

European Regional Development Fund



D3.1.1: LEARNING REPORT

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1. INTRODUCTION

This deliverable aims to report the activity of the creation and lecturing the transnational learning course on Metal Additive Manufacturing. The activity is dedicated to the knowledge transfer for students of each university and engineering school by creating a new learning module and focused on MAM for the tooling industry.

Although Metal AM technologies do not replace any traditional manufacturing process, they are an essential catalyst for creation and innovation and act as a good complement to improve competitiveness. However, although the potential scope for the adoption of these technologies in all sectors (and particularly in tooling sector) is considered to be very large and can have a disruptive impact, the level of knowledge and adoption of Metal AM still remains low, particularly if the analysis focuses on SMEs.

Several analyses highlight the demand on training for AM processes but one of the most recent and direct ones has been published by Thomas-Seale et al.¹, where literally states that "A paradigm shift in education is required to increase graduates understanding of Additive Manufacturing" and subsequently identifies the Education as one of the barriers for the implementation of the AM processes. Most of the die & mould manufacturers in Europe are still SMEs with high innovation capacity but low or null training on Metal AM processes.

Thus, the 3.1 activity have involved the creation of a new educational program for engineer students, duplicated in all the universities and Engineering schools from ADDITOOL partners. This course include Theoretical courses, experimental work on labs and visits to the local ecosystem of each partners.

The training module have been dispensed by ENIT, ESTIA, FADA CATEC, IPLEIRIA and UPV/EHU in their own facilities. In addition, CEIT and LORTEK have also participated in the design and creation of the module and visits from the students to their facilities.

¹ L.E.J. Thomas-Seale, J.C. Kirkman-Brown, M.M. Attallah, D.M. Espino, D.E.T. Shepherd, The barriers to the progression of additive manufacture: Perspectives from UK industry, Int. J. Production Economics, Vol. 198, pp 104-118, 2018

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2. Training Module design

2.1. General Overview

The proposed Training Module includes specific training in Metal AM for the die and mold sector. A 10-day course has been designed for engineers and technicians with some experience in the sector and with a previous degree training. The aim is to go into more detail on specific aspects of Metal AM processes applicable to the tooling sector, including not only manufacturing processes, but also design and inspection procedures. Thus, the final objective is to accelerate the introduction of MAM techniques in die and mold companies through the training of specialized people. Within this objective, special emphasis is placed on the recruitment of people in SMEs.

In order to achieve this objective, the Training Course has been divided into 6 main modules, which are further divided into more specific topics. The aim is to cover all the relevant contents of Metal AM and its potential application in the tooling sector. The documentation, which has been created by all project participants, is distributed to all students and serves as a basis for the theoretical part of the course.

In addition, the course includes a 3 days practical part, where students can analyze real additive manufacturing systems, observe real parts in-situ and perform validation measurements. This content, given that experimental equipment is required, is adapted to each center that teaches the course, using the equipment available at each laboratory. Finally, there is a scheduled visit to a platform or to an industrial company working with AM.

The course content was selected based on feedback from the different partners. In a series of meetings, the modules were agreed upon to cover the most relevant content. The general content includes the following topics:

- Introduction to the tooling sector & MAM technologies
- Materials for MAM adapted to the tooling sector, including both powders and wires
- Multi-process design rules for PBF, DED wire laser, DED wire arc, DED powder laser, ...
- Topological optimization adapted to MAM
- Programming of trajectories both for cartesian machine-tools and robots
- Practical work, which will rely on equipment of each partners
- Visits to the local ecosystem

Once the modules were defined, they were distributed among the partners so that each one could elaborate the detailed slides and contents.



2.2. Training course modules

The training course is divided into 6 modules with a series of contents. All the modules include a series of slides and additional material (media, web links, references,...) to help to students to follow the content of the course.

