

Supplementary

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Table S1. Sample code and slicing of 3D printed forearm of solid pattern with three different thickness

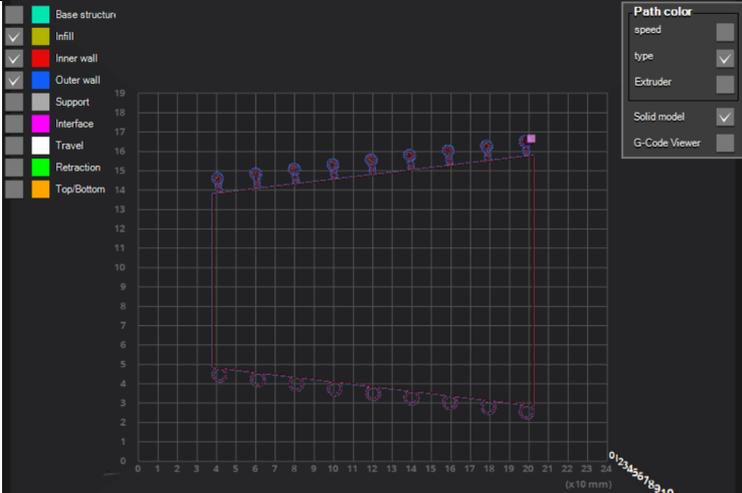
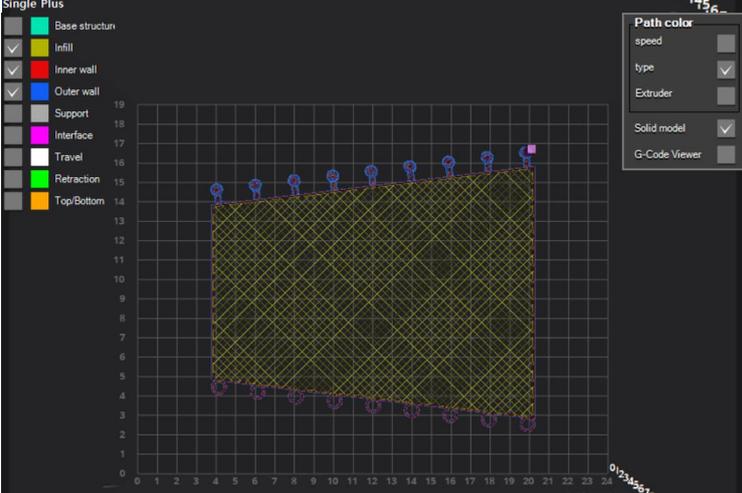
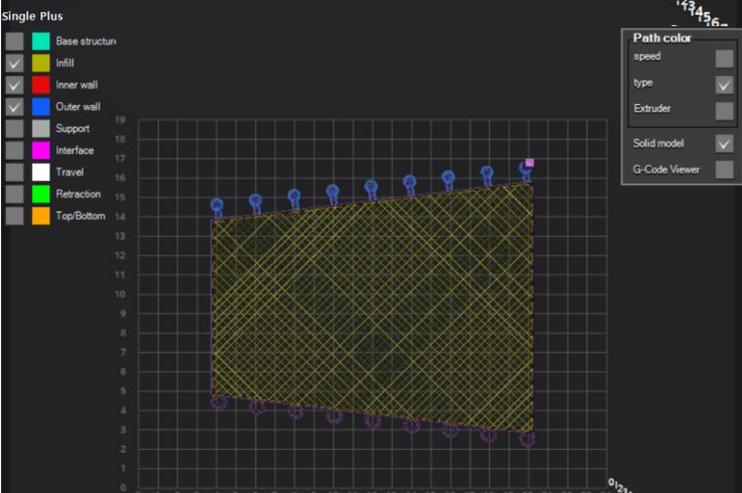
Sample code	Slicing
FA_SL1	<p style="text-align: center;">Top</p> 
FA_SL2	<p>Single Plus</p> 
FA_SL4	<p>Single Plus</p> 

