

General Info		Filam Calc	
Innovy Print Statistics	14.00		
David Cochran	17.43h		
www.innovy.fr	4.119%		
Simplify 3D Software			
2 mm Layer Height	Remain to Print		
Support and Raft used	11.89%		
Nozzel Temp - 225			
Build Rate Temp - 110			

Parts Status			
231	Total Parts		
204	Printed Parts		
88.3%	Completed printing		
Restarts/Reprints		Time Wasted	
8		16 hours 30 minutes	
NOTES SECTION			
Now in printers			
Assumptions made that all parts use the same amount of filament			
I already have the head and will be using modified parts			

Printers		Print Time Statistics	
2 Flash Forge Creator Pro Printers	28-Apr-17	Started	
	23-May-17	Current Date	
	25	Print Days	50
Maintenance time	0.1	Maintenance	0.05
Est Print Finished = 26-May-17	-28.42	Estimated Total Days	56.67
Maintenance Info		L R	
Level Build Plate	After parts	Maintenance	
Clean Extruder Gear	After parts	Maintenance	
Replace Nozzle with Stainless Steel	Wait on pcs	Maintenance	
Grease printers - Bi-weekly	5/26/2017	Maintenance	
Replace Build Plate Tape	Wait on pcs	Maintenance	
Replace 9 Axis Stepper Cables	Wait on pcs	Maintenance	
W-White Hatchbox 3D ABS	<a href="https://www.amazon.com/gp/product/B0010H6NWM/ref=oh_aui_detailpage_o04_s00?ie=UTF8&amp;psc=1">https://www.amazon.com/gp/product/B0010H6NWM/ref=oh_aui_detailpage_o04_s00?ie=UTF8&amp;psc=1</a>		
B-Black Hatchbox 3D ABS	<a href="https://www.amazon.com/gp/product/B0010H6EWA/ref=oh_aui_detailpage_o04_s01?ie=UTF8&amp;psc=1">https://www.amazon.com/gp/product/B0010H6EWA/ref=oh_aui_detailpage_o04_s01?ie=UTF8&amp;psc=1</a>		

Costs	
Printers	\$ -
Filament	\$ 296.82
Stainless Steel MK10	\$ 15.30
Printer Sheets	\$ 25.80
9 axis cables	\$ 31.14
Print Cost	\$ 369.06

Filament Statistics					
HATCHBOX 3D ABS - \$296.82					
Current Cost					
KG Total Purchased	Used	KG Total Remaining	KG Total Unspooled	Color	Cost
2.25	2	0.25	4	Black	\$ 47.86
10	6	4	4	White	\$ 112.74
	8.25	6	5		\$ 160.60

2	Skull	2	1	Eyes	1	1	Face and Jaw	1
EyeBlock	1	1x2EyeBallUV2	1	LowerBackV3	1			
EyeSupport	1	1xEyeHinge	2	SideHeadV3	1			
Internal_MidBase	1	1xEyeHolder	1					
Internal_RaiserBlock	1	1xEyePlateLeft	1					
Internal_ServoBase	1	1xEyePlateRight	1					
Internal_TopMount	1	1xEyeSupport (print with support)	1					
JawArmLeft	1	1xEyeTo Nose	1					
JawArmRight	1	EyeBallSupportHerculeLeft	1					
JawBeam	1	EyeBallSupportHerculeRight	1					
JawWashers	1	EyeBallSupportLefCamMDLeft	1					
JawWormGear	1	EyeBallSupportLefCamMDRight	1					
Neck_Gear	1							
NeckGear_RetainingCollar	1							
Servo_NeckGear	1							
Skull_Bottom	1							
Skull_Jaw	1							
Skull_Top	1							
8 Ears	2							
Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	100.00%	

