

**Phase I
Screening**

Definition of
the virgin /
recycled
material

DoE
Selection of
parameters
and initial
range

Mechanical
testing

ANOVA

Focus on significant factors

**Phase II
Focusing**

Extension of
the factor
ranges

Experimental
design

Mechanical
testing

**Phase III
Anisotropy**

Variation of
printing
orientation

Experimental
design

Mechanical
testing

