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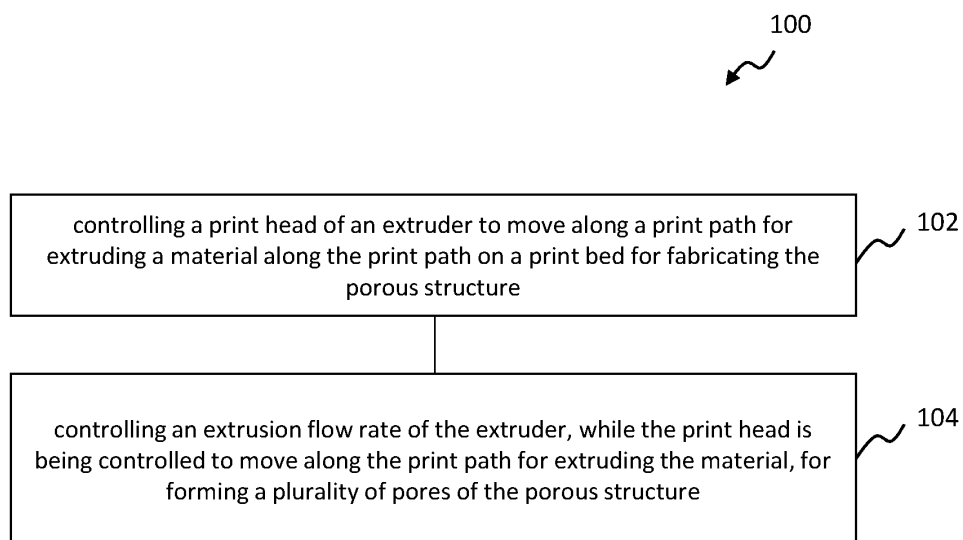


