



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	Disabled	Optional for overhangs.
ADHESION TYPE	None	No special adhesion; PEI textured plate.

CREATED BY
RULOBOT TEAM 08/06/2025

DOCUMENT NAME
RULOBOT_ASSEMBLY

TITLE
Chassis_Joint

MANUFACTURING TECHNOLOGY
FDM 3D PRINTING

APPROVED BY
WILMER DE JESÚS REYES 08/12/2025

EVENT
WRO SINGAPORE INTERNATIONAL FINAL

MATERIAL
PLA

REV	DATE OF ISSUE	SHEET
REV1	08/12/2025	1

