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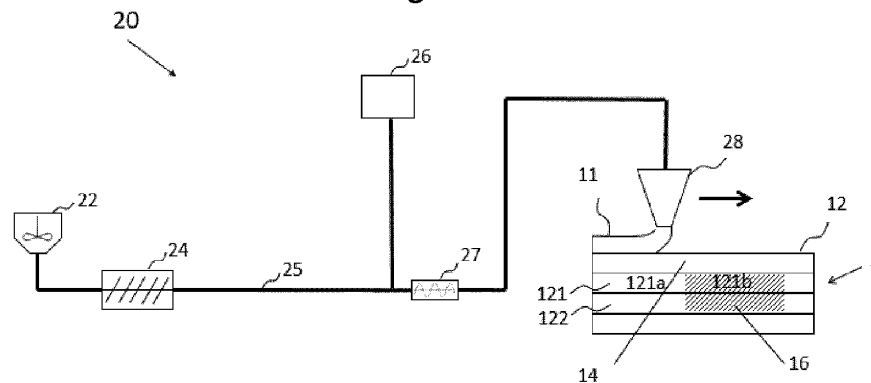
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Fig. 1



(57) Abstract: The invention relates to a 3-D printing method for manufacturing an element (1, 200) made of a material which comprises hydraulic binder and aggregates, said element comprising at least a primary zone (14, 206) and at least a secondary zone (16, 202, 204), the density of the material being higher in the or each primary zone (14, 206) than in the or each secondary zone (16, 202, 204), said method comprising mixing (22) a dry mortar composition with water to form a base wet mortar, conveying said base wet mortar towards a printer head (28) and, by moving said printer head, depositing superposed mortar layers (11, 12) to form said element (1, 200), wherein, before depositing the mortar layers, or the portions of mortar layers, that belong to the secondary zone (16, 202, 204), an aqueous foam is added to said base wet mortar during said conveying of the base wet mortar towards the printer head (28), and wherein at least part of the mortar layers, or portions of mortar layers, that belong to a secondary zone (16, 202, 204) support some of the mortar layers, or portions of mortar layers, that belong to a primary zone (14, 206).

WO 2022/112380 A1

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