FIG. 1

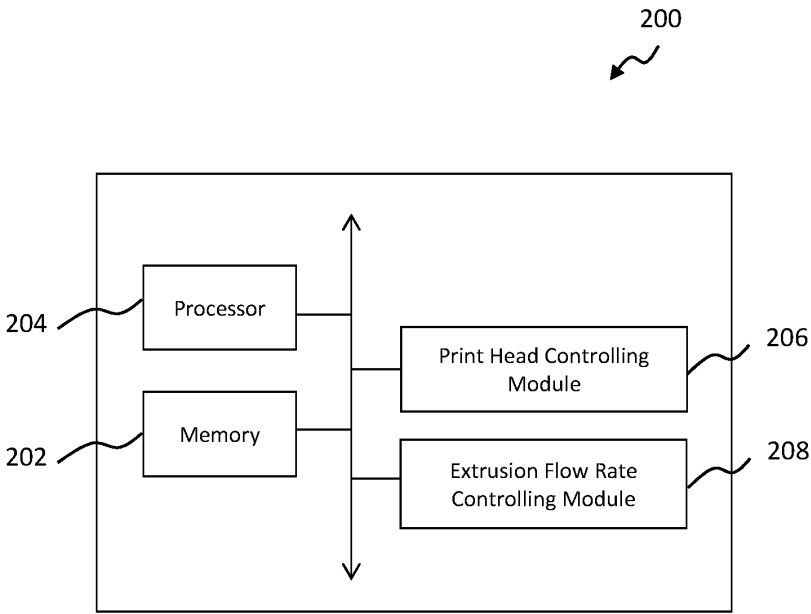


FIG. 2

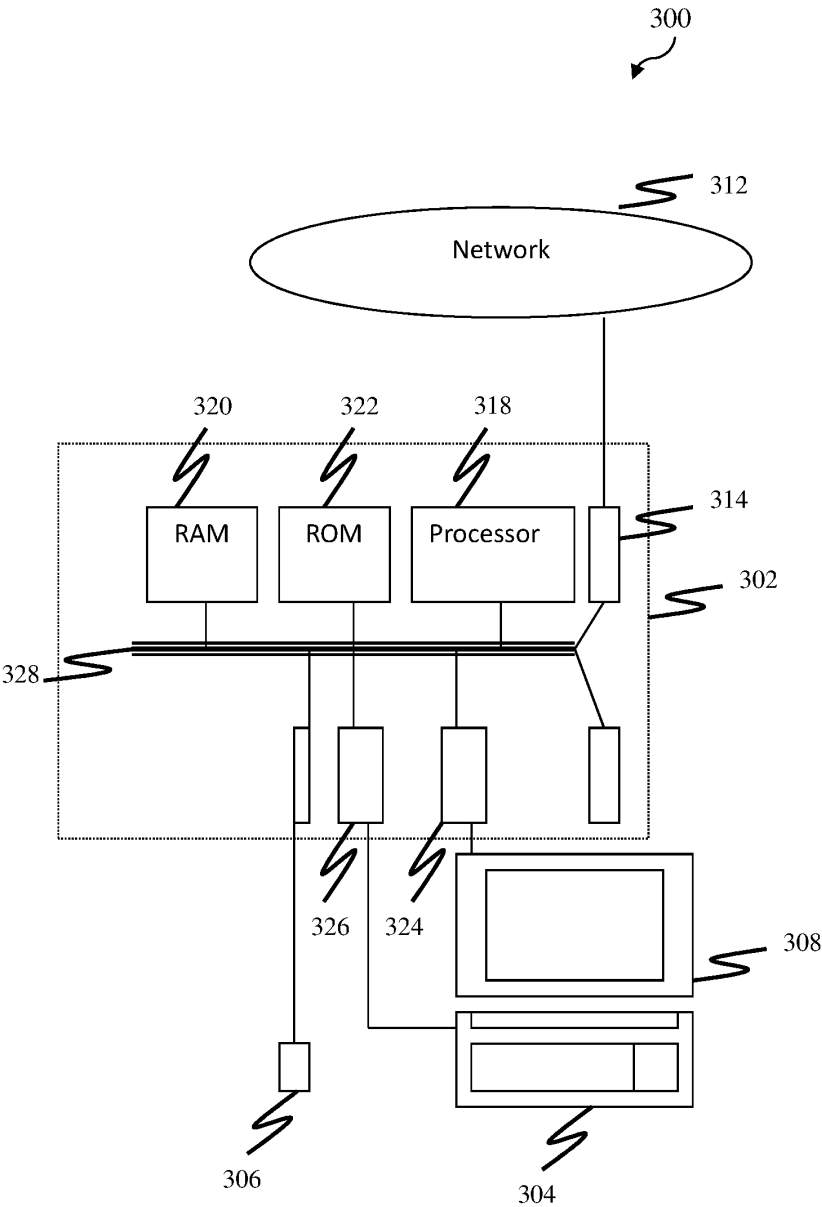


FIG. 3

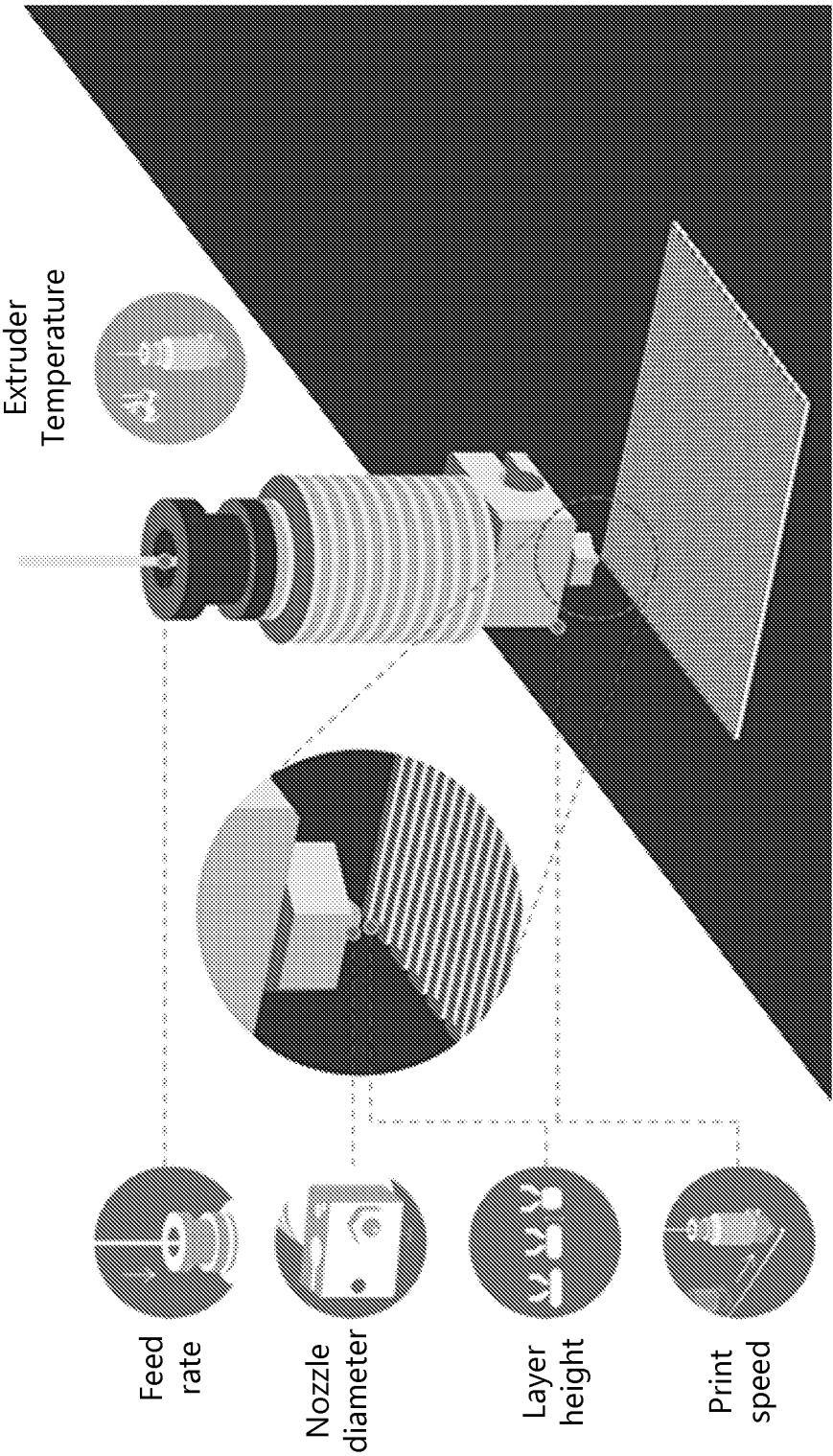


FIG. 4

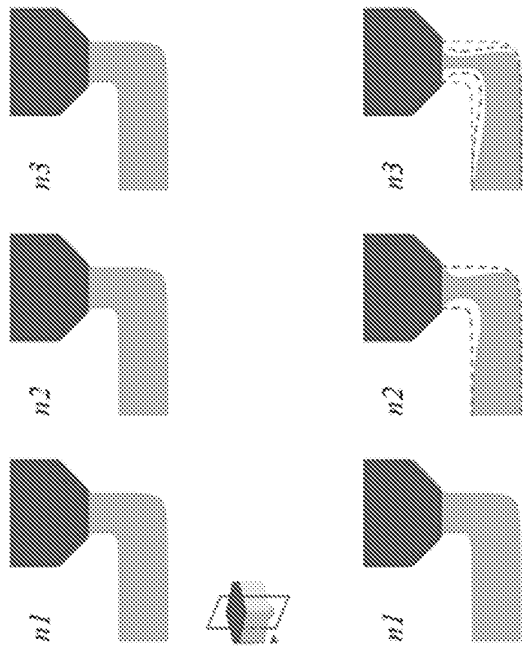


FIG. 5C

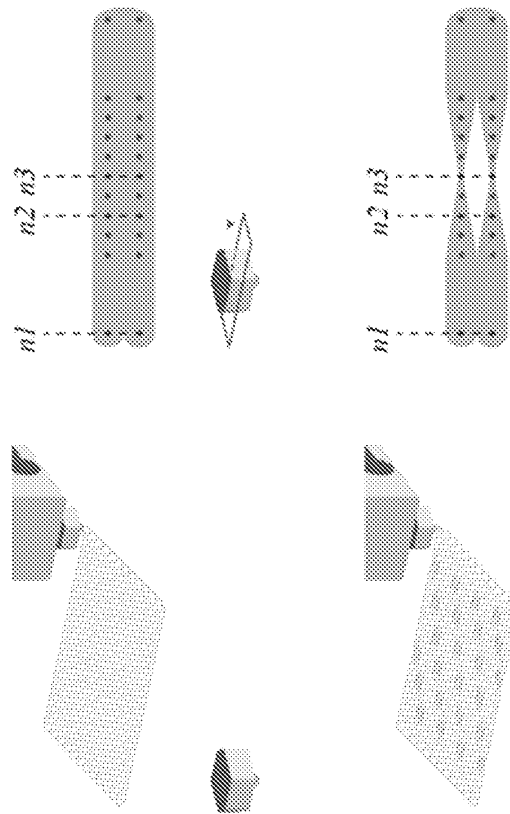


FIG. 5B

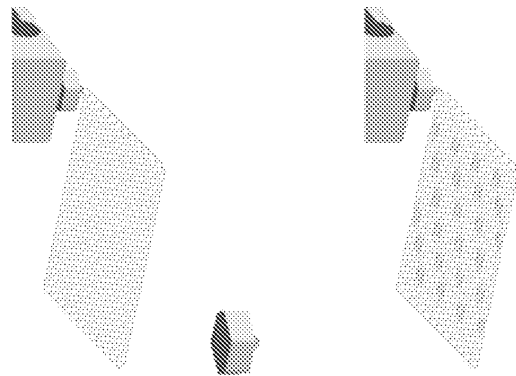
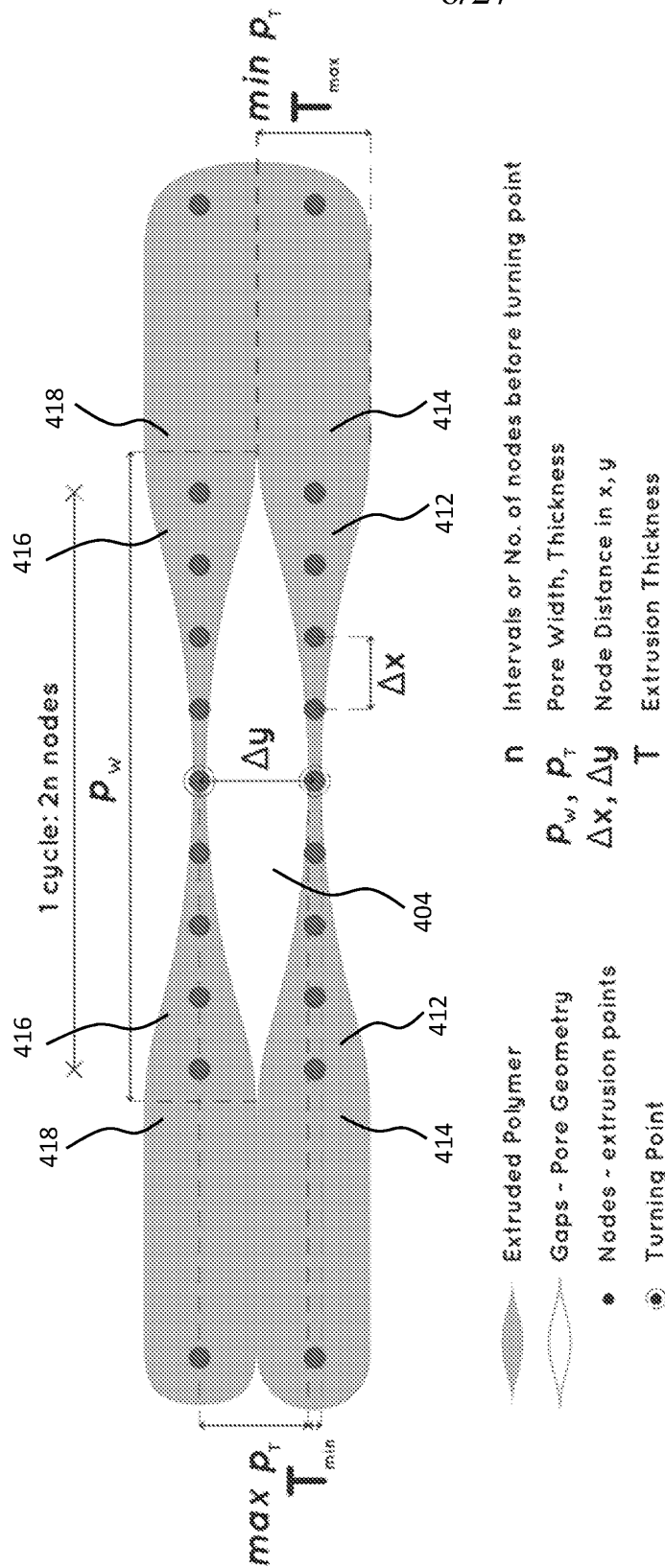


FIG. 5A



For Width of Pore p_w :
 $p_w = \Delta x * (2n-1)$

For Thickness of Pore p_t :
 $\max p_t = \Delta y - T_{\min}$, $\min p_t = \Delta y - T_{\max}$

FIG. 6

degree:

