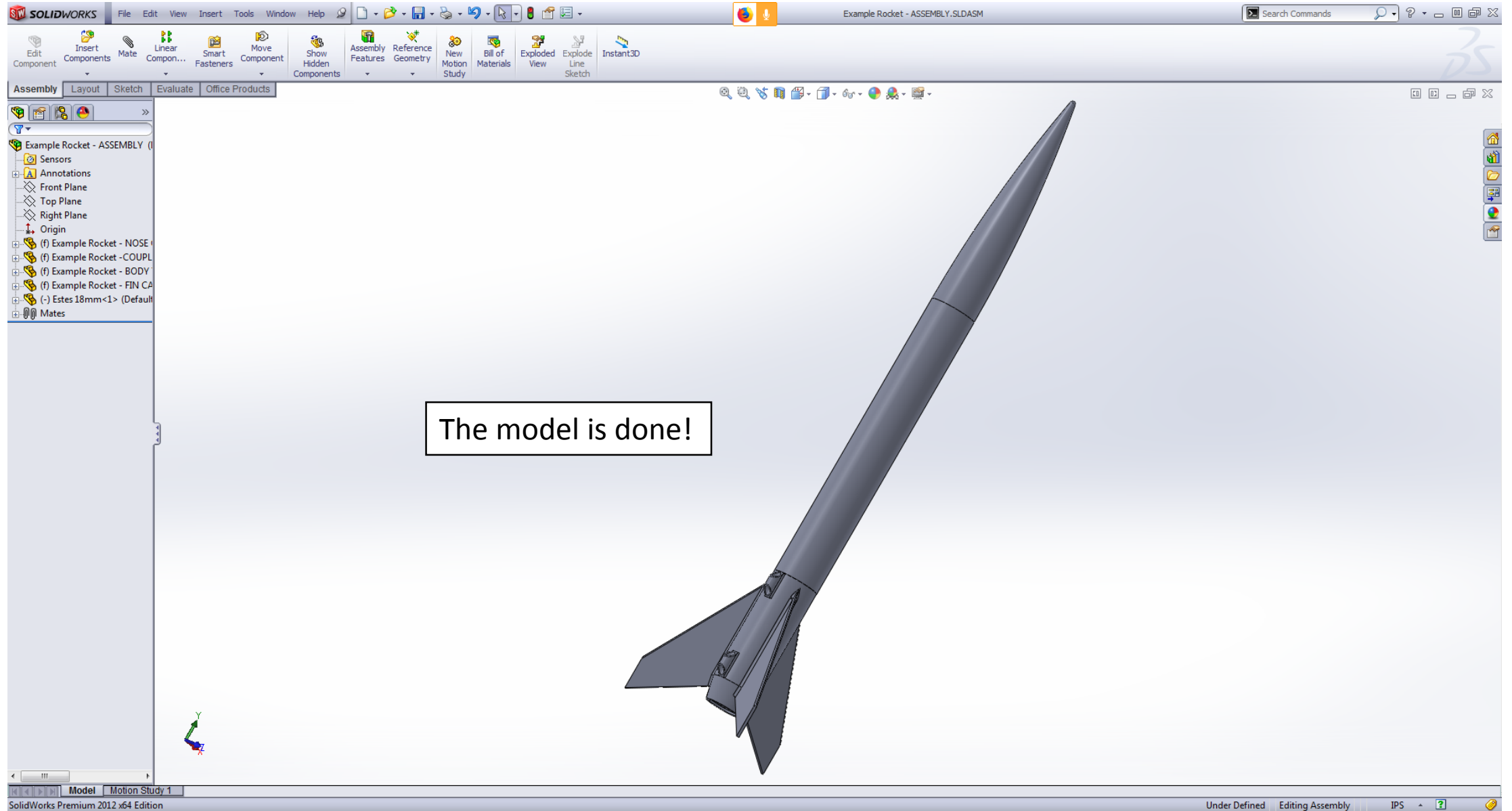




Constrain it to the forward end of the motor



The motor is now in place



The model is done!

Rocket (Example Rocket.ork)

File Edit Tools Help

Rocket design Motors & Configuration Flight simulations

New simulation Edit simulation Run simulations Delete simulations Plot / export

Name	Configuration	Velocity off rod	Apogee	Velocity at depl...	Optimum delay	Max. velocity	Max. acceleration	Time to apogee	Flight time	Ground hit velocity
Simulation 1	[C6-5]	43.6 mph	1032 ft	27.6 mph	6.22 s	199 mph	16.9 G	7.41 s	79.4 s	9.22 mph
Simulation 2	[B6-4]	43.5 mph	412 ft	8.87 mph	4.37 s	113 mph	15.9 G	5.15 s	34.2 s	9.25 mph

Simulating the model in Open Rocket revealed that the Solidworks model is tail heavy

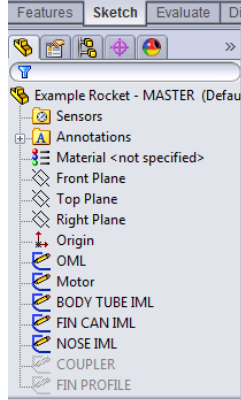
View Type: Side view Fit (100%) Stage 1 Flight configuration: [C6-5]

