

### CONTENTS

#### 1 CONCEPT

1a Conceptual framework
1b List of programme
1c Programme to form

#### 2 DESIGN FORM

2a Complete form proposal

### 3 PRODUCTION

3a Materials

3b Finishing

3c Usage

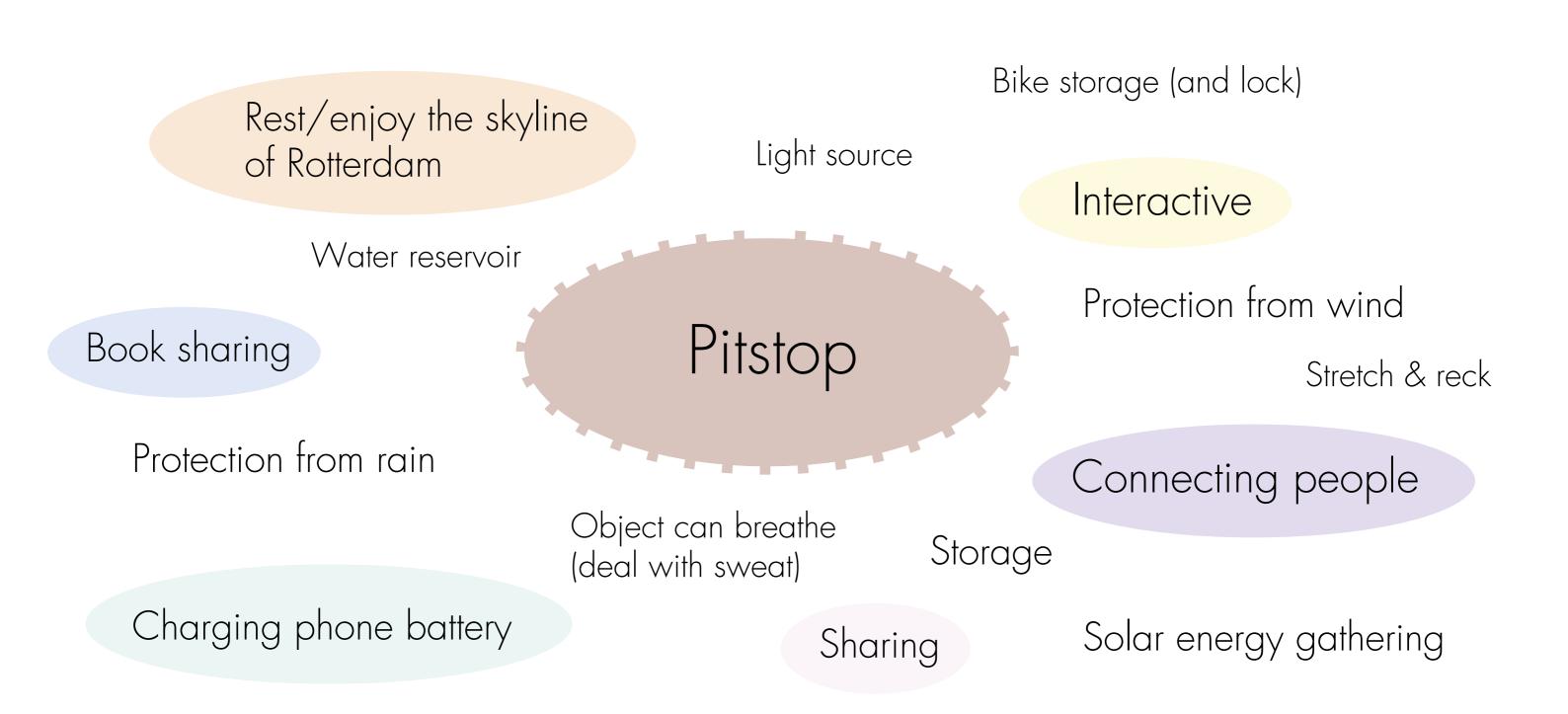
3c Assembly methods

Direction

### 1a Conceptual framework



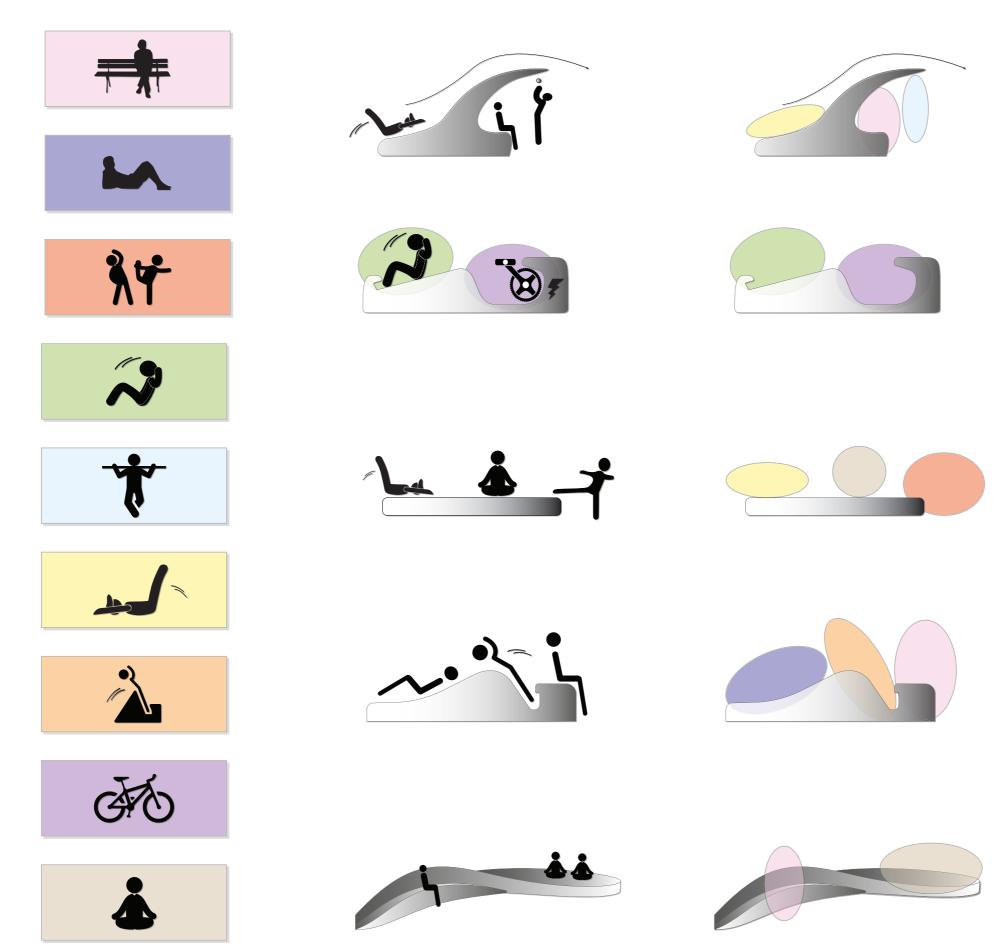
1a What do we want to achieve with our furniture?



