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# *In situ* bioprinting: Control strategies, bioinks, applications, challenges and future perspectives

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# *In situ* bioprinting: Control strategies, bioinks, applications, challenges and future perspectives

*Running title: In situ* bioprinting: control, applications, and outlook

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**Abstract**

In situ bioprinting is an emerging technology that directly deposits bioinks on demand within clinical environments to generate targeted tissue structures. It integrates the printing and implantation processes, enabling the cultured constructs to take advantage of the biological microenvironment of the organism. This technology reduces the risk of contamination during transplantation and improves operational precision, thus demonstrating broad application prospects in fields such as tissue repair and biomedical sensor fabrication. This paper discusses the following aspects: from the perspective of control strategies, it summarizes the developmental trend of in situ bioprinting from open-loop control toward closed-loop control, and outlines key procedures including geometric reconstruction, conformal slicing, infill trajectory planning, and parameter mapping in in situ bioprinting.; combined with body-surface and open-exposure scenarios, minimally invasive intervention scenarios, remote energy-driven scenarios, and biosensing scenarios, this review discusses the demands faced by in situ bioprinting in different application settings, the design logic of bioinks, and representative research progress; the printable characteristics and application boundaries of natural polymers, synthetic polymers, and 4D smart materials in in situ bioprinting are summarized. Finally, the challenges faced by this technology and its potential directions for improvement in the future are also discussed.

***Keywords:*** In situ bioprinting; Control strategy; Actuation system; Bioink; Application scenarios

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## 1. Introduction

In situ bioprinting can be defined as a technology that directly patterns bioinks within clinical environments to generate tissue structures with the desired volumetric geometry[1]. As an advanced biomanufacturing strategy, in situ bioprinting integrates the deposition process of cells and biomaterials with clinical intervention procedures, enabling the direct construction of tissue structures in vivo or on body surfaces. Through this approach, the printed structures can be immediately exposed to the physiological microenvironment of the host after formation, achieving in situ maturation under the synergistic effects of blood supply, immune regulation, and mechanical signals, thereby promoting tissue integration and functional recovery[2,3]. Meanwhile, this strategy avoids complex in vitro culture and transportation processes, helping to reduce the risk of exogenous contamination and improve the precision of spatial positioning and morphological matching between the constructed structures and target tissues.

From the perspective of technical systems, three-dimensional bioprinting can mainly be classified into extrusion-based, inkjet-based, and photocuring-based approaches according to their forming principles. Extrusion-based bioprinting achieves material deposition through continuous extrusion and exhibits good adaptability to high-viscosity bioinks and high-cell-density systems[4]. Inkjet-based bioprinting enables high-resolution deposition in the form of droplets, but it requires strict control over material viscosity and environmental stability[5,6]. Photocuring-based bioprinting relies on photocrosslinking reactions for rapid fabrication, offering high precision but showing strong dependence on material systems and operational conditions[7–9]. To meet the demand for stable deposition in complex and dynamic environments during in situ bioprinting, extrusion-based technology has become the predominant implementation approach due to its relatively simple system architecture, broad compatibility with bioinks, and ease of handheld operation or integration with robotic arms. Inkjet-based technology demonstrates certain potential in scenarios requiring precise deposition; however, it imposes stringent requirements on bioinks and may cause damage to cells

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encapsulated within the bioink. It has been applied in bone and skin repair but is less suitable for organ repair[10,11]. Photocuring-based technology is limited in in situ bioprinting applications because of its dependence on optical pathways and operational space. In most cases, bioinks are first extruded and subsequently irradiated with an external ultraviolet lamp on a platform. Nevertheless, vat photopolymerization technology is expected to overcome some of application limitations[12,13].

In terms of implementation mechanisms, in situ bioprinting generally requires material deposition to be performed on non-ideal and dynamically changing substrates. The printing region exhibits continuous variations in spatial posture and Z-axis height, which imposes higher requirements on the motion control, path planning, and real-time feedback capabilities of the printing system. In addition, during in vivo repair processes, target tissues undergo movement and deformation caused by physiological rhythms such as respiration, pulsation, and changes in muscle tension, resulting in printing surfaces that are typically freeform and time-varying[14]. These characteristics have driven the development of control strategies in in situ bioprinting from traditional open-loop control toward closed-loop control based on perceptual feedback.

The applicability of in situ bioprinting is closely related to the anatomical location and accessibility of the target tissue. From the perspective of application scenarios, this strategy has been extensively explored in superficial tissue repair, such as skin wounds, cartilage, and bone defects. These tissues have favorable visualization conditions and operational accessibility and are usually treated in open environments, enabling high-precision deposition. On the other hand, with the development of flexible printing devices, minimally invasive platforms, and endoscopic-assisted systems, in situ bioprinting has also shown potential applications in internal organs such as the liver and stomach wall. For example, biomaterials and cells can be precisely deposited at injury sites through minimally invasive platforms to promote local tissue regeneration. It is noteworthy that, compared with superficial tissues, internal organ environments are significantly more dynamic and complex[15–18]. Taking the liver as an example, liver tissue is characterized by high vascularization, a complex mechanical environment, and

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continuous physiological motion, all of which impose higher demands on path planning, deposition stability, and real-time feedback control of printing systems. For visceral organs such as the liver, repair in an open environment is feasible, however, it requires a large surgical incision. Minimally invasive surgery, by contrast, can accomplish the same task through a small incision and is more conducive to postoperative recovery. In this scenario, the system only needs to "puncture" the actuator into the body and then autonomously complete the repair process. However, how to achieve accurate positioning and motion control of the actuator under puncture conditions remains a challenging problem. Therefore, although current in situ bioprinting has shown potential for expansion toward deep tissues, its applications are still under active development. In addition, in situ bioprinting provides a new paradigm for the on-site fabrication of wearable and implantable biosensors. For example, flexible electrodes, conductive hydrogels, and strain-sensing structures can be directly printed at wound sites to enable continuous monitoring of tissue healing, infection status, or local mechanical environments[19–22].

In situ bioprinting is an interdisciplinary research field that integrates control strategies, bioinks, printing systems, and sensing technologies. This paper reviews the research progress of in situ bioprinting in terms of control strategies, algorithms, application scenarios, and bioinks, and further discusses its future development directions.

## 2. Control Strategies and algorithms for in situ bioprinting

### 2.1. Control Strategies

Zhu et al. classified in situ bioprinting into open-loop printing and closed-loop printing[23]. Accordingly, control strategies can also be divided into open-loop control strategies and closed-loop control strategies. Open-loop control relies on preoperative modeling and predefined path execution, without real-time correction based on environmental changes during the printing process. In contrast, closed-loop control continuously senses the target state through a feedback system composed of sensors

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and uses the feedback information in real time for trajectory correction and parameter adjustment, thereby improving the system's adaptability to dynamic environments during the printing process.

### 2.1.1. Open-Loop Control Strategy

Open-loop control is an earlier adopted control mode in in situ bioprinting. Its basic idea is to complete geometric acquisition of the target region, path planning, and printing parameter setting before printing, and then perform material deposition according to a pre-generated trajectory during the printing process. This strategy typically includes steps such as preoperative imaging, three-dimensional model reconstruction, defect modeling, offline path planning, and trajectory execution. Its characteristics include a relatively simple system architecture and clear control logic, making it suitable for printing scenarios where the target position is stable and morphological changes are minimal.

Cohen et al. used a 3D printer based on a three-axis gantry motion system . By performing Boolean operations on CT images acquired before and after defect creation, they generated a defect model and successfully completed the repair of osteochondral defects, with outcomes meeting clinically acceptable standards[24]. Li et al. employed a modified four-degree-of-freedom robotic arm to perform repair printing on porcine bone defects and established a robotic arm error model and kinematic model to compensate for ex vivo printing errors[25]. Specifically, recognition and compensation were introduced into the defect model, ultimately reducing the average error to 0.5157 ± 0.4240 mm. The system completed tibial defect repair within 12 minutes and achieved superior tissue regeneration quality during the postoperative recovery phase. The above studies indicate that open-loop control can achieve relatively high-precision in situ construction by relying on compensation methods to reduce errors under conditions where geometric information is accurate and the target region is relatively stable.

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However, the limitation of open-loop control lies in its strong dependence on the accuracy of preoperative modeling and the precision of predefined paths. When the target tissue undergoes displacement, deformation, or posture changes during the printing process, the system cannot promptly correct trajectory deviations, which may easily lead to deposition mismatch, structural deformation, or even printing failure. Therefore, open-loop control is more suitable for relatively stable printing scenarios such as bone and cartilage, while its adaptability is limited in motile tissues, and complex in vivo environments.

### 2.1.2 Closed-Loop Control Strategy

Closed-loop control is a further development based on open-loop control, and its core feature is the introduction of a feedback system during the printing process, enabling the execution system to dynamically correct the printing process according to changes in the target state. Unlike the asynchronous mode of planning and execution in open-loop control, planning and execution in closed-loop control are synchronized, and the system is typically composed of a sensing module, a state estimation module, a control decision-making module, and an execution module. This strategy can perceive in real time the geometric changes of the printing surface, deformation states, and the relative relationship between the nozzle and the surface, and accordingly dynamically adjust the printing trajectory, nozzle height, or printing parameters, thereby improving the stability and precision of in situ printing in dynamic environments.

