1. Gaps in the Z-axis are filled with support material.
2. Matte finish puts a layer of support material on top of part.
3. To minimize cost:
   1. Select Glossy finish.
   2. Make flat parts by splitting your part into smaller parts.
   3. Orient parts to eliminate gaps under the build material:
The same part made two different ways:

One Piece

Two Pieces

Support Material
After printing:

Cost = $37

Cost = $24
## Material & Time

<table>
<thead>
<tr>
<th></th>
<th>One Piece</th>
<th>Two Pieces</th>
</tr>
</thead>
<tbody>
<tr>
<td>Build Material</td>
<td>15 g</td>
<td>15 g</td>
</tr>
<tr>
<td>Support Material (Matt)</td>
<td>28 g</td>
<td>14 g</td>
</tr>
<tr>
<td>Support Material (Glossy)</td>
<td>22 g</td>
<td>9 g</td>
</tr>
<tr>
<td>Time (hh:mm)</td>
<td>3:54</td>
<td>2:27</td>
</tr>
</tbody>
</table>
Printed differently but identical after assembly.