Figure 1. Scheme of the external extrusion module (component E in Figure 1A) showing the two electric stepper motors, as well as the timing belts and pulleys that drive the system. \( w_g, w_1, w_2, w_3 \) and \( w_4 \) are the angular speeds of the main stepper motors and the driving screws of syringes \( a, b, c \) and \( d \), respectively. \( n, n_1, n_2, n_3 \) and \( n_4 \) are the teeth numbers of the pulleys of the stepper motors and the syringes \( a, b, c \) and \( d \), respectively.