



Figure S1. The geometry of the injection moulded part with the sprue and runners.

Table S1. Injection moulding processing parameters.

Process Parameters	Values
Melt Temperature	270 °C
Packing pressure	35 MPa
Packing time	10 sec
Injection speed	20 cm ³ /sec
Cooling time	30 sec
Mould temperature	80 °C