

Advancing PLA 3D Printing with Laser Polishing: Improving Mechanical Strength, Sustainability, and Surface Quality

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Table S1. Laser parameters.

Parameter	Value
Laser on delay	30 μ s
Mode quality (M ²)	1.24
Power stability	<+ or -5.5%
Laser off delay	150 μ s
Mark delay	180 μ s
Poly delay	170 μ s
Jump delay	200 μ s
Jump speed	3000 mm/s