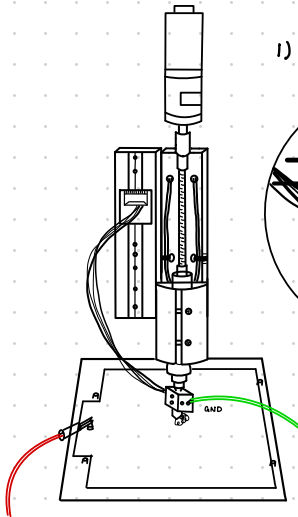
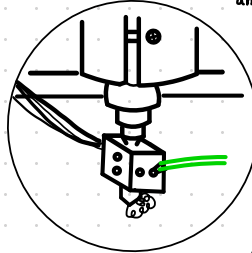


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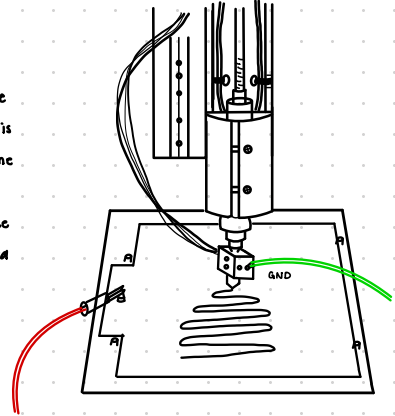


1) When attempting to find the ideal nozzle and cartilage

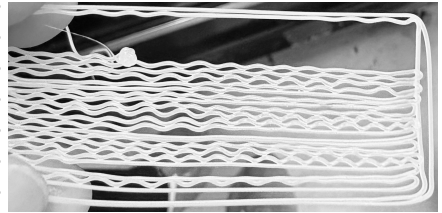
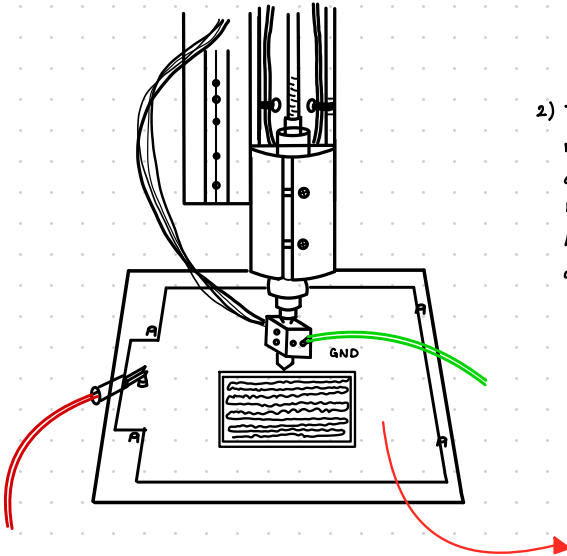


temperature ratio, we noticed that when the cartilage temperature is above 100°C , the

material starts to curl upwards towards the nozzle heater. Once the nozzle temperature was adjusted to 90°C , the issue was resolved.



2) Instead of immediately sticking to the bed, the extruded material dragged on the plate, therefore the shape became distorted. Therefore, we increased the flow rate from $1200 \rightarrow 6000$ and decreased the bed speed from $1000 \rightarrow 700$. After these adjustments were made, the shape distortion decreased by $75-80\%$.



3) At the bed speed of 500 , we saw waves being created in the print. Therefore, we increased the speed to 6000 and the shape distortion from the waves minimized.