12	Mod Neck	16	16	Torso	22	12	Right Shoulder	14
W_GearStemV1	1	8 2x KinectSidelocker	2	W 1x ClawFront	1			
W_GearStemV2	1	8 2x KinectSidelock	2	W 1x ClawFront	1			
W_GearRedV1	1	W 1x KinectMidFront	1	B 1x PistonClaw	1			
W_GroundPlateV3a	1	W 1x KinectMidBack	1	B 1x Pistonbase	1			
W_UpperPlateV2	1	7 2x InterKinectSide	2	B 2x PivConnector	2			
W_PinionBlueV2	1	7 2x InterKinectMid	2	B 1x PivGear	1			
W_PinionGreenV2	1	6 2x HomLowFront	2	B8 1x PivMit	1			
W_PinionRedV2	1	6 2x HomLowBack	2	W 1x PivPotentio	1			
W_Ramenov1b	1	W 2x ChestLow	2	W 1x PivPotentio	1			
W_HomePlateFront	1	W_HomePlateFront	1	B 1x PivIt	1			
W_HomePlateLow	1	W_HomePlateBackLow	1	B 1x PivWorm	1			
W_SternumV1	1	W_SternumV1	1	B9 1x Pivcenter	1			
W_ServoHolderV3	1	W_HomeplateBackV1	1	W 1x servoHolder	1			
W_TopPlateV1	1	W_ThroatLower	2					
Percent Complete	75.00%	Percent Complete	72.73%	Percent Complete	85.71%	Percent Complete	85.71%	

10	Left Forarm - Hand	10	24	Left Bicep	24	10	Right Forarm - Hand	10
B 1x Thumb	0	B 1x HighArmSide	2	B 1x GearHolder	1	B 1x GearHolder	1	B 1x GearHolder
B 1x Majure	0	B 1x Pistonanticlock	1	B 1x Index	0	B 2x HighArmSide	2	B 1x HighArmSide
B 1x Pistonbaseanti	0	B 1x Pistonbaseanti	1	B 1x Majure	0	B 1x Pistonanticlock	1	B 1x Pistonanticlock
B 1x Rotator	0	B 1x Rotator	1	B 1x Axiurality	0	B 1x Pistonbaseanti	1	B 1x Pistonbaseanti
B 1x RotMit	0	B 1x RotMit	1	B 1x PivIt	0	B 1x Rotator	1	B 1x Rotator
B 1x RotPotentio	0	B 1x RotPotentio	1	B 1x RotMit	0	B 1x RotMit	1	B 1x RotMit
B 1x RotTie	0	B 1x RotTie	1	B 1x Wristarge	0	B 1x RotPotentio	1	B 1x RotPotentio
B 1x RotWorm	0	B 1x RotWorm	1	B 1x Wristsmall	0	B 1x RotTie	1	B 1x RotTie
B 1x Rotcenter	0	B 1x Rotcenter	1	B 1x TopgearFace	0	B 1x RotWorm	1	B 1x RotWorm
B 1x armpcover1	1	W 1x armpcover1	1	B 1x Coverfinger	0	B 1x Rotcenter	1	B 1x Rotcenter
B 1x armpcover2	1	W 1x armpcover2	1	B 1x Coverfinger	0	B 1x armpcover1	1	B 1x armpcover1
B 1x elbowshifter	1	W 1x elbowshifter	1	B 1x Coverfinger	0	B 1x armpcover2	1	B 1x armpcover2
B 1x gearpotentio	1	B 1x gearpotentio	1	W 1x rotawrist1	1	B 1x elbowshifter	1	B 1x elbowshifter
B 2x lowarmside	2	B 1x lowarmside	2	B 1x rotawrist2	1	B 1x gearpotentio	1	B 1x gearpotentio
B 2x reinforcer	2	B 2x reinforcer	2	B 1x rotawrist1	1	B 2x lowarmside	2	B 2x lowarmside
W 1x servobase	1	W 1x servobase	1	B 1x rotawrist2	1	B 2x reinforcer	2	B 2x reinforcer
W 1x servoHolder	1	W 1x servoHolder	1	W 1x servobase	1	W 1x servobase	1	W 1x servobase
B 1x spacer	1	B 1x spacer	1	W 1x servoHolder	1	W 1x servoHolder	1	W 1x servoHolder
W Back Arm Cover	1	W Back Arm Cover	1	B 1x spacer	1	B 1x spacer	1	B 1x spacer
Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete

24	Right Bicep	24	12	Left Shoulder	14
B 1x GearHolder	1	B 1x GearHolder	1	B 1x ClawBack	1
B 2x HighArmSide	2	B 2x HighArmSide	2	W 1x ClawFront	1
B 1x Pistonanticlock	1	B 1x Pistonanticlock	1	B 1x PistonClaw	1
B 1x Pistonbaseanti	1	B 1x Pistonbaseanti	1	B 1x Pistonbase	1
B 1x Rotator	1	B 1x Rotator	1	B 2x PivConnector	2
B 1x RotMit	1	B 1x RotMit	1	B 1x PivGear	1
B 1x RotPotentio	1	B 1x RotPotentio	1	B7 1x Left PivMit	1
B 1x RotTie	1	B 1x RotTie	1	W 1x PivPotentio	1
B 1x RotWorm	1	B 1x RotWorm	1	W 1x PivPotentio	1
B 1x Rotcenter	1	B 1x Rotcenter	1	B 1x PivIt	1
B 1x armpcover1	1	W 1x armpcover1	1	B 1x PivWorm	1
B 1x armpcover2	1	W 1x armpcover2	1	B9 1x Left Pivcenter	1
B 1x elbowshifter	1	W 1x elbowshifter	1	W 1x servoHolder	1
B 1x gearpotentio	1	B 1x gearpotentio	1		
B 2x lowarmside	2	B 2x lowarmside	2		
B 2x reinforcer	2	B 2x reinforcer	2		
W 1x servobase	1	W 1x servobase	1		
W 1x servoHolder	1	W 1x servoHolder	1		
B 1x spacer	1	B 1x spacer	1		
W Back Arm Cover	1	W Back Arm Cover	1		
Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	85.71%

25	Top Stomach	31	10	Mid Stomach	12
W 1x DiskInternV3.stl	1	W 1x BotBackLeftV1.stl	1	W 1x 15StomLowLeft	1
W 1x 15StomSpacerV1.stl	1	W 1x BotBackRightV1.stl	1	W 1x 15StomLowRight	1
W 1x 15StomFrontFrontV1.stl	1	W 1x BotCovLeftV1.stl	1	W 1x 15StomSupportRight	1
W 1x 15StomRotBackV1.stl	1	W 1x BotCovRightV1.stl	1	W 1x 15StomSupportLeft	1
W 1x 15StomPotHolderV1.stl	1	W 1x BotFrontLeftV1.stl	1		
B3 1x 15StomCovRightV2.stl	1	W 1x BotFrontRightV1.stl	1		
B3 1x 15StomCovLeftV2.stl	1	W 1x BotFrontRightV2.stl	1		
W 1x 15StoServoHolderV2.stl	1	W 1x BotFrontRightV3.stl	1		
W 1x 15StoPistonRightV2.stl	1	W 1x BotFrontRightV4.stl	1		
W 1x 15StoPistonLeftV2.stl	1	W 1x BotFrontRightV5.stl	1		
W 1x 15StoPistonV1.stl	2	W 1x BotFrontRightV6.stl	1		
W 1x 15StoFrontStandV1.stl	1	W 1x BotFrontRightV7.stl	1		
W 1x 15StoFrontRightV1.stl	1	W 1x BotFrontRightV8.stl	1		
W 1x 15StoFrontLeftV1.stl	1	W 1x BotFrontRightV9.stl	1		
W 1x 15StoBackStandRightV1.stl	1	W 1x BotFrontRightV10.stl	1		
W 1x 15StoBackLeftV1.stl	1	W 1x BotFrontRightV11.stl	1		
W 1x 15StoBackRightV1.stl	1	W 1x BotFrontRightV12.stl	1		
W 1x 15StoBackLeftV2.stl	1	W 1x BotFrontRightV13.stl	1		
W 1x 15StoBackRightV2.stl	1	W 1x BotFrontRightV14.stl	1		
W 1x 15ServoBackV1.stl	1	W 1x BotFrontRightV15.stl	1		
W 1x 15RollFrontRightV1.stl	1	W 1x BotFrontRightV16.stl	1		
W 1x 15RollFrontLeftV1.stl	1	W 1x BotFrontRightV17.stl	1		
W 1x 15RollBackRightV1.stl	1	W 1x BotFrontRightV18.stl	1		
W 1x 15RollBackLeftV1.stl	1	W 1x BotFrontRightV19.stl	1		
W 1x 15DiskInternV2.stl	2	W 1x BotFrontRightV20.stl	1		
Percent Complete	80.65%	Percent Complete	83.23%	Percent Complete	100.00%

