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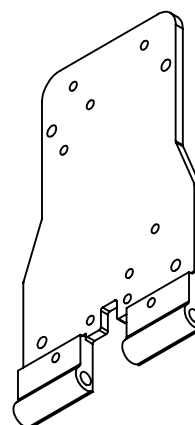
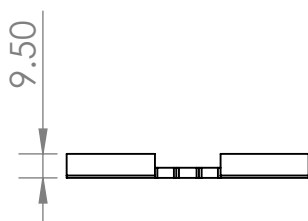
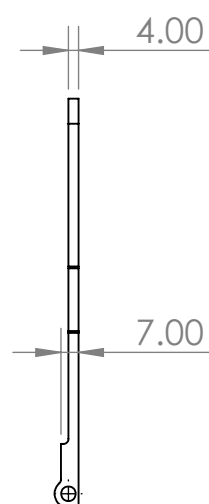
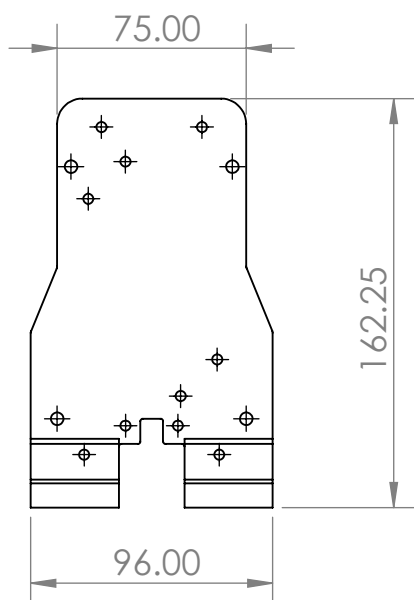
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3D PRINTING PARAMETERS			CREATED BY RULOBOT TEAM 08/06/2025	APPROVED BY WILMER DE JESÚS REYES 08/12/2025			
PARAMETER	TYPICAL VALUE	DESCRIPTION		EVENT WRO SINGAPORE INTERNATIONAL FINAL			
LAYER HEIGHT	0.20 mm	Vertical resolution per layer.	DOCUMENT NAME RULOBOT_ASSEMBLY	MATERIAL PLA			
WALL THICKNESS	1.2 mm (≈3 walls)	Number of perimeter walls.		REV			
INFILL DENSITY	15-35 %	Internal structure fill percentage.	TITLE  Base	DATE OF ISSUE		SHEET	
PRINTING SPEED	~60 mm/s (standard)	Linear print speed of nozzle.		REV1		08/12/2025	1
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.					
			MANUFACTURING TECHNOLOGY FDM 3D PRINTING				

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