Rocket  
Length 15.098 in, max. diameter 1 in  
Mass with motors 78.7 g

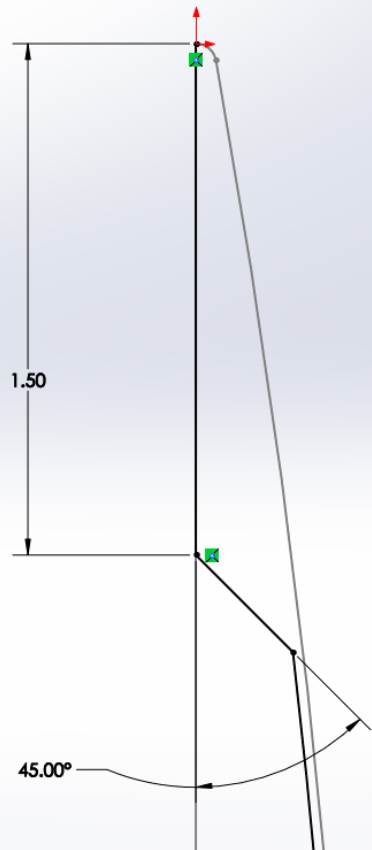
Stability: 1.65 cal  
CG: 9.98 in  
CP: 11.631 in at  $M=0.30$

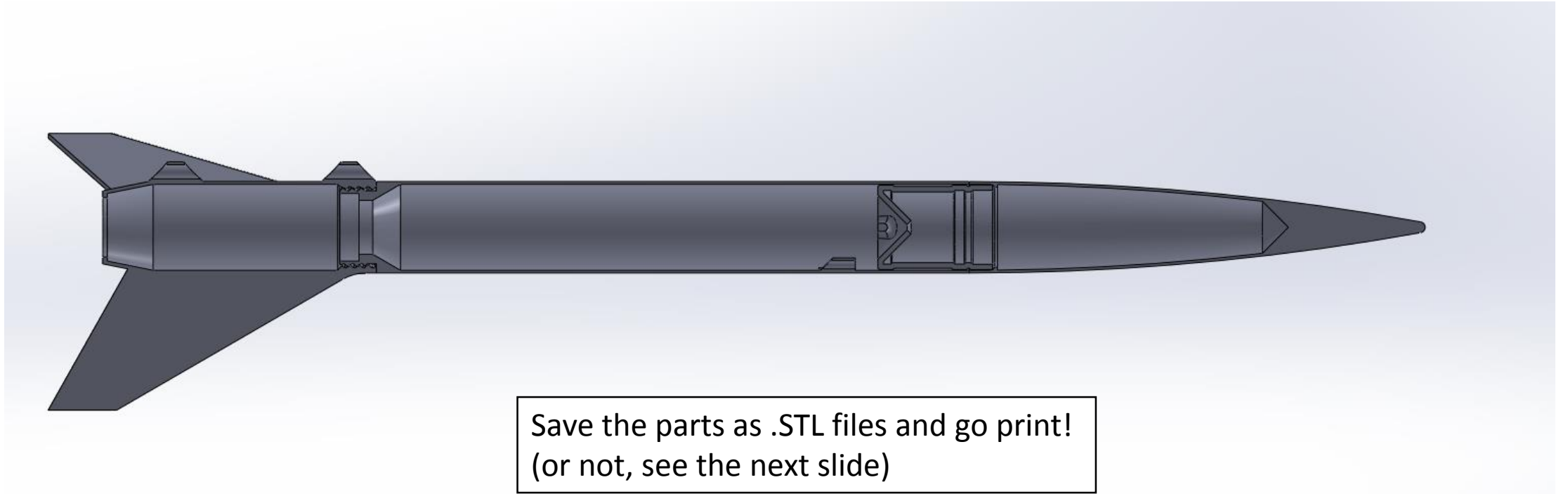
Apogee: 1038 ft  
Max. velocity: 198 mph (Mach 0.26)  
Max. acceleration: 16.8 G

Click to select Shift+click to select other Double-click to edit Click+drag to move



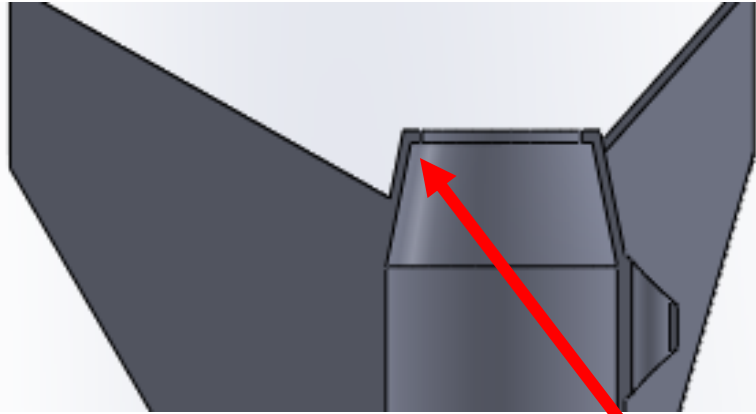
Adjust the solid portion of the nose cone in the Master file to add "printed in" nose weight





