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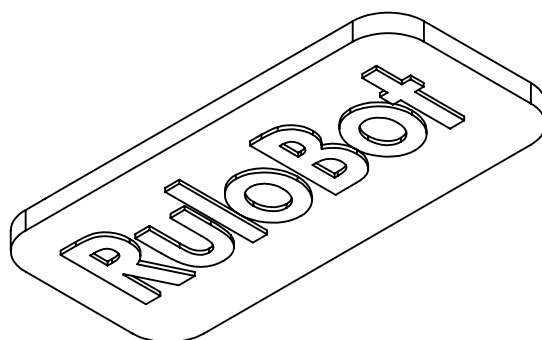
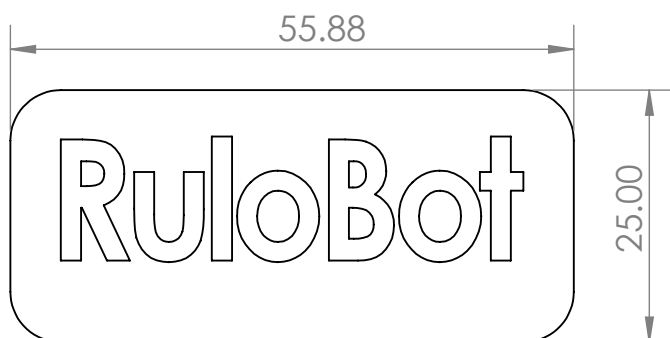
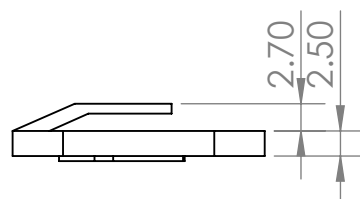
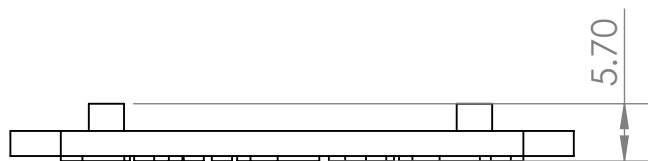
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| 3D PRINTING PARAMETERS |                     |  | CREATED BY<br>RULOBOT TEAM 08/06/2025       | APPROVED BY<br>WILMER DE JESÚS REYES 08/12/2025 |  |  |
|------------------------|---------------------|--|---|---|--|--|
| PARAMETER              | TYPICAL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



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