Table S1: Summary of the data gathered from publications considered in this systematic review

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
Nifedipine	Polyvinyl alcohol (PVA)	Soaking	4%	A FlashForge Creator Pro	-	223	Sustained release	Spherical mini-tablets	(1)
	Kollidon VA64 (KVA) and ethylcellulose (EC)	Single screw extruder	30%,40 %,50% and 60%		110-165				
venlafaxine hydrochloride	hydroxypropyl methylcellulose (HPMC) polylactic acid (PLA)	Single screw extruder	25%	Raise 3D Pro2-series	160 °C	185 °C For HPMC 210 °C, for PLA	Sustained release	Intragastric floating tablets	(2)
Deflazacort	poly(e-caprolactone) (PCL) and Eudragit RL100(ERL)	Soaking	0.14%-0.22% for ERL and 0.06%-0.6% for PCL	MakerBot Replicator 2,	-	170 °C ERL and 95°C PCL	Controlled release	Tablets	(3)
paracetamol or caffeine	Polyvinyl alcohol (PVA)	Single screw extruder	5% and 10%	MakerBot Replicator 2X	180 °C	200 °C	Controlled release	Caplets	(4)
Metformin HCl	Polyvinyl alcohol (PVA)	Soaking	0.08% in absolute ethanol and 1.40% in ethanol-water (9:1)	Makerbot experimental 2×	-	205°C	Sustained release	Tablets	(5)
Hydrochlorothiazide	hypromellose acetate succinate (HPMCAS)	Twin-screw extruder	5%	MakerBot Replicator 2X	165	170	Sustained release	Tablets	(6)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
Felodipine	Polyvinyl alcohol (PVA)	Single-screw extruder	5% and 15%	MakerBot Replicator 2X	170 and 190°C	165-180	Prolonged release	Tablets	(7)
Isoniazid	Hydroxypropyl Cellulose (HPC)	Single-screw extruder	30%	A MakerBot Replicator 2	100-155	165-195	Sustained release	Tablets	(8)
celecoxib	Polyvinyl Alcohol (PVA)	Single-screw extruder	10%	Prusa i3 MK3S printer	175 °C	205	Sustained release	Tablets	(9)
Pramipexole	combinations of Eudragit EPO and polyethylene oxide	Single-screw extruder	0.7%	MakerBot Inc	120-130	160°C to 175°C	Immediate release	Tablets	(10)
felodipine	Eudragit E PO, Soluplus	Twin-screw extruder	10%	MakerBot Replicator II desktop	100-130	150	Sustained release IN PH6.8 and immediate IN PH 1.2	Discs	(11)
Quinine	Eudragit RS, polycaprolactone (PCL), poly(L-lactide) (PLLA), and ethyl cellulose (EC)	Solvent casting and subsequent hot melt extrusion (HME)	5%	Multirap M420	47-140	53-164	Controlled release	Implants	(12)
5-Fluorouracil	Eudragit® L100-55 and Eudragit® S100	Single-screw extruder	0.54%-2.04%	MakerBot Replicator ® 2X	150 °C, except for one formulation extruded at 165 °C	182 °C	Controlled release	Hollow pH-responsive tablet	(13)
anhydrous caffeine	Poly vinyl alcohol (PVA)	Microwave impregnation	> 0.95%	Ultimaker	-	215	Sustained release	Gastro-retentive capsular devices	(14)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
hydrocortisone	Affinisol® 15LV and Kollidon® VA64.	Twin-screw extruder	10% and 20%	Prusa® i3MK3 3D desktop printer	90-140	155-210	Immediate release	Mini-waffle	(15)
paracetamol	hydroxypropyl methylcellulose (HPMC) - Affinisol™ LV15	Twin screw extruder	5 to 50 wt%	STARTT printer kit	150°C - 210°C	190 °C	Sustained release	Tablets	(16)
ketoprofen,	hydroxypropyl methylcellulose (HPMC-K4M), hydroxypropyl methylcellulose acetate succinate (HPMCAS HG), and Hydroxypropyl Cellulose (HPC LF)	Twin-screw extruder	30%	Prusa i3 MK3S kit	150	200 ◦C	Controlled release	Tablets	(17)
Caffeine	Hydroxypropyl-cellulose (HPC), Kollidon VA64 and Kollicoat IR	Twin-screw extruder	5%- 20%	BoltPro 1.75 mm 3D-printer	120°C - 145°C	155-180°C	Immediate release	Tablets	(18)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
Acetaminophen	Hydroxypropyl Cellulose (HPC), hydroxypropyl methylcellulose (HPMC), Polyethylene oxide (PEO) and Eudragit RS	Twin-screw extruder	1%	Prusa FDM 3D printer	185 ◦C.	200	Controlled release	Multifunctional core–shell model	(19)
curcumin	Polyvinyl alcohol (PVA)	Soaking	5%	FDM-200W, Ninjabot,	-	210	Delayed release	Tablets	(20)
Atorvastatin calcium and Amlodipine besylate	polyvinyl alcohol (PVA)	Twin-Screw Extruder	2,2.5,5% FOR AMLO 20-30% for atorva	Prusa i3 3D desktop printer	160-180	180-187	Immediate release	Shell-core tablet	(21)