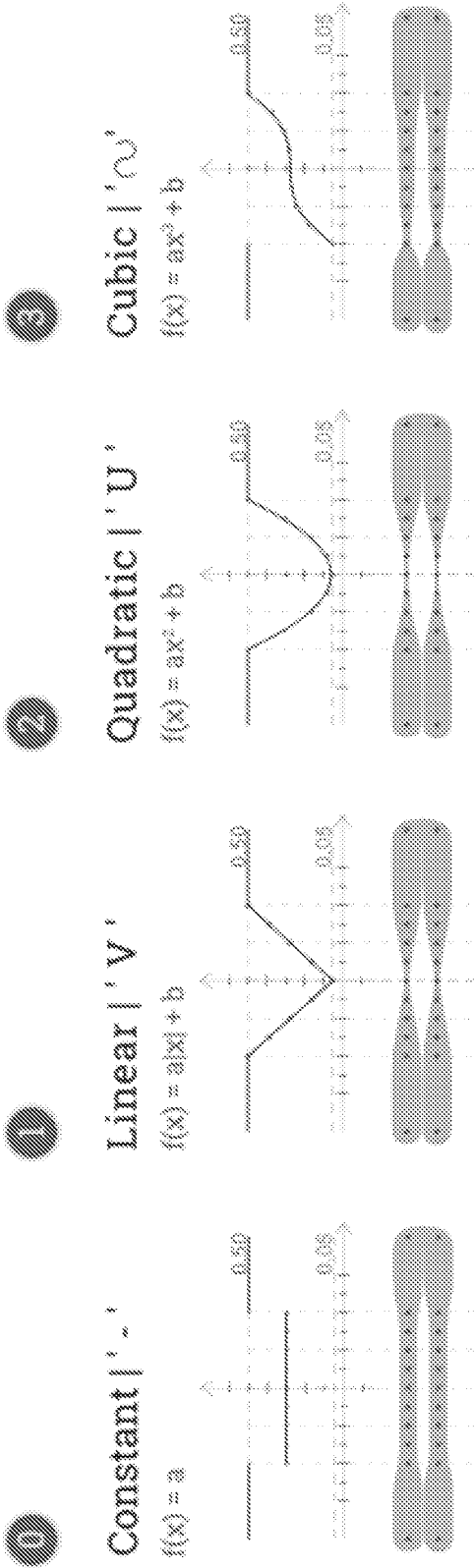


FIG. 7A

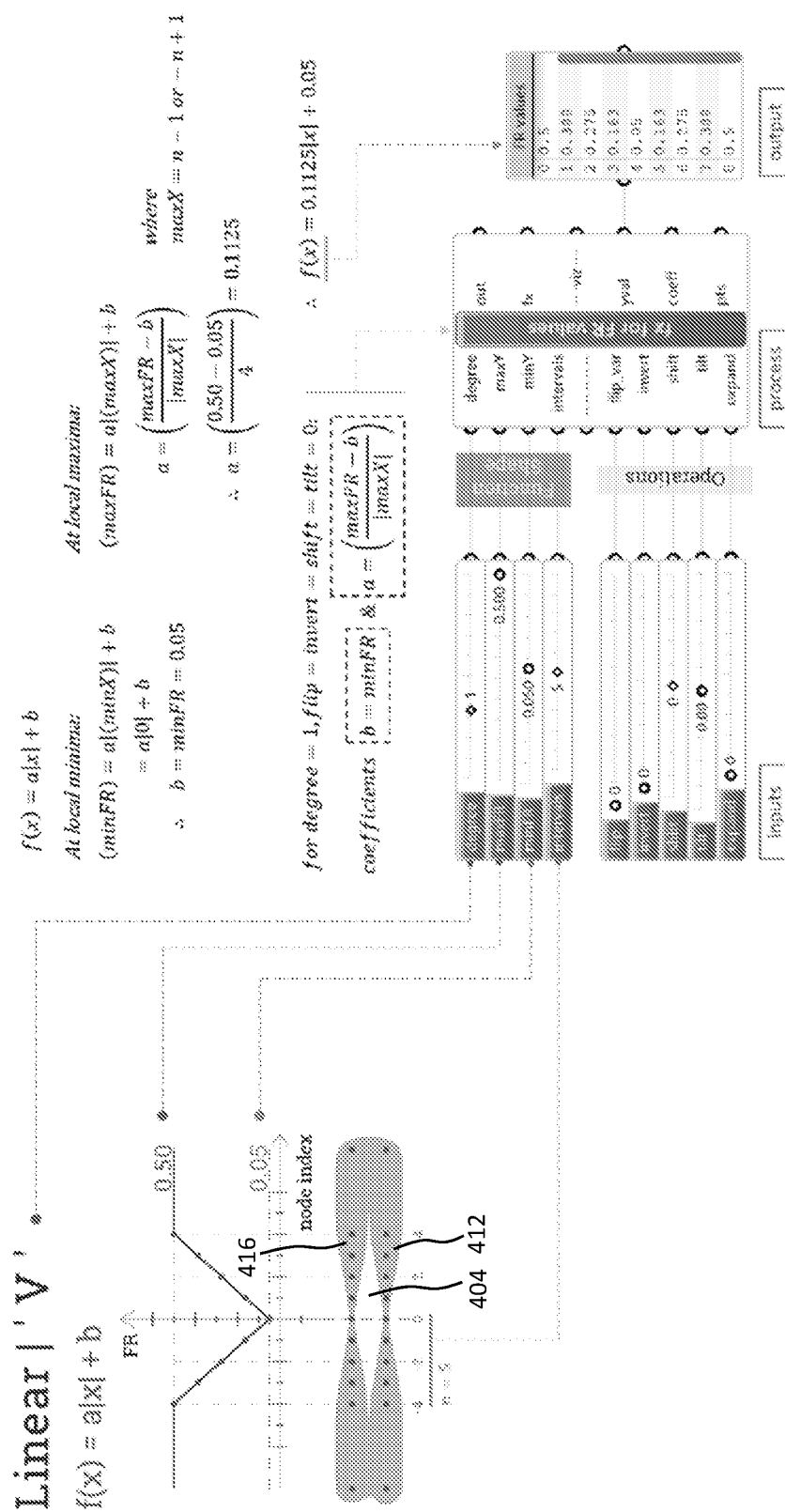


FIG. 7B

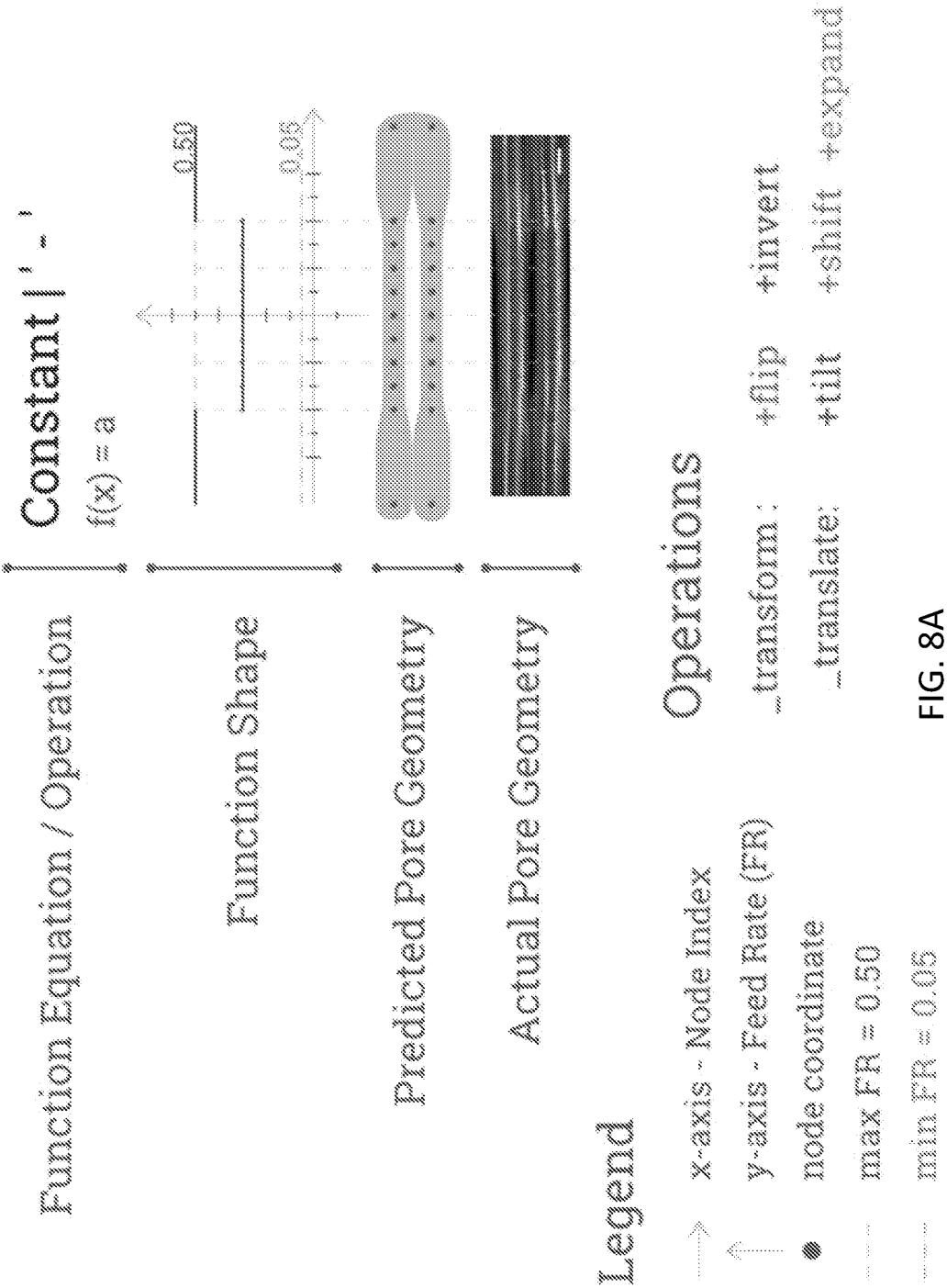
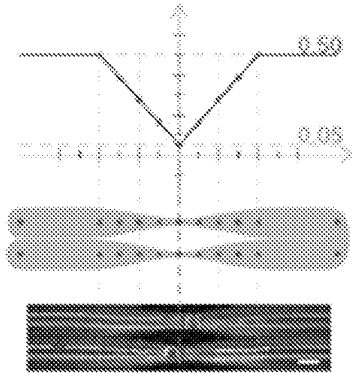


FIG. 8A

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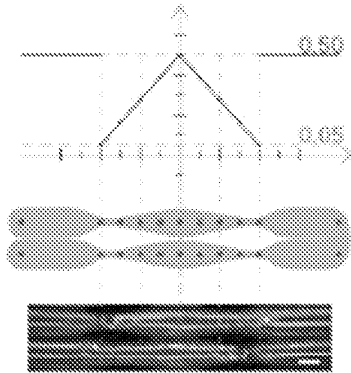
Linear | ' V '

