**Supplementary Information**

**Table 1** The curing parameters and calculated optimum exposure times for all mixtures.

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Binder**  |  | **Layer Thickness** | **Curing Parameters** |  | **Exposure Time** |
| **Type of Mixture** |  | **Cd** | **Dp** | **EC** |  | **Calculated**  | **Applied** |
|  | **[μm]** | **[µm]** | **[mJ cm-2]** |  | **[ms]** | **[ms]** |
| **Binder Mixtures** |  |  |  |  |  |  |  |
| **B-37 at 25,35,45 and 55 °C** |  | 50 | 183.1 | 503.3 |  | 20504 | 26000 |
| **B-42 at 25,35,45 and 55 °C** |  | 50 | 184.4 | 491.3 |  | 12503 | 16000 |
| **Ceramic Suspensions** |  |  |  |  |  |  |  |
| **B-37 loaded with 61.2 vol.% of EB01 at 25,35,45 and 55 °C** |  | 50 | 49.8 | 95.6 |  | 18473 | 28000 |
|  | 100 | 49.8 | 95.6 |  | 50265 | 75000 |
| **B-42 loaded with 61.2 vol.% of EB01 at 25,35,45 and 55 °C** |  | 50 | 56.6 | 107.4 |  | 16119 | 25000 |
|  | 100 | 56.6 | 107.4 |  | 38000 | 58000 |



**Figure 1** The comparison of the bottom, middle and top cross-sections and the dimensional accuracy of randomly selected points in these cross-sections