

4

3

2

1

F

F

E

E

D

D

C

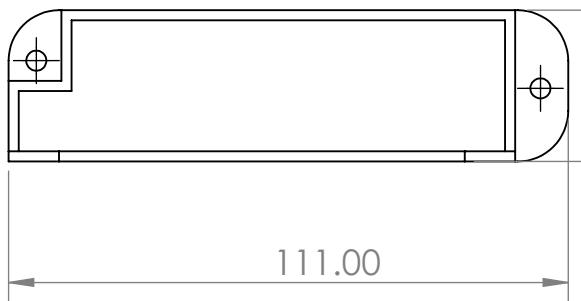
C

B

B

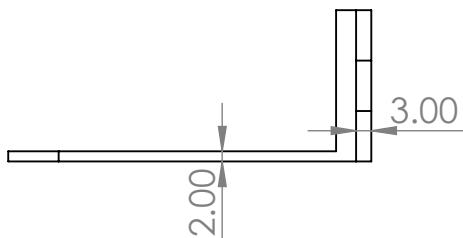
A

A



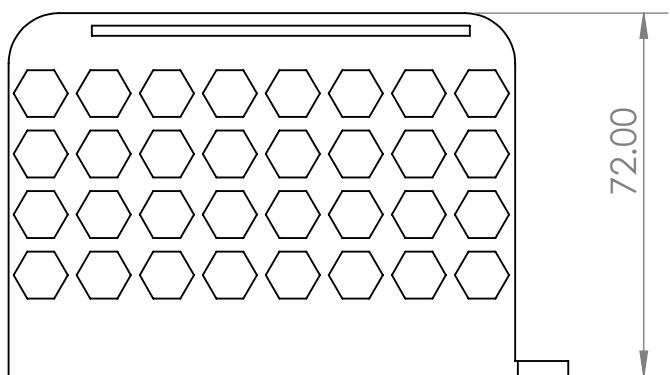
30.00

111.00

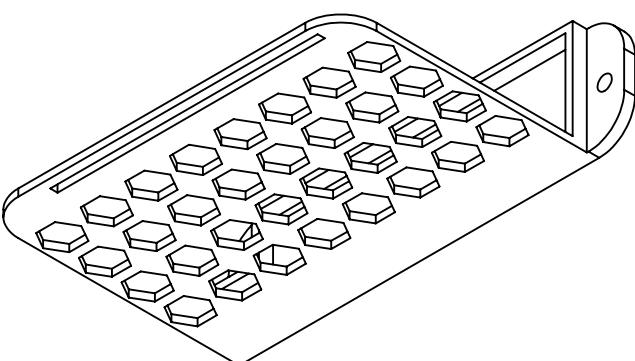


2.00

3.00



72.00



3D PRINTING PARAMETERS		
PARAMETER	TYPICAL VALUE	DESCRIPTION
LAYER HEIGHT	0.20 mm	Vertical resolution per layer.
WALL THICKNESS	1.2 mm (~3 walls)	Number of perimeter walls.
INFILL DENSITY	15-35 %	Internal structure fill percentage.
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.
NOZZLE TEMPERATURE	210-220 °C (PLA)	Extruder temperature.
BED TEMPERATURE	60 °C (PLA)	Heated bed temperature.
COOLING FAN SPEED	100 %	Improves surface finish and overhangs.
SUPPORTS	Enabled	Optional for overhangs.
ADHESION TYPE	None	No special adhesion; PEI textured plate.

CREATED BY  
RULOBOT TEAM 08/06/2025APPROVED BY  
WILMER DE JESÚS REYES 08/12/2025DOCUMENT NAME  
RULOBOT\_ASSEMBLYEVENT  
WRO SINGAPORE INTERNATIONAL FINAL

TITLE

MATERIAL  
PLA

REV

DATE OF ISSUE

SHEET

REV1

08/12/2025

1

Raspberry\_Base

MANUFACTURING TECHNOLOGY

FDM 3D PRINTING

