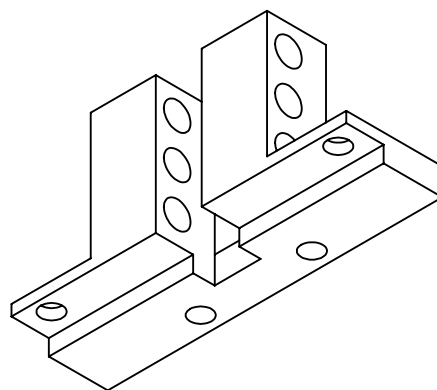
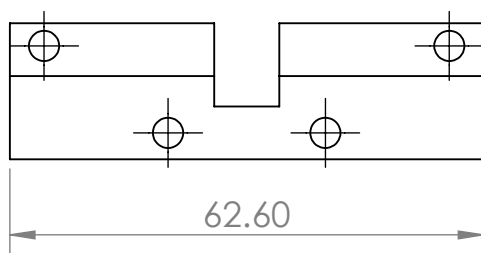
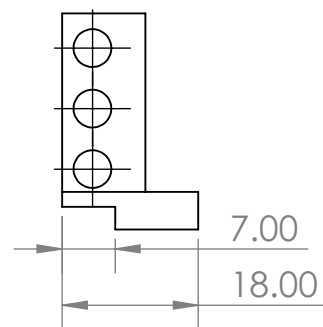
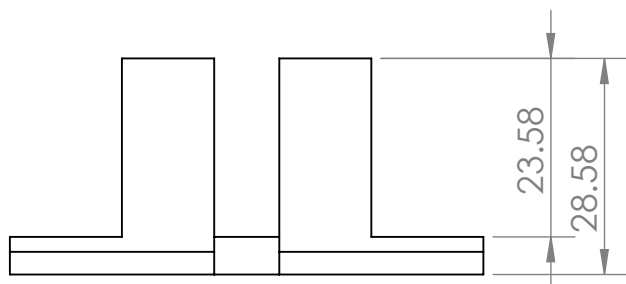



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3D PRINTING PARAMETERS			CREATED BY	APPROVED BY
PARAMETER	TYPICAL VALUE	DESCRIPTION		
LAYER HEIGHT	0.20 mm	Vertical resolution per layer.	RULOBOT TEAM 08/06/2025	WILMER DE JESÚS REYES 08/12/2025
WALL THICKNESS	1.2 mm (~3 walls)	Number of perimeter walls.		EVENT
INFILL DENSITY	15-35 %	Internal structure fill percentage.	DOCUMENT NAME	WRO SINGAPORE INTERNATIONAL FINAL
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.	TITLE	MATERIAL
NOZZLE TEMPERATURE	210-220 °C (PLA)	Extruder temperature.		PLA
BED TEMPERATURE	60 °C (PLA)	Heated bed temperature.	MANUFACTURING TECHNOLOGY	REV
COOLING FAN SPEED	100 %	Improves surface finish and overhangs.		DATE OF ISSUE
SUPPORTS	Enabled	Optional for overhangs.	FDM 3D PRINTING	SHEET
ADHESION TYPE	None	No special adhesion; PEI textured plate.		REV1
			08/12/2025	
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