

# Body/Ribcage

B19-Flat\_stand\_right

Suggested layer height	0.3mm
Suggested infill percentage	50%-60%

## Supports

Number of this part for one arm Pib	1
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Number of this part for two arm Pib	1
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Mass – (Mass with supports)	315g
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Printing time	10h 45min
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Suggested  
orientation

After printing  
processing

None

Suggested layer  
height

0.3mm

Suggested infill  
percentage

50%-60%

Number of this  
part for one arm

1

Pib

Number of this  
part for two arm

1

Pib

Mass – (Mass with  
supports)

292g

Printing time 9h 45min

Suggested  
orientation

After printing  
processing Clean supports

Suggested layer height	0.2mm
Suggested infill percentage	20%-30%
Supports	
Number of this part for one arm Pib	1
Number of this part for two arm Pib	1
Mass – (Mass with supports)	290g
Printing time	9h 20min

Suggested  
orientation

After printing  
processing

Clean supports

Suggested layer height	0.2mm
Suggested infill percentage	20%-30%
Supports	None
Number of this part for one arm Pib	1
Number of this part for two arm Pib	1
Mass – (Mass with supports)	290g
Printing time	9h

Suggested  
orientation

After printing  
processing

None

Suggested layer height	0.2mm
Suggested infill percentage	20%-30%
Supports	
Number of this part for one arm Pib	1
Number of this part for two arm Pib	1
Mass – (Mass with supports)	230g
Printing time	7h 30min

Suggested  
orientation

After printing  
processing

None

Suggested layer height	0.2mm
Suggested infill percentage	20%-30%
Supports	
Number of this part for one arm Pib	1
Number of this part for two arm Pib	1
Mass – (Mass with supports)	230g
Printing time	7h 30min

Suggested  
orientation

After printing  
processing

None

Suggested layer height	0.2mm
Suggested infill percentage	40%-50%
Supports	
Number of this part for one arm Pib	1
Number of this part for two arm Pib	1
Mass – (Mass with supports)	200g
Printing time	6h 15min

Suggested  
orientation

After printing  
processing

None

B43-R-Rip cage\_Lower\_Right

Suggested layer  
height

0.2mm

Suggested infill  
percentage 40%-50%

## Supports

Number of this  
part for one arm 1  
Pib

Number of this  
part for two arm 1  
Pib

Mass – (Mass  
with supports) 200g

Printing time 6h 15min

Suggested  
orientation

After printing  
processing

None

B44-Electronics\_back

Suggested layer  
height

0.2mm

Suggested infill percentage	20%-30%
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## Supports

Number of this part for one arm Pib	1
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Number of this part for two arm Pib	1
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Mass – (Mass with supports)	88g
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Printing time	5h
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Suggested  
orientation

After printing  
processing

None

Suggested layer  
height

0.2mm

Suggested infill percentage	20%-30%
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## Supports

Number of this part for one arm	1
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Pib

Number of this part for two arm	1
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Pib

Mass – (Mass with supports)	40g
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Printing time	1h 20min
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Suggested  
orientation

After printing  
processing

None

B46-Power\_back

Suggested layer  
height

0.2mm

Suggested infill percentage	20%-30%
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## Supports

Number of this part for one arm Pib	1
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Number of this part for two arm Pib	1
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Mass – (Mass with supports)	110g
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Printing time	5h
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Suggested  
orientation

After printing  
processing

None

B55-Logo\_edu

Suggested layer  
height

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Suggested infill  
percentage ?

Supports

Number of this  
part for one arm 1  
Pib

Number of this  
part for two arm 1  
Pib

Mass – (Mass with  
supports) ?

Printing time ?

Suggested  
orientation

After printing  
processing

None