

**Phase I  
Screening**

Definition of  
the Virgin /  
Recycled  
material

DoE  
Selection of  
Parameters  
and initial  
range

Mechanical  
test

ANOVA

Focus on significant factors

**Phase II  
Focusing**

Extension of  
the factor  
ranges

DoE

Mechanical  
test

**Phase III  
Anisotropy**

Variation of  
printing  
orientation

DoE

Mechanical  
test

