3DTY Demonstration 09 – Small Stool

Printed by: REDU

Four legs were printed consecutively to expedite the manufacturing process. The part was printed in horizontal orientation. The geometry was optimized for large format AM.

For this part Sulapac Flow 1.7 was used. It contains 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.

The material reacts quickly to humidity and is susceptible to warping when cooling down during the printing process in typical industrial hall conditions without chamber. When printing large structures, it is important to ensure good adhesion to the print bed, preferably with mechanical fastening.

Print info: Stools

Material: Sulapac Flow 1.7
Weight: 3kg
Print time: 8min. per leg
Software: Siemens NX
Hardware: CEAD AM Flexbot
Nozzle size: 12 mm
Layer height: 5 mm
Layer width: 15.5 mm
Layer time: 180sec.