The course has been designed with a face-to-face methodology, with the aim of involving the students in the theoretical classes as well as in the workshop practices and visits. However, the theoretical content is prepared for its potential implementation in online teaching platforms and the possibility of teaching the course remotely. As for the number of students, the limit is set by the facilities where the practice work is carried out, but in any case, the number of students per course is limited to 15. The following table show the content of each module:

TOPIC/MODULE TITLE	POSSIBLE CONTENT
	Market definition
INTRODUCTION TO THE TOOLING	Tooling type depending on activity
SECTOR	Tooling types
	Opportunities of MAM technologies
	AM processes overview
INTRODUCTION TO MAM	Material for tooling & choice criteria
TECHNOLOGIES	AM Raw material
	Market definition
	Metallurgy introduction
	PBF Laser
	Binder Jetting
DESIGN RULES FOR MAM	DED Wire Arc
TECHNOLOGIES & MANUFACTURING	DED Wire Laser
METHOD	DED Powder Laser
	FFF Metal
	AM post-processing
	General concepts
TOPOLOGY OPTIMIZATION	Application for the Die & Moulds
	Metal AM and TO
	Machine Kinematics
	Hybrid Machines
PROGRAMMING OF TRAJECTORIES	CAM programming for AM – Robot & Cartesian Machines
	PBF CAM step: Slicing and layer programming
	FFF CAM step: Slicing and layer programming
	Choice of the technology & the material
	Potential / Benefit
	Manufacturing procedures
MAM FOR TOOLING	Monitoring & Digital Twin
	Characterization & Metallurgy
	AM part inspection
	Practical training sheets



2.3. Training course accessibility and content

The training modules preparation were finished since January 2022, so the courses could start from these dates. Therefore, the implementation of the courses has follow a smooth and previously planned scheduled. Moreover, at the end of a course, an evaluation of the students was carried out, gathering their impressions, aspects for improvement, etc. The results were analysed and transmitted to the other partners to be considered in the implementation of the next course.

All the training modules and relevant information were shared on the Teams platform. The slides and content were organised by days and the presentations include also comments to explain the different subjects.

Docume	ents > General > ADDITOOL > WP3 Formati	ion > Act.3.1 Students	s training module
\Box	Nom \lor	Modifié 🗸	Modifié par \checkmark
	Day 1	26 novembre 2021	eukar.ehu
	Day 2	26 novembre 2021	eukar.ehu
	Day 3	26 novembre 2021	eukar.ehu
	Day 4 & 5	26 novembre 2021	eukar.ehu
	Day 6, 7 & 8	26 novembre 2021	eukar.ehu
	Term of References	5 mai 2021	Pierre DIAZ
P *	ADDITOOL Ejemplo presentacion WP3.pptx	29 septembre 2021	Pierre DIAZ
	Training Module structure.docx	29 septembre 2021	Pierre DIAZ
X	WP3 - Training Course Content.xlsx	16 février	Fábio Jorge Pereira

In any case, each entity was free to adapt the planning and modify the scheduling, depending on the availability of the workshops, time slots,...



3. Training Module organization

Once the design and the content of the course was available, a schedule was proposed for the different partners that participated in the activity. The courses started on February 2022 and finishes on June 2022. An additional course (not planned in the proposal) was carried out during January 2023. The following list shows the detailed dates and sites of the training modules.

ORDER NR.	PARTNER	DATES						
1 st Training	ENIT	January 24 th to February 04 th 2022						
2 nd Training	ESTIA	March 07 th to March 18 th 2022						
3 rd Training	FADA CATEC	May 23 rd to June 2 nd 2022						
4 th Training	IPLEIRIA	May 2 nd to May 13 th 2022						
5 th Training	UPV/EHU	June 6 th to June 16 th 2022						
6 th Training	ENIT	January 16 th to January 20 th 2023						

In total, 60 students were trained during 2 weeks, mainly last year engineers and PhD researchers, but also people coming from companies.

Regarding to the evaluation, an open questionnaire has been uploaded for the students to obtain information and opinion about the modules.

Questionnaire : Evaluation of the Training	Objectives and results of the prestation : (0 : Totally disagree, 5 : Totally agree)						
pilot		0	1	2	3	4	5
This questionnaire is for the evaluation of the Educational pilot realized by the consortium of ADDITOOL. It concerns all the Educational pilots of the project. We thank you to select the pilot you attended and to be as exhaustive as possible on your answers.	Your goals and expectations have been understood and taken into account						
	The results of the module are in line with your expectations						
Name : (facultative)	•						
Tu respuesta	Comments :						
	Tu respuesta						
What module did you attend?							
O ENIT	Quality of the pr	estation : (0 : Totally d	isagree, 5 :	Totally agre	ee)	
O ESTIA		0	1	2	3	4	5
O FADA CATEC	The contents are adapted and pertinent.						
O IPLEIRIA O UPV/EHU	The time of the realization of the prestation were enough.						



