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Supplementary Material

Degree of crystallinity of the parts produced by BCC and CCC.

Crystallization melting peak												
Part	*BCC*						*CCC*					
	Bottom		*Middle*		*Top*		*Bottom*		*Middle*		*Top*	
	$\Delta H_f(T_c)$	(T_c)	$\Delta H_f(T_c)$	(T_c)	$\Delta H_f(T_c)$	(T_c)	$\Delta H_f(T_c)$	(T_c)	$\Delta H_f(T_c)$	(T_c)	$\Delta H_f(T_c)$	(T_c)
1	*91.48*	*112.7*	*94.04*	*112.96*	*96.6*	*113.02*	*95.45*	*114.27*	*93.23*	*114.13*	*95.45*	*114.42*
2	*90.04*	*113.83*	*93*	*114.26*	*92.84*	*114.26*	*89.67*	*114.15*	*94.76*	*114.16*	*90.02*	*114.21*
3	*91.2*	*114.35*	*93.2*	*113.81*	*94.27*	*114.03*	*88.29*	*114.51*	*89.36*	*114.52*	*91.28*	*114.22*
4	*95.33*	*114.41*	*95.23*	*114.31*	*94.86*	*114.06*	*87.29*	*113*	*92.69*	*113.37*	*93.57*	*113.41*
5	*93.38*	*114.54*	*90.2*	*114.53*	*96.51*	*114.1*	*94.96*	*114.2*	*90.73*	*114.03*	*93.05*	*114.35*
Mean	***92.29***	***113.97***	***93.13***	***113.97***	***95.02***	***113.89***	***91.13***	***114.03***	***92.15***	***114.04***	***92.67***	***114.12***
Stdv.	***2.08***	***0.75***	***1.86***	***0.62***	***1.59***	***0.50***	***3.82***	***0.59***	***2.13***	***0.42***	***2.10***	***0.41***
Xc_net	*7.23*		*7.19*		*8.84*		*7.00*		*6.63*		*7.30*	
Xc_Tm	*36.92*		*37.37*		*36.62*		*36.60*		*37.46*		*37.05*	
Xc_Tc	*44.16*		*44.56*		*45.46*		*43.60*		*44.09*		*44.34*	