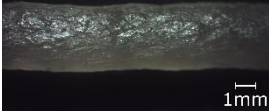


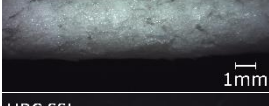
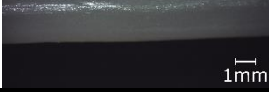


**Table 1.** Characterization of different matrix polymers in terms of extrusion temperatures (°C), screw speed (rpm), extrusion torque (Nm) and filament diameter deviation (mm).

Polymer	Extrusion temperature [°C]	Screw speed [rpm]	Max. Torque [Nm]	Diameter deviation [mm]
<div>HEC L</div> 	140	10	Limit reached (> 15)	> 0.05
<div>HEC G</div> 	150	5	Limit reached (> 15)	> 0.05
<div>HEC M</div> 	150	5	Limit reached (> 15)	> 0.05
<div>HEC HX</div> 	155	5	Limit reached (> 15)	> 0.05
<div>HPC SSL</div> 	130	25	< 15	< 0.05