O'Neill et al. designed an early closed-loop printing strategy[26]. The team tracked the moving hand using hardware composed of a hand-tracking sensor and a laser profilometer, combined with a custom software stack, and integrated with a three-degree-of-freedom robot to print predefined geometries onto unfixed and dynamic substrates by using piezoelectric microjet technology. Kucukdeger and Johnson achieved planar and non-planar additive manufacturing on moving substrates and objects through real-time sensing of local object–tool offsets[27]. Specifically, they employed a process-integrated one-dimensional laser displacement sensor to locally monitor the nozzle–surface offset, thereby enabling real-time control of the z-axis

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position of the microextrusion nozzle. Finally, a three-axis robot was used to accomplish in situ conformal additive manufacturing of single-layer and multilayer hydrogel structures on a vertically moving adult hand.

In the field of in situ bioprinting for biological tissues, Zhu et al. designed a computer vision-assisted integrated robotic system to achieve adaptive printing[28]. This system acquired surface information via structured-light scanning, combined it with real-time estimations of rigid-body motion of the target surface. The integrated feedback was then transmitted to the motion controller to realize adaptive printing. Finally, the system was integrated with an extrusion-based 3D printer for two experiments: first, the strategy was validated by directly fabricating high-performance and easily removable wirelessly powered electronic devices on unconstrained human hands; and second, repair was performed on mouse skin wounds, demonstrating the feasibility of in situ bio-repair applications.

Furthermore, the same team proposed another closed-loop bioprinting system integrating artificial intelligence (AI)[29]. They used a structured-light 3D scanner to construct an offline learning point cloud dataset and a pair of synchronized machine vision cameras to perform 3D tracking of reference markers. Subsequently, a 3D bioprinting gantry system was used to print electrical impedance tomography (EIT) sensors on periodically contracting porcine lungs, achieving in situ monitoring of lung deformation. Derayatifar et al. also incorporated AI algorithms into Closed-Loop Control Strategy[30]. In their previous studies on direct sound printing, the team found that although the conventional Iterative Angular Spectrum Approach (IASA) could effectively reconstruct target acoustic patterns, it exhibited significant limitations in efficiency and practical feasibility. Therefore, they introduced penalty functions and deep learning algorithms into the reconstruction process to rapidly and accurately reconstruct holographic images. The results showed that the uniformity of the final printed parts was improved, alleviating the thickening problem of partially cured components before the completion of printing. Discussions regarding applications in the field of biosensing and other studies on direct sound printing will be presented in

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subsequent sections. Figure 1 presents two closed-loop control strategies applied in in situ bioprinting.

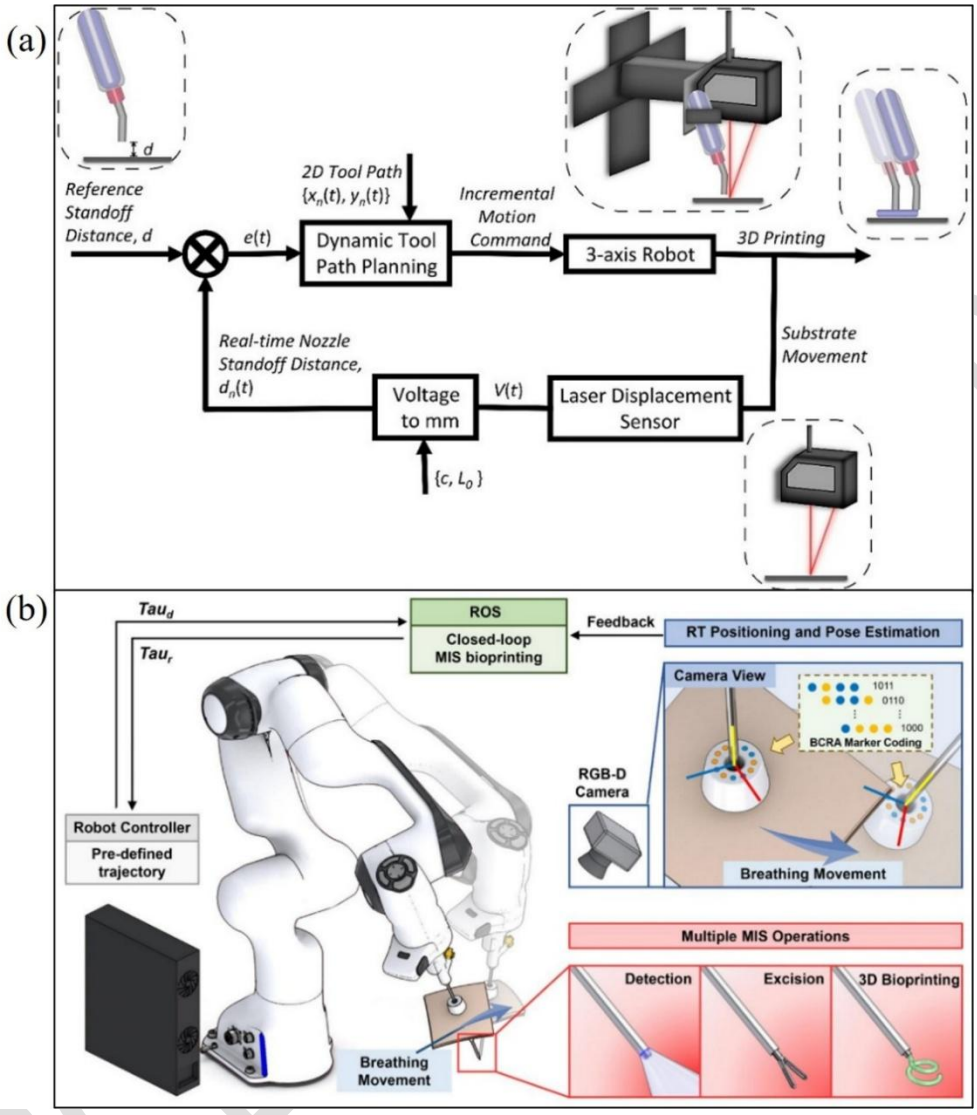



**Figure 1.** Sensing device-based closed-loop control strategies for in situ bioprinting. (a) Closed-loop control strategy based on a one-dimensional laser displacement sensor, the distance between the nozzle and the printing surface is adjusted by comparing the measured values of the laser sensor with the reference values, thereby improving the printing effect. Reprinted with permission from Kucukdeger and Johnson[27] Copyright © 2023 Elsevier Inc; (b) Visual-recognition-based trocar needle closed-loop in situ bioprinting strategy used, the system adjusts the pose of the trocar based on the color ring numbers collected by the vision camera, where a group of four consecutive marking points is assigned a specific number. Reprinted with permission from Zhao et al.[31] Copyright © 2023 Elsevier Inc.

For deep-tissue and minimally invasive scenarios, Zhao et al. proposed a closed-loop in situ printing strategy suitable for minimally invasive surgery[31]. Specifically, they developed a novel Binary Coded Ring Array (BCRA) marker for robust trocar recognition, which enables precise localization and pose estimation of the trocar. This marker, together with a 7-degree-of-freedom bioprinting robot, constituted a closed-loop system. To make the printing robot's kinematics an adaptive closed-loop system, they introduced fixed RGB-D-based visual servo control. Using this system, the team achieved 3D bioprinting for lesion resection and tissue repair on curved surfaces of porcine liver tissue via minimally invasive procedures, achieving good printing results and minimal contact force control at the incision site.

### 2.2 Path planning and slicing algorithms

In situ bioprinting usually needs to deal with real tissue surfaces that are irregular, non-planar, deformable, and often subject to physiological motion. Therefore, its path generation process must not only satisfy geometric filling requirements, but also take into account surface conformity and deposition continuity. This poses challenges for print path planning. In general, path planning in in situ bioprinting typically includes four major steps: geometric reconstruction of the defect region, generation of slicing strategies, infill trajectory planning, and mapping of printing parameters.

#### 2.2.1 Geometric reconstruction and defect modeling

The prerequisite for path planning is the acquisition of three-dimensional geometric information of the target region. For stable tissues such as bone and cartilage, volumetric data of the defect region are usually obtained through CT, CBCT, or MRI, followed by three-dimensional reconstruction and extraction of defect boundaries. In contrast, for soft tissue scenarios such as skin and visceral organs, surface information is more commonly acquired in real time using structured-light scanning, laser profilometry, binocular vision, or RGB-D sensors[32]. Subsequently, three-dimensional models of the target printing region are generated through point cloud registration,

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surface fitting, and mesh reconstruction, thereby providing the basis for subsequent slicing and path planning.

### 2.2.2 Slicing algorithms

Slicing is a key step in converting a three-dimensional target model into executable printing trajectories. Its core task is to decompose the target region into a series of two-dimensional or quasi-two-dimensional paths that can be deposited layer by layer. For in situ bioprinting, because the target surface often exhibits significant curvature or even dynamic fluctuations, traditional planar slicing can easily lead to interlayer mismatch, frequent nozzle lifting, and nonuniform deposition. Therefore, the concept of "conformal" slicing has emerged.

