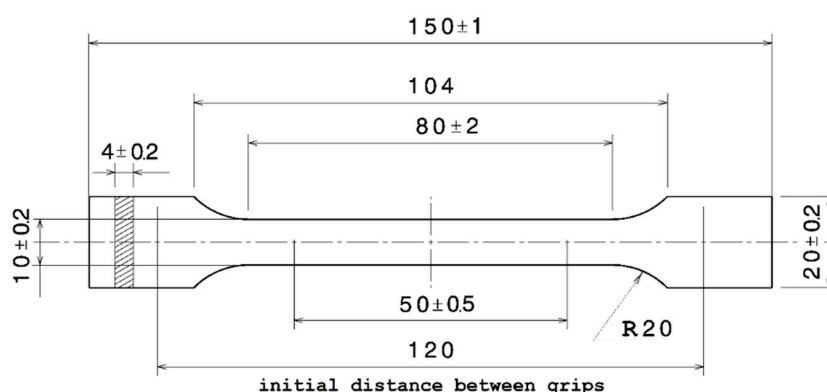# Supplementary Materials

On the Thermomechanical Behavior of 3D-Printed Specimens of Shape Memory R-PETG

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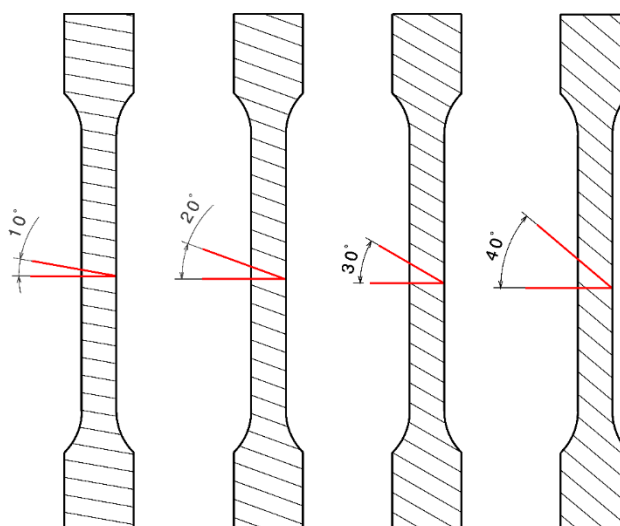Specimen geometry according to EN ISO 527-2

Illustration of the printing angle between transversal direction and filament deposition direction

Figure S1. 3D printed specimen geometry and deposition angle.

Table S1. Summary of the values of the printing parameters and printer s specifications.

	Build Surface	Extruder temperature	Bed temperature	Nozzle height	Printing speed	Travel speed	Cooling
Printing parameters	PEI (Polyetherimide)	205-220 °C	60-70 °C	0.1-0.2mm	20-80mm/s	120mm/s	moderate
	Style	Frame	Build volume, mm	Extruder configuration	Extruder	Accuracy	Speed
Printer s specifications	CoreXY Cartesian	Aluminum extrusions with 3D printed parts	210 x 130 x 140	Direct	Bondtech BMG extruder (3:1 gear ratio)	0.2-0.4mm	20-130mm/s
	Bed leveling	Stepper motors	Voltage	Mainboard	Bed surface	Firmware	Computer
	manual leveling	NEMA 17	24 V (with Meanwell PSU)	SKR V1.4 with TMC2209 stepper motor drivers	PEI sheet	Klipper	Raspberry Pi 4 (to work with Klipper firmware)