theophylline	Eudragit RL	Twin screw extruder	30%	Prodim XXL printer	140-180	180 C	Sustained release	Tablet	(22)
paracetamol and domperidone	Polyvinyl alcohol (PVA)	Twin screw extruder	para 40% 10-20% for domp	FDM ZMorph® 2.0 S personal fabricator	145-200	165 to 250	Immediate release	Orodispersible tablets	(23)
placebo	hydroxypropyl methylcellulose (HPMC) and ethyl cellulose (EC)	Twin screw extruder		Prusa i3/MK3	190 C	180		Rectangular shapes solid	(24)
ketoprofen	Polyvinyl alcohol (PVA)	Twin screw extruder	20-40-50%	FDM ZMorph® 2.0 S personal fabricator	130°C to 175°C,	175 to 190	Sustained release	Oblong tablets	(25)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
Prednisolone	hydroxypropyl methylcellulose (HPMC)	Twin screw extruder	2.5, 5, 10 and 20	Ultimaker 3	150-180	200-220◦C	Not mentioned	Tablets	(26)
naproxen	Kollidon® VA 64	Twin screw extruder	10%, 20%, and 30%	Ultimaker 3 printer	140-160	160	Immediate release	Tablet	(27)
paracetamol, hydrochlorothiazide celecoxib	hydroxypropyl cellulose (HPC EF), Polyvinyl alcohol (PVA) and hydroxypropyl methylcellulose acetate succinate (HPMC-AS LG)	Twin screw extruder	10%, and 30%	Prusa i3 MK3S printer	115-210	140-220	Sustained release	Tablets	(28)
naringenin	hydroxypropyl methylcellulose acetate succinate (HPMCAS), polyvinyl alcohol (PVA), and Eudragit RL PO	Twin screw extruder	over 25%	Voolt FDM 3D printer model Gi3	140-150	180-190	Sustained release	Cylinder shape printlets	(29)
Ramipril	Kollidon VA64 and Kollidon 12PF	Single-screw extruder	3%	MakerBot Replicator 2X Desktop	65-70	90	Immediate release	Tablets	(30)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
dipyridamole and theophylline	Eudragit EPO and Eudragit RL	Coordinated 3D printing and liquid dispensing	1.5% of dipyridamole 4% of theophylline	Makerbot Replicator Experimental 2×	-	135-170	Immediate and extended release	Liquid capsules	(31)
paroxetine	hydroxypropyl cellulose (HPC LF)	Single-screw extruder	30%	Delta WASP 2040 Turbo 2, Wasp	90-120	190-220	Sustained release	Tablets	(32)
Nifedipine	Thermoplastic polyurethane (TPU), polylactic acid (PLA), Polyvinyl alcohol (PVA), and Hydrosupport(96% Polyvinyl alcohol + polyethylene glycol)	Soaking	3% w/w	Voolt FDM 3D printer model Gi3	-	226	Sustained release	Tablets	(33)
Ciprofloxacin HCl	Polypropylene (PP) and Polyvinyl Alcohol (PVA)	Soaking	3 ± 1% w/w for PP and 5 ± 1% w/w for PVA	MakerBot Replicator 2x desktop	-	190-200	Sustained release	Mesh	(34)
ketoprofen	Polyvinyl Alcohol (PVA)	Single-screw extruder	30%	MakerBot Replicator 2X	180	185	Controlled release	Channeled tablet	(35)
indomethacin (IND) and theophylline	polycaprolactone (PCL).	Single-screw extruder	20%,30,40%	Zmorph 3D-printing	100-125	175-190	Prolonged release	Tablets	(36)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
Ibuprofen	Ethyl cellulose (EC)	Twin-screw extruder	20%	MakerBot Replicator 2X	80-100	178	Sustained release	Tablets	(37)
Ibuprofen	Hydroxypropyl Methylcellulose Acetate Succinate (HPMCAS)	Twin-screw extruder	20%	Ultimaker S3 printer	130	180	Sustained release	Tablets	(38)
Ketoprofen	Polylactic Acid (PLA)	Supercritical impregnation	9%	-	35,55,75	-	Controlled release	Filament	(39)
mango leaf extract	polylactic acid (PLA)	Supercritical impregnation	3%	ANYCUBIC Mega S model 3D printer	35-55	200	Sustained release	3D-printed disks	(40)
ethanolic mango leaf extract	Polylactic Acid (PLA)	Supercritical impregnation	3%	ANYCUBIC (model MEGA S,	35-55	200	Sustained release	Biomedical devices	(41)
sodium warfarin	Eudragit EPO	Twin-screw extruder	1%	MakerBot Replicator 2X	90-100	135	Immediate release	Tablet	(42)
indomethacin	poly(ε-caprolactone) (PCL)	Twin-screw extruder	5%, 15%, and 30%	MakerBot Replicator 2 desktop	100	100	Controlled release	Implants	(43)
Fenofibrate	Hydroxypropyl Methylcellulose Acetate Succinate (HPMC AS LG)	Twin-screw extruder	20%	Batch 3D printer	90-130	140	Sustained release	Tablets	(44)

