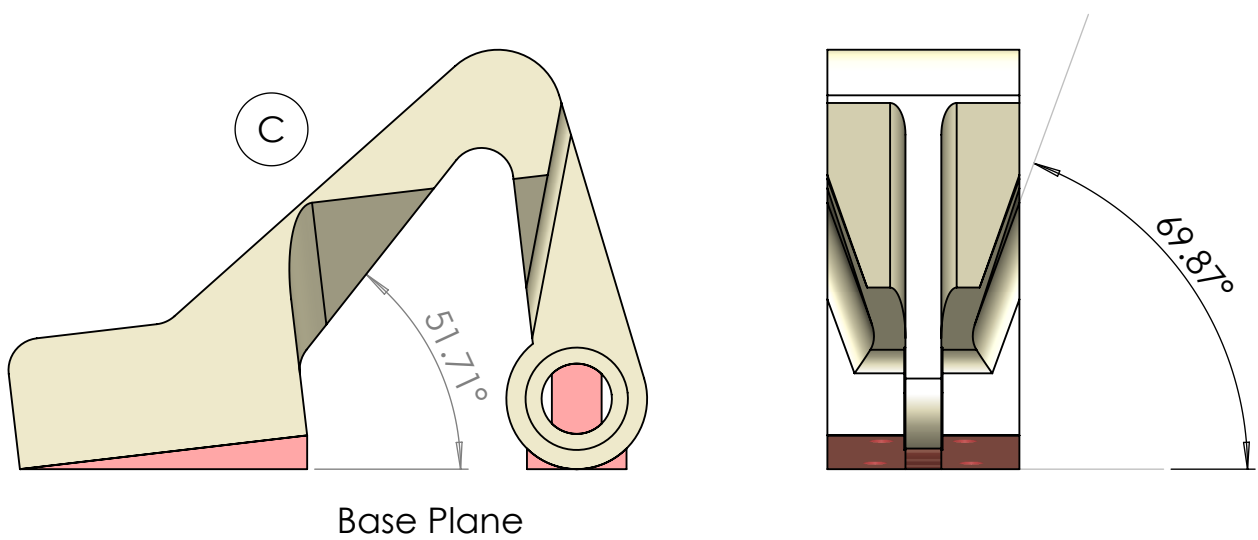
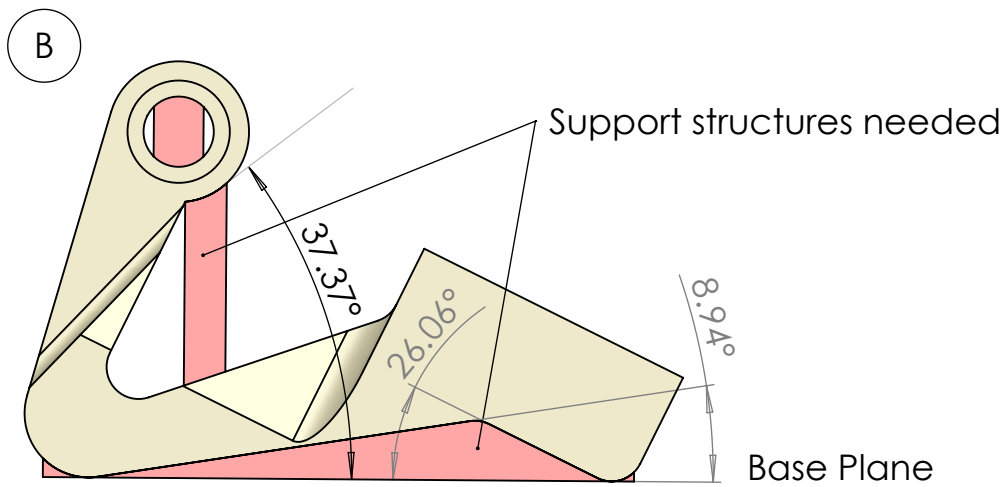
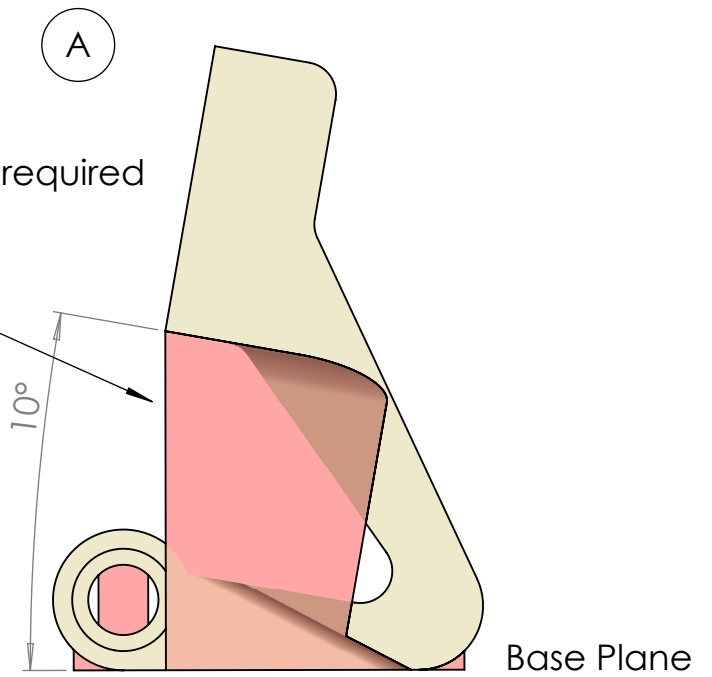


Less than 45 degrees
to the base plane: nested supports required
(Costly to remove)



No surfaces with less than 45 degree inclination: only base supports needed
(Easier to remove)