# Problems

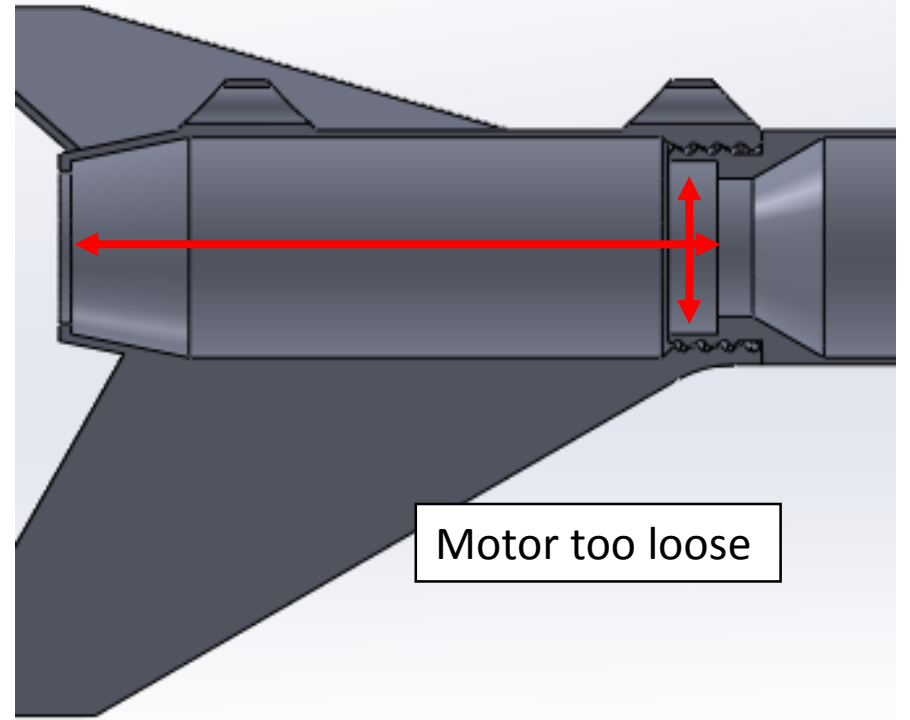
- Overhangs
  - Aft motor retention (found before printing)
  - Shock cord mount (found after printing)
- Tolerances (found after printing)
  - Fin can threads loose
  - Motor loose axially
  - Motor loose radially