Table S2. Sample code and slicing of 3D printed forearm of re-entrant pattern with three different thickness

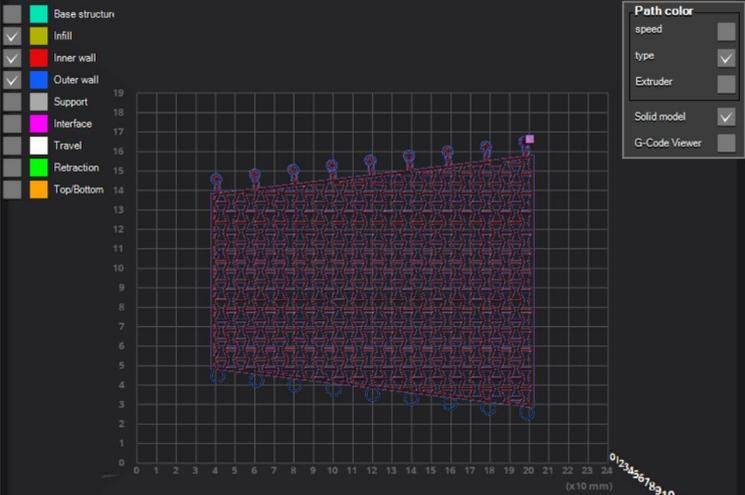
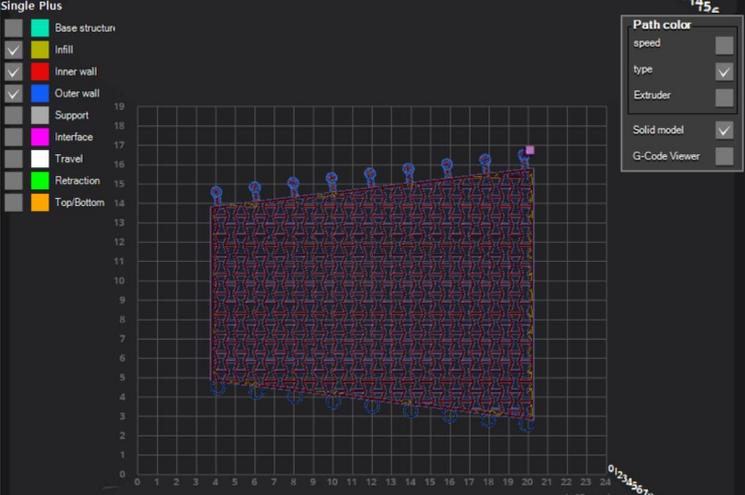
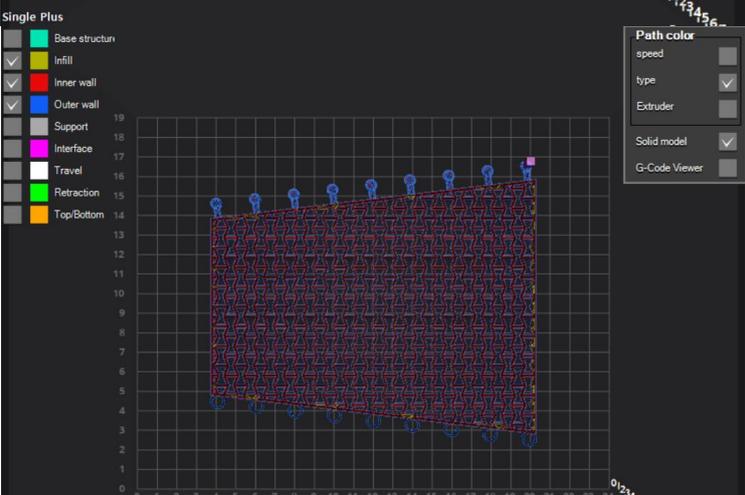
Sample code	Slicing
FA_RE1	<p style="text-align: center;">Top</p> 
FA_RE2	
FA_RE4	

