

Article

Rheological Behavior and Dynamic Mechanical Properties for Interpretation of Layer Adhesion in FDM 3D Printing

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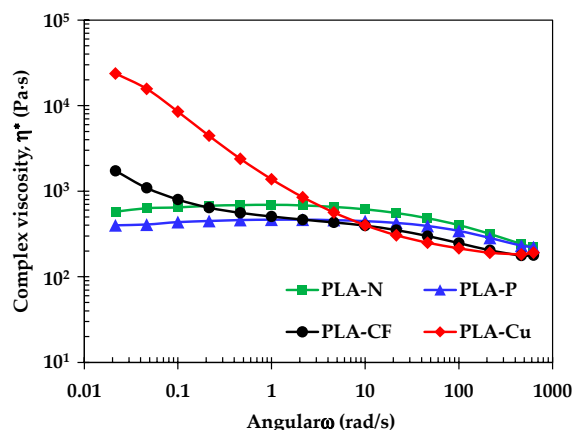


Figure S1. Complex viscosity as a function of angular frequency of PLA filaments.

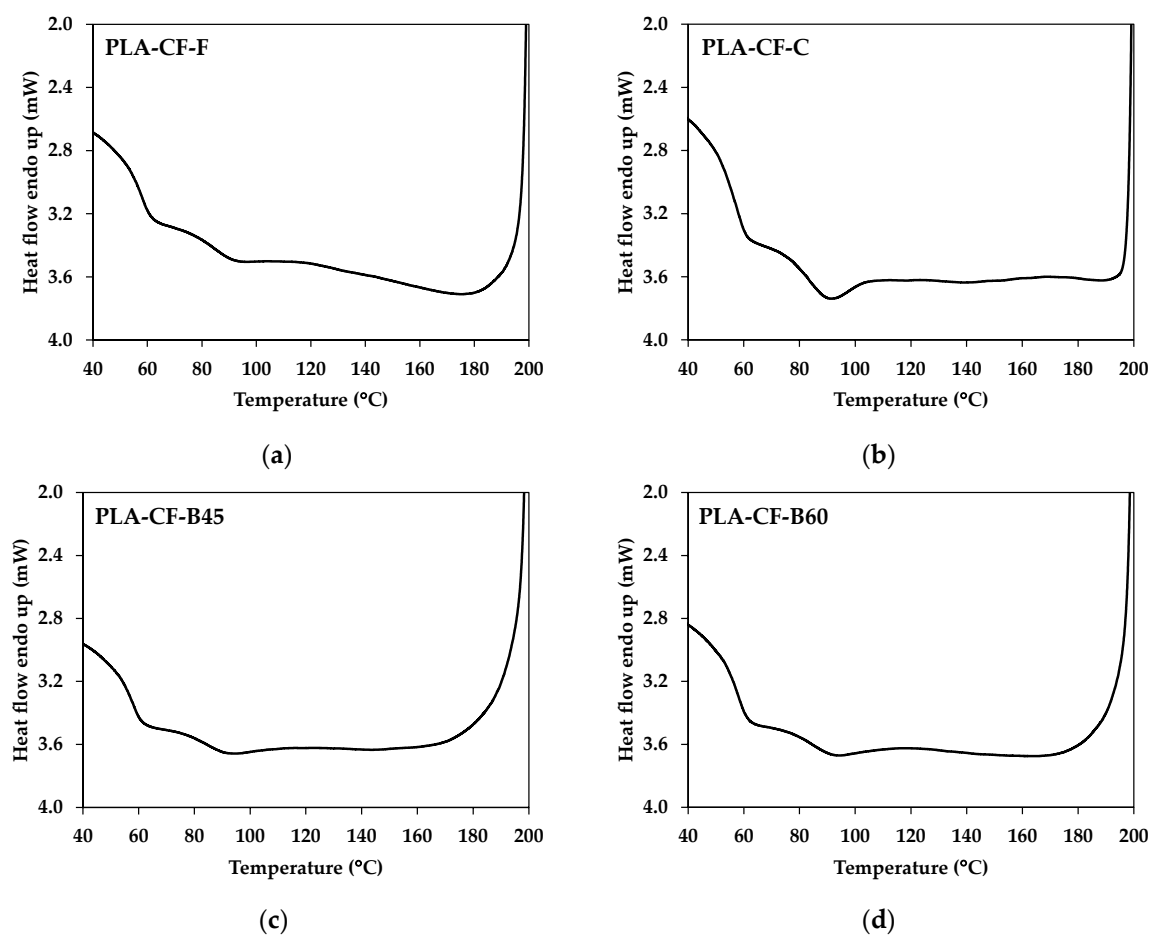


Figure S2. DSC thermograms of the enlarging cooling cycles of PLA-CF samples: (a) PLA-CF-F; (b) PLA-CF-C; (c) PLA-CF-B45; (d) PLA-CF-B60.