$f(x) = a|x| + b$



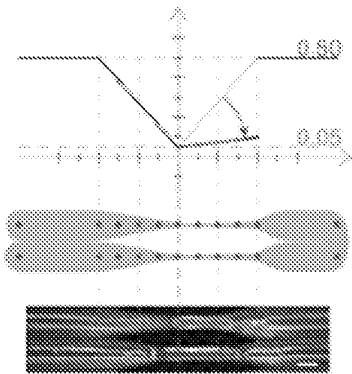
+invert

$f(x) = -a|x| + b$



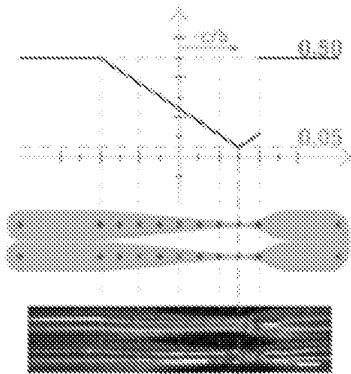
+tilt

$f(x) = ax + b|x| + c$



+shift

$f(x) = ax + b|x + c| + d$



+flip

$f(x) = ax + b|x| + c$

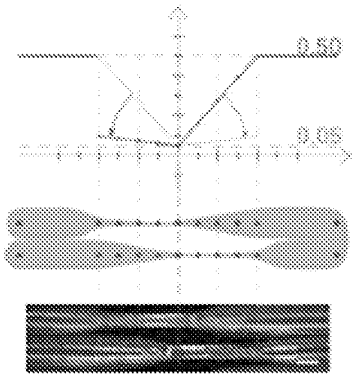


FIG. 8B

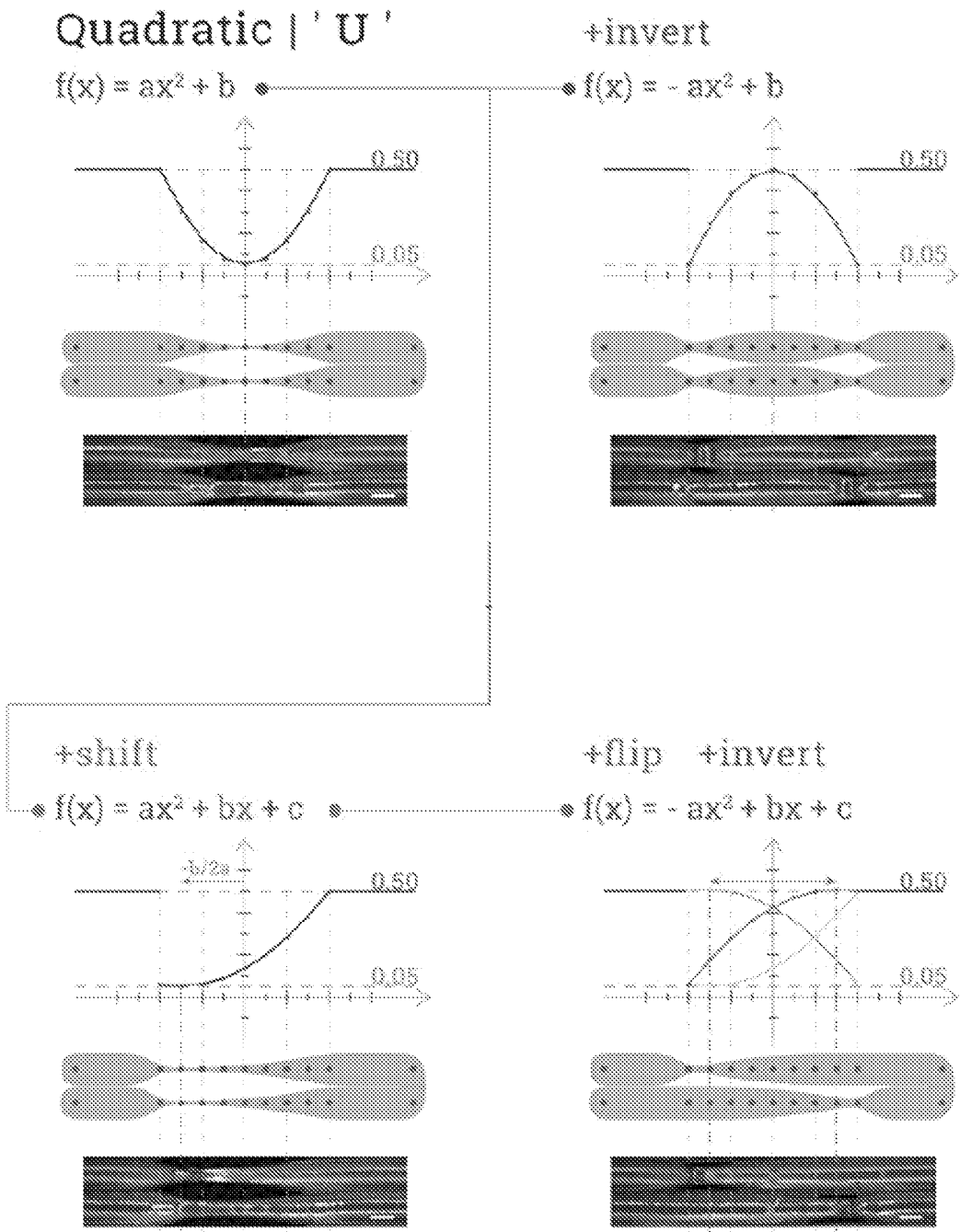


FIG. 8C

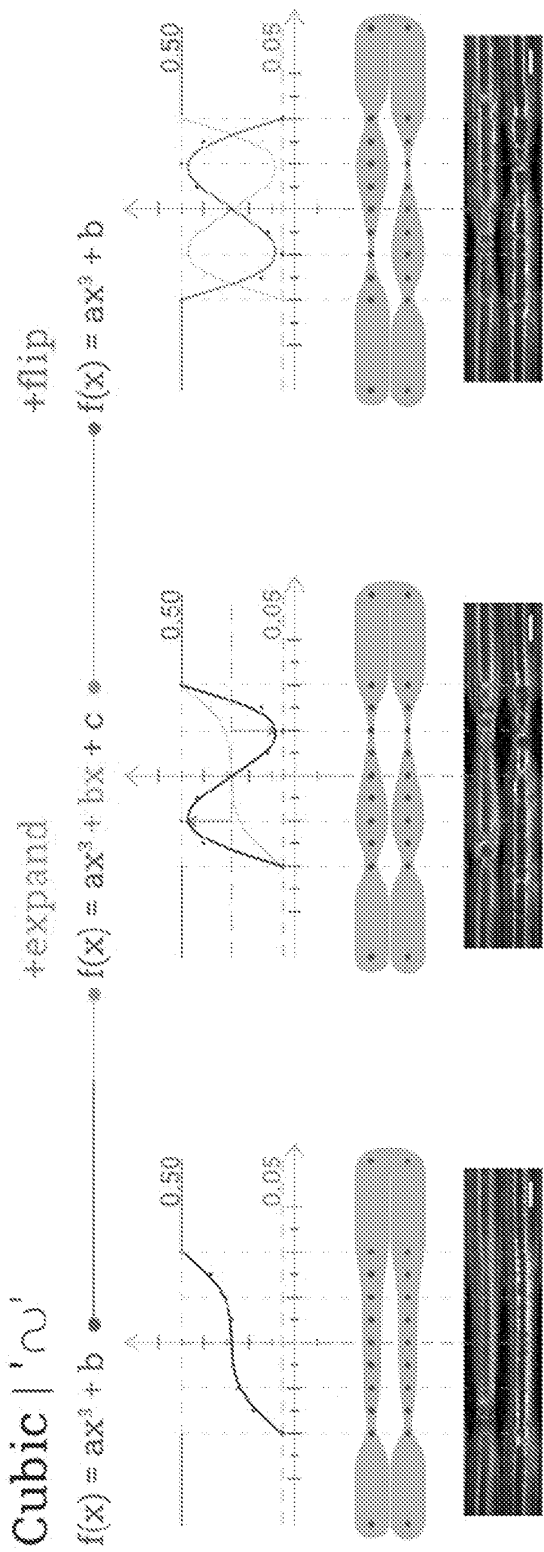


FIG. 8D

Linear | ' V ' +tilt
+flip

$$f(x) = ax + b|x| + c$$

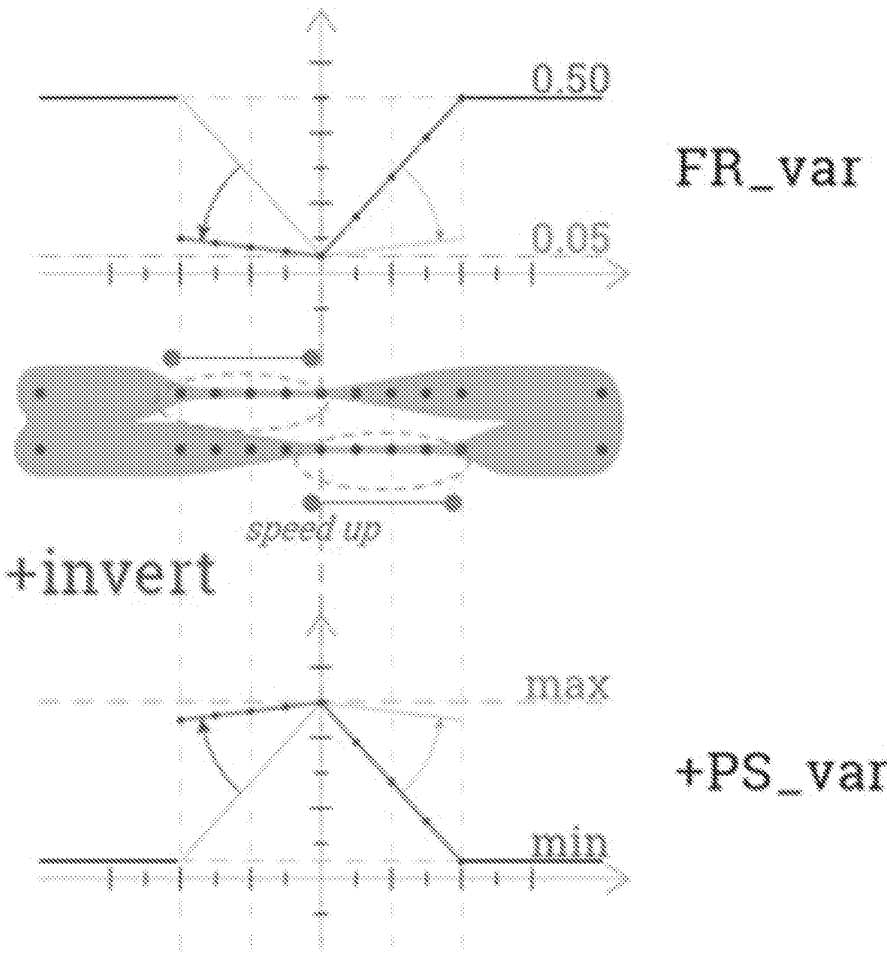


FIG. 9A

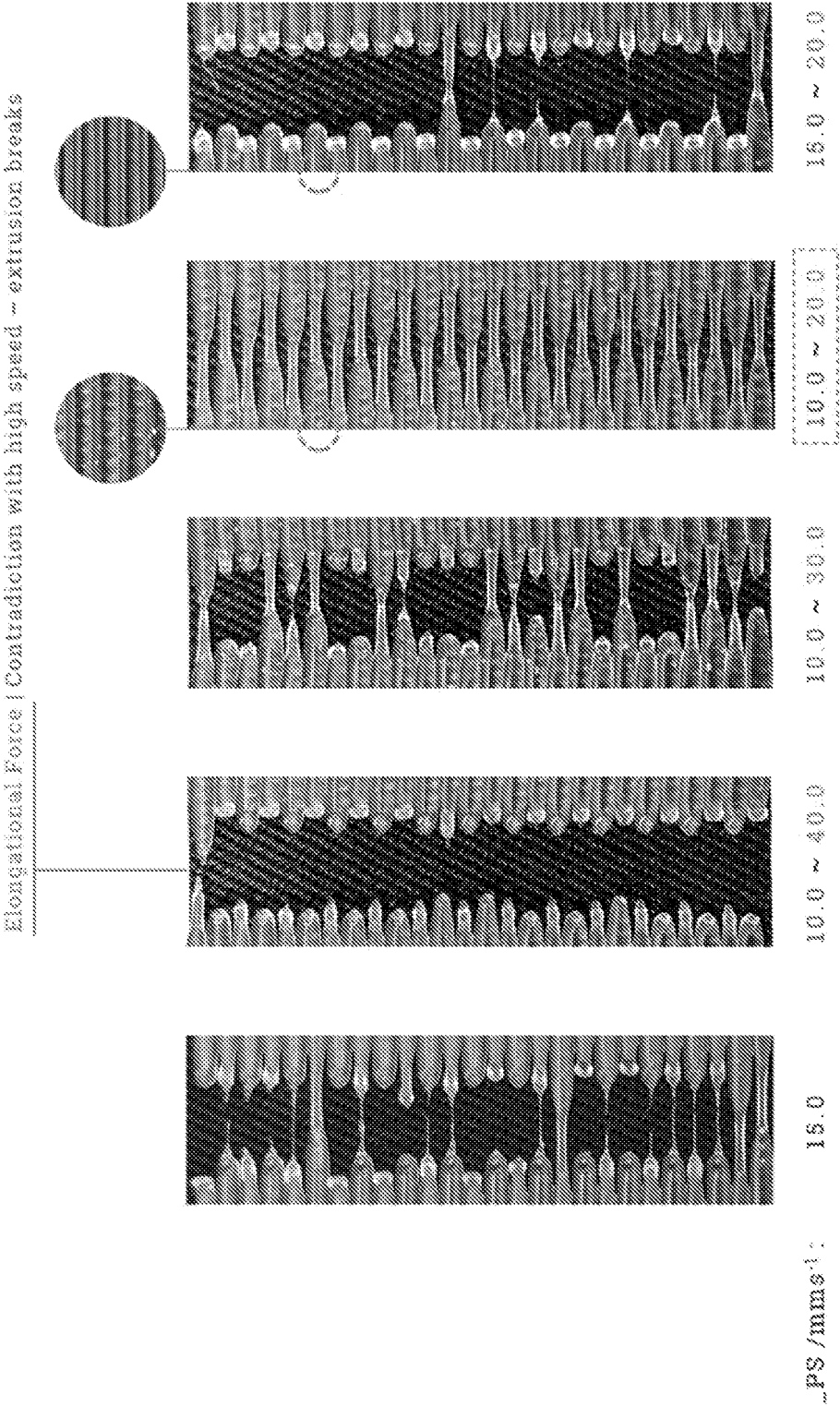


FIG. 9B

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Quadratic | ' U '