Overhang

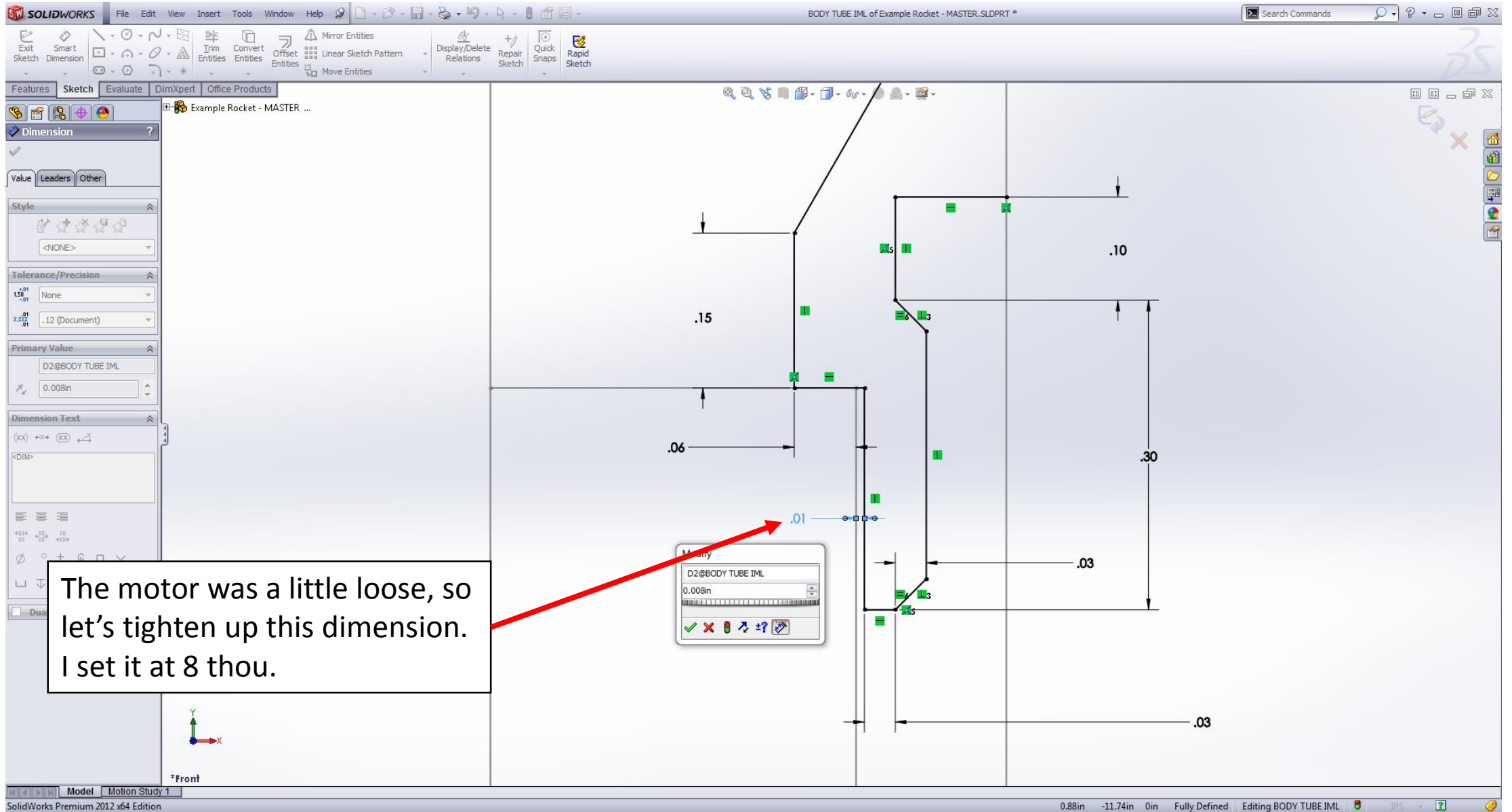


Overhang

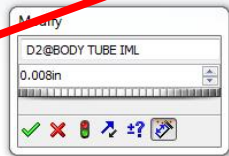


Motor too loose





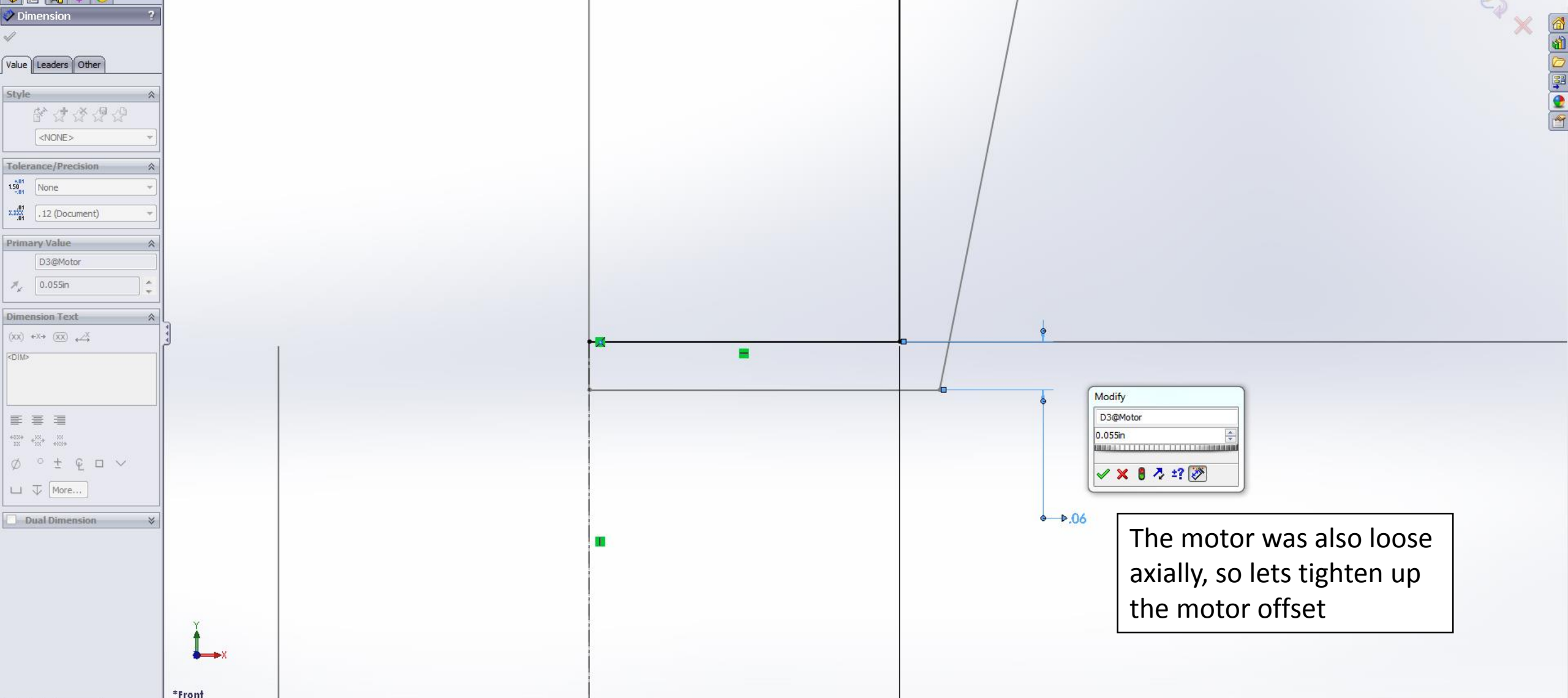
The motor was a little loose, so let's tighten up this dimension. I set it at 8 thou.

