


B

A

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	MATERIAL PLA		
WALL THICKNESS	1.2 mm (≈3 walls)	Number of perimeter walls.		REV		
INFILL DENSITY	15-35 %	Internal structure fill percentage.	TITLE Camera_stick	DATE OF ISSUE		
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.		SHEET		
NOZZLE TEMPERATURE	210-220 °C (PLA)	Extruder temperature.	MANUFACTURING TECHNOLOGY FDM 3D PRINTING	REV1		
BED TEMPERATURE	60 °C (PLA)	Heated bed temperature.		08/12/2025		
COOLING FAN SPEED	100 %	Improves surface finish and overhangs.		1		
SUPPORTS	Disabled	Optional for overhangs.				
ADHESION TYPE	None	No special adhesion; PEI textured plate.				