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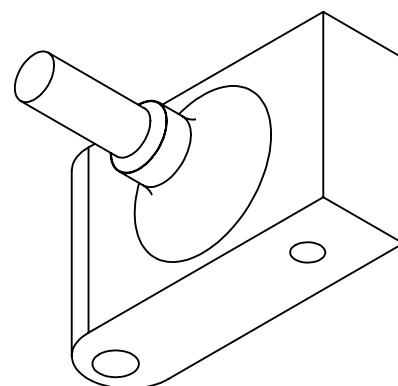
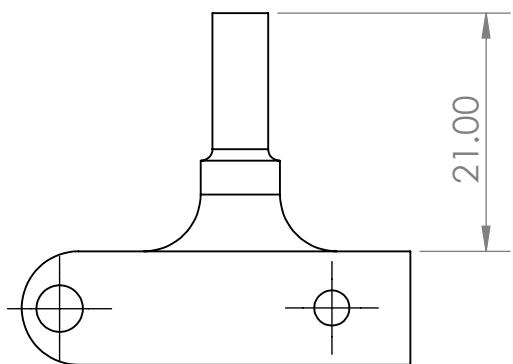
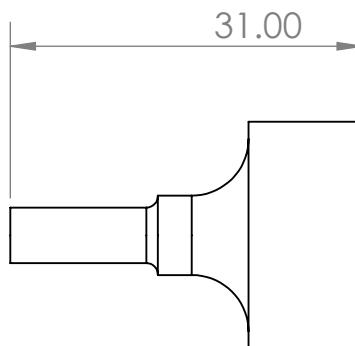
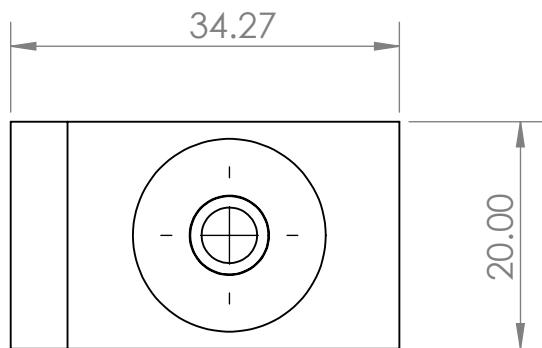
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3D PRINTING PARAMETERS		
PARAMETER	TYPICAL VALUE	DESCRIPTION
LAYER HEIGHT	0.20 mm	Vertical resolution per layer.
WALL THICKNESS	1.2 mm (=3 walls)	Number of perimeter walls.
INFILL DENSITY	15-35 %	Internal structure fill percentage.
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.
NOZZLE TEMPERATURE	260 °C (ABS)	Extruder temperature.
BED TEMPERATURE	100 °C (ABS)	Heated bed temperature.
COOLING FAN SPEED	0-10 %	Low cooling to reduce warping; keep chamber warm/closed.
SUPPORTS	Enabled	Use as needed for overhangs/bridges.
ADHESION TYPE	Brim	Improves bed adhesion on PEI textured plate.

CREATED BY
RULOBOT TEAM 08/06/2025

APPROVED BY
WILMER DE JESÚS REYES 08/12/2025

DOCUMENT NAME
RULOBOT_ASSEMBLY

EVENT
WRO SINGAPORE INTERNATIONAL FINAL

MATERIAL
PLA

TITLE

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

Drive_Wheel_Support

MANUFACTURING TECHNOLOGY

FDM 3D PRINTING

