

## 3DTY Demonstration 05 – Wall panel

Printed by: REDU

This demonstration aims to show the capabilities of non-planar slicing and explore the limits of layer height variation during continuous extrusion printing.

Parts were printed using variable feed rate to slow the robot movement down in sharp corners. This helps to smooth tilting in places where robot orientation has to change drastically in a short time.

Geometry was optimized for large format AM.

### Print info: Wall panels

**Material:** Selenis Mimesis DP300 PETG

**Total weight:** ~ 47kg

**Print time:** 3-4h per piece

**Software:** Rhino Grasshopper & Siemens NX

**Hardware:** CEAD AM Flexbot

Nozzle size: 4mm

Layer height: 0.8-2.5mm

Layer width: 6 mm

Layer time: ~ 40sec.