$f(x) = ax^2 + b$

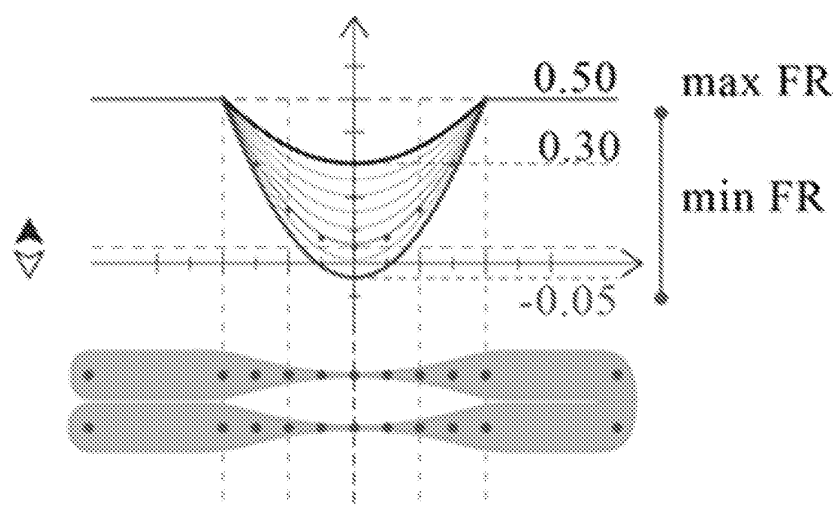


FIG. 10A

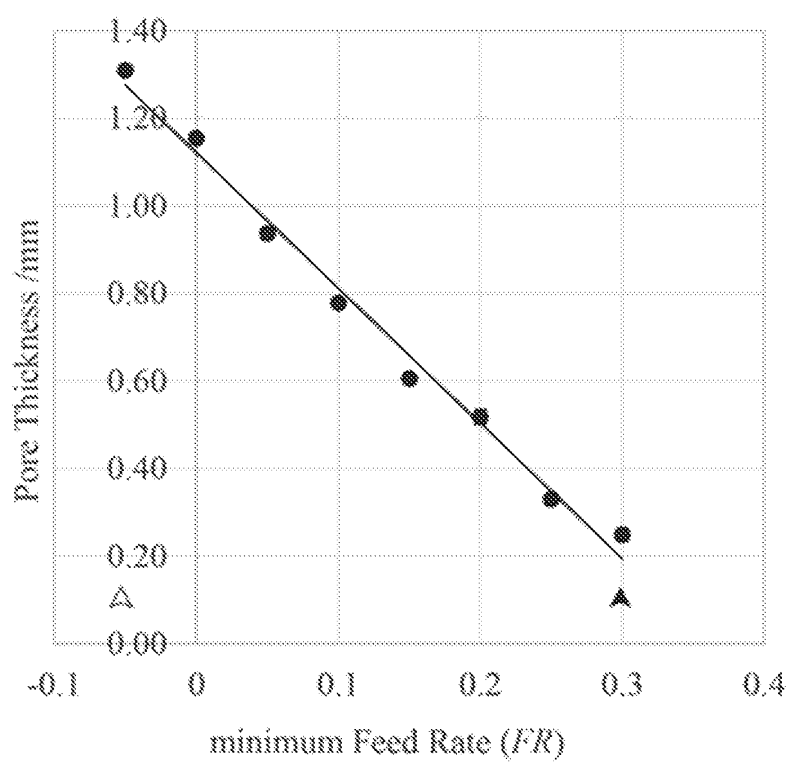


FIG. 10B

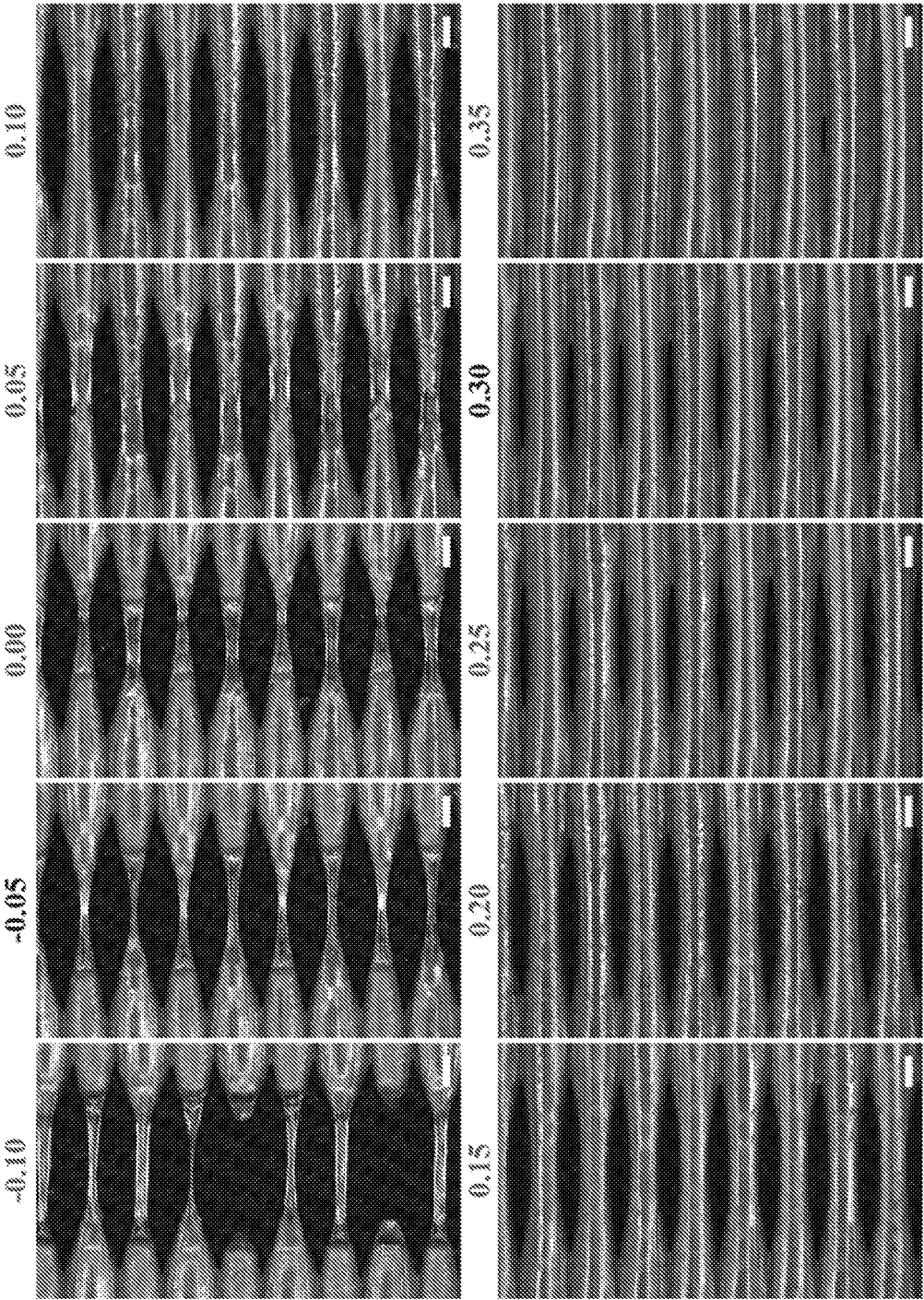


FIG. 10C

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Quadratic | ' U '