10	Left Forarm - Hand	10	24	Left Bicep	24
B 1x Thumb	0	B 1x HighArmSide	2	B 1x GearHolder	1
B 1x Majure	0	B 1x Pistonanticlock	1	B 1x Index	0
B 1x Pistonbaseanti	0	B 1x Pistonbaseanti	1	B 1x Majure	0
B 1x Rotator	0	B 1x Rotator	1	B 1x Axiurality	0
B 1x RotMit	0	B 1x RotMit	1	B 1x PivIt	0
B 1x RotPotentio	0	B 1x RotPotentio	1	B 1x RotMit	0
B 1x RotTie	0	B 1x RotTie	1	B 1x Wristarge	0
B 1x RotWorm	0	B 1x RotWorm	1	B 1x Wristsmall	0
B 1x Rotcenter	0	B 1x Rotcenter	1	B 1x TopgearFace	0
B 1x armpcover1	1	W 1x armpcover1	1	B 1x Coverfinger	0
B 1x armpcover2	1	W 1x armpcover2	1	B 1x Coverfinger	0
B 1x elbowshifter	1	W 1x elbowshifter	1	B 1x armpcover1	1
B 1x gearpotentio	1	B 1x gearpotentio	1	B 1x armpcover2	1
B 2x lowarmside	2	B 1x lowarmside	2	B 1x elbowshifter	1
B 2x reinforcer	2	B 2x reinforcer	2	B 1x gearpotentio	1
W 1x servobase	1	W 1x servobase	1	B 2x lowarmside	2
W 1x servoHolder	1	W 1x servoHolder	1	B 2x reinforcer	2
B 1x spacer	1	B 1x spacer	1	B 1x rotawrist2	1
W Back Arm Cover	1	W Back Arm Cover	1	W 1x servobase	1
Percent Complete	100.00%	Percent Complete	100.00%	Percent Complete	100.00%

10	Right Forarm - Hand	10	24	Right Bicep	24
B 1x GearHolder	1	B 1x GearHolder	1	B 1x GearHolder	1
B 2x HighArmSide	2	B 2x HighArmSide	2	B 1x HighArmSide	2
B 1x Pistonanticlock	1	B 1x Pistonanticlock	1	B 1x Pistonanticlock	1
B 1x Pistonbaseanti	1	B 1x Pistonbaseanti	1	B 1x Pistonbaseanti	1
B 1x Rotator	1	B 1x Rotator	1	B 1x Rotator	1
B 1x RotMit	1	B 1x RotMit	1	B 1x RotMit	1
B 1x RotPotentio	1	B 1x RotPotentio	1	B 1x RotPotentio	1
B 1x RotTie	1	B 1x RotTie	1	B 1x RotTie	1
B 1x RotWorm	1	B 1x RotWorm	1	B 1x RotWorm	1
B 1x Rotcenter	1	B 1x Rotcenter	1	B 1x Rotcenter</	