3.1. First training: ENIT (January 24th to February 04th 2022)

Place:	École Na	tionale d	Ingénieur	rs de Tarl	oes – FN	IT			
		cionale u	ingenieu	Juciult					
Dates of the course:	From Jar	nuary 24t	h to Febru	ary 04th	2022				
Number of students:	12 stude	nts							
Training &	Training	on both s	study and	research	facilitie	s (LGP	and CRT	CI of ENI	Г)
students:	Visit of E		ldimadou			-			
	24/01/2022 Introduction to the tooling sector (J.Alexis) CRTCI 1	25/01/2022 Design rules for mam technologies & manufacturing method (Y. Balcaen) CRTCI 1	26/01/2022 MAM for tooling (M. Mokhtari) CRTCI 1	27/01/2022 Programming of trajectories (M. Benoussaad) Salle pédagogie active	28/01/2022 Visit of associate partners (ESTIA)	31/01/202 Topology optimisatic (A.Vezerian CRTCI 1	MAM for tooling	2/02/2022 MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	3/02/2022 MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.
	Introduction to the tooling sector (V. Nassiet) CRTCI 1	Design rules for mam technologies & manufacturing method (Y. Balcaen) CRTCI 1	MAM for tooling (M. Mokhtari) CRTCI 1	Programming of trajectories (M. Benoussaad) Salle pédagogie active	Visit of associate partners (ESTIA)	Topology optimisatic (L.Arnaud) CRTCI 1	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.
	Introduction to MAM Technologies (J.Alexis) CRTCI 1	Design rules for mam technologies & manufacturing method (Y. Balcaen) CRTCI 1	MAM for tooling (M. Mokhtari) CRTCI 1	Programming of trajectories (practical works) (F. Nourredine) Labo Robotique	Visit of associate partners (ESTIA)	Topology optimisatic (Practical works) (L.Arnaud) BE1	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.
	Introduction to MAM Technologies (J.Alexis) CRTCI 1	troduction to Design rules for MAM for tooling IAM mam (M. Mokhtari) technologies & CRTCl 1 Alexis) manufacturing			Visit of associate partners (ESTIA)	Topology optimisatic (Practical works) (L.Arnaud) BE1	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.	MAM for tooling (practical works) (A.Ayed) CRTCI 1 + LABO.
		4 days of	lectures				4 days of	f practical	works
				1 day	of partne	ers visit			
Photos:									



3.2. Second training: ESTIA (March 07th to March 18th 2022)

Place:	Ecole Supérie	eure	des Technologies - ESTIA				
Dates of the course:	From March	07tl	n to March 18th 2022				
Number of students:	10 students						
Training & Visits:	Training on A	٨ddi	madour platform				
	Jour		Nom du module	Nom intervenant			
	Lundi 07/03/22		MODULE 1_01 Introduction_notes MODULE 1_02 Glass Moulds MODULE 1_03 METAL_Forming_Tools MODULE 1_04 Molds For Plastics_notes MODULE 1_05_Intro_Die_Casting_Moulds MODULE 1_05_Intro_Die_Casting_Moulds	Pierre DIAZ			
	8h3 Mardi 08/03/22		Introduction Procédés Fabrication Additive + Visite MODULE 2_01 Material for tooling and choice criteria MODULE 2_02 AM Raw material powder MODULE 2_03 AM Raw material Wire MODULE 2_06 Metallurgy Introduction MODULE 3_06 AM Post-processing	Pierre MICHAUD			
		h - 18h n - 18h	MODULE 3_01 Design Rules PBF Laser MODULE 3_02 Design Rules Binder Jetting MODULE 3_03 Design Rules WIRE Arc & Laser	Pierre DIAZ			
Short	merered 05,05,22 5h		MODULE 3_04 Design Rules_FFF Metal Charged MODULE 3_05 Design_Rules_DED Powder Laser				
	Jeudi 10/03/22 9h	n - 18h	MODULE 4_01 Topology Optimization	Pierre DIAZ			
description:			MODULE 5_02 Hybrid Machine Tools	Fabien POULHAON ou Valentin PEIGNE			
	Vendredi 11/03/22 9h -	- 12h30	MODULE 5_03 DED Powder Programming MODULE 5_04 LPBF Programming	Fabien POULHAON			
	14	h - 18h	MODULE 5_04 Programming_DED_Wire	ADAXIS			
			ADDITOOL_ENIT_Characterization_and_metallurgy V4	Pierre MICHAUD & Fabien POULHAON			
			MODULE 6_05 Monitoring_digital twin TP Lynxter 2h // Assignment Optim Topo 2h 2 groupes	Pierre DIAZ			
	1403	50 - 1011	TP WAAM Groupe 1	Anais DOMERGUE			
	Mardi 15/03/22 9h	n - 18h	TP WLAM Groupe 2	Pierre DIAZ			
			TP BeAM Groupe 3 TP WAAM Groupe 3	Valentin PEIGNE Anais DOMERGUE			
	Mercredi 16/03/22 9h	n - 18h	TP WLAM Groupe 1	Pierre DIAZ			
			TP BeAM Groupe 2	Valentin PEIGNE			
	Jeudi 17/03/22 9h	n - 18h	TP WAAM Groupe 2 TP WLAM Groupe 3	Anais DOMERGUE Pierre DIAZ			
	Jeddi 17/03/22 51	1- 100	TP BeAM Groupe 1	Valentin PEIGNE			
	Vendredi 18/03/22 9h	n - 18h	Visite LAUAK et SOMOCAP	Pierre DIAZ			
Photos:							