+invert

$f(x) = -ax^2 + b$

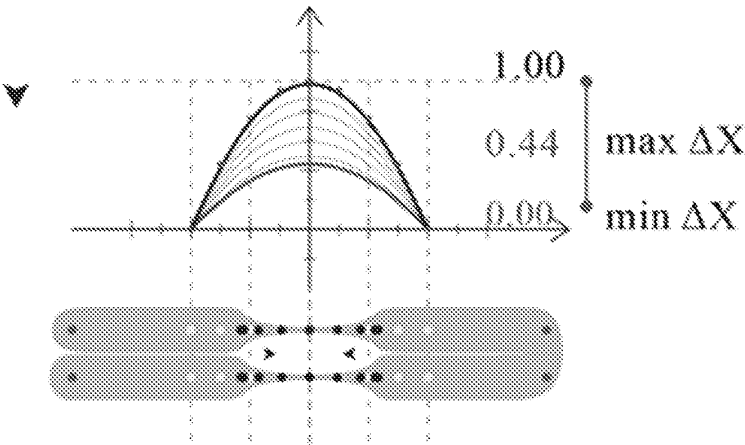


FIG. 11A

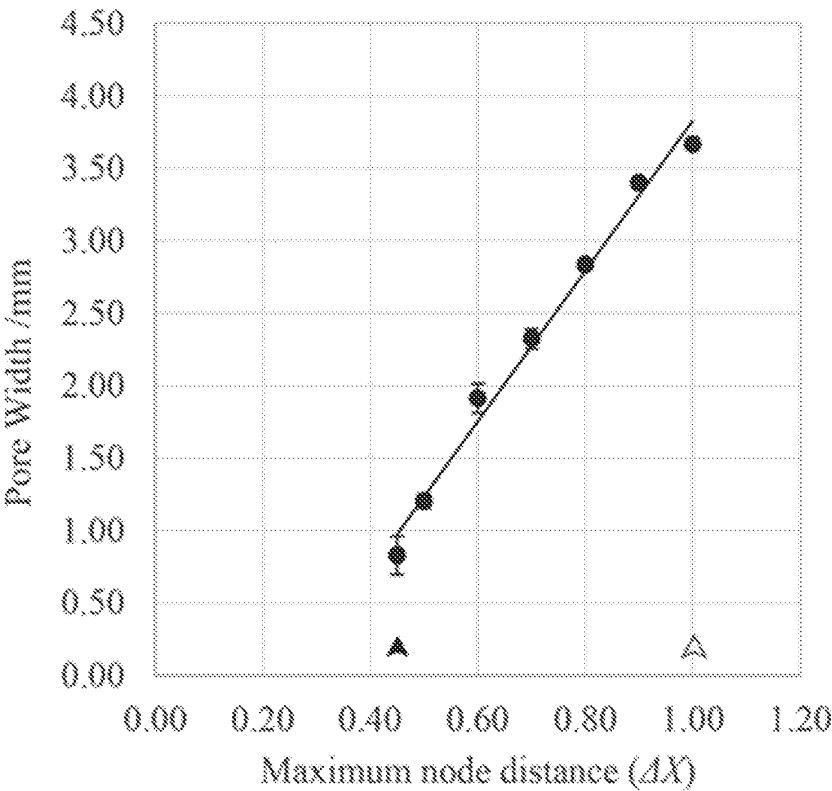


FIG. 11B

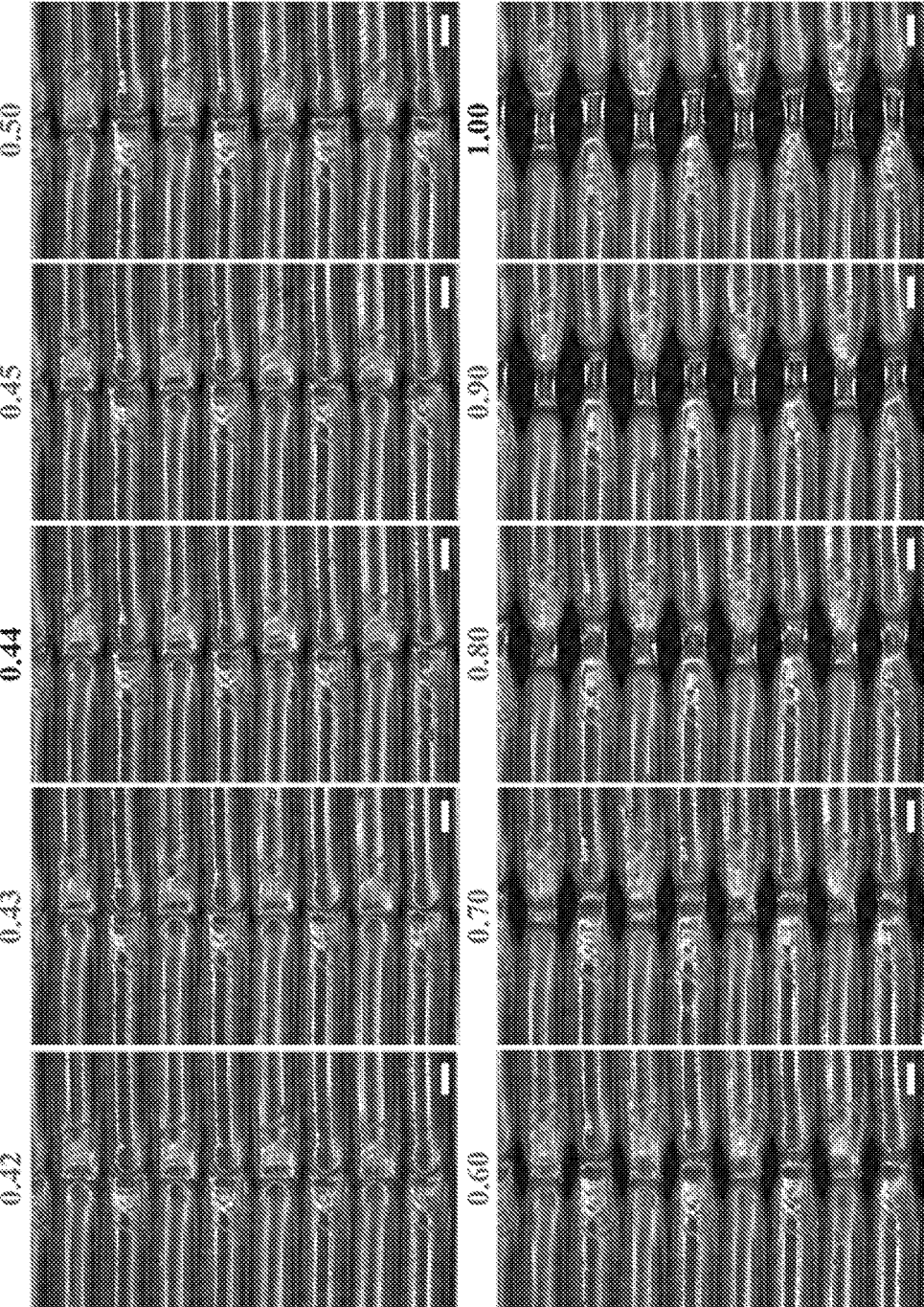
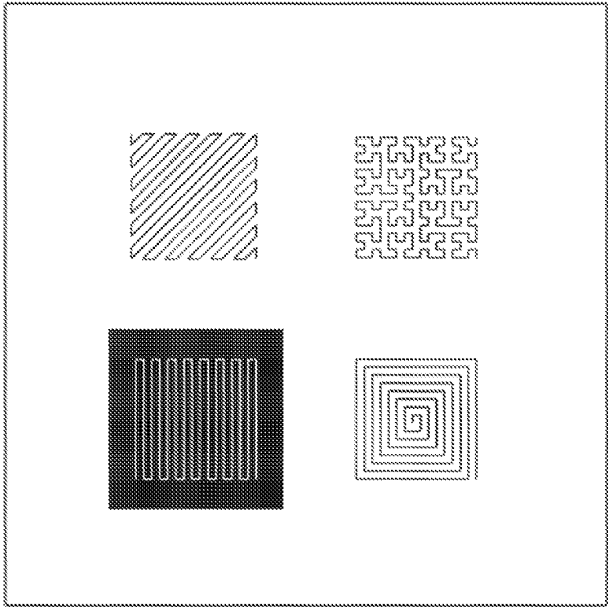
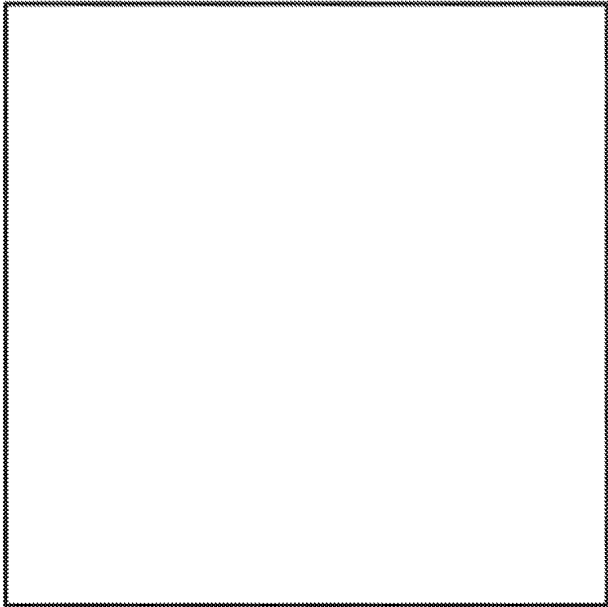


