

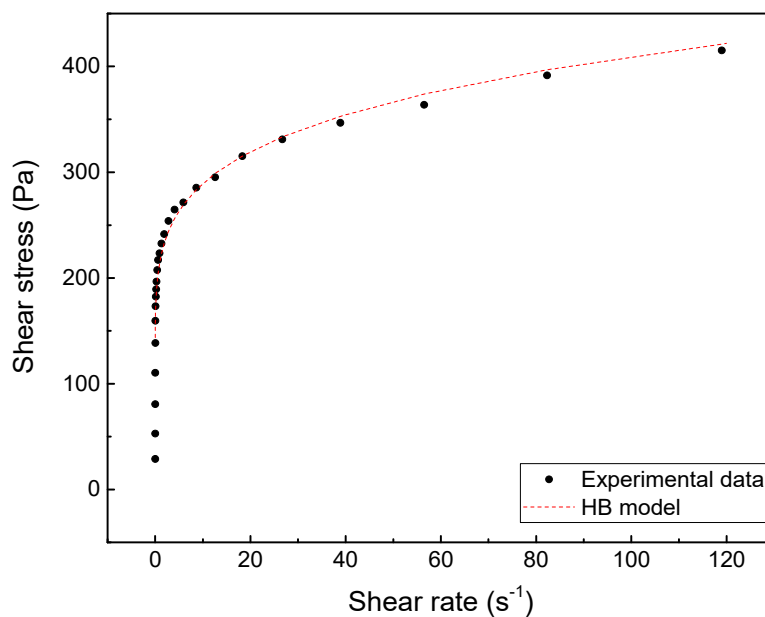
## Design of a Waterborne Polyurethane–Urea Ink for Direct Ink Writing 3D Printing

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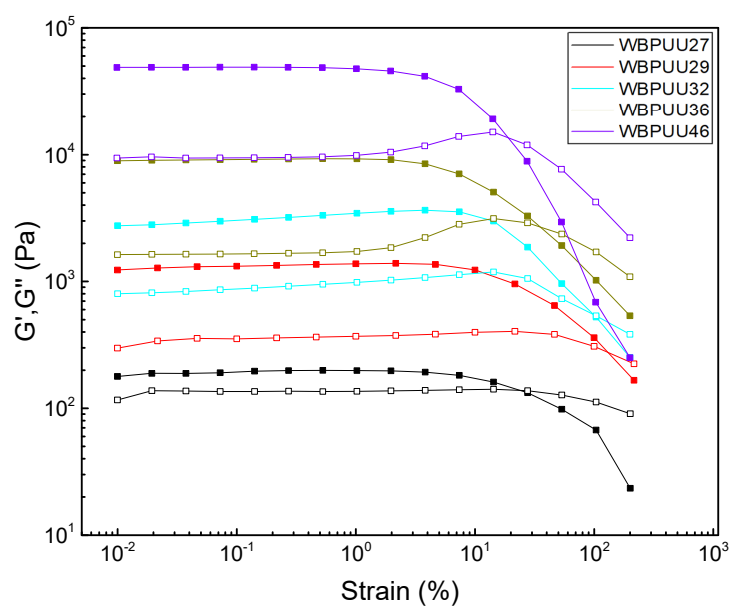
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**Figure S1.** Adjustment to the Herschel-Bulkley model of WBPUU29 flow curve.



**Figure S2.**  $G'$  (■) and  $G''$  (□) as a function of strain ( $T = 22.5$  °C) of WBPUU inks with different solid content at 1Hz.