Increasing density and mechanical performance of binder jetting processing through bimodal particle size distribution

Supplementary File

Table S1. Truncated data-summary results of the full data set of 3-point bending test

| Group     | Ultimate flexural strength (MPa) |
|-----------|----------------------------------|
|           | Mean    | Std.    | RSD    |
| 10 µm     | 198.53  | 9.50    | 4.78%  |
| 20 µm     | 89.45   | 2.88    | 3.21%  |
| 30 µm     | 63.99   | 4.78    | 7.47%  |
| 40 µm     | 14.72   | 1.32    | 8.99%  |
| 30 + 10 µm| 297.70  | 59.90   | 20.10% |
| 40 + 10 µm| 362.00  | 20.10   | 5.55%  |

Figure S1. Truncated data-ultimate flexural strength for each particle size group, with mean values shown. *Bracket comparison denotes $P = 0.01$–0.05.