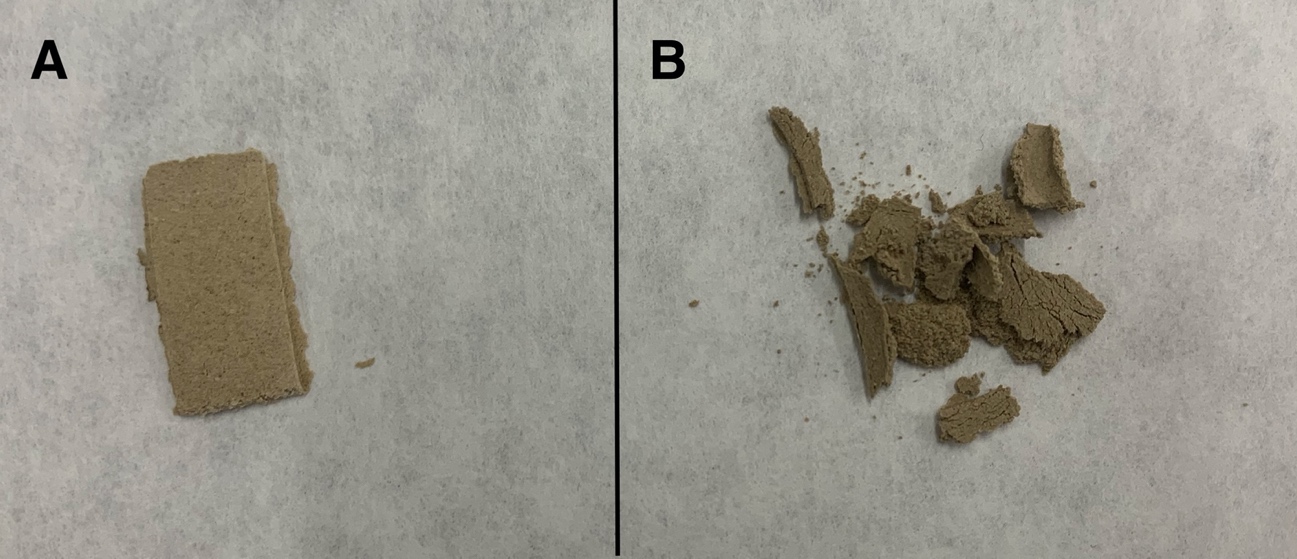
**SUPPLEMENTARY MATERIAL**



**Figure S1.** Specimens obtained during injection moulding with excess water in the dough.



**Figure S2.** Appearance of the specimens after the freeze drying stage (A) 50 ºC and (B) 110 ºC system.