



Figure S1. Filament cooling rate results of (a) cooling rate versus time with extrusion velocity of 3.5 mm/s; (b) cooling rate versus temperature with extrusion velocity of 3.5 mm/s; (c) cooling rate versus time with extrusion velocity of 3.0 mm/s; (d) cooling rate versus temperature with extrusion velocity of 3.0 mm/s; (e) cooling rate versus time with extrusion velocity of 2.8 mm/s; (f) cooling rate versus temperature with extrusion velocity of 2.8 mm/s; (g) cooling rate versus time with extrusion velocity of 2.4 mm/s; (h) cooling rate versus temperature with extrusion velocity of 2.4 mm/s.