

## 3DTY Demonstration 08 – Bar table & Stools

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This demonstration aims to find new ways of reducing material usage by optimizing the manufacturing process for wider design possibilities of 3D printed furniture. These products are assembled from pieces which allows more efficient packaging for transportation.

Parts were printed multiplanar on top of a curved 3D printed mold surface. Alignment holes were drilled after printing using the robot.

Sulapac Flow 1.7 has 72% USDA certified biobased content with wood from industrial side streams and biodegradable biopolymers. It also meets EU and US FDA requirements for food contact materials. More information can be found from [sulapac website](#).

KCL Biocomposites (formerly UPM Formi 3D 20/19)  
[KCL website](#)

Link to video: [Bar table manufacturing timelapse](#)



### Print info: Bar table

**Material:** Sulapac Flow 1.7 & KCL Biocomposites (UPM Formi)

**Weight:** 9kg

**Print time:** 40 min x3

**Software:** Rhino Grasshopper & Siemens NX

**Hardware:** CEAD AM Flexbot

Nozzle size: 18 mm

Layer height: 5 mm

Layer width: 30mm

Layer time: 380sec

### Print info: Stools

**Material:** Sulapac Flow 1.7

**Weight:** 7kg

**Print time:** 40min x3

**Software:** Rhino Grasshopper & Siemens NX

**Hardware:** CEAD AM Flexbot

Nozzle size: 18 mm

Layer height: 5mm

Layer width: 30mm

Layer time: 380sec