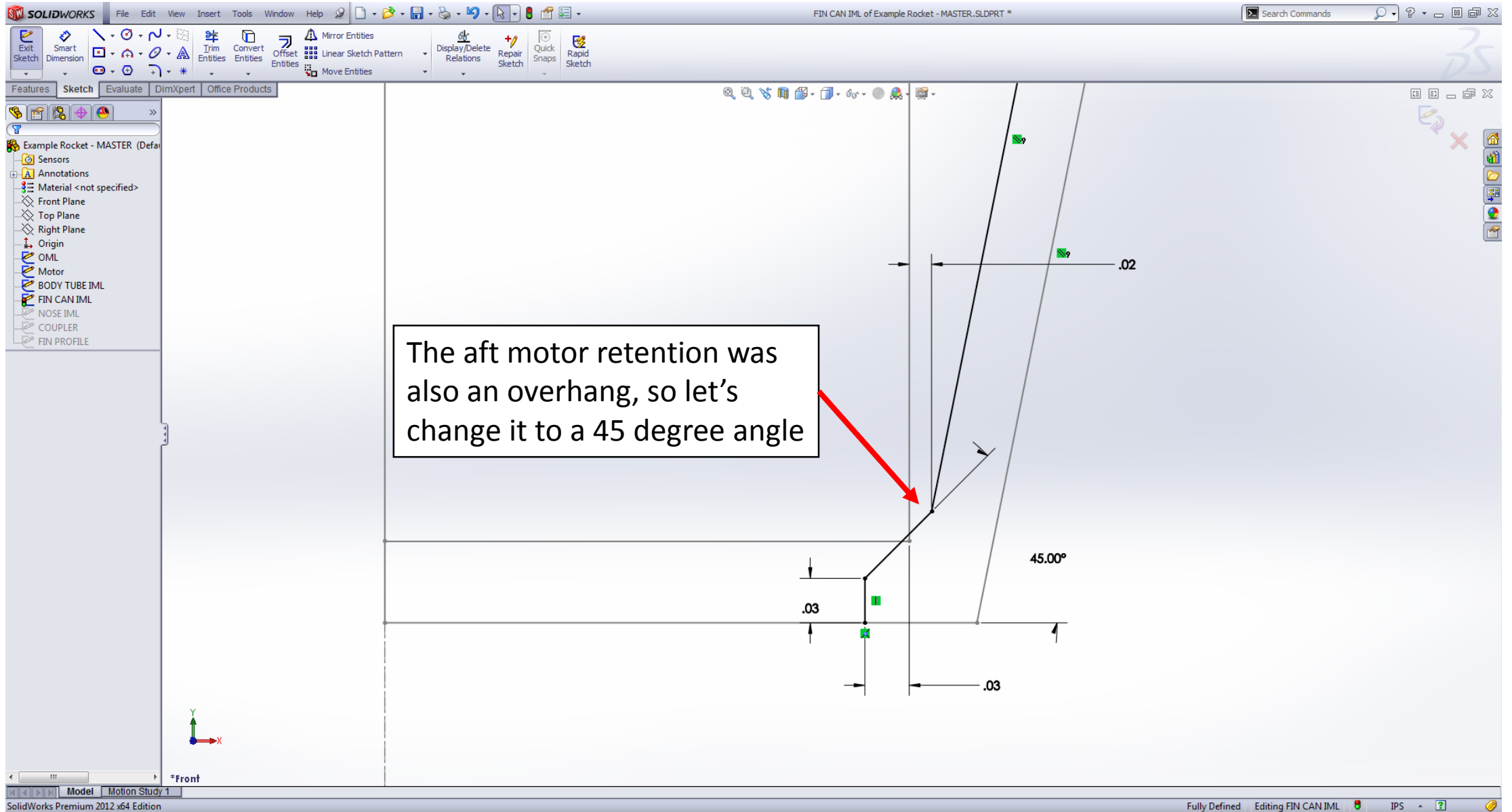




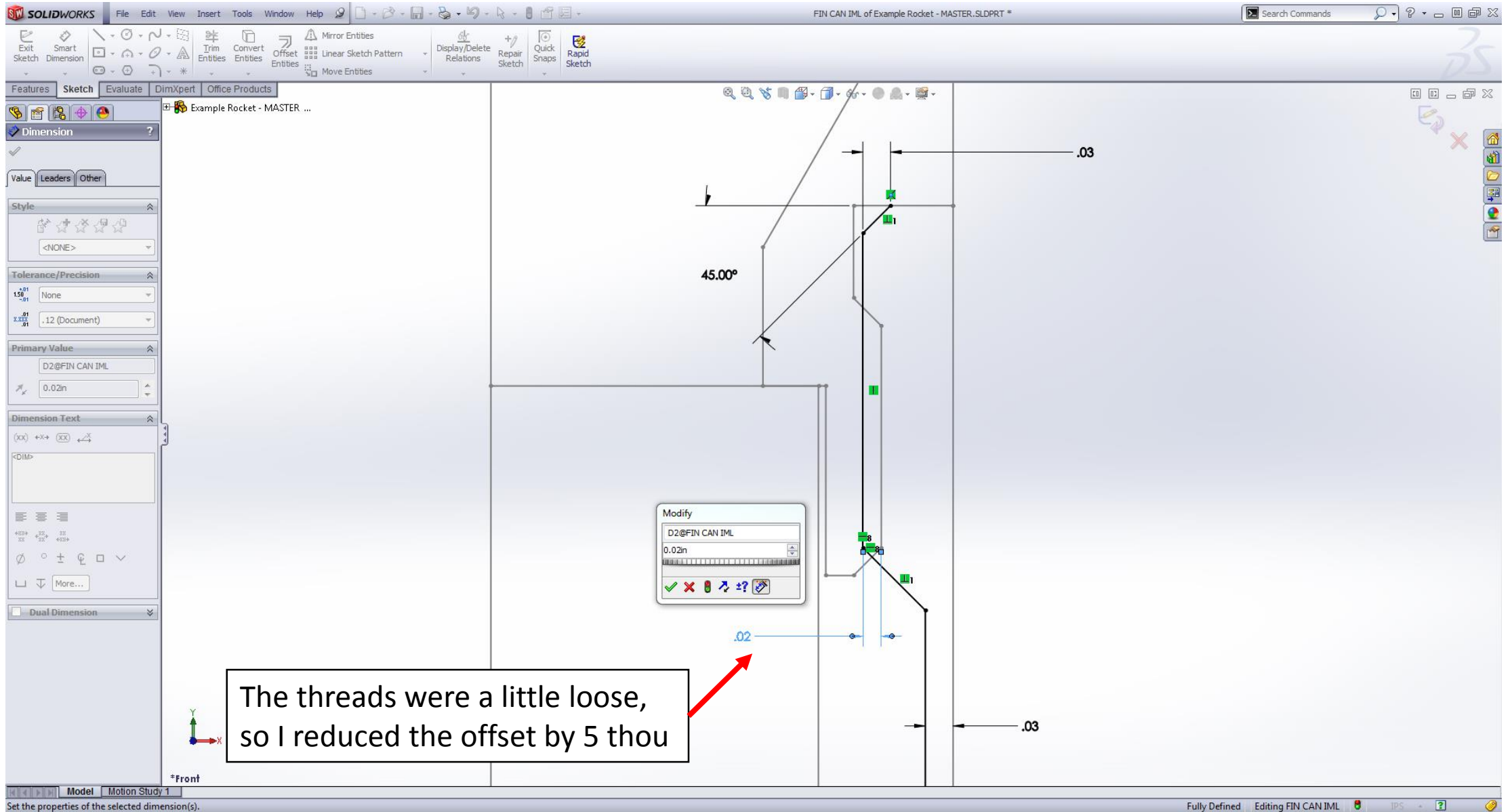
Features Sketch Evaluate DimXpert Office Products

Example Rocket - MASTER ...