Table S3. Sample code and slicing of 3D printed forearm of solid pattern with three different thickness

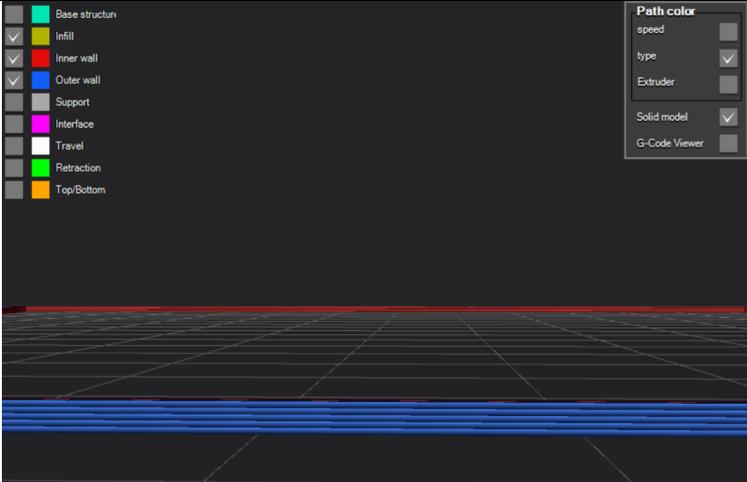
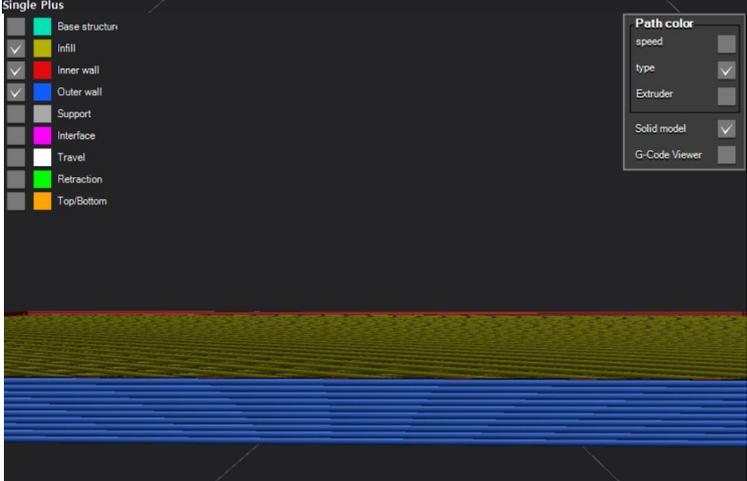
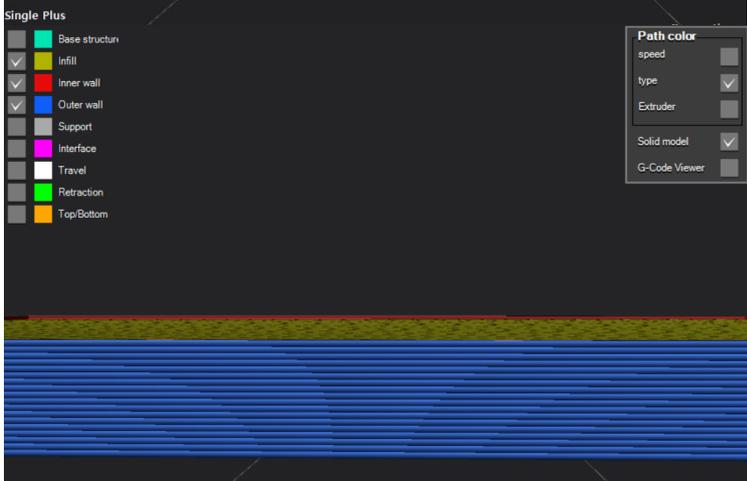
Sample code	Slicing Front
FA_SL1	 <p>The image shows a 3D slicing software interface for a forearm model. The main view displays a thin blue layer (Outer wall) on a black base (Base structure). The left sidebar contains a legend with items: Base structure (cyan), Infill (yellow), Inner wall (red), Outer wall (blue), Support (grey), Interface (magenta), Travel (white), Retraction (green), and Top/Bottom (orange). The right sidebar shows 'Path color' settings: speed (checkbox), type (checkbox), Extruder (checkbox), Solid model (checkbox), and G-Code Viewer (checkbox). The text 'Single Plus' is visible at the bottom left of the main view.</p>
FA_SL2	 <p>The image shows a 3D slicing software interface for a forearm model. The main view displays a thicker blue layer (Outer wall) with a green infill pattern (Infill) on a black base (Base structure). The left sidebar contains a legend with items: Base structure (cyan), Infill (yellow), Inner wall (red), Outer wall (blue), Support (grey), Interface (magenta), Travel (white), Retraction (green), and Top/Bottom (orange). The right sidebar shows 'Path color' settings: speed (checkbox), type (checkbox), Extruder (checkbox), Solid model (checkbox), and G-Code Viewer (checkbox). The text 'Single Plus' is visible at the bottom left of the main view.</p>
FA_SL4	 <p>The image shows a 3D slicing software interface for a forearm model. The main view displays a very thick blue layer (Outer wall) with a green infill pattern (Infill) on a black base (Base structure). The left sidebar contains a legend with items: Base structure (cyan), Infill (yellow), Inner wall (red), Outer wall (blue), Support (grey), Interface (magenta), Travel (white), Retraction (green), and Top/Bottom (orange). The right sidebar shows 'Path color' settings: speed (checkbox), type (checkbox), Extruder (checkbox), Solid model (checkbox), and G-Code Viewer (checkbox). The text 'Single Plus' is visible at the bottom left of the main view.</p>

