

ABSTRACT

An object of the present invention is to provide a laminating-printing system which can further improve the quality of laminated-printed objects. The present invention provides a laminating-printing system including a laminating-printing unit (10) which prints the layers and sequentially laminates the layers; and a concentration adjusting unit (30) which adjusts the concentration of gas components in the shield gas, the laminating-printing unit (10) including: an irradiation section including an irradiation source of energy rays to irradiate the powder material, and a printing section including a chamber filled with the shield gas and a printing stage on which the layers are printed and laminated, and the concentration adjusting unit (30) including: a purification section which removes a first gas component which is an impurity in the shield gas based on the powder material; and a supply section which supplies a second gas component selected based on the powder material inside of the chamber as needed.