1b Program defenition



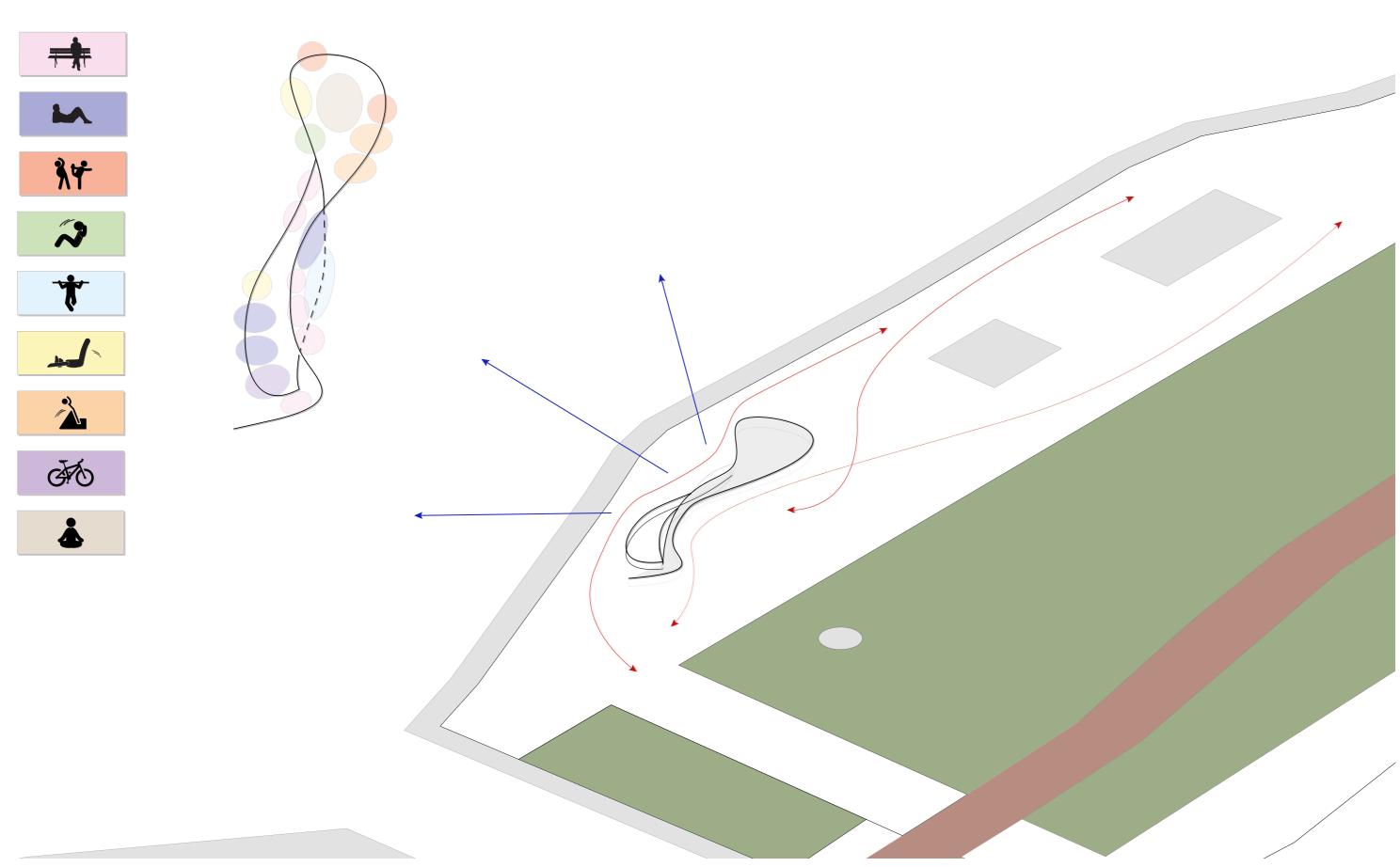
### 1c Program as form



# 2 DESIGN FORM

## DESIGN FORM

2a Design proposal



3D-printing materials - Skelet

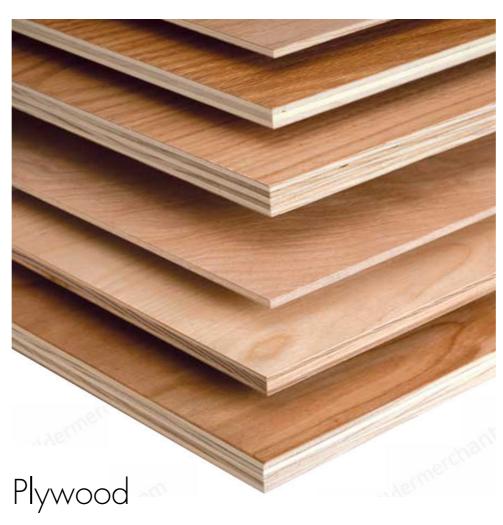
Objectives: Material has to be strong, durable, cheap, sustainable, demountable (maintenance), smooth texture.