FIG. 11C



+toolpath_var
+pitch

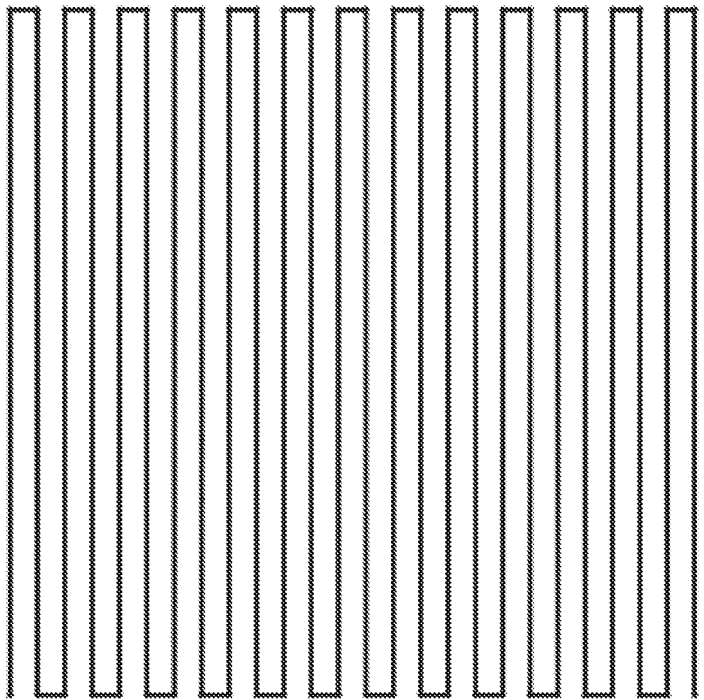
FIG. 12B



+base_geom

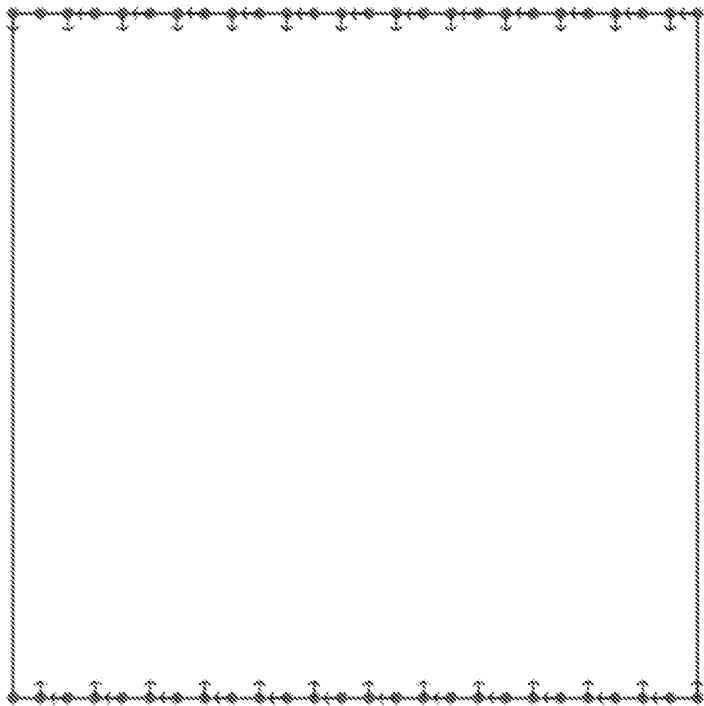
1

FIG. 12A



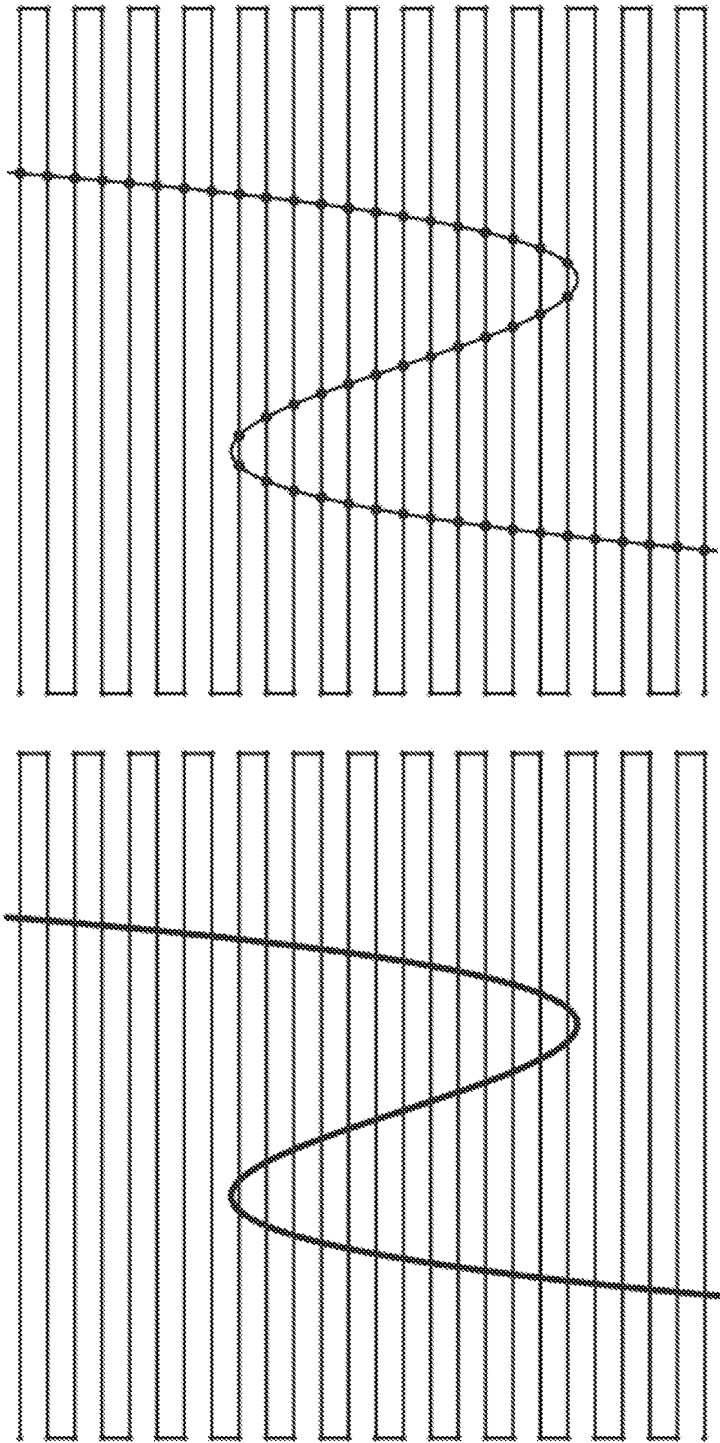
toolpath lines

FIG. 12D



@ edge_nodes
node sequencing

FIG. 12C



2 +int_curves

intersection
@ pore_nodes

FIG. 12E

FIG. 12F

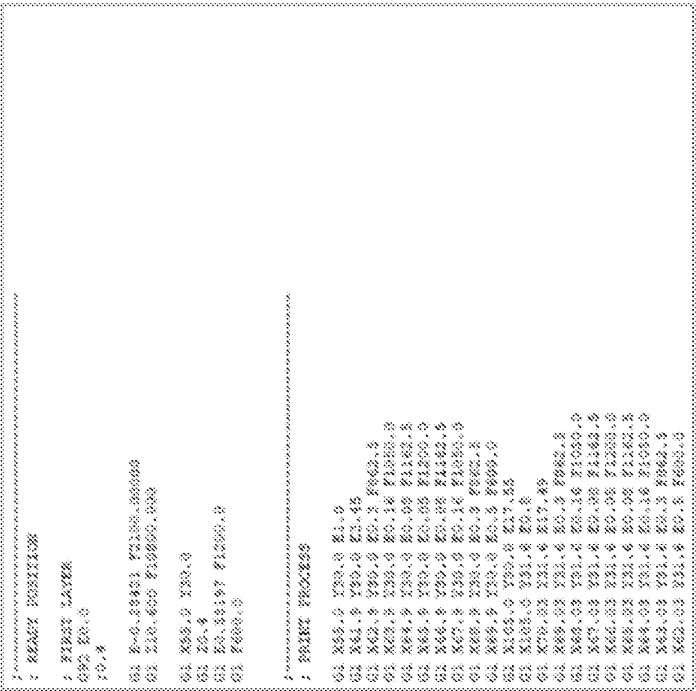


FIG. 12H

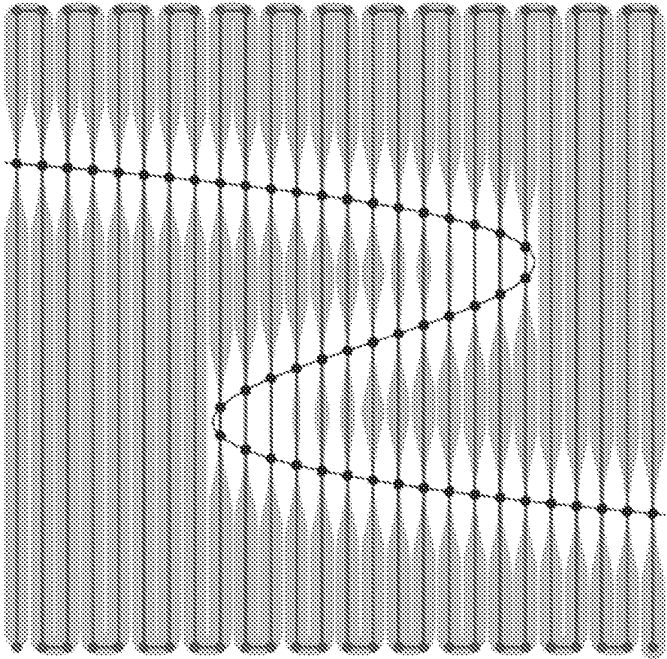
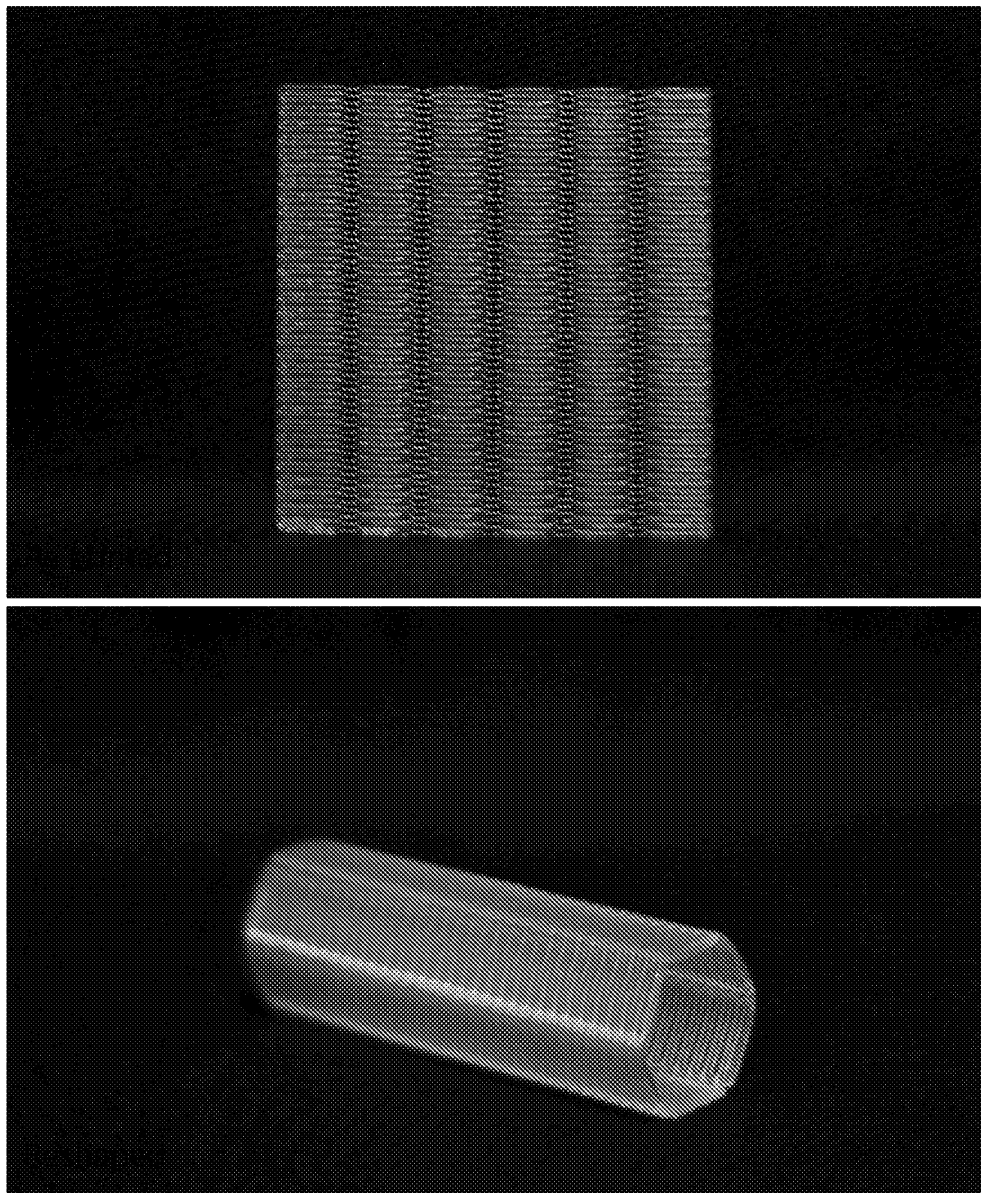


FIG. 12G

3 +pore_var X, Y, Z/LH, FR, PS, eT, hT
Class attributes

4 g-code
compute print params

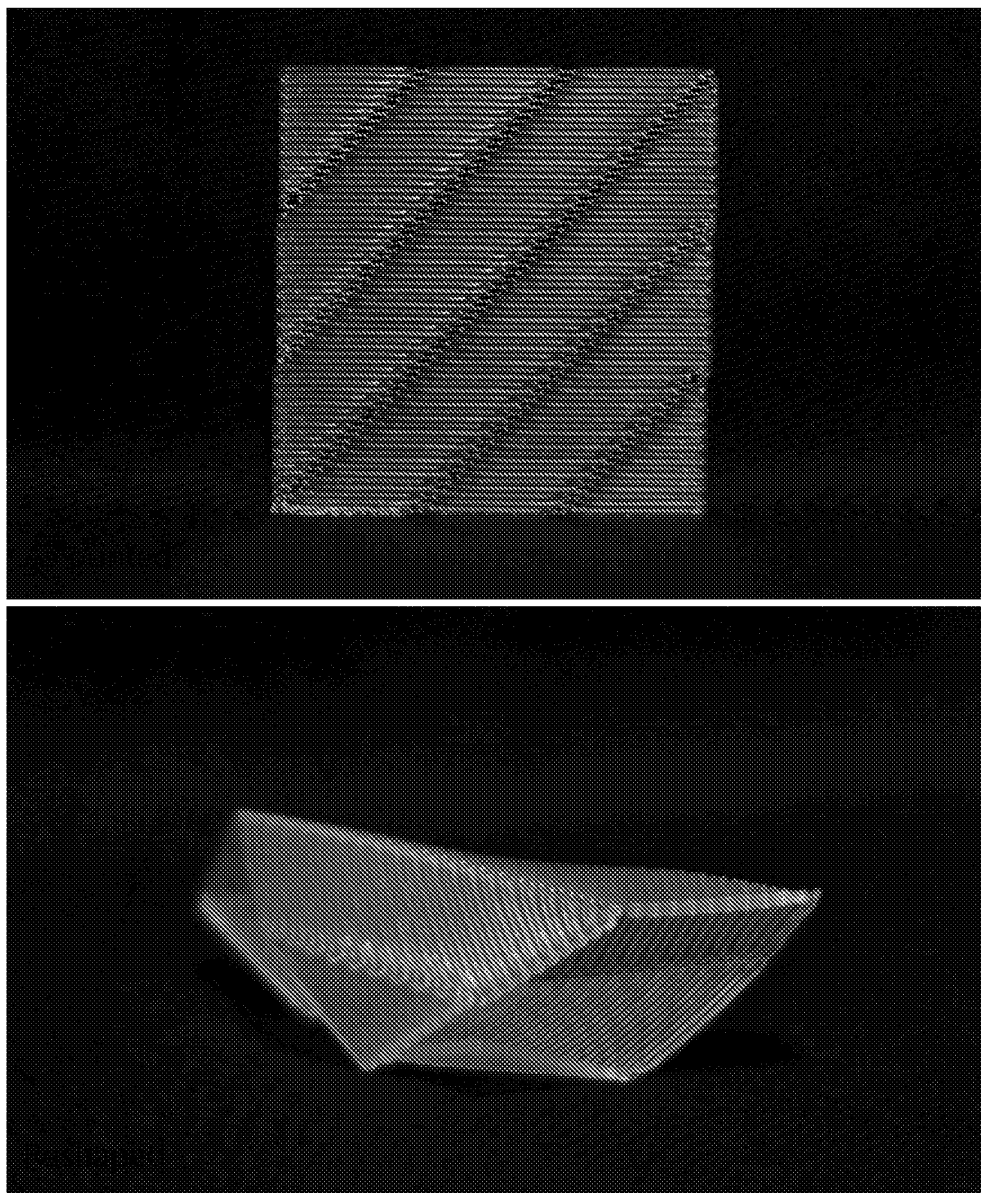
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Vertical