Drug	Carrier polymer	Loading techniques	Drug amount	3d printer used	Temperature of extrusion	Temperature of printing	Release behaviour	Dosage form	Ref
glibenclamide	polylactic acid (PLA)	Soaking	0.6%	Zmorph VX 3D-printing system	-	180-200	Sustained release	Tablets	(45)

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Table S2: Data maxtrix after data curation for statistical analysis

Carrier polymer	Loading technique	Max. drug amount (%)	Max. pretreat. Temp (°C)	Printing temp. (°C)	Release time (h)
Ethyl cellulose (EC)	Extrusion	20	100	178	24
Eudragit EPO	Extrusion	1	100	135	0,5
Eudragit RL	Extrusion	30	180	180	24
Hydroxypropyl Cellulose (HPC)	Extrusion	30	120	220	12
Hydroxypropyl Cellulose (HPC)	Extrusion	30	155	195	14
Hydroxypropyl methylcellulose (HPMC)	Extrusion	25	160	185	24
Hydroxypropyl Methylcellulose Acetate Succinate (HPMC AS)	Extrusion	20	130	140	8
Hydroxypropyl Methylcellulose Acetate Succinate (HPMC AS)	Extrusion	20	130	180	6,6
Hydroxypropyl Methylcellulose Acetate Succinate (HPMC AS)	Extrusion	25	150	190	24
Hydroxypropyl Methylcellulose Acetate Succinate (HPMC AS)	Extrusion	5	165	170	3
Kollidon® VA 64	Extrusion	30	160	160	0,75
poly(ε-caprolactone) (PCL)	Extrusion	30	100	100	720
poly(ε-caprolactone) (PCL)	Extrusion	40	125	190	24
Polylactic acid (PLA)	Extrusion	25	160	210	24
Polymer mixture	Extrusion	20	140	210	0,5
Polymer mixture	Extrusion	0,7	130	175	0,5
Polymer mixture	Extrusion	10	130	150	0,5
Polymer mixture	Extrusion	5	140	164	4248
Polymer mixture	Extrusion	2,04	150	182	9
Polymer mixture	Extrusion	30	210	220	6
Polymer mixture	Extrusion	1	185	200	12

Polymer mixture	Extrusion	50	210	190	6
Polymer mixture	Extrusion	30	150	200	24
Polymer mixture	Extrusion	20	145	180	0,5
Polymer mixture	Extrusion	60	165	223	6
Polymer mixture	Extrusion	3	70	90	30
Polyvinyl alcohol (PVA)	Extrusion	10	180	200	6
Polyvinyl alcohol (PVA)	Extrusion	30	180	185	8
Polyvinyl alcohol (PVA)	Extrusion	10	175	205	24
Polyvinyl alcohol (PVA)	Extrusion	40	145	250	0,25
Polyvinyl alcohol (PVA)	Extrusion	50	175	190	5
Polyvinyl alcohol (PVA)	Extrusion	15	190	180	5
polyvinyl alcohol (PVA)	Extrusion	30	180	187	0,5
Eudragit RL100	Impregnation	0,22	25	170	24
poly(ε-caprolactone) (PCL)	Impregnation	0,6	25	95	24
Polylactic acid (PLA)	Impregnation	0,6	25	200	24
Polylactic acid (PLA)	Impregnation	3	55	200	6
Polylactic Acid (PLA)	Impregnation	3	55	200	600
Polylactic Acid (PLA)	Impregnation	9	75	200	24
Polymer mixture	Impregnation	4	25	170	16
Polymer mixture	Impregnation	1,5	25	170	16
Polymer mixture	Impregnation	3	25	226	24
Polypropylene (PP)	Impregnation	5	25	200	12
Polyvinyl alcohol (PVA)	Impregnation	0,95	25	215	6
Polyvinyl alcohol (PVA)	Impregnation	3	25	200	12
Polyvinyl alcohol (PVA)	Impregnation	1,4	25	205	3
Polyvinyl alcohol (PVA)	Impregnation	5	25	210	24