3.3. Third training: FADA - CATEC (May 23rd to June 2nd 2022)

Place:	FADA - CATEC		
Dates of			
the course:	From May 23rd to June 2r	nd 2022	
Number of students:	14 students		
Training & Visits:	Training on CATEC Facilitie Visit to ARUS	25	
VISILS.	VISIT TO ANOS		
	Day	Content	Lecturers
	Day 1	MODULE 1 - Introduction and visit to CATEC	Carlos Galleguillos/ Antonio Periñán
	Day 2	MODULE 2 - Materials	Álvaro Nieto/Ignacio González-Barba
Short	Day 3	MODULE 3- Design rules	Daniel Hervás
description :	Day 4	MODULE 4 - Topology optimization	Jorge Sogorb/Pablo Gómez
	Day 5	MODULE 5 - AM programming	Javier Santaolaya
	Day 6	MODULE 6 Quality Assurance of AM components	Carlos Galleguillos
	Day 7 and 8	Practical exercises-labs	
	Day 9	Visit to ARUS	
Photos:			



3.4. Fourth training: IPLEIRIA (July 14th to July 22nd 2022)

Practical Application – SLM Olivier Gouveia Processmerie (Proint Part) Divier Gouveia Visit to Company: Evolo Pedro Mattinho Pedro Mattinho Fablo Simões Montorreg and Digital Tiven (20) Fablo Simões	Deceste
students: 6 Training & Visits: Training on CDRSP facilities Visits: Visits to Moldetipo, Vidrimolde, EROFIO and NM3DIbérica Short Image: Comparison of the second of the se	Decester
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Short description : · · · · · · · · · · · · ·	
Short description	Olivier Gouveia
Short description : -PBF WorkfLOW -PBF WorkfLOW -PBF WorkfLOW -PBF WorkfLOW -PBF Pagammig [30 min] -PBF Pagamig [30 min] -PBF Pagammig [30 mi	António Silva
Description Discontribution Discontribution L-PBF WORKFLOW Discente L-PBF WORKFLOW Discente Discente MAM FOR TOOLING 3 19-07-2022 20-07-2022 21-07-2022 22-07-22 Machine Kinematics (20 min) Filipe Castanheira Filipe Castanheira Chicke of Technology (15min) Filipe Simoles Prescient Application - StM Offinier Gouveia With tis Company: Enello Pedro Martinio Filipio Simoles Chicke of Vectorial (20 min)	
Image: second	
19-07-2022 20-07-2022 21-07-2022 22-07-22 Machine Kinematics (20 min) Filipe Catathelea Hybrid Machine Tools (20 min) Filipo Simoles Obice of Technology (15 min) L-PBP Frogramming (30 min) Antonio Silva Barbine Technology (15 min) Filipo Simoles Obice of Technology (15 min) Partical Application - Stati Olivier Gouvela Visit to Company: Evalo Pedro Martinho Olivier Gouvela Prostowning Provider Lawier Programming (30 min) Olivier Gouvela Visit to Company: Evalo Pedro Martinho	
L-PBF Programming [30 min] Antainio Silva	
Pactical Application – SLM Phactical Application – SLM Processmine (Provert Sam) Olivier Gouveia Pedro Marinho Pedro Mari	/ Paulo Novo
Paid braining Pa	s / Paulo Novo
	s / Paulo Novo s / Ruben Silva
António Silva de Montílio and Practical Application - DE Plasma - CN CC Goffee brook	
Olivier Gouveia AM post-processing Paulo Novo António Situa	
Lunch + Mesa redanda com Lunch Lunch	
Robot assisted manufacturing Filipe Castanheira AH Part inspection Paulo Novo Robot programming Filipe Castanheira Filipe Castanheira AH Part inspection Paulo Novo	
Olivier Gouveia	
Workflow and Petricking Application - António Silva Antonio Silva	o Custódio o Simões