Alkadi et al. investigated conformal 3D slicing algorithms[33]. In their study, "layers" were no longer treated as planar surfaces; instead, they redefined a "layer" as a set of conformal slicing surfaces generated by progressively offsetting along the normal direction of the substrate surface. In this way, a series of nonplanar slicing surfaces consistent with the substrate morphology was constructed, enabling the printing path of each layer to conform to the continuously varying geometry of the target surface.

Ji et al. proposed a conformal algorithm capable of fabricating three-dimensional structures on freeform curved substrates without parameterizing the substrate surface or modifying the geometric design of the printed structure[34]. Unlike the approach of Alkadi et al., they first extracted the top-layer contour and surface height information from the conventional slicing paths of the substrate and represented them as a height mapping function H(x,y) on a two-dimensional plane. Subsequently, the target structure was sliced, and the Z-coordinates of all path points were compensated by adding the values of H(x,y) corresponding to their X and Y coordinates. This slicing method does not require extensive computational resources; however, it cannot guarantee a safe distance between the nozzle and the substrate. The detailed slicing procedure is illustrated in Figure 2(a).

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### 2.2.3 Path planning

After slicing is completed, infill paths within each layer must be further generated. Infill paths directly determine material distribution, pore structure, mechanical anisotropy, and nutrient diffusion behavior, making them important factors affecting the quality of tissue regeneration in in situ printing. Common path patterns include parallel grids, cross grids, and biomimetic gradient paths[35]. Parallel and cross-grid paths are widely adopted because of their simple implementation and high controllability, making these two grid structures the mainstream approaches in current applications. Biomimetic gradient paths were developed to address the complex gradient heterogeneity exhibited by native osteochondral units. Scaffolds fabricated using such paths possess smooth interlayer gradient transitions, which can significantly reduce the occurrence of complex problems such as scaffold delamination[36].

In in situ bioprinting, infill path planning must additionally consider nozzle pose constraints, tissue curvature variations, and local accessibility. Especially in robotic-arm or minimally invasive printing systems, path planning often needs to be coupled with inverse kinematics solving in order to avoid nozzle–tissue collisions, singular poses, and unreachable regions, thereby ensuring the executability of trajectories in real surgical environments. To address this issue, Zhao et al. proposed a conformal algorithm that searches for optimal path points on point-cloud-approximated surfaces through constrained optimization, ensuring a high degree of similarity in both shape and angle between the predefined planar paths and the mapped three-dimensional surface paths[37]. They further designed multilayer conformal paths on a mouse dorsal wound model and used a self-developed multi-degree-of-freedom bioprinter to perform wound filling.

### 2.2.4 Parameter mapping and trajectory correction

In situ bioprinting paths are not merely spatial geometric trajectories, but must be further mapped into executable process parameters, including nozzle speed, extrusion rate, and nozzle pose. On complex tissue surfaces, deposition quality is highly

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dependent on the dynamic matching relationship between nozzle speed and extrusion rate. If the nozzle speed is too high while the material supply is insufficient, filament breakage is likely to occur; conversely, excessive material supply may lead to accumulation or collapse.

For open-loop in situ printing systems, path planning is a one-time offline result. The entire system generally adopts a fixed set of printing parameters throughout the printing process. Therefore, before each printing task, researchers typically conduct experiments to determine the optimal printing parameters for the bioink.

For closed-loop in situ printing systems, path planning is no longer a one-time offline result, but instead becomes a dynamically updatable online process. During execution, the system continuously receives sensor feedback and performs real-time replanning of local trajectories, including nozzle height compensation and local path offset correction. The work conducted by Kucukdeger and Johnson, as mentioned earlier, is an example of this approach.

The correction of printing parameters can be achieved based on the detection results of hydrogel printing defects. Jin et al. developed an anomaly detection system based on layer-by-layer sensor images and machine learning algorithms[38]. This system is capable of detecting and localizing discontinuity, irregularity, and non-uniformity defects, showing the potential for real-time autonomous correction of printing process parameters. The correction process is as follows: first, the system evaluates parameters such as the line width and continuity of the hydrogel. If defects are detected, the printing parameters are corrected accordingly. Since G-code contains part of the printing parameter information, the correction of printing parameters here essentially refers to modifying the parameters within the G-code. For parameters that are not included in the G-code, such as the air pressure parameter in extrusion-based printing, additional control of the pneumatic valve is required. Figure 2(b) shows the detection and positioning of hydrogel defects.

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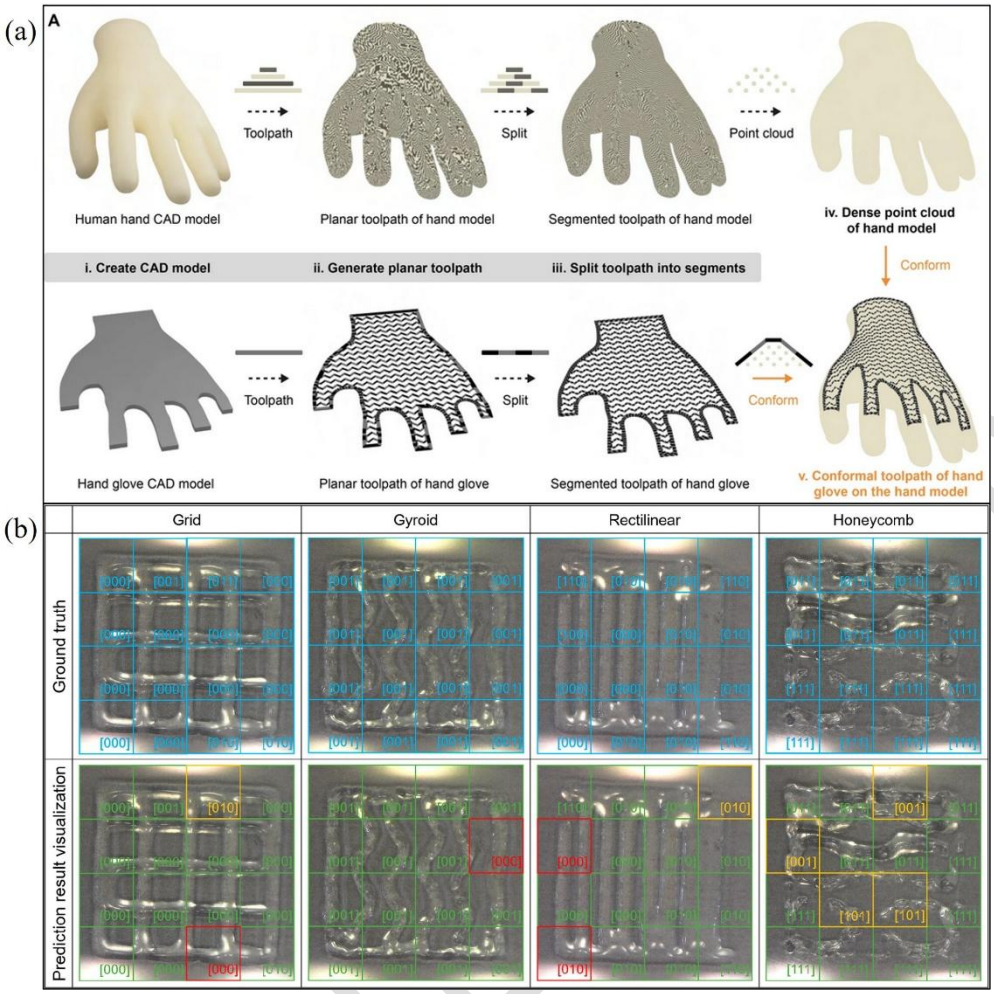



**Figure 2.** Schematic of conformal algorithm and hydrogel defect identification. (a) Schematic diagram of the conformal algorithm proposed by Ji et al., which adopts a point cloud matching method. With this strategy, the system is not required to calculate the intersection position between the substrate and the to-be-printed region. Instead, it only needs to slice the two parts separately and perform height compensation for each point of the target printing area. Reprinted with permission from Ji et al.[34] Copyright © 2023, licensed under CC BY 4.0;(b) Detection results of hydrogel defects. The system can not only classify three types of defects but also realize defect localization. Reprinted with permission from Jin et al.[38] Copyright © 2023 ACS Biomater. Sci. Eng.

## 3 Application Scenarios and Bioinks

In in situ bioprinting, specific application scenarios determine the final choice of printing strategies, device configurations, and material systems[39]. Here, based on the mode of intervention and the manner in which the tissue printing environment is integrated, application scenarios are classified into three categories: body-surface and

open-exposure scenarios, minimally invasive intervention scenarios, and remotely energy-driven scenarios. In addition, a biosensing scenario is introduced as an extended application direction.

The material system mainly involves the selection of bioinks, which largely affects multiple variables associated with in situ bioprinting, including cell viability, biocompatibility, and the mechanical properties [40–42]. Researchers can improve the properties of bioinks by adjusting their compositions to accommodate specific application scenarios.

### 3.1 Body-surface and open-exposure scenarios

These environments are commonly encountered in skin repair as well as in the repair of superficial tissues such as bone and cartilage. These scenarios share several characteristics, including sufficient exposure of the target region, favorable visualization conditions, and ample operational space. As a result, they can provide relatively high positioning accuracy and operational flexibility for in situ bioprinting, making them one of the most mature and thoroughly validated application directions in current in situ bioprinting research.

