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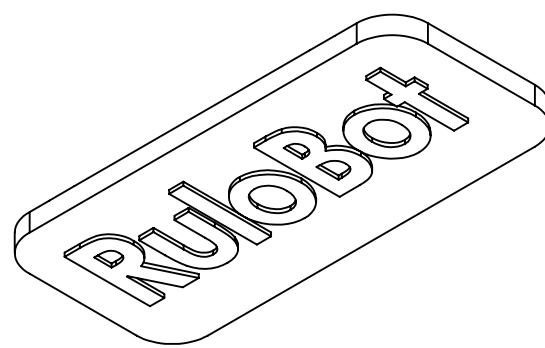
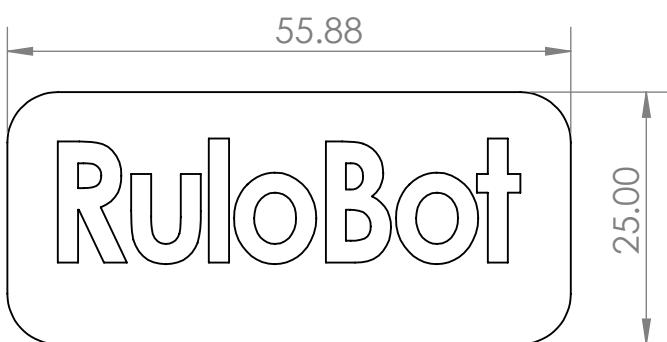
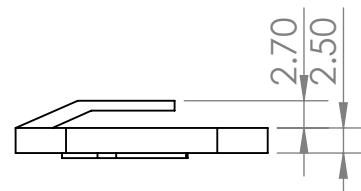
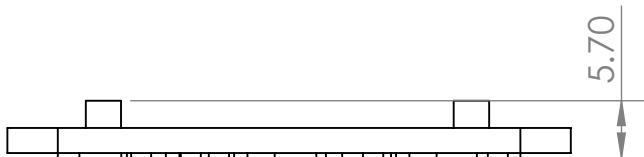
C

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

APPROVED BY  
WILMER DE JESÚS REYES 08/12/2025

DOCUMENT NAME  
RULOBOT\_ASSEMBLY

EVENT  
WRO SINGAPORE INTERNATIONAL FINAL

TITLE

MATERIAL  
PLA

MANUFACTURING TECHNOLOGY

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

Label\_Plate

FDM 3D PRINTING