FIG. 13A

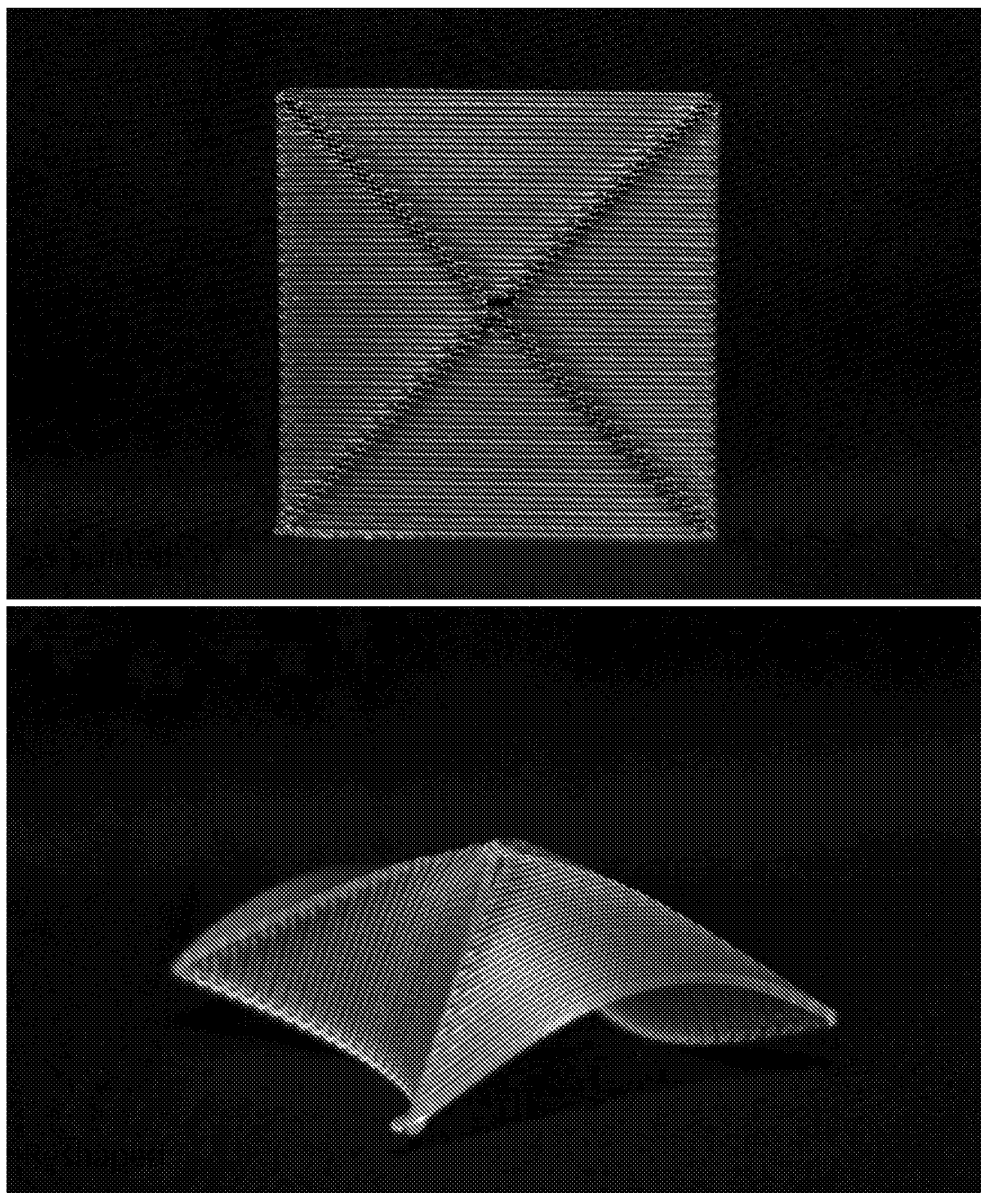
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Diagonal

FIG. 13B

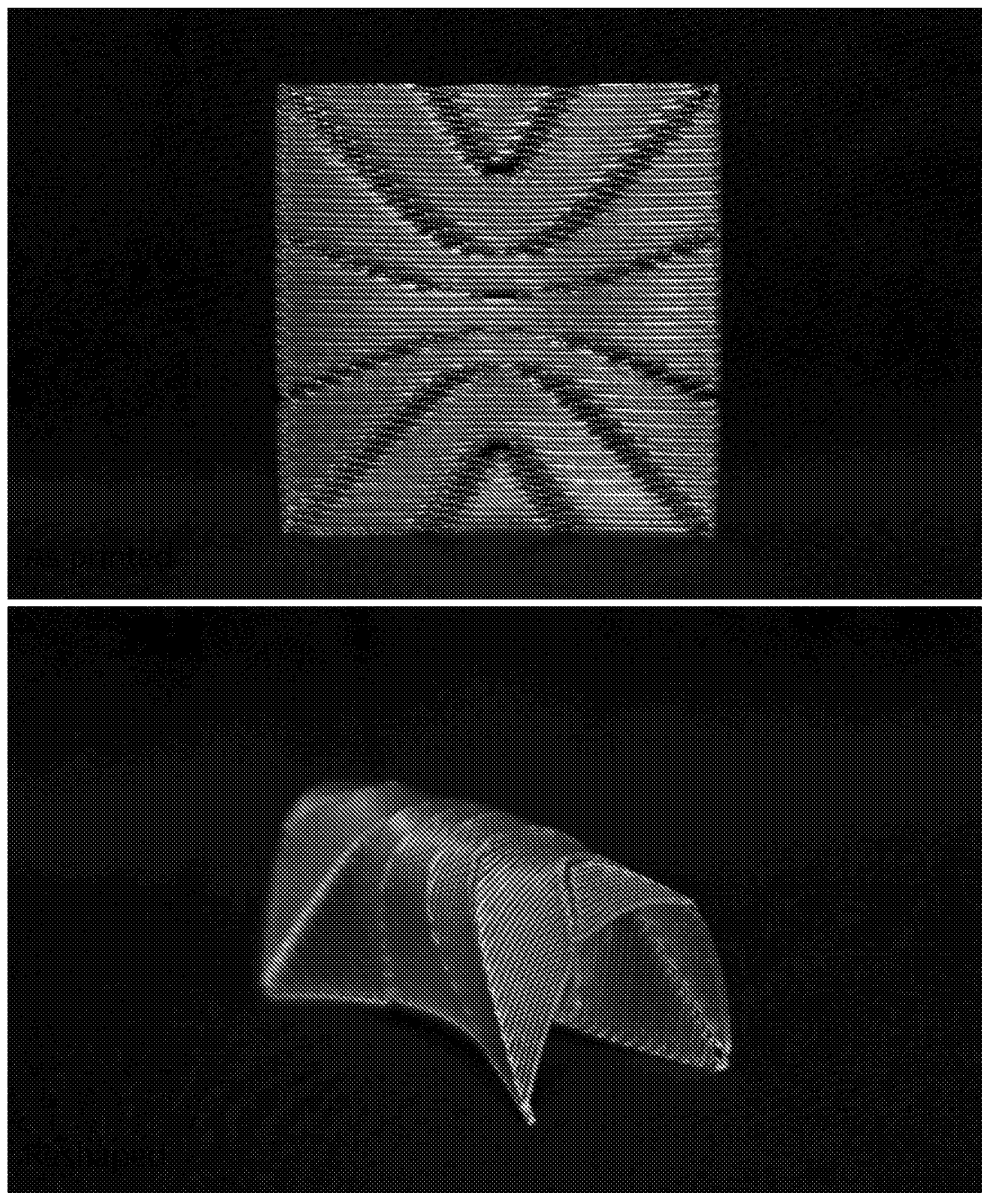
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Cross

FIG. 13C

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Curves

FIG. 13D

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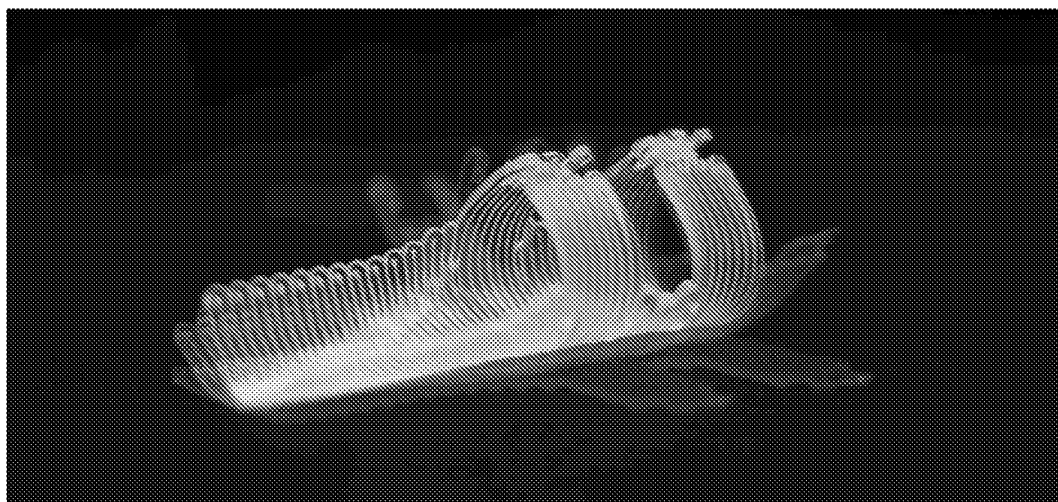


FIG. 14A

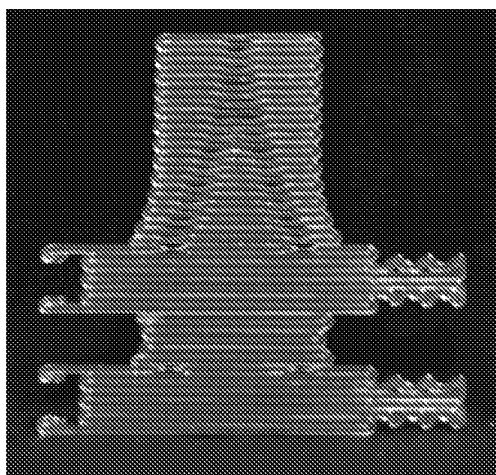


FIG. 14B

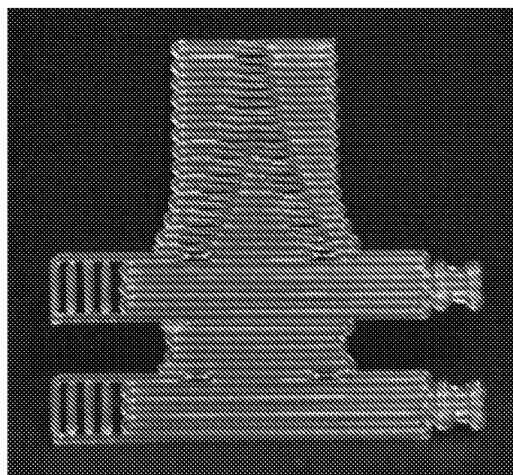


FIG. 14C

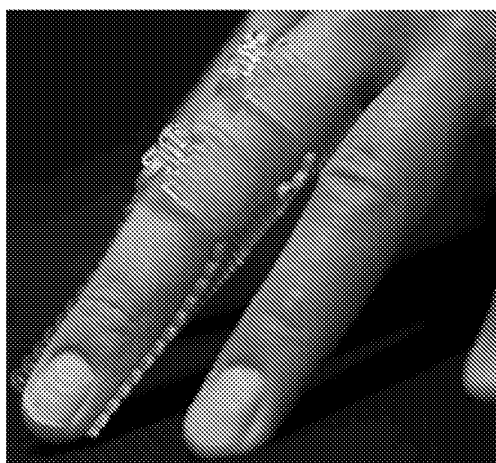


FIG. 14D

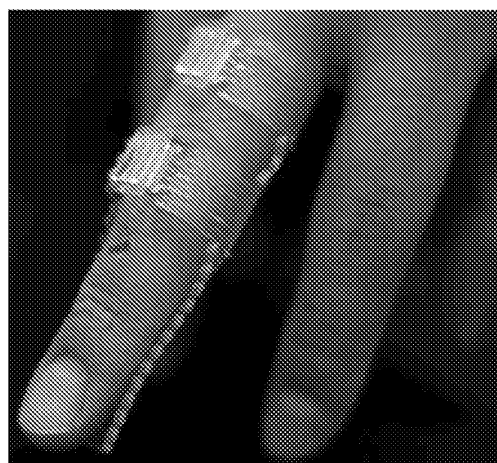


FIG. 14E