In bone and osteochondral repair scenarios, bioinks must first satisfy relatively high mechanical requirements. Unlike soft tissues such as skin, bone defect regions are subjected to long-term compressive, shear, and locally concentrated stress environments during the repair process. Therefore, printed structures must not only exhibit good printability, but also provide sufficient initial support capacity after fabrication to maintain the spatial stability of the defect region and withstand early physiological loads. To this end, bioinks for in situ bone repair are typically based on natural polymers and are further combined with bioceramics, nanoparticles, or mineralizable components to enhance the modulus, compressive strength, and osteogenic induction capability of the system[43–45]. Hindi et al. adopted this strategy by combining alginate with hydroxyapatite (HAp), thereby balancing extrusion stability, structural support capability, and simulation of the osteogenic microenvironment, and

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successfully completed bone defect repair on rabbit calvaria[46]. Figure 3 (a) illustrates the repair process.

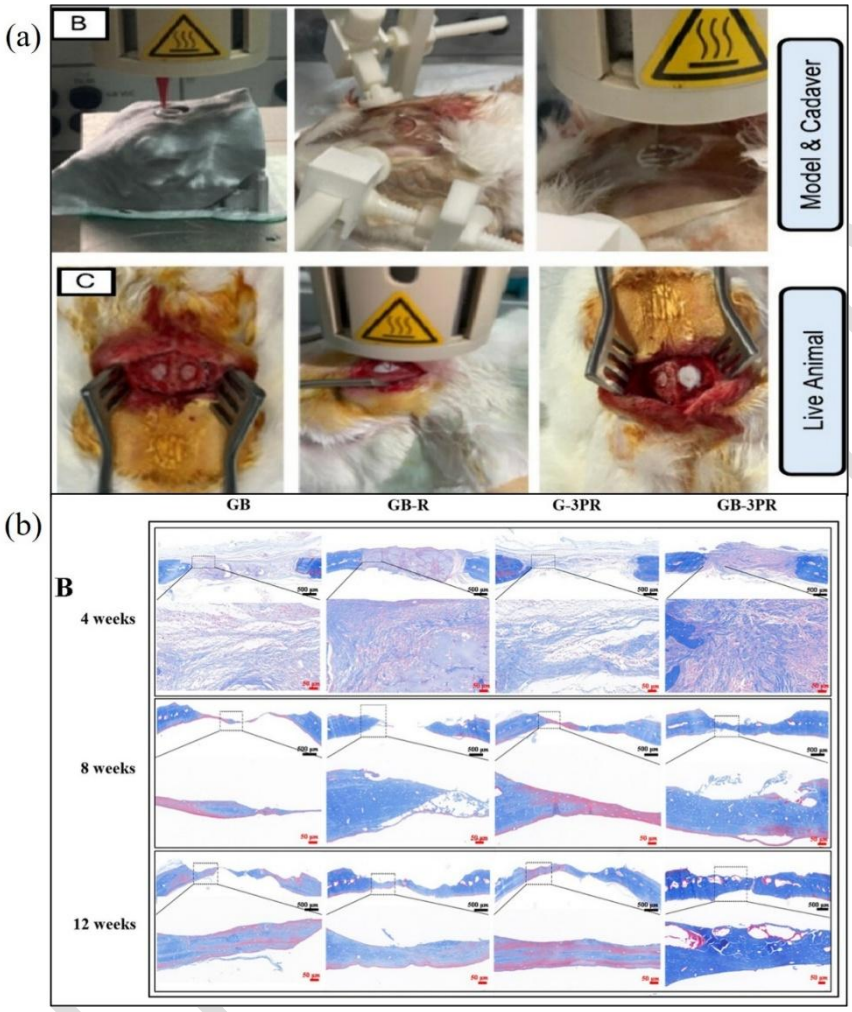



**Figure 3.** Bone repair applied to body surface and open exposure scenarios. (a) Workflow of rabbit skull repair. Before animal experiments, the research team optimized the bioprinting procedure using a 3D-printed rabbit head model. Reprinted with permission from Hindi et al.[46] Copyright © 2025, licensed under CC BY 4.0. (b) Staining images of the repair outcomes. The GB-3PR(3D dual-extrusion bioprinted BMSCs-laden GelMA hydrogel and RAOECs-laden 3P hydrogel scaffold, Among them, bone mesenchymal stem cells are abbreviated as BMSCs, Gelatin Methacryloyl is abbreviated as GelMA, rat aortic endothelial cells are abbreviated as RAOECs) group formed intact bone tissue at week 8, exhibiting the optimal healing effect. Reprinted with permission from Shen et al.[47] Copyright © 2022, licensed under CC BY-NC-ND 4.0.

In addition to mechanical properties, cell adhesion is also a factor that needs to be considered. Particularly in relatively thick bone repair structures, if effective nutrient

exchange channels are absent within the interior, cell survival and subsequent osteogenic efficiency will be significantly limited. One feasible approach is to improve the internal mass transfer environment by constructing predefined pores or transformable microchannels, thereby enabling the scaffold to maintain overall structural stability while possessing enhanced cell permeability. The work of Shen et al. reflects this concept. They used 4D materials as cell carriers and incorporated PLA (Polylactic acid)-PEG (Polyethylene glycol)-PLA (3P) into hydrogel-based bioinks to form hollow channels that allow cells to distribute uniformly[47]. During printing, 3P enabled endothelial cells to be evenly distributed, and after printing, it could transform into a gel state under temperature control and remain directly on the inner walls of the channels, forming a vessel-like endothelial layer. Results from rat calvarial defect repair experiments demonstrated that this scaffold could promote new bone formation in critical-sized rat calvarial defects. Figure 3 (b) displays the repair results for each group.

Because skin wound surfaces are usually irregular, moist, and required to withstand a certain degree of stretching, bioinks need to possess high adhesiveness and elasticity. Researchers can regulate the adhesiveness and elasticity of bioinks by adjusting the concentration of natural components or incorporating inorganic materials[48,49]. The work of Wang et al. adopted this approach. Their team developed two types of bioinks by introducing different materials into the matrix: one was an XLG-based bioink derived from synthetic lithium saponite, which exhibited relatively high viscosity and could also construct high-strength scaffolds; the other was a low-viscosity granular hydrogel bioink based on hyaluronic acid (HA) and Poly (ethylene glycol) diacrylate (PEGDA), which additionally possessed softness and flexibility. They subsequently performed in vitro porcine skin wound repair and in vivo rat full-thickness skin wound repair experiments, and the results shown in Figure 4 (a) reveal that the bioinks could effectively seal and uniformly cover the wounds[50].

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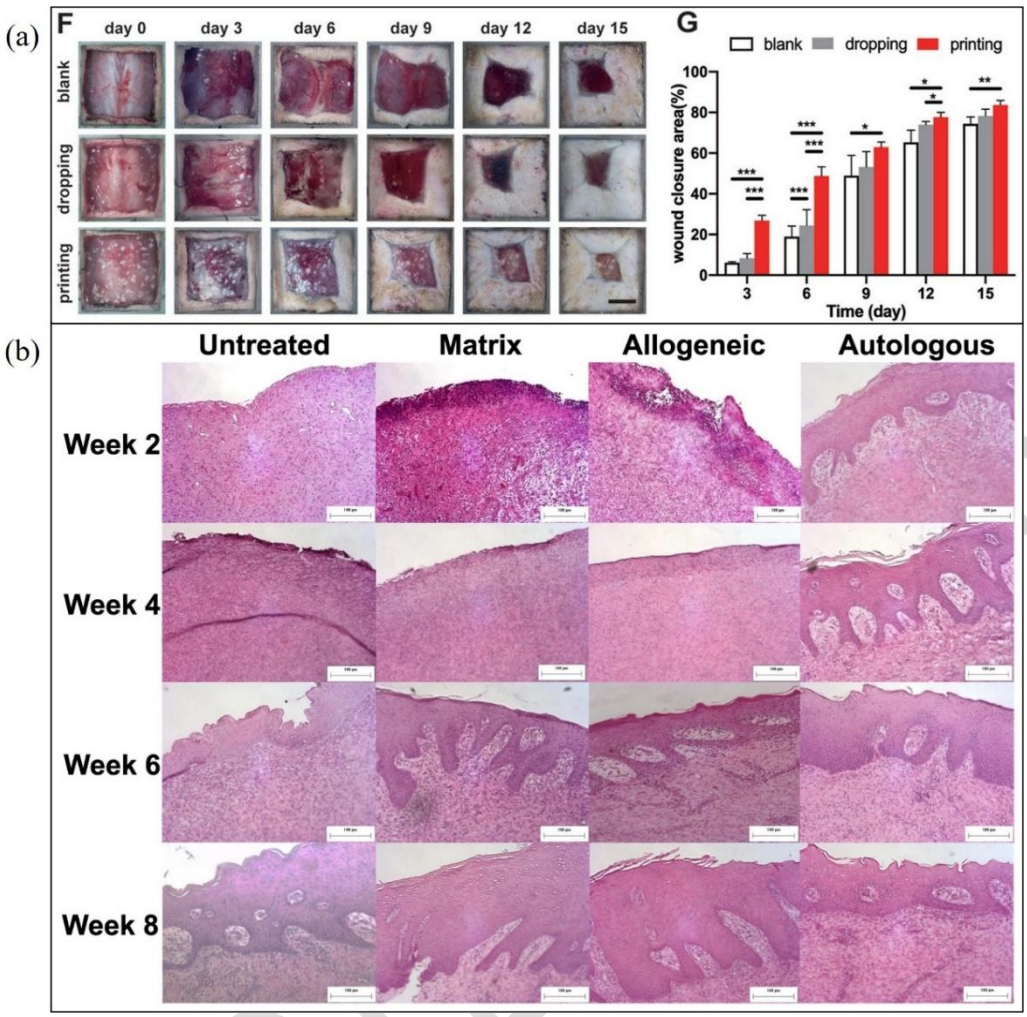