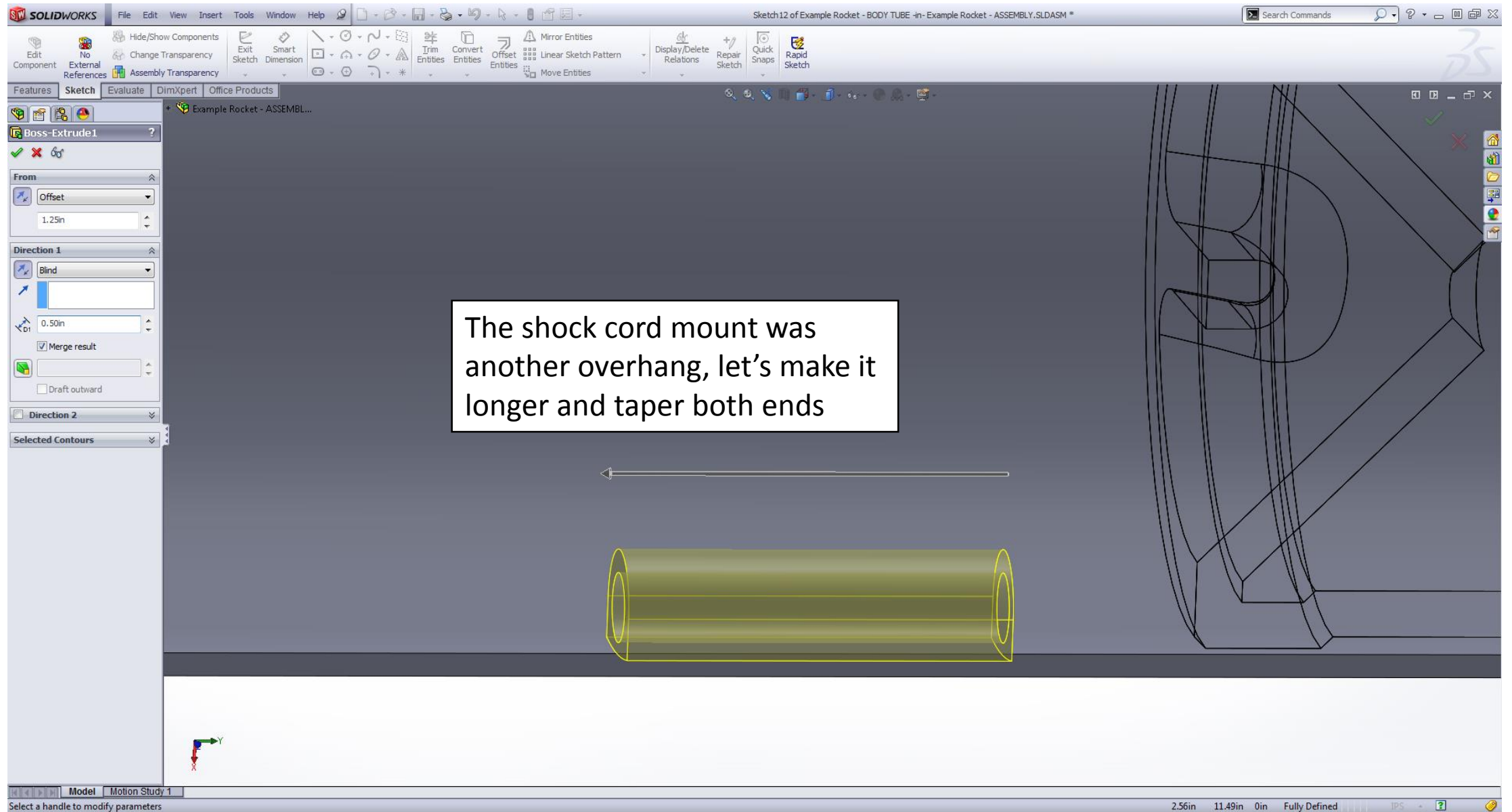


The aft motor retention was also an overhang, so let's change it to a 45 degree angle



