



3D PRINTING PARAMETERS			CREATED BY RULOBOT TEAM 08/06/2025	APPROVED BY WILMER DE JESÚS REYES 08/12/2025		
PARAMETER	TYPICAL VALUE	DESCRIPTION		EVENT WRO SINGAPORE INTERNATIONAL FINAL		
LAYER HEIGHT	0.20 mm	Vertical resolution per layer.	DOCUMENT NAME RULOBOT_ASSEMBLY			
WALL THICKNESS	1.2 mm (≈3 walls)	Number of perimeter walls.	MATERIAL PLA			
INFILL DENSITY	15-35 %	Internal structure fill percentage.	REV			
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.	DATE OF ISSUE			
NOZZLE TEMPERATURE	210-220 °C (PLA)	Extruder temperature.	SHEET			
BED TEMPERATURE	60 °C (PLA)	Heated bed temperature.	REV1			
COOLING FAN SPEED	100 %	Improves surface finish and overhangs.	08/12/2025			
SUPPORTS	Disabled	Optional for overhangs.	1			
ADHESION TYPE	None	No special adhesion; PEI textured plate.	Gyro_support_Bracket			
MANUFACTURING TECHNOLOGY FDM 3D PRINTING						
						