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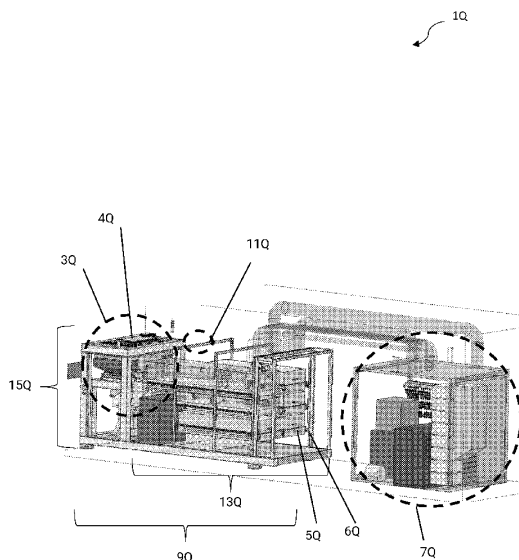


Fig. 1Q

(57) Abstract: A print engine of an additive manufacturing system includes a print station configured to hold a removable cartridge. A laser engine including a frame can be positioned to hold at least one removable field replaceable unit that includes at least some laser optics or patterning optics. An optical alignment system can be attached to at least one of the print station or the laser engine to align the field replaceable unit with respect to the removable cartridge.

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