

Fig.1

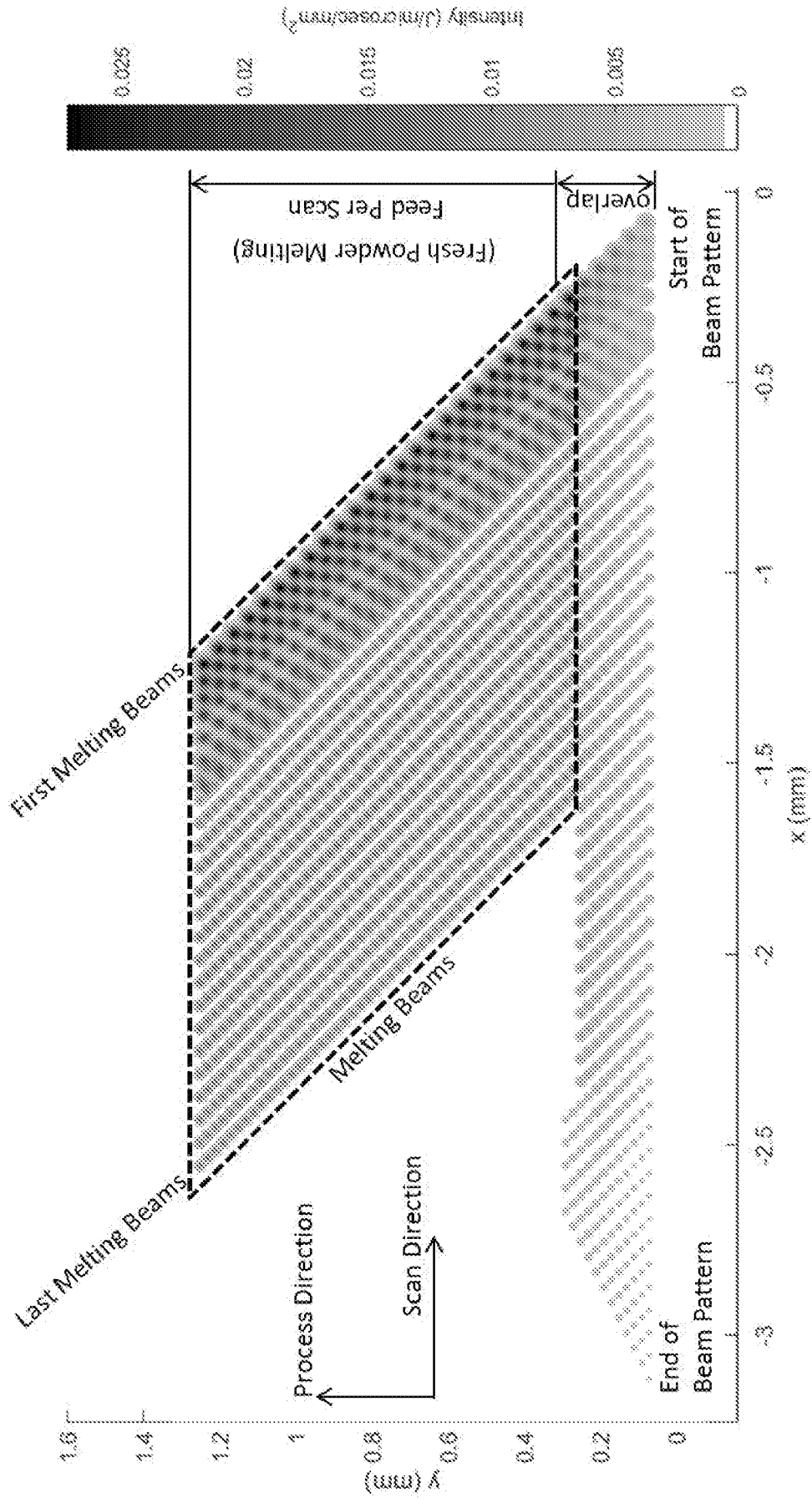


Fig.2

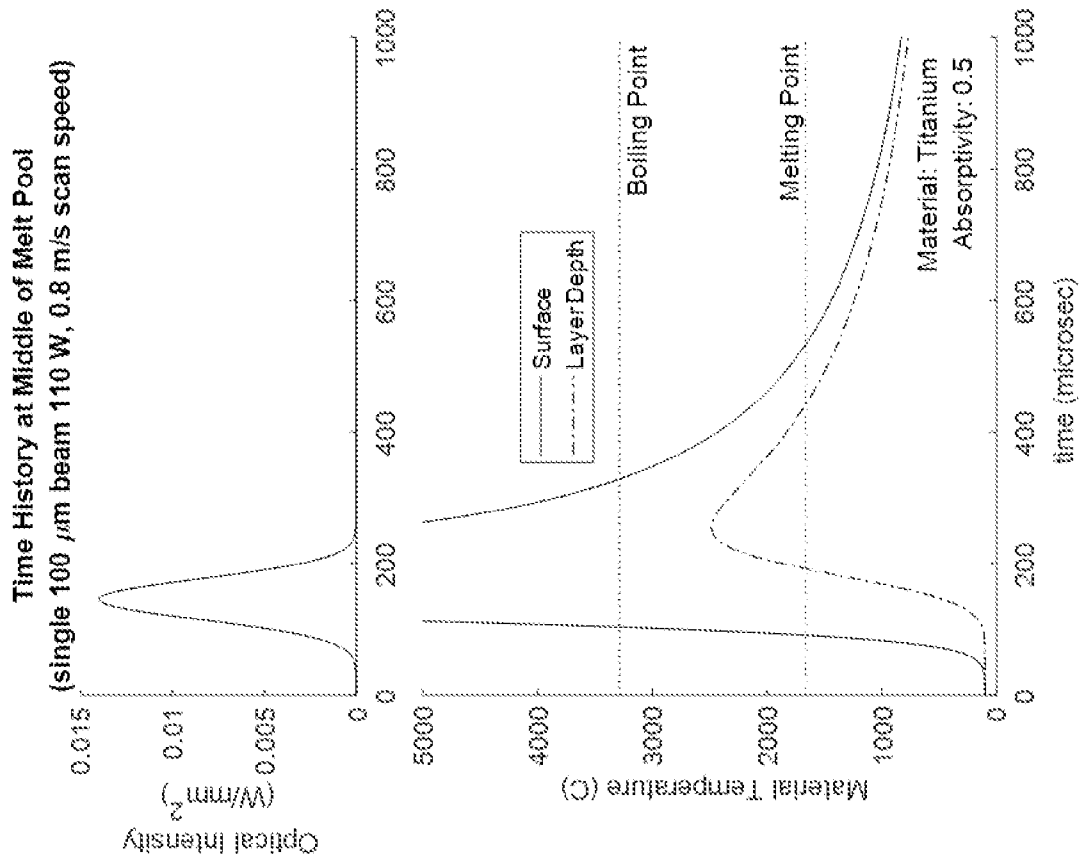


Fig.3B

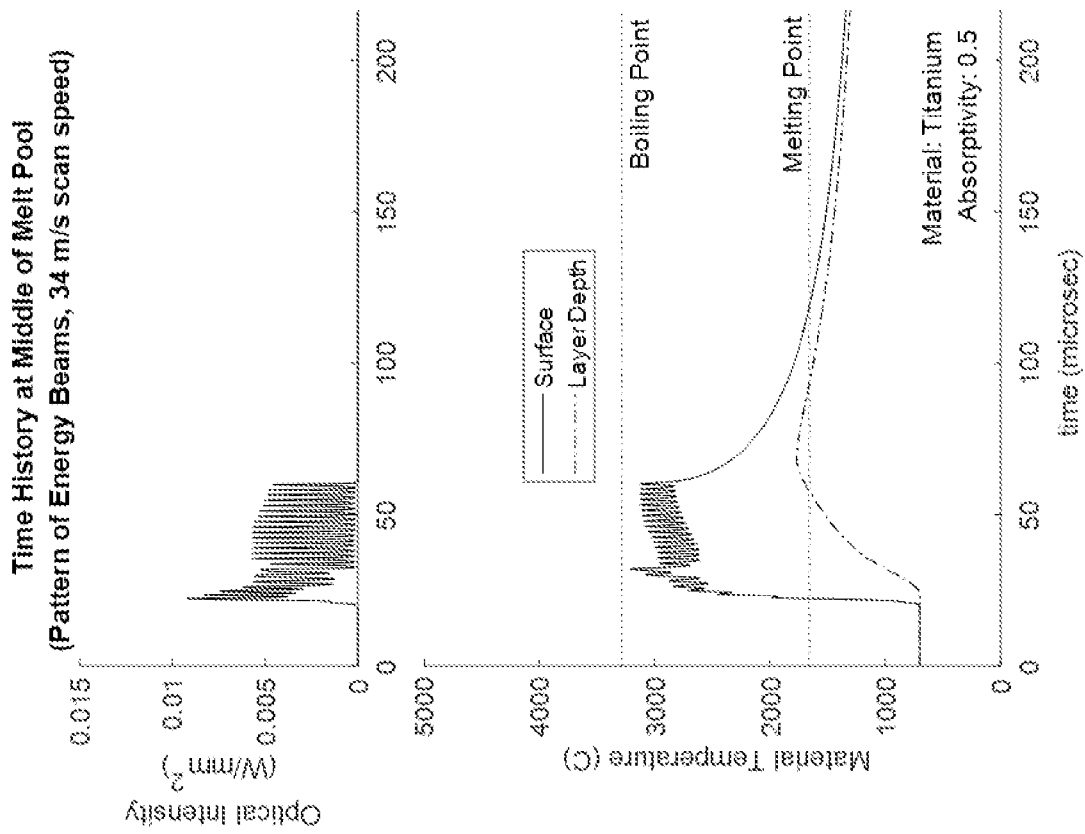


Fig.3A

Comparison of Material Processing Rate (Titanium Examples)

	Invention	Conventional	Invention / Conventional
layer depth (mm):	0.015	0.045	
scan speed (mm/s):	34,000	800	
hatch spacing (mm):	1	0.060	
area process rate (mm <sup>2</sup> /s):	34,000	48	708
volume process rate (mm <sup>3</sup> /s):	510	2.16	236

Fig. 11