**Figure 4.** Skin repair applied to body surface and open exposure scenarios. (a) Compared with the blank group and the drop printing group, the group treated with the handheld in situ bioprinter exhibited the fastest recovery rate and the best healing effect, and the highest level of wound protection was also observed. Reprinted with permission from Wang et al.[50] Copyright © 2024, licensed under CC BY 4.0.; (b) Staining results of wound healing. Wounds treated with bioprinted autologous cells achieved faster and superior healing outcomes, demonstrating that the incorporation of animal tissue components into hydrogel matrices can effectively accelerate wound repair. Reprinted with permission from Albanna et al.[53] Copyright © 2019, licensed under CC BY 4.0.

Merely achieving wound coverage often provides only a temporary physical barrier and is insufficient to adequately promote wound healing and tissue reconstruction. One possible strategy is to use animal tissue-derived components as materials for hydrogel matrices[51,52]. Albanna et al. incorporated autologous dermal

fibroblasts and epidermal keratinocytes into bioinks and used these bioinks to perform repair in a porcine large-area full-thickness skin defect model[53]. As shown in Figure 4(b), the results demonstrated that, compared with the acellular matrix group, the allogeneic cell group, and the untreated group, the autologous cell in situ printing group exhibited a faster wound closure rate, lower contraction rate, and higher re-epithelialization efficiency. Specifically, wound closure occurred approximately three weeks earlier than in the control groups, while the re-epithelialization process was accelerated by approximately four to five weeks. In addition, the repaired tissue formed dermal structures, collagen arrangements, and mature vascular networks more closely resembling those of natural skin, demonstrating favorable tissue reconstruction capability.

### 3.2 Minimally Invasive intervention scenarios

The above printing environments imply that the wound area of the organism is sufficiently exposed during surgery, otherwise, a large incision must be created on the surface of the organism to fully expose the target tissue to the external environment. This provides sufficient spatial adaptability and operational flexibility for bioprinting procedures, but it remains inadequate in terms of precise manipulation and safe accessibility under dimensional constraints. Integrating in situ bioprinting with minimally invasive surgery is a feasible approach.

Organ repair has always been a major research focus in in situ bioprinting. Compared with tissues such as skin bone, and cartilage, organ surfaces are more complex and immune rejection responses are more severe. Therefore, organ repair imposes higher requirements on the structural complexity, biological functionality, and microenvironmental adaptability of in situ bioprinting[54]. Such application scenarios drive the design of bioinks toward enhanced biocompatibility and elasticity, while also demanding higher precision from the actuators.

The microstructure of the liver is highly complex, which means that bioinks with high shear forces cannot be used for repair. In Ref. [31], Zhao et al. incorporated poly

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(acrylic acid)-N-hydroxysuccinimide ester (PAA-NHS) into a hydrogel matrix to enhance tissue adhesiveness of the bioink, and used a 7-axis robot based on trocar needle recognition to perform liver repair in liver tissue, achieving favorable printing results and minimal contact force control at the incision site. The repair process is shown in Figure 5 (a).

To address the problem of premature rupture of fetal membranes, Zhao et al. further developed an ultrafast light-responsive hydrogel, GMPD, in which PEGDA serves to delay thermal degradation of the hydrogel. The printing device was mounted at the end of a 7-degree-of-freedom robotic arm and served as a minimally invasive surgical actuator[55]. Using this printing system, the team successfully fabricated hydrogel patches with gel rivet structures underwater. These patches exhibited strong tissue adhesion, good biocompatibility, mechanical properties similar to natural tissue, and appropriate sealing duration, effectively extending the gestation period.

Flexible bioprinting platforms are also a type of printing platform developed within the context of minimally invasive surgical applications. Such platforms can access target printing regions through minimally invasive incisions or natural openings in animals, offering a wide workspace and relatively high printing precision. Thai et al. integrated a highly flexible soft printing head into a flexible robotic arm and designed a multifunctional flexible in situ 3D bioprinter (F3DB), which is capable of printing biomaterials on fresh porcine kidneys and artificial colons[56]. The repair process is shown in Figure 5 (b).

In situ bioprinting combined with minimally invasive surgery is not limited to changing the form of the robotic arm end effector; the use of alternative driving methods is also a feasible approach. Zhou et al. designed a magnetically driven computer-controlled minimally invasive in situ bioprinting system known as the Ferromagnetic Soft Catheter Robot (FSCR) system[57]. This system uses a set of computer-controlled motors to generate controllable magnetic fields, enabling printing on the surface of rat livers. The repair process is shown in Figure 5 (c). But the FSCR relied on CT-based preoperative reconstruction. So, unpredictable collisions could

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occur intraoperatively due to dynamic organ movement, thereby affecting printing quality. To address this, Hu et al. developed a binocular vision-assisted magnetic soft catheter robotic system (BV-MSCRS), which completed in situ bioprinting process for cartilage defect in 88 seconds[58].

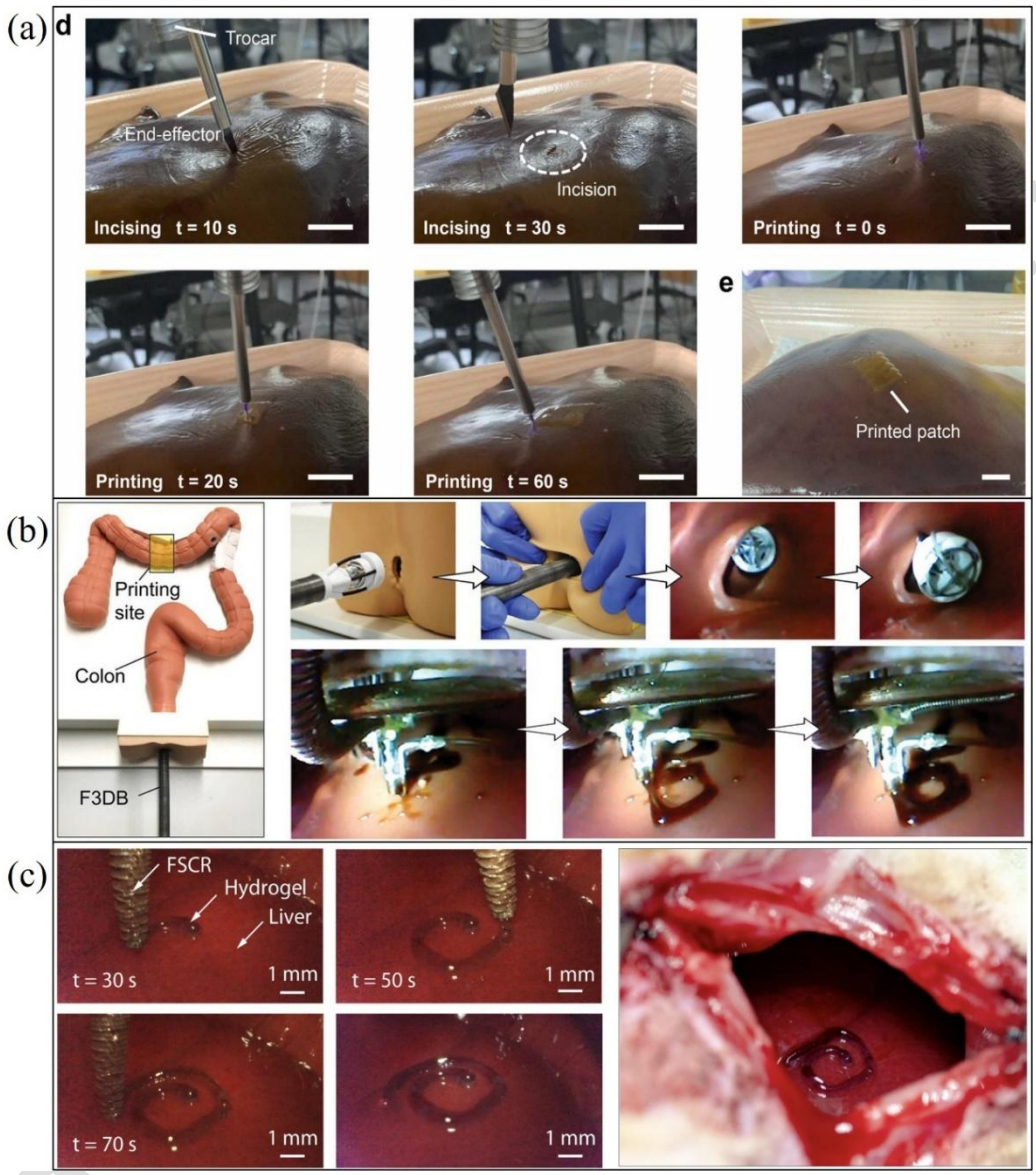



**Figure 5.** Repair of internal organs via minimally invasive surgery. (a) Repair printing process on porcine liver, the hydrogel film adheres well to the tissue surface. Reprinted with permission from Zhao et al.[31] Copyright © 2023 Elsevier Inc. (b) F3DB successfully performs endoscopic procedures in a simulated intestinal environment. Reprinted with permission from Thai et al.[56] Copyright © 2023, licensed under CC BY 4.0. (c) Minimally invasive bioprinting on rat liver using FSCR(Ferromagnetic Soft Catheter Robot). Reprinted with permission from Zhou et al.[57] Copyright © 2021, licensed under CC BY 4.0.

