

4

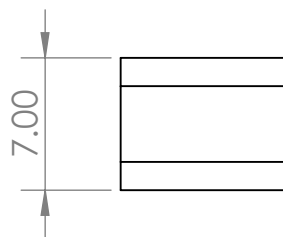
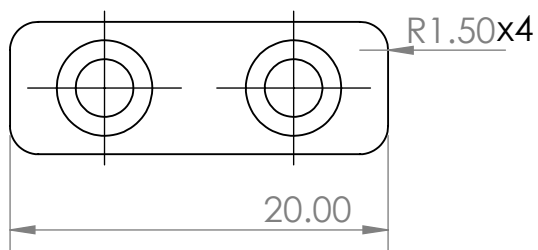
3

2

1

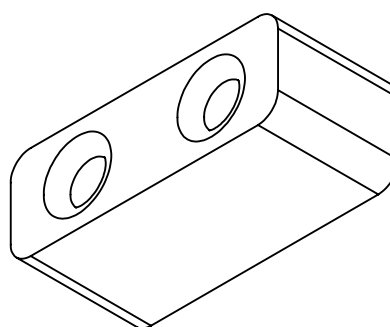
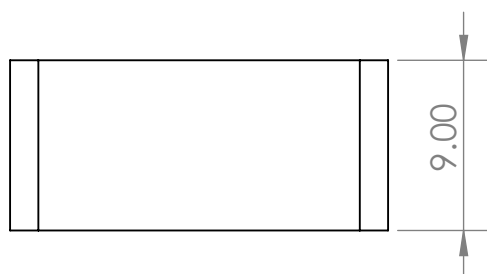
F

F



E

E



D

D

C

C

B

B

A

A

## 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

Servo\_Screw\_Mount

## MANUFACTURING TECHNOLOGY

FDM 3D PRINTING

## APPROVED BY

WILMER DE JESÚS REYES 08/12/2025

## EVENT

WRO SINGAPORE INTERNATIONAL FINAL

## MATERIAL

PLA

## REV

REV1

## DATE OF ISSUE

08/12/2025

## SHEET

1



4

3

2

1