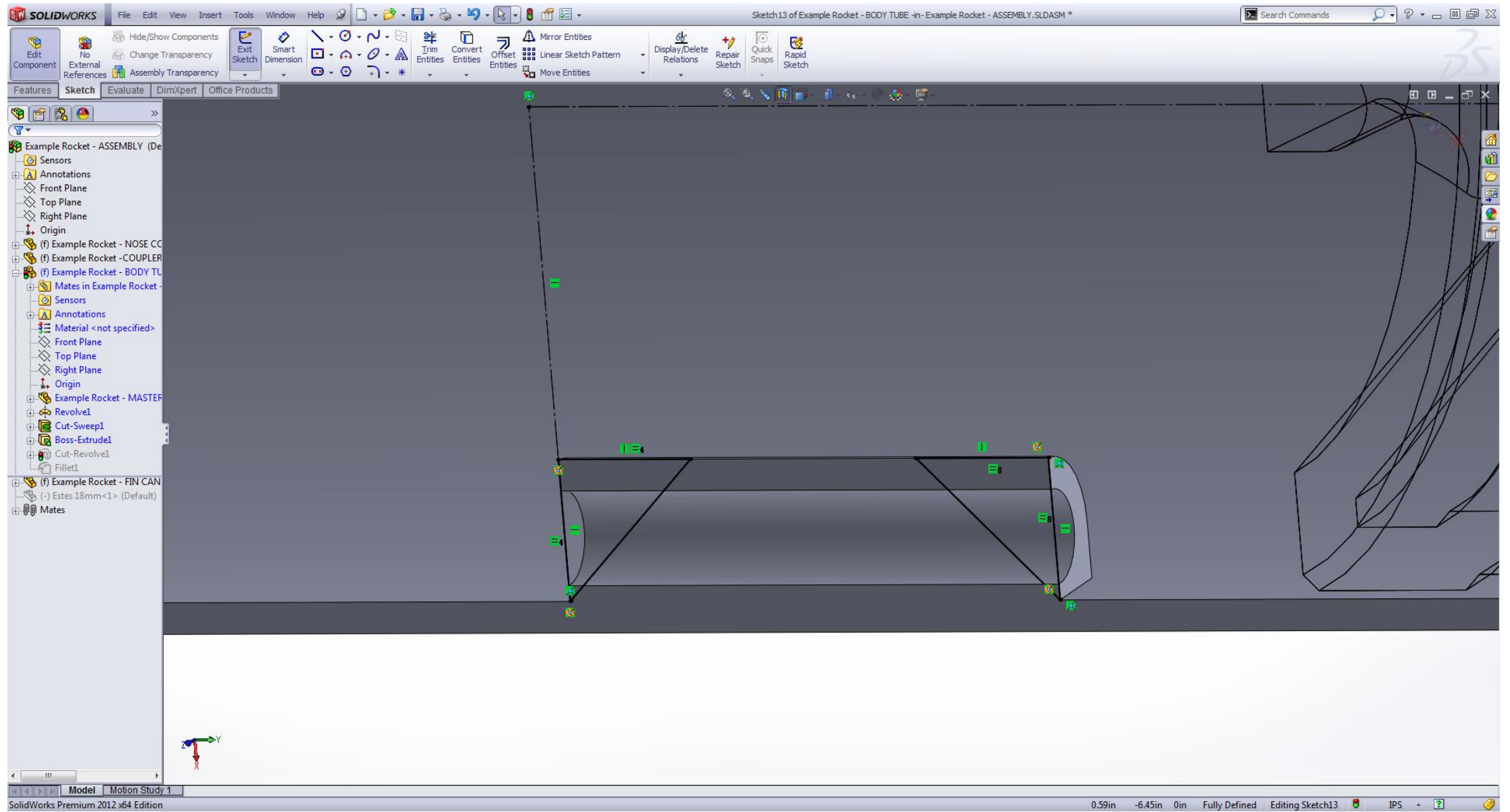
Set the properties of the selected dimension(s).