Table S4. Sample code and slicing of 3D printed forearm of re-entrant pattern with three different thickness

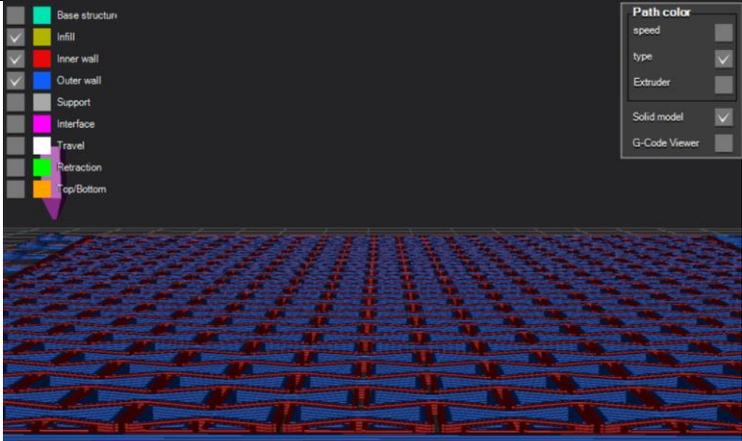
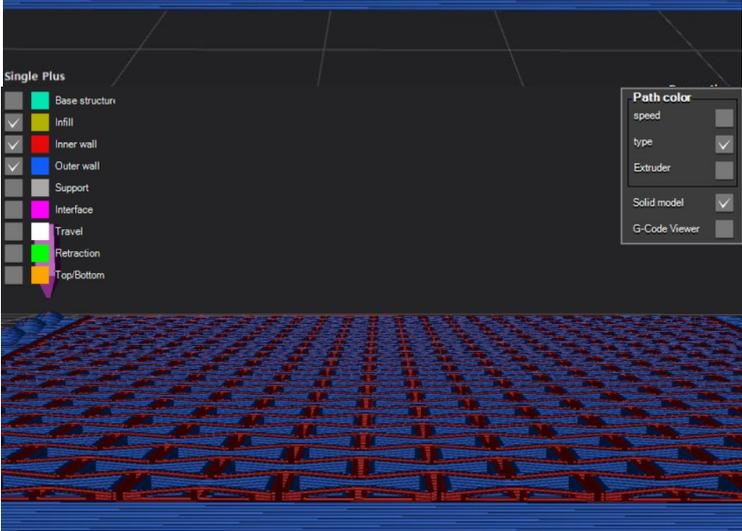
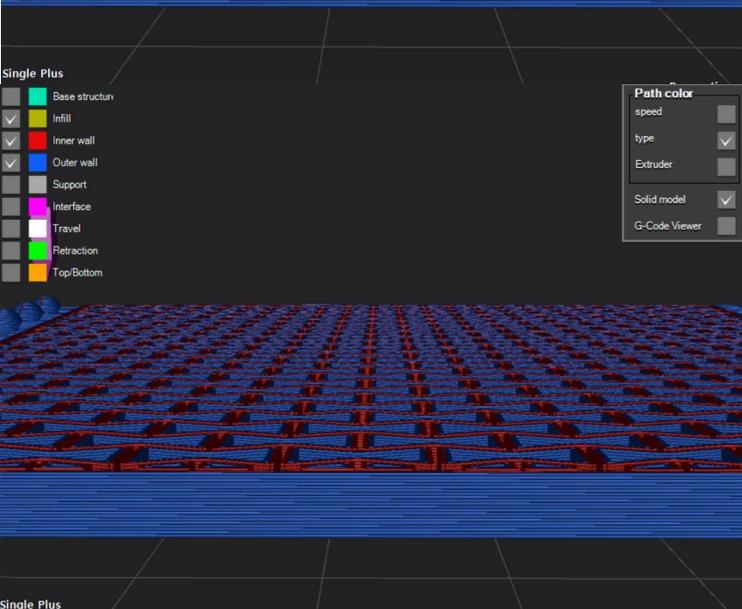
Sample code	Slicing
	Front
FA_RE1	
FA_RE2	
FA_RE4	

Table S5. Sample code and slicing of 3D printed upperarm of solid pattern with three different thickness

Sample code	Slicing
UA_SL1	<p style="text-align: center;">Top</p> <p>012345678910123456-</p>
UA_SL2	<p>Single Plus</p> <p>012345678910123456-</p>
UA_SL4	<p>Single Plus</p> <p>012345678910123456-</p>

Table S6. Sample code and slicing of 3D printed upperarm of re-entrant pattern with three different thickness

