

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
EYES & EARS (E)										
1	E1	White	4	41	3	30	-	41	-	4
1	E2	White	2.25	23	3	30	-	23	-	2.25
1	E3	White	1	9	3	30	-	9	-	1
1	E4	White	1.5	15	3	30	-	15	-	1.5
1	E5	White	1	10	3	30	-	10	-	1
1	E6a	White	0.33	4	3	30	-	4	-	0.33
1	E6b	Black	0.5	5	3	30	5	-	0.5	-
1	E6c	Any color	0.25	2	3	30	-	-	-	-
1	E7 & E8 & E9	White	0.25	2	3	30	-	2	-	0.25
1	E10L	Black	4.5	55	3	30	55	-	4.5	-
1	E10R	Black	4.5	55	3	30	55	-	4.5	-
FIBER EYES (F)										
1	F1	White	4.5	47	3	30	-	47	-	4.5
1	F2	White	1.75	16	3	30	-	16	-	1.75
1	F3	White	1.25	12	3	30	-	12	-	1.25
1	F4	Black	0.5	4	3	30	4	-	0.5	-
1	F5 *Acrylic eye replacement	Natural	Provided in Kit	-	3	30	-	-	-	-
INTERNAL (I)										
1	I1	White	2.2	24	3	30	-	24	-	2.2
1	I2	White	5.2	58	3	30	-	58	-	5.2
1	I3	White	0.5	5	3	30	-	5	-	0.5
1	I4	White	4	45	3	30	-	45	-	4
1	I5	White	0.33	3	3	30	-	3	-	0.33
1	I6	White	1.5	17	3	30	-	17	-	1.5
JAW (J)										
1	J1	White	3.75	38	3	30	-	38	-	3.75
1	J2	White	4.25	44	3	30	-	44	-	4.25
1	J3L & J3R	White	2	19	3	30	-	19	-	2
1	J4	White	1	9	3	30	-	9	-	1

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	J5	White	0.5	4	3	30	-	4	-	0.5
1	J6	White	0.2	1	3	30	-	1	-	0.2
1	J7	White	1.5	17	3	30	-	17	-	1.5
NECK (N)										
1	N1	White	3.5	40	3	30	-	40	-	3.5
1	N2	White	1.8	23	3	30	-	23	-	1.8
1	N3	White	5.2	59	3	30	-	59	-	5.2
1	N4	White	2	21	3	30	-	21	-	2
1	N5	Black	2.8	35	3	30	35	-	2.8	-
1	N5a & N5b	Black	2.8	35	4	40	35	-	2.8	-
1	N6	Black	4.33	47	3	30	47	-	4.33	-
1	N6a & N6b	Black	3.2	31	3	30	31	-	3.2	-
1	N7	White	1.5	16	3	30	-	16	-	1.5
SKULL (SK)										
1	SK1	White	4.8	52	3	30	-	52	-	4.8
1	SK2L & SK2R	White	6.5	72	3	30	-	72	-	6.5
1	SK3L & SK4L & SK5L	White	6.6	74	3	30	-	74	-	6.6
1	SK3R & SK4R & SK5R	White	6.6	74	3	30	-	74	-	6.6
1	SK6L & SK6R	White	3.75	39	3	30	-	39	-	3.75
1	SK7L & SK7R	White	4.5	49	3	30	-	49	-	4.5
HAND RIGHT (HR)										
1	HR1	White	6	61	3	30	-	61	-	6
1	HR2	White	5	57	3	30	-	57	-	5
1	HR3	White	4.6	46	3	30	-	46	-	4.6
1	HR4	White	8.5	92	3	30	-	92	-	8.5
1	HR5	White	0.5	4	3	30	-	4	-	0.5
1	HR6	Black TPU	Provided in Kit	-	5	90	-	-	-	-
1	HR6a	Black TPU	Provided in Kit	-	3	0	-	-	-	-
FOREARM RIGHT (FR)										
1	FR1	White	6.6	74	3	30	-	74	-	6.6

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	FR2	White	7	75	3	30	-	75	-	7
1	FR3	White	3.33	40	3	30	-	40	-	3.33
1	FR4	White	2.5	32	3	30	-	32	-	2.5
1	FR5	White	1.75	18	3	30	-	18	-	1.75
1	FR6	White	2	21	3	30	-	21	-	2

BICEP RIGHT (BR)

1	BR1	Black	3.6	45	3	30	45	-	3.6	-
1	BR2	Black	8.33	100	3	30	100	-	8.33	-
1	BR3	Black	8	101	3	30	101	-	8	-
1	BR4	Black	6.75	82	4	40	82	-	6.75	-
1	BR5	Black	1.5	18	4	40	18	-	1.5	-
1	BR6 & BR7	White	6.33	70	3	30	-	70	-	6.33
1	BR8 & BR8a	White	1	11	3	30	-	11	-	1
1	BR9 & BR10	Black	2.33	25	3	30	25	-	2.33	-
1	BR11 & BR12	White	5.25	59	3	30	-	59	-	5.25
1	BR13 & BR14	White	5.25	59	3	30	-	59	-	5.25
1	BR15	White	2.75	28	3	30	-	28	-	2.75

SHOULDER RIGHT (SR)