### 3.3 Remotely energy-driven scenarios

Acoustic printing is an in situ manufacturing strategy that uses acoustic fields to remotely regulate the formation of biomaterials. Its basic principle is to convert acoustic energy into localized controllable physical or chemical stimuli through focused ultrasound, cavitation effects, or acoustofluidic induction, thereby triggering localized crosslinking, polymerization, or cellular assembly of bioinks in the target region, ultimately achieving in situ construction of structures[59,60]. Because this process does not require a rigid nozzle to directly contact the tissue surface, acoustic printing can be considered a non-contact, low-mechanical-disturbance, remotely energy-driven mode of in situ printing. During the acoustic printing process, the system only needs to deliver the bioink into the body via a catheter or injection prior to printing. Once the bioink reaches the target printing region, an external actuator remotely induces crosslinking of the material at the body surface, thereby forming the desired structure.

Acoustic printing platforms, as a new paradigm of in situ bioprinting, represent a remotely energy-driven in situ bioprinting approach. Habibi and Derayatifar successively developed two generations of direct acoustic bioprinting platforms: the Direct Sound Printing (DSP) platform and the Holographic Direct Sound Printing (HDSP) platform. The concept of the DSP platform originated from the team's sonochemiluminescnce experiments using alkaline aqueous solution of luminol (3-aminophthalhydrazide). They found that exploiting this reactivity in local regions of printed polymers could drive polymerization in those areas, thereby enabling material solidification. Based on this property, Habibi et al. developed the first-generation DSP platform [61]. Figure 6(a) presents printing results on tissue phantoms. This platform consists of a transducer and a robotic arm. The printing performance can be by adjusting parameters such as the transducer driving pulse characteristics, the material, and the transducer configuration. However, the DSP printing region is limited to a single acoustic focal point, requiring voxel-by-voxel printing. To overcome this limitation, Mahdi et al. developed the second-generation HDSP platform[62]. This platform stores cross-sectional images of the desired components via acoustic holography, induces

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localized cavitation bubbles t using wave-patterned acoustic fields, enabling on-demand regional polymerization as needed. This approach not only improves printing speed but also enables structure-free printing. The above studies mainly represent early conceptual validation of acoustic printing platforms and have not yet progressed to in vivo animal experimental validation.In the field of deep tissue in situ bioprinting, Elham et al. developed a deep-tissue in vivo image-guided sound printing (DISP) platform[63]. They integrated gas vesicle (GV) ultrasound imaging into the printing system to achieve real-time monitoring of the printing process, precise focal localization, and verification of in situ crosslinking. They also performed in vivo printing in the bladder and muscles of live animals. This study demonstrated that acoustic printing not only enables remote patterning within deep tissues, but also has the potential to be coupled with imaging systems, laying the foundation for closed-loop acoustic printing.

Sun et al. further proposed a Reconfigurable Acoustic Printing (RAP) strategy, extending acoustic printing toward remote repair and structural reconstruction[64]. This platform uses focused ultrasound waves to drive bioacoustic inks for solidification under centimeter-scale tissue penetration, and further induces localized softening and controllable deformation of materials through acoustic stimulation. Experiments were conducted on skull repair in live rabbits and cranial defect repair in dogs. The two in vivo validation studies demonstrated that acoustic printing can not only serve as a remote in situ fabrication approach, but can also be combined with minimally invasive repair to achieve reconfigurable fabrication of deep tissues. Figure 6(b) displays outcomes of canine skull defect repair.

Wu et al. also developed an acoustic bioprinting platform. The team proposed an ultrahigh cell density (UHCD) bioprinting platform based on acoustic fluids-mediated stereolithography (ASL) technology[65]. The ASL technique induces vortices through focused surface acoustic waves, causing cell aggregation at pre-polymerized solid–liquid interfaces, enabling the bioprinting of arbitrary multicellular structures. Figure 6(c) shows the UHCD bioprinting platform and related printing results on rabbit livers.

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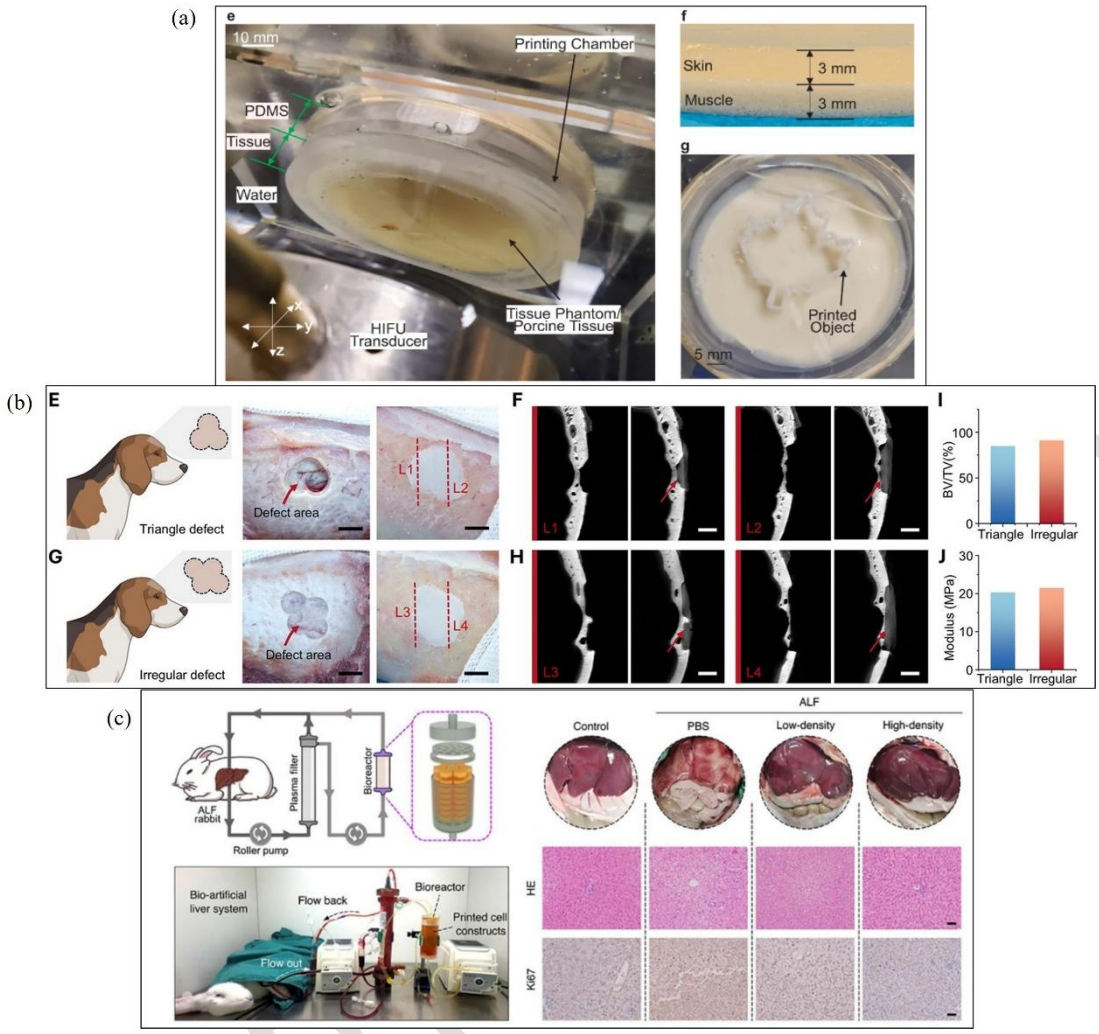



**Figure 6.** Concepts and biological experiments of acoustic printing. (a) External ear tissue was fabricated via the DSP(Direct Sound Printing) platform, and the fabrication was completed under simulated skin. Although no in vivo animal verification was performed, this work provides valuable insights and references for subsequent biological printing of auricular tissues. Reprinted with permission from Habibi et al.[61] Copyright © 2022, licensed under CC BY 4.0 (b) Canine cranial defect repair results. Both triangular and irregular defects were fully filled with good mechanical properties. Reprinted with permission from Sun et al.[64], Copyright © 2026 Wiley-VCH GmbH (c) Bioprinting results on rabbit liver using the UHCD(Ultrahigh Cell Density) platform. The liver condition of rabbits treated with ALF(Acute Liver Failure) was significantly improved. Reprinted with permission from Wu et al.[65] Copyright © 2025 Wiley-VCH GmbH.