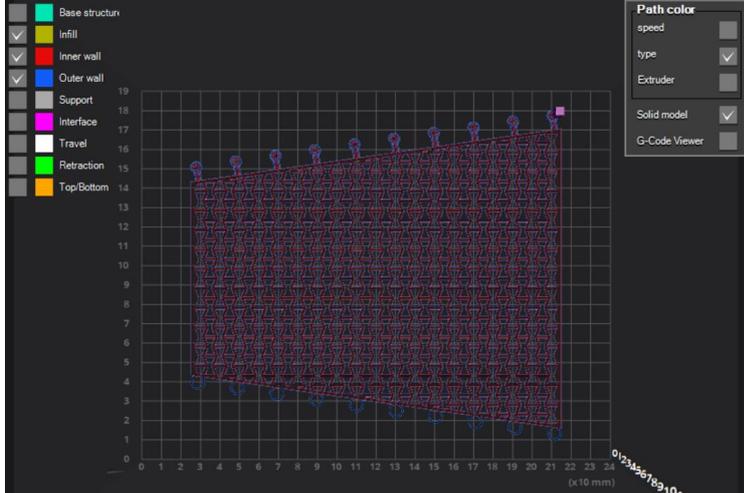
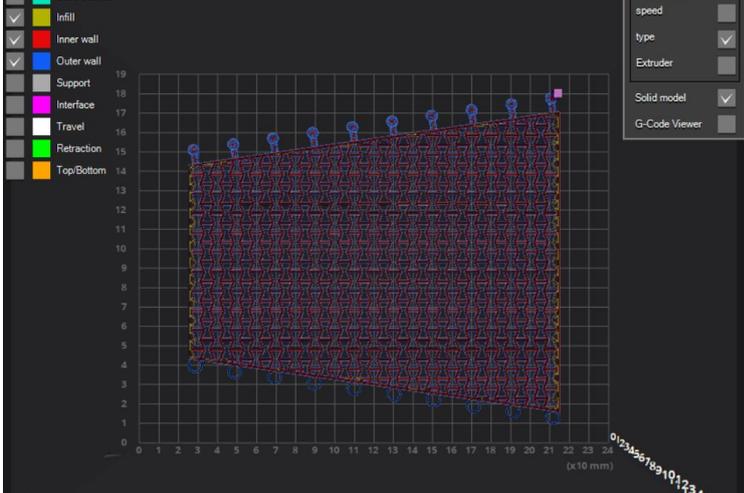
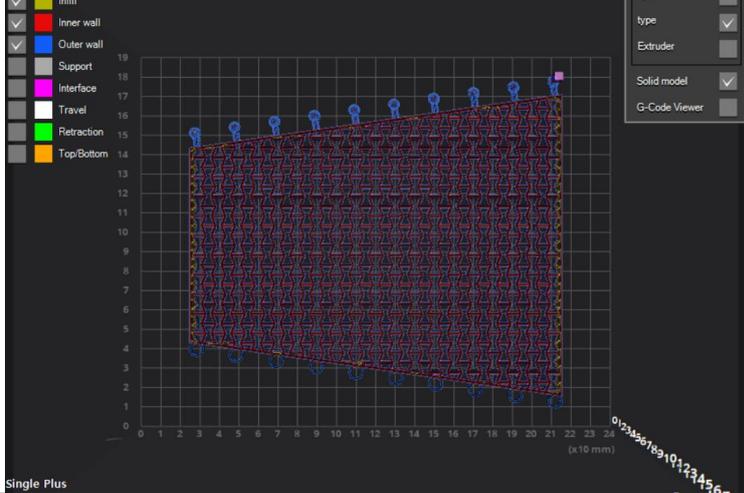
Sample code	Slicing
UA_RE1	<p style="text-align: center;">Top</p> 
UA_RE2	
UA_RE4	

Table S7. Sample code and slicing of 3D printed upperarm of solid pattern with three different thickness