| Туре              | Pros   | Cons   | Cost per kg     |
|-------------------|--|--|-----------------|
| — ABS             | Tough; Common; Non-toxic   | High melting point; Unpleasant fumes           | €20,- to €50,-  |
| PLA PLA           | Easy to print with; Biodegradable  | Prints degrade over time; Rough texture        | €20,- to €50,-  |
| PVA               | Water soluble; Fairly easy to print  | Expensive; Risk of toxic fumes                 | >€100,-         |
| Nylon             | Tough; Inexpensive   | High temperature requirement                   | €18,-           |
| HDPE              | Easy to dissolve; Lightweight  | High temperature requirement                   | €30,-           |
| T-Glase/PETT      | Food-safe; Glass-like look   | Slow to print; Heated printing bed needed      | €30,-           |
| Wood Filament     | Attractive wood-like look  | Finicky to use; Requires sanding               | €60,- to €100,- |
| Metal Filament    | Attractive metal-like finish   | Finicky to use; Expensive                      | €75,- to €120,- |
| Carbon Fiber Mix  | Mimics carbon fiber's lightweight strength   | Tough on extruders; Expensive                  | €50,- to €120,- |
| Flexible filament | Produces flexible prints   | Requires tinkering with the printer            | €50,- to €120,- |
| TPU95A            | High impact strengt, durable flexible, chemical resistant  | Not flexible .                                 | €75,-           |
| CPE-FAMILY        | Chemical resistant, tough and demonstrate good dimensional stability, higher temperature resistance and increased impact strength    | High temperature requirement                   | €60,-           |
| РС                | Strong and tough parts that retain dimensional stability when subjected to temperatures as high as 110 °C.                           | UV sensitive                                   | €65,-           |
| PP                | High toughness, exceptional fatigue resistance, and low friction. It also has good chemical, temperature, and electrical resistance. | Difficult to print                             | €80,-           |
| RECYCLED          | Prevents plastic waste   | Adjustment process is not environment friendly | Depends         |

## 3D-printing materials - Skelet

| Туре         | Pros   | Cons  | Cost per m2    |
|--------------|--|---|----------------|
| MDF exterior | Cheaper than plywood, smooth surface (no knots). The consistency and smoothness of MDF allows for easy cutting of detailed designs | Soak up water and other liquids like a sponge,<br>doesn't hold screws very well, very heavy,                | €15,- to €35,- |
| PLYWOOD      | Strong building material, less susceptible to water damage than MDF, It holds screws very tightly.                                 | More expensive than MDF, finish off the edges is needed. Plywood will often splinter on the edges when cut. | €25,- to €50,- |





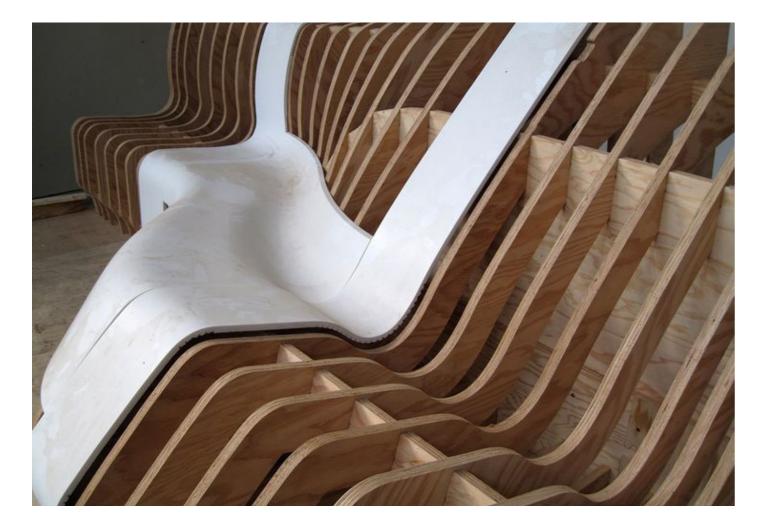
Exterior plywood, water-resistant glued

Assembly and comfort

Objectives: Comfortable to sit on, weather-proof, durable, smooth texture for excercises, anti-slip, vandalism-proof.



—> Laser cutted plywood boards







# 4 DIRECTION