### 3.4 Biosensing

Although in situ bioprinting is primarily aimed at tissue repair and regeneration, its ability to directly deposit functional materials on the surface of living tissues also gives it another important application potential: the in situ construction of biosensing interfaces. In this scenario, in situ bioprinting is no longer limited to structural reconstruction of damaged tissues, but can directly fabricate flexible, conformal, and functional bioelectronic devices on biological tissue surfaces for physiological monitoring and therapeutic feedback[66].

This application direction remains closely aligned with the core concept of in situ bioprinting, as it similarly relies on direct deposition on dynamic and irregular biological surfaces, adaptive matching to target geometries, and the stable fabrication of functional materials under physiological conditions. In situ bioprinting enables the direct construction of freeform functional devices conforming to target tissue surfaces. This, in turn, extends the application boundary of in situ bioprinting from structural repair to remote operation, medical treatment, and health monitoring[67].

In such applications, bioinks must not only exhibit good printability and biocompatibility, but also prioritize stretchability, electrical conductivity, and stable signal transmission under dynamic deformation conditions, in order to adapt to the continuous deformation of biological tissue surfaces and the requirements of functional monitoring. In Ref. [28], Zhu et al. proposed a method called “adaptive 3D bioprinting.” The team emphasized that the key to this process lies in developing functional bioinks that meet both conductivity and processability under natural conditions. They ultimately developed a bioink composed of polyethylene oxide (PEO) as the matrix and Ag flakes as the conductive filler. Using a closed-loop printing system integrated with a structured-light scanner, they fabricated wirelessly powered devices and wireless humidity sensors on moving human hands, and autonomously deposited cell-laden hydrogels at target locations in live mice. The results are shown in Figure 7(a).

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Electrical impedance tomography (EIT) is a medical imaging technique that forms images of the body using electrical currents[68,69]. Due to its high temporal resolution, portability, and lack of ionizing radiation, EIT is suitable for biosensing applications[70]. Clinically, it has been applied to guide care for patients with acute respiratory distress syndrome[71]. In Ref. [29], Zhu et al. further investigated 3D-printed wearable sensors combining ionic hydrogels with EIT technology using a closed-loop printing system composed of a stereo camera system and a structured-light 3D scanner. The team developed an ionic hydrogel with polyacrylamide (PAM) as the matrix and LiCl as the ionic conductive medium and directly fabricated EIT strain sensors on the surface of pig lungs undergoing respiration-induced deformation. The printing results are shown in Figure 7(b), these sensors not only monitored in situ lung deformation but also maintained close adhesion to the lung surface under repeated deformation.

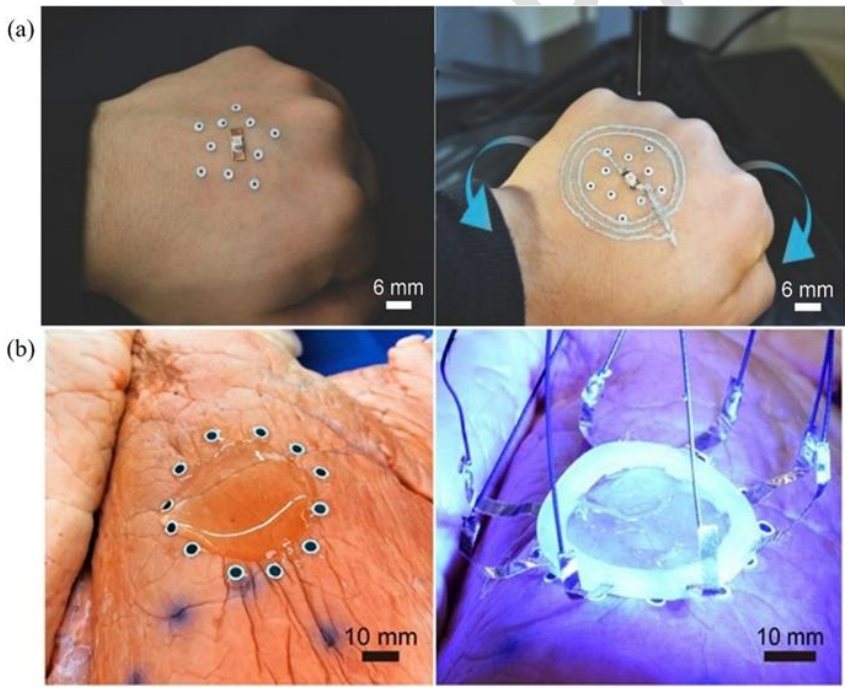



**Figure 7.** In situ bioprinting of EIT sensors on organism. (a) Multifunctional devices were fabricated on moving human hands, in which hydrogel lines served as conductive components. This printing system was also applied to the repair of skin defects on the dorsum of mice. Reprinted with permission from Zhu et al.[28] Copyright © 2018 WILEY-VCH Verlag GmbH & Co. KGaA, Weinheim. (b) In-situ fabrication results on deformed porcine lungs. The average printing error of was 0.657 mm, and the sensor could monitor lung deformation under external stimulation. Reprinted with permission from Zhu et al.[29] Copyright © 2020, licensed under CC BY-NC 4.0.

In in situ bioprinting systems, bioinks not only serve the roles of carrying cells, delivering bioactive factors, and construct the microenvironment for new tissue formation, but also need to maintain good printability, biocompatibility, and adaptability in complex, dynamic, and often traumatically affected in vivo environments[72,73]. A wide range of materials have already been applied in the fabrication of bioinks. According to the classifications by Bramhe et al**.** and Kim et al**.**, materials used in bioinks can be divided into natural polymers and synthetic polymers: Common natural polymers include collagen, chitosan, alginate, GelMA(Gelatin Methacryloyl), fibrinogen, hyaluronic acid (HA), cellulose, agarose, and carrageenan; while commonly used synthetic polymers include poly(lactic-co-glycolic acid) (PLGA), polycaprolactone (PCL), polylactic acid (PLA), polyethylene glycol (PEG), polyethylene oxide (PEO), and polyacrylamide (PAM) [74,75]. Natural polymers generally exhibit excellent biocompatibility and are the most widely used materials in bioink formulations; however, their mechanical properties are relatively weak, making them suitable for applications such as skin repair, soft tissues, and blood vessels. In contrast, synthetic polymers can modulate mechanical properties but generally have low bioactivity; therefore, they are often blended with natural polymers to tune bioink performance. Composite bioinks are typically composed of natural polymers combined with synthetic polymers, bioceramics, or nanomaterials, and represent the current mainstream trend in bioink development.

An ideal bioink should possess excellent biocompatibility to ensure non-toxicity, non-inflammatory response, and support for cell survival and development. It should also exhibit appropriate printability to ensure stable extrusion, high structural fidelity, and suitable viscosity. In addition, bioinks should have functions such as rapid crosslinking, fast and non-toxic degradation, strong tissue adhesiveness, and promotion of tissue regeneration.

Most currently used bioinks rely on photocuring or gelation processes to convert biological materials from a liquid state into a gel-like structure, which adheres to tissue and forms single-layer or multi-layer architectures[76,77]. Depending on the target tissue,

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the design, processing, and composition of bioinks vary. For example, LAP can be added to hydrogel matrices to accelerate curing and address hydrogel degradation issues[78]; gelatin can undergo electrochemical treatment to form bio-concrete bioinks with strong rheological properties for bone repair applications; bioconcrete can be incorporated into gelatin–alginate hydrogel matrices to increase ink viscosity and scaffold Young's modulus[79]; nanoparticles or oxides can be introduced into hydrogel matrices to enhance scaffold mechanical properties[80,81]. Further information concerning the materials used in bioinks can be found in Table 1.