Density Measurement

Densities of samples were carried out by a gas displacement pycnometer (Micromeritics AccuPyc II 1345, Micromeritics Instrument Corporation, Norcross, GA, USA). The sample about 0.5–1.0 g was put in the sample cap. The densities of the samples were measured at room temperature under helium atmosphere.

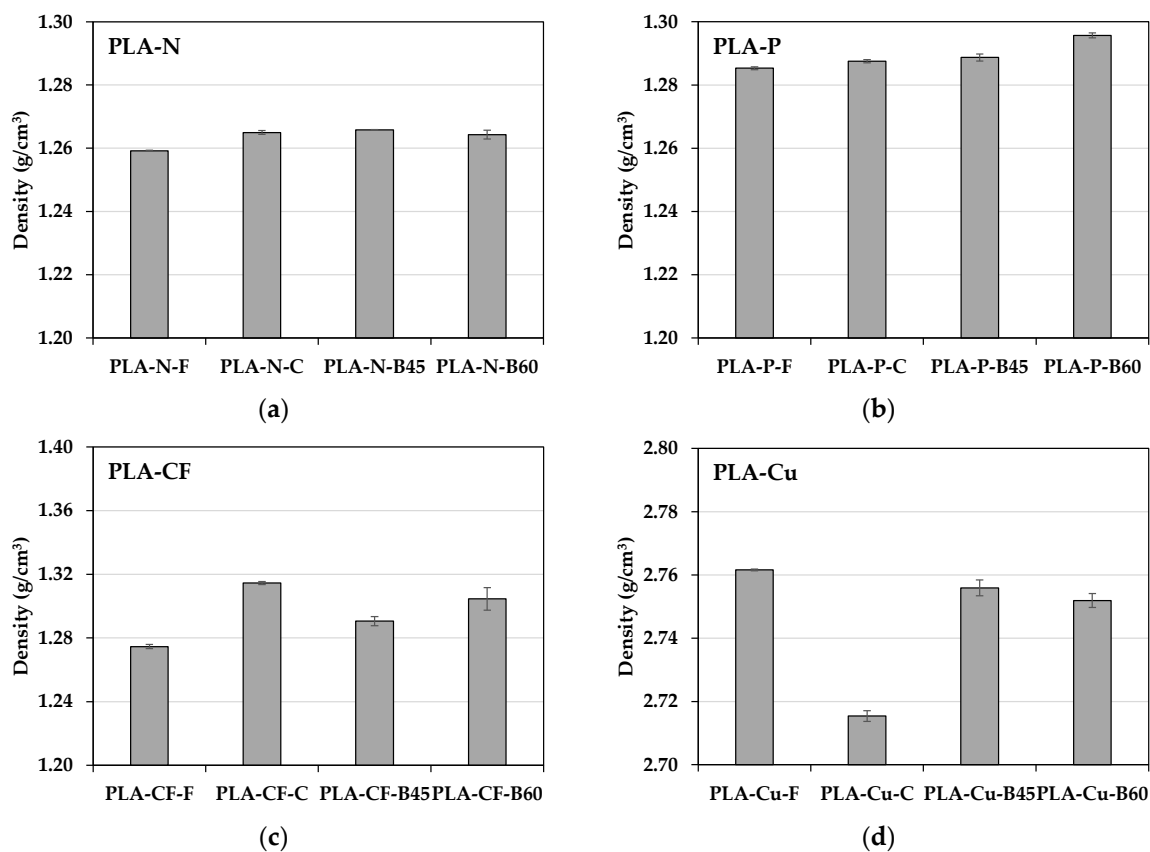


Figure S3. Density of samples: (a) PLA-N; (b) PLA-P; (c) PLA-CF; (d) PLA-Cu.