

BET ABRAM - REFERENCE DOCUMENT

BetAbram is a 3D Printing project based in Slovenia, and led by Joze Abram with a small team of enthusiasts. The projects aim is to bring 3D Construction Printing to the everyone, by selling extremely affordable printers.

The printers movement is a gantry system of various sizes, up to 9 x 16 meters in its largest model. The 3d printing software used is mostly open source desktop variants, adapted to the larger system. The machine extrudes fresh concrete that hardens with time in open air conditions, following a typical material extrusion process. Currently, the machine uses traditional construction pumps to deliver materials with a smaller aggregate, in the mortar range. There is extensive use of additives in order to enhance the hardening and pumpability properties, making the material very similar to sprayed concrete (or shotcrete).

Apart from a few smaller prototypes, which include a 1,5m high spiral stair, the project has not produced many structures. There is also no research of the 3D Printed material. The focus of the project is mostly concentrated on developing the machine.

Despite some media attraction in the first years of existence, the company has seen financial issues in the last couple of years, and has had troubles restarting ever since. The of the facility is a very "home made", low production facility, with a lot of work ahead to be able to achieve its goals.



Company: Interelab / BetAbram

Technology: BetAbram

Issued by: Anes Jakupovic, 3D Printhuset A/S

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C o e m p e r a l n o m p & n t	Year of establishment	2012								
	Year of entering into construction	2014								
	Number of employees	Less than 10	Less than 25	Less than 50	Less than 100	Less than 500	Less than 1000	More than 1000	Unknown/Undefined	
	Targeted market	Printers	Printer parts	Materials	Furniture/Sculptures	Building components	Building projects	Other	Unknown/Undefined	
	Development stage of printers	Conceptual	Prototypes	Working products	Commercial products	Other	Unknown/Undefined			
	Development stage of printed materials	Conceptual	Prototypes/Test prints	Usable products	Commercial products	Other	Unknown/Undefined			
	Patent(s) status	Not patented	Patent pending	Patent granted	Other	Unknown/Undefined				
	Patent coverage	Printer design	Printing technology	Material	Nozzle/Deposition system	Material feeding system	Movement system	Software/Firmware	Other	Unknown/Undefined
	Largest print up to date (size)	Less than 1m3	Less than 5m3	Less than 10m3	Less than 25m3	Less than 50m3	Less than 100m3	More than 100m3	Unknown/Undefined	
	Largest print up to date (category)	Minor test prints	Furniture/Sculptures	Building elements	Less than 50m2 buildings	Less than 100m2 buildings	More than 100m2 buildings	Multiple storey building	Other	Unknown/Undefined
T e c h n o l o g y	Additive Manufacturing technology type	Material Extrusion (Layered)	Material Extrusion (Suspended)	Binder Jetting	Other	Unknown/Undefined				
	Form Freedom	2D freedom	2.5D freedom	3D freedom	Full 3D freedom	Other	Unknown/Undefined			
	Fabrication location	In situ	On-site prefabrication	Off-site prefabrication	Partial prefabrication	Other	Unknown/Undefined			
	Fabrication approach	Direct fabrication	Semi-direct fabrication	Component fabrication	Formwork fabrication	Stay-in-place formwork fabrication	Cover/Engulfing fabrication	Other	Unknown/Undefined	
P r i n t e r	Movement system	Cartesian gantry	Delta gantry	Robotic arm	Mobile robotic vehicle	Cable suspension	Other	Unknown/Undefined		