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**Table 1** Natural Polymers, Synthetic Polymers, and 4D Materials with Potential Applications in In Situ Bioprinting

| Category | Material | Properties | Application Scenarios | Ref. |
|---|---|---|---|---|
| Natural Polymers | Collagen | Good cell adhesion and biocompatibility, but low mechanical strength and slow gelation rate | Skin repair, cartilage repair | 82 |
| | Gelatin /GelMA | Good cell affinity and modifiability; GelMA in particular possesses both natural bioactivity and photocrosslinking ability | Skin wounds, muscle injury, cartilage repair, and flexible biosensor substrates | 83 |
| | Alginate | Good printability, fast crosslinking with $Ca^{2+}$, but poor cell adhesion | Usually used in combination with other materials | 25 |
| | HA | High water retention and excellent lubricity | Cartilage repair, skin filling, and soft tissue regeneration | 84 |
| | Fibrin / Fibrinogen | Good tissue adhesion and hemostatic properties | Skin injury repair | 51 |
| | Chitosan | Natural antibacterial activity and favorable biocompatibility | Skin repair | 85 |
| | Cellulose* | Good rheological regulation capability | Commonly used as a rheological modifier or thickening support agent; also applicable for bone repair | 86 |
| | dECM | Provides a microenvironment close to natural tissues | Tissue repair such as muscle and cartilage | 52 |
| Synthetic Polymers | PEG and its derivatives （PEGDA、4-arm PEG） | Good biocompatibility, rapid curing, and stable structure | Bone repair, cartilage scaffolds, and minimally invasive organ surface sealing | 87 |
| | PAM | Elasticity and excellent stretchability | Flexible sensors | 29 |

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| | | | |
|---|---|---|---|
| PLA* | High mechanical strength and biodegradability | Bone repair | 57 |
| PCL* | Excellent mechanical properties but slow degradation | Generally used in load-bearing scenarios such as bone support | 88 |
| PLGA* | Tunable degradation rate | Used in scenarios requiring adjustable degradation rates | 89 |
| Polyacrylic acids (PAA-NHS, etc.) | Good bioadhesion | Used for visceral tissue surface repair to enhance tissue adhesion | 90 |
| PLA-TMC* | Biodegradable, good biocompatibility, tunable mechanical properties | Bone repair | 89 |
| β-TCP* | Fast degradation rate and excellent biocompatibility | Bone repair | 89 |
| PNIPAM* | Rapid and controllable deformation, good biocompatibility | Skin repair | 91 |
| MNp* | Magnetic responsiveness | Cartilage repair; usually added to hydrogel matrices as a functional component | 92 |
| Acrylate-based* | Fast curing rate, tunable mechanical properties | Gastric or intestinal inner wall repair | 93 |

**Note:** The superscript "*" indicates that the material is also a 4D material. The applications of 4D materials are not directly for in situ bioprinting, but are potential uses or have been proven promising in in situ bioprinting under other contexts. HA: hyaluronic acid; dECM: Decellularized Extracellular Matrix; PEG: Percutaneous Endoscopic Gastrostomy; PEGDA: Poly(ethylene glycol) diacrylate; PAM: Polyacrylamide; PLA: Polylactic acid; PCL: poly-ε-caprolactone; PLGA: Poly(lactic-co-glycolic acid); PAA-NHS: Poly(acrylic acid)-N-hydroxysuccinimide ester; PLA-TMC: Poly(L-lactide-co-trimethylene carbonate); β-TCP: β-Tricalcium Phosphate; PNIPAM: Poly(N-isopropyl acrylamide); MNp: Magnetic Nanoparticles.

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## 4. Summary and Outlook

With the continuous integration of tissue engineering, biomanufacturing, and clinical regenerative medicine, in situ bioprinting is gradually transitioning from a laboratory concept to practical medical applications. Its core value lies in its ability to directly construct tissue structures at the site of injury, rapidly provide a cell-friendly microenvironment, and promote tissue repair in a highly personalized and minimally invasive manner.

From the perspective of technological development, control strategies are gradually transitioning from static path planning to dynamic environment-adaptive adjustments. In the future, tighter integration with multi-sensor fusion and autonomous control algorithms will be required to cope with complex wound geometries and highly dynamic in vivo conditions. In this process, artificial intelligence technologies, particularly machine learning- and deep learning-based methods, are expected to play an important role in multimodal data fusion, real-time state recognition, and dynamic path optimization, thereby improving both the efficiency and precision of printing.As application scenarios expand from body surfaces to deep organs, existing systems still face challenges in positioning accuracy, response speed, and robustness in complex environments. These issues become even more pronounced during the transition from animal models to human applications. In this context, integrating artificial intelligence may be a feasible approach, and some studies have already explored its potential[94–96]. In Ref. [31], Zhu et al. noted that AI can facilitate the execution, management, and coordination of in situ bioprinting workflows. As mentioned earlier, Zhu et al. also employed machine learning algorithms to learn a linear shape basis model of surface deformation. In addition, artificial intelligence can be integrated with medical imaging technologies to achieve the integration of preoperative planning and intraoperative navigation, providing decision support for in situ printing in complex internal organs. There have already been some applications focusing on preoperative planning; for example, In Ref. [25], Li et al. used AI to reconstruct a bone defect model before surgery. With the assistance of artificial intelligence, combined with high-performance sensors, it may be possible to further advance the development of in vivo bioprinting. In situ bioprinting is gradually transitioning from an application

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stage focused on superficial tissue repair toward the repair of complex internal organs. At present, its applications in superficial or relatively stable tissues such as skin wounds and musculoskeletal injuries have undergone extensive experimental validation and are approaching early clinical investigation. These tissues offer good accessibility and visualization conditions, enabling high-precision deposition and real-time control. In contrast, for organs such as the liver and gastrointestinal tract, in situ bioprinting remains primarily at the stage of laboratory studies and animal model validation. For organ repair, with the assistance of flexible deployable printing tools, endoscopic platforms, and intraoperative navigation systems, in situ bioprinting is expected to achieve precise deposition in continuously moving or spatially constrained environments, thereby promoting its development toward minimally invasive or even intracavitary surgery. Recently, a research group has explored device localization issues by integrating two medical imaging modalities, CT and magnetic resonance imaging[97]. This may contribute to advances in visceral organ repair research.

Acoustic printing may also become a future research hotspot. Since Derayatifar et al. proposed and developed the direct acoustic printing method, many groups have explored acoustic printing with different materials as well as other forms of acoustic-based printing. In Ref. [30], Derayatifar et al. also pointed out that one of the unique applications of direct acoustic printing is the ability to print beyond optically opaque barriers, enabling exciting possibilities such as non-invasive deep tissue printing. However, acoustic printing is still in its early stage of development, and several key challenges remain for further applications. These include the significant impact of tissue heterogeneity on acoustic wave propagation and focusing accuracy in complex biological environments, the limited types of acoustically responsive bioinks, the unclear mechanisms by which cavitation behavior affects printing resolution and cell viability, and the lack of a stable closed-loop feedback system integrating real-time imaging, acoustic field regulation, and in situ crosslinking. Therefore, future development of acoustic printing will require further integration of medical imaging guidance, acoustic field control, acoustically responsive bioink design, and real-time closed-loop control strategies, in order to promote its transition from proof-of-concept studies toward a non-invasive in situ manufacturing platform for deep tissue applications.



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Regarding bioinks, their physicochemical properties, curing mechanisms, and biological functions often determine whether in situ bioprinting can achieve the desired repair quality and clinical safety[98,99]. With the continuous evolution of actuator systems and fabrication strategies, higher demands are being placed on bioinks, including rapid gelation, injectability, multi-material synergistic printing, tunable mechanical properties, and the ability to promote tissue remodeling[100,101]. Some research groups have already explored the use of artificial intelligence to assist in screening bioink properties and optimizing printing parameters, which also represents a potential application of AI in in situ bioprinting.

In real physiological environments, the gelation behavior of bioinks, in situ bioprinting often occurs on moist, warm tissue surfaces with physiological fluid flow. Under such conditions, the gelation behavior of bioinks, material degradation rates, and the mechanical matching between printed constructs and surrounding tissues can change significantly[102,103]. Zhao et al. pointed out: "Primarily in terms of the printing materials, i.e., bioinks, most efforts have focused on the modification and secondary development of existing bioinks used in conventional bioprinting, but there is always a trade-off between the various properties of bioinks required for in vivo bioprinting"[104]. Therefore, future studies need to further investigate the coupling mechanisms between material design and the real in vivo environment. According to the conclusions of Mirasadi et al., magnetically responsive shape memory polymers as 4D printing materials are expected to be extended to the field of in situ bioprinting[105]. Such materials can be used to fabricate desired structures through magnetically driven control according to design. For example, in thermoplastic polymers such as PCL, the glass transition temperature is approximately -60 °C and the melting temperature is around 60 °C, giving it high flexibility and biodegradability. By incorporating magnetically responsive $Fe_3O_4$ nanoparticles into PCL, an alternating magnetic field can be used to guide the bioink to aggregate at defect sites and form structures, providing mechanical support upon cooling and gradually degrading during tissue regeneration[105–108]. Therefore, Table 1 includes some 4D materials.

In real human physiological environments, complex physiological motions, multiscale mechanical coupling, and inter-individual variability exist, making the translation of animal experimental results



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into clinical practice still face significant challenges. In situ bioprinting also faces a series of regulatory and standardization challenges. Since it simultaneously involves biomaterials, living cells, and medical devices, its approval process must meet requirements related to biosafety, material controllability, and device reliability. In fact, some countries have already established relatively clear regulatory frameworks. For example, the United States considers bioprinted products as “combination products” consisting of drugs, biologics, and medical devices. In practice, most current regulatory frameworks are still based on this “combination product” concept, resulting in a patchwork-style regulatory approach rather than an independent regulatory system, although oversight is applied to each component product.

In addition, in situ bioprinting processes are highly dependent on real-time operating environments, and standards for process consistency, reproducibility, and quality control have not yet been fully established, which imposes higher demands on clinical safety evaluation. At the same time, the characteristics of personalized treatment make traditional evaluation systems difficult to directly apply; therefore, dynamic regulatory frameworks tailored to in situ manufacturing processes are still needed.

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**Conflict of interest**

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*Writing–review & editing:* Xinrong Tan

**Ethics approval and consent to participate**

Not applicable.

**Consent for publication**

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**Availability of data**

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