3.5. Fifth training: UPV/EHU (June 6th to June 16th 2022)

Place:	UPV/EHU
Dates of the course:	From June 6th to June 16th 2022
Number of students:	11 students
Training & Visits:	Training on Faculty of Engineering and CFAA (UPV/EHU) Visit to LORTEK (Topology MODULE) and BIEMH'22
	Lunes 6 de junio Martes 7 de junio Miércoles 8 de junio Jueves 9 de junio Viernes 10 de junio 9:00-9:30 Lunes 6 de junio Martes 7 de junio Miércoles 8 de junio Jueves 9 de junio Viernes 10 de junio 9:00-9:30 11 - Introducción Sector Molde AulaMH AulaMH T1 - Introducción Sector
Short description :	In:so-10:30 AulaMH 10:30-10:30 AulaMH 10:30-11:30 T2 - Metal forming 11:30-11:30 T2 - Metal forming 11:30-11:30 T3 - Plastic Moulds 11:30-11:30 AulaMH 12:00-12:30 AulaMH 12:00-12:30 T3 - Hilo para AM
	14:30-15:00 AulaMH 15:00-15:30 Taller EIB Práctica de Materialev de aporte AulaMH 15:30-16:00 T3-Design rules PBF 16:00-16:30 T3-Design Rules FFF 16:30-17:00 T5-Design Rules L-DED 16:30-17:00 T6-Postprocessing
Photos:	<image/>



3.6. Sixth training: ENIT (January 16th to January 20th 2023)

Place:	École Nationale d'Ingénieurs de Tarbes – ENIT
Dates of the course:	From January 16 th to January 20 th 2023
Number of students:	12 students
Training & Visits:	Training on both study and research facilities (LGP and CRTCI of ENIT) Visit of ESTIA – Addimadour platform and to Lynxter campany
Short description:	Not planned initially. 2 nd course at ENIT. 2 days lecture and 2 days experimental classes 1 day visit on Addimadour platform (ESTIA): presentation of AM equipment's
Photos:	



4. Evaluation results

In the following section, the results of the evaluation questionnaire are presented. The results are based on the answers that students have chosen after the finishing of the module. The results are presented for a general overview, but they can be analysed individually for each training module or focusing on determined questions.

4.1. Questionnaire design

The questionnaire was designed and uploaded using Google Forms tool. Since all the students have a Google account, 100% of potential answers were available.

The form was designed with the double objective of getting information but with minimum effort. Therefore, each student could finish the questionnaire in less than 3 minutes.

Some examples of questions and format are presented below.

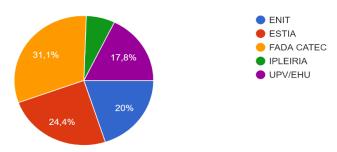
Objectives and res	Objectives and results of the prestation : (0 : Totally disagree, 5 : Totally agree)								Quality of the prestation : (0 : Totally disagree, 5 : Totally agree)								
	0	1	2	3	4	5			0	1	2	3	4	5			
Your goals and expectations have been								The contents are adapted and pertinent.									
understood and taken into account								The time of the realization of the prestation									
The results of the module are in line with your expectations								were enough. The deliverables are satisfying									
Comments : Tu respuesta	expectations Comments :							Comments : Tu respuesta									
How do you rate your le	vel on MA	M before th	ne Training	module?			Do you recommand this Training Module?										
No experience							O YES O NO										
Basic experience Good experience																	
O Expert																	
							Suggestion(s) to improve this module :										
How do you rate your le	vel on MA	M after the	Training m	iodule?			Tu respuesta										
O No experience																	
O Basic experience							F	ree comments	and appre	ciation :							
Good experience																	
O Expert	Expert									Tu respuesta							



