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(54) **METHOD OF REDUCING THE FORCE
REQUIRED TO SEPARATE A SOLIDIFIED
OBJECT FROM A SUBSTRATE**

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(57) **ABSTRACT**

A method and apparatus for making a three-dimensional object from a solidifiable material such as a photopolymer is shown and described. In accordance with the method, positions relative to a build axis are subdivided into first and second exposure data subsets, and the first and second exposure data subsets are solidified in alternating sequences to reduce the surface area of solidified material in contact with a solidification substrate.

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