	Maximum printable volume	Less than 1m3	Less than 5m3	Less than 10m3	Less than 25m3	Less than 50m3	Less than 100m3	More than 100m3	Unknown/Undefined	
	Maximum printable area	Less than 1m2	Less than 2m2	Less than 5m2	Less than 10m2	Less than 25m2	Less than 50m2	More than 50m2	Unknown/Undefined	
	Deposition method	Jetting	Pressure extrusion	Mechanical extrusion	Mechanical movement	Gravity deposition	Sintering/Welding	Other	Unknown/Undefined	
	Number of print heads	Single	Multiple	Array	Other	Unknown/Undefined				
	Print Head/ Nozzle diameter	Less than 1mm	Less than 5mm	Less than 10mm	Less than 25mm	Less than 50mm	Less than 100mm	More than 100mm	Unknown/Undefined	
	Print head/ Nozzle features	Three axis motion	Rotational/Tangential motion	Omni-directional motion	Troweling mechanism	Other	Unknown/Undefined			
	Material feeding system	Manual	Included, semi-automated	Included, fully automated	Separate, semi-automated	Separate, fully automated	Other	Unknown/Undefined		
	Theoretical printing speed	Less than 0.1 m3/h	Less than 0.5 m3/h	Less than 1m3/h	Less than 2m3/h	Less than 5m3/h	Less than 10m3/h	Less than 20m3/h	More than 20m3/h	Unknown/Undefined
	Actual printing speed	Less than 0.1 m3/h	Less than 0.3 m3/h	Less than 0.5 m3/h	Less than 1m3/h	Less than 2m3/h	Less than 5m3/h	Less than 10m3/h	More than 10m3/h	Unknown/Undefined
	Accuracy	Less than 5mm	Less than 10mm	Less than 50mm	Less than 100mm	More than 100mm	Unknown/Undefined			
	Printer (diss) assembly speed	Less than 1 hour	Less than 10 hours	Less than 24 hours	Less than 2 days	More than 2 days	Other	Unknown/Undefined		
	Price per printer unit	Less than 10.000\$	Less than 50.000\$	Less than 100.000\$	Less than 250.000\$	Less than 500.000\$	More than 500.000\$	Unknown/Undefined		
M a t e r i a l	Material possibilities	Single material	Multiple materials	Structure/Support material	Other	Unknown/Undefined				
	Material type	Traditional concrete	Alternative concrete	Clay	Soil	Plastic	Metal	Resin	Other	Unknown/Undefined
	Price	Less than 50\$/m3	Less than 100\$/m3	Less than 150\$/m3	Less than 300\$/m3	Less than 500\$/m3	Less than 1000\$/m3	Less than 2000\$/m3	More than 2000\$/m3	Unknown/Undefined
	Compression strength	Less than 5MPa	Less than 15MPa	Less than 25MPa	Less than 50MPa	Less than 100MPa	Less than 200MPa	More than 200MPa	Unknown/Undefined	
	Tensile strength	Less than 1MPa	Less than 3MPa	Less than 5MPa	Less than 10MPa	More than 10MPa	Unknown/Undefined			
	Aggregate size	No aggregates (Paste)	Up to 2mm (Fine mortar)	Up to 4mm (Rough mortar)	Up to 6mm (Fine concrete)	Up to 16mm (Concrete)	Up to 40mm (Rough concrete)	Over 40mm (Rough concrete)	Other	Unknown/Undefined
	Aggregate weight (kg/m3)	Ultralightwt. (<500)	Lightweight (500-1000)	Normal weight (1000-2000)	Normal weight (1000-2000)	Heavyweight (<2000)	Unknown/Undefined			
	Material verification	Conceptual	Prototype	Partially tested	Extensively tested	Certified	Other	Unknown/Undefined		
	Material hardening time	Less than 1 hour	Less than 10 hours	Less than 24 hours	Less than 2 days	Less than 5 days	Less than 10 days	More than 10 days	Other	Unknown/Undefined
	Material usability time	Less than 15 minutes	Less than 60 minutes	Less than 2 hours	Less than 5 hours	Less than 10 hours	More than 10 hours	Other	Unknown/Undefined	
	Raw material price	Less than 50\$/m3	Less than 100\$/m3	Less than 150\$/m3	Less than 300\$/m3	Less than 500\$/m3	Less than 1000\$/m3	Less than 2000\$/m3	More than 2000\$/m3	Unknown/Undefined
Raw material availability (in construction)	Industry standard	Extensively used	Partially used	Niche usage	Not used	Other	Unknown/Undefined			