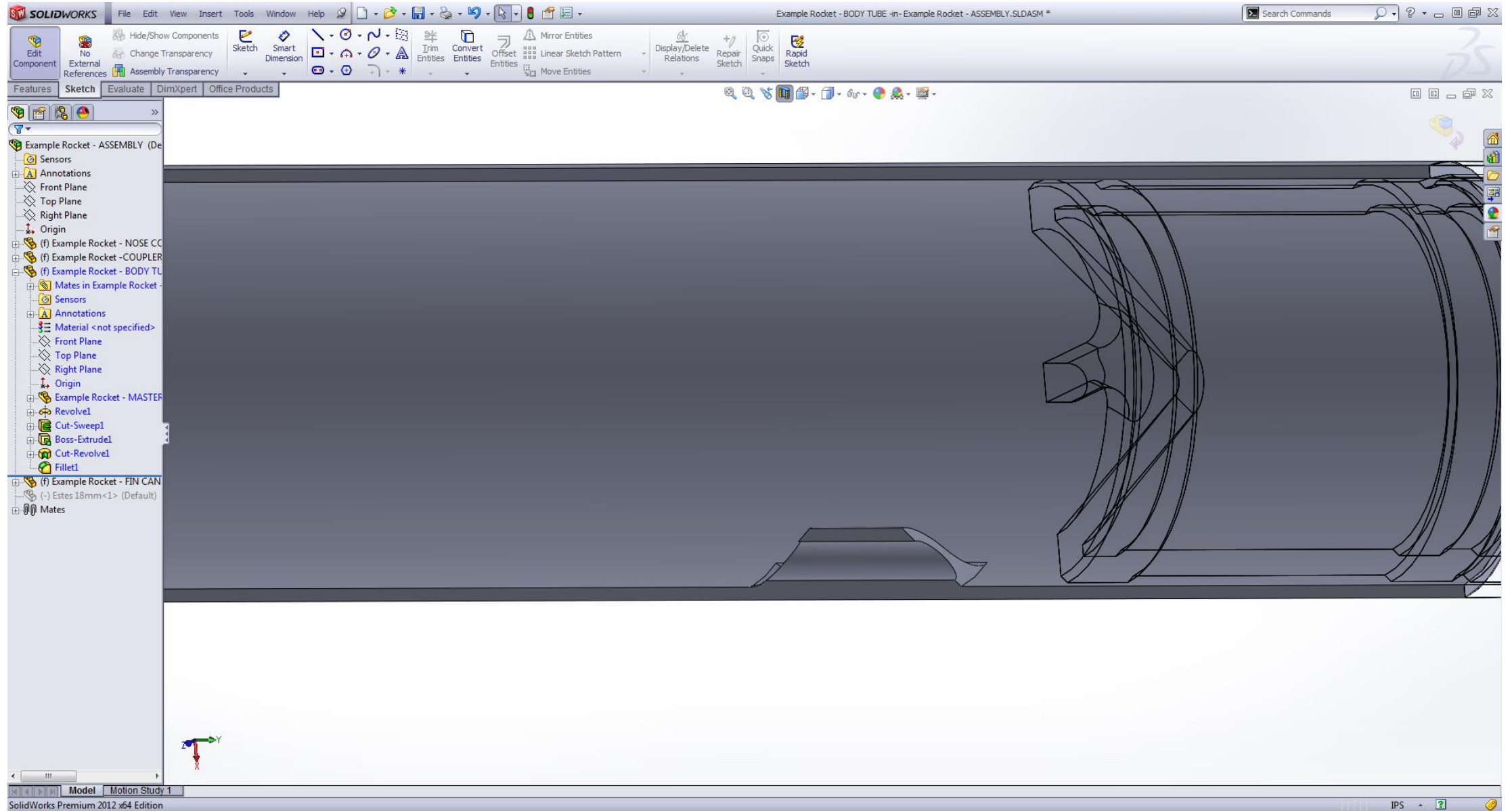
Fully Defined Editing FIN CAN IML TPS

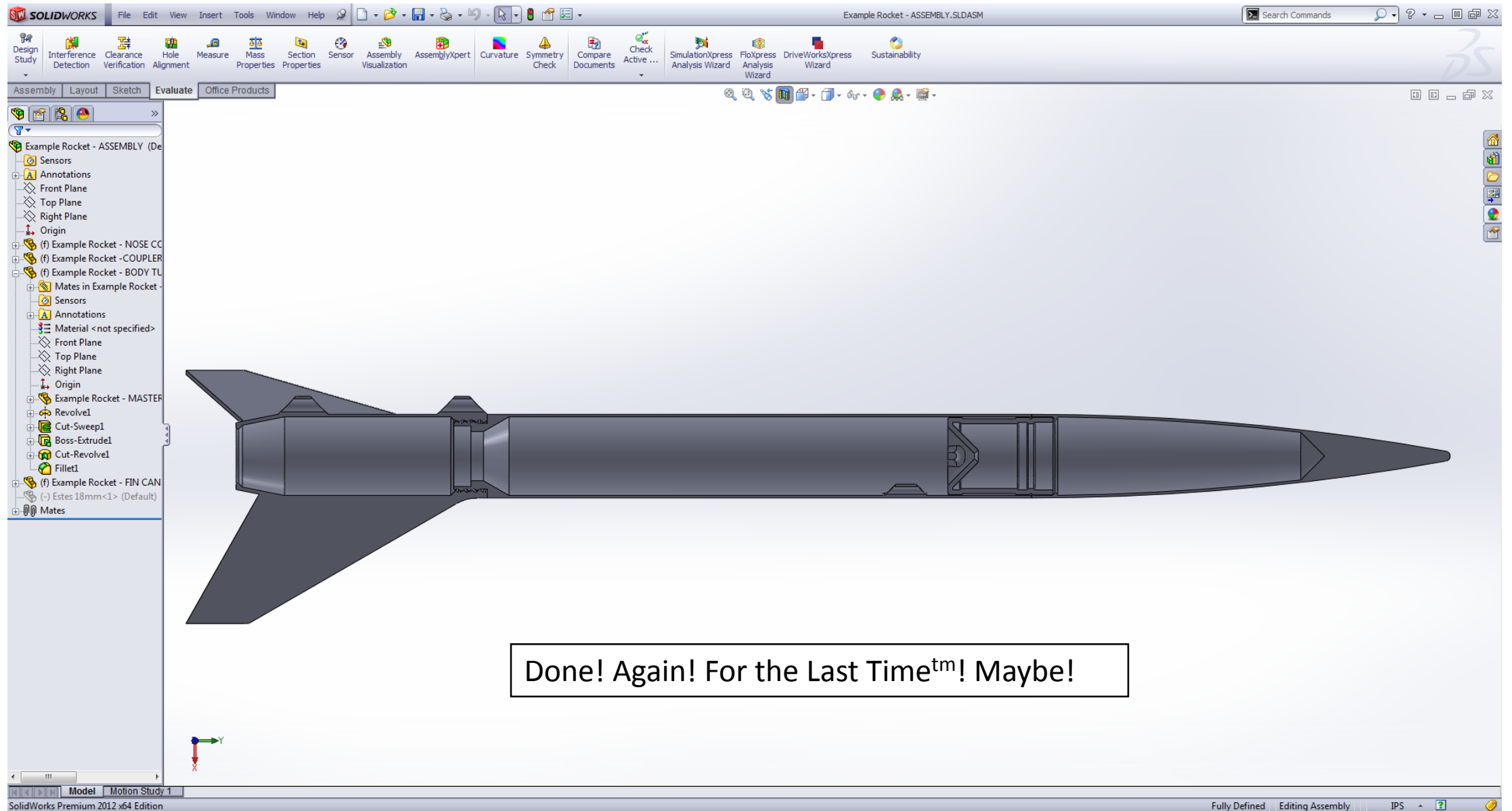


The shock cord mount was another overhang, let's make it longer and taper both ends









Done! Again! For the Last Time™! Maybe!