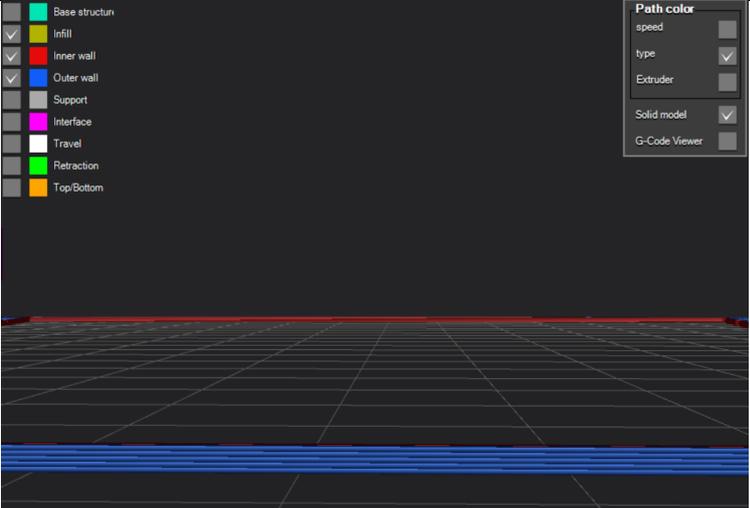
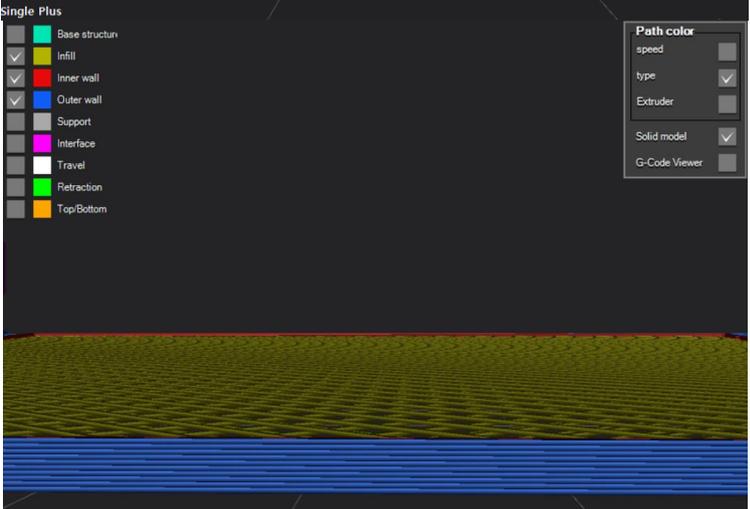
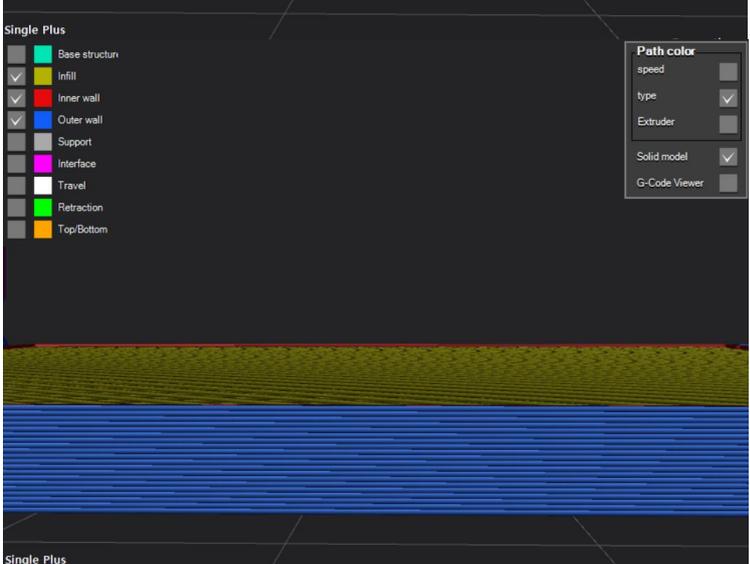
Sample code	Slicing
	Front
UA_SL1	 <p>This screenshot shows the slicing of a thin layer. The main view displays a blue layer on a grid. On the left, a legend lists: Base structure (cyan), Infill (yellow), Inner wall (red), Outer wall (blue), Support (grey), Interface (magenta), Travel (white), Retraction (green), and Top/Bottom (orange). On the right, a 'Path color' panel includes: speed (checkbox), type (dropdown), Extruder (checkbox), Solid model (checkbox), and G-Code Viewer (checkbox). The text 'Single Plus' is visible at the bottom left of the view.</p>
UA_SL2	 <p>This screenshot shows a thicker layer with a green infill pattern. The legend and 'Path color' panel are identical to the UA_SL1 view. The text 'Single Plus' is visible at the bottom left of the view.</p>
UA_SL4	 <p>This screenshot shows a very thick layer with a green infill pattern. The legend and 'Path color' panel are identical to the previous views. The text 'Single Plus' is visible at the bottom left of the view.</p>

Table S8. Sample code and slicing of 3D printed upperarm of re-entrant pattern with three different thickness

Sample code	Slicing Front
UA_RE1	
UA_RE2	
UA_RE4	