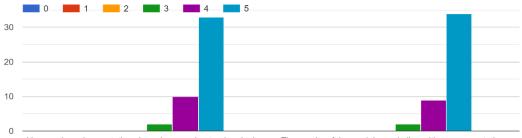
4.2. Evaluation results

The results of the course evaluation are shown below.

What module did you attend? 45 réponses

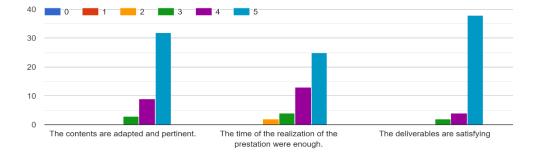


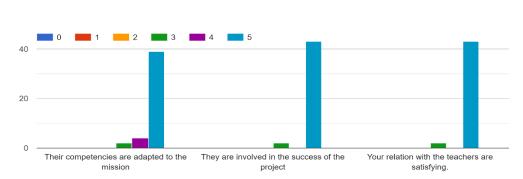
Objectives and results of the prestation : (0 : Totally disagree, 5 : Totally agree)



Your goals and expectations have been understood and taken The results of the module are in line with your expectations into account

Quality of the prestation : (0 : Totally disagree, 5 : Totally agree)

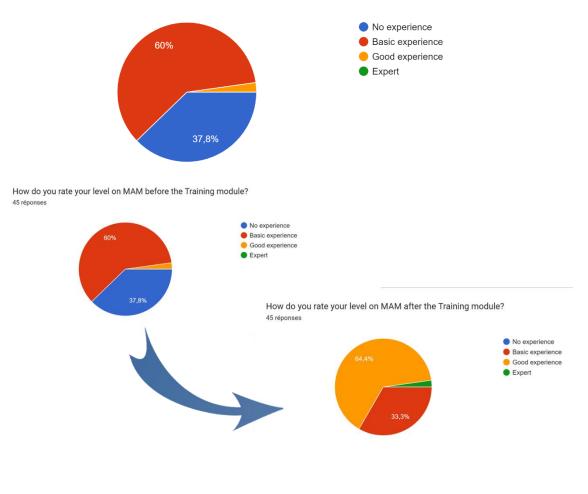




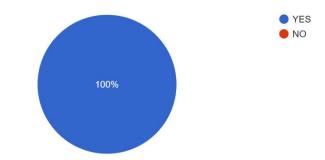
Satisfaction with teachers : (0 : Totally disagree, 5 : Totally agree)



How do you rate your level on MAM before the Training module? ^{45 réponses}



Do you recommand this Training Module? 45 réponses





5.Conclusions

The "Learning" activity of the ADDITOOL project has concluded with results that exceed initial expectations. First of all, more than 60 people have been trained in MAM technologies, which will help companies to adopt these technologies more easily and gradually. On the other hand, knowledge and experience has been shared among the different project partners, to obtain an advanced training course on MAM technologies that has been of high interest to students.

In addition, there have been visits and activities added to the course itself, which has enriched both the students and the people who have organized and taught the courses.

A final evaluation have concluded that a very efficient use of resources has been made, since different partners with different teams and specialties have been involved. Thus, each partner has developed a section of the course in which it was specialized, adding up to a set of documents and practices of great value for the students. It has been concluded that obtaining this result by a single partner would have been extremely complex and expensive.

The course has been given in 5 different centres with 6 editions (one of them not foreseen at the beginning of the project) and in all of them there has been a high level of interest from the participating students. The results of the surveys agree on the quality ands the degree of the capacitation.

In summary, thanks to the ADDITOOL project, 60 people have been trained over the course of a year to help integrate additive manufacturing technologies in companies. In addition, the design and development of the course has served to create collaborative links between partners and associate partners.





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