1	SR1	Black	10.33	123	3	30	123	-	10.33	-
1	SR2	Black	6.25	77	3	30	77	-	6.25	-
1	SR3B	Black	3.2	39	4	40	39	-	3.2	-
1	SR3S	Black	3.2	39	4	40	39	-	3.2	-
1	SR4	Black	3.2	35	4	40	35	-	3.2	-
1	SR5 & SR5a	Black	6.25	70	3	30	70	-	6.25	-
1	SR6	Black	2.2	23	3	30	23	-	2.2	-
1	SR7	Black	3.8	39	4	40	39	-	3.8	-
1	SR8	Black	2.4	27	4	40	27	-	2.4	-
1	SR9	Black	5.75	70	3	30	70	-	5.75	-
1	SR10	Black	0.33	3	3	30	3	-	0.33	-
1	SR11 & SR11a	Black	1.75	19	3	30	19	-	1.75	-

HAND LEFT (HL)

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	HL1	White	6	61	3	30	-	61	-	6
1	HL2	White	5	57	3	30	-	57	-	5
1	HL3	White	4.6	46	3	30	-	46	-	4.6
1	HL4	White	8.5	92	3	30	-	92	-	8.5
1	HL5	White	0.5	4	3	30	-	4	-	0.5
1	HL6	Black TPU	Provided in Kit		3	30	-	-	-	-
1	HL6a	Black TPU	Provided in Kit		3	0	-	-	-	-

FOREARM LEFT (FL)

1	FL1	White	6.6	74	3	30	-	74	-	6.6
1	FL2	White	7	75	3	30	-	75	-	7
1	FL3	White	3.33	40	3	30	-	40	-	3.33
1	FL4	White	2.5	32	3	30	-	32	-	2.5
1	FL5	White	1.75	18	3	30	-	18	-	1.75
1	FL6	White	2	21	3	30	-	21	-	2

BICEP LEFT (BL)

1	BL1	Black	3.6	45	3	30	45	-	3.6	-
1	BL2	Black	8.33	100	3	30	100	-	8.33	-
1	BL3	Black	8	101	3	30	101	-	8	-
1	BL4	Black	6.75	82	4	40	82	-	6.75	-
1	BL5	Black	1.5	18	4	40	18	-	1.5	-
1	BL6 & BL7	White	6.33	70	3	30	-	70	-	6.33
1	BL8 & BL8a	White	1	11	3	30	-	11	-	1
1	BL9 & BL10	Black	2.33	25	3	30	25	-	2.33	-
1	BL11 & BL12	White	5.25	59	3	30	-	59	-	5.25
1	BL13 & BL14	White	5.25	59	3	30	-	59	-	5.25
1	BL15	White	2.75	28	3	30	-	28	-	2.75

SHOULDER LEFT (SL)

1	SL1	Black	10.33	123	3	30	123	-	10.33	-
1	SL2	Black	6.25	77	3	30	77	-	6.25	-
1	SL3B	Black	3.2	39	4	40	39	-	3.2	-
1	SL3S	Black	3.2	39	4	40	39	-	3.2	-

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	SL4	Black	3.2	35	4	40	35	-	3.2	-
1	SL5 & SL5a	Black	6.25	70	3	30	70	-	6.25	-
1	SL6	Black	2.2	23	3	30	23	-	2.2	-
1	SL7	Black	3.8	39	4	40	39	-	3.8	-
1	SL8	Black	2.4	27	4	40	27	-	2.4	-
1	SL9	Black	5.75	70	3	30	70	-	5.75	-
1	SL10	Black	0.33	3	3	30	3	-	0.33	-
1	SL11 & SL11a	Black	1.75	19	3	30	19	-	1.75	-
STOMACH (ST)										
1	ST1L	White	12	172	3	30	-	172	-	12
1	ST1R	White	12	172	3	30	-	172	-	12
1	ST2	White	0.5	4	3	30	-	4	-	0.5
1	ST3	White	4.2	47	3	30	-	47	-	4.2
1	ST4	White	8.5	108	3	30	-	108	-	8.5
1	ST5 & ST6	White	2	22	3	30	-	22	-	2
1	ST7	White	0.25	2	3	30	-	2	-	0.25
1	ST8	Black	8	84	3	30	84	-	8	-
1	ST9	Black	4	42	3	30	42	-	4	-
TORSO (T)										
1	T1L	Black	13	165	3	30	165	-	13	-
1	T1R	Black	13	165	3	30	165	-	13	-
1	T2L	White	15	187	3	30	-	187	-	15
1	T2R	White	15	187	3	30	-	187	-	15
1	T3L	Black	9	116	3	30	116	-	9	-
1	T3R	Black	9	116	3	30	116	-	9	-
1	T4L	White	8.75	113	3	30	-	113	-	8.75
1	T4R	White	8.75	113	3	30	-	113	-	8.75
1	T5	White	2.5	25	3	30	-	25	-	2.5
1	T6R & T6L	Black	4.75	49	4	40	49	-	4.75	-
1	T7L & T7R	Black	1.5	15	4	40	15	-	1.5	-
1	T8	Black	3.33	37	4	40	37	-	3.33	-
1	T9	Black	2.33	28	4	40	28	-	2.33	-

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	T10 & T10A & T10B	White	5.33	60	4	40	-	60	-	5.33
2	T11	Black	1.2	13	3	30	13	-	1.2	-
1	T12L & T12R	Black	1.5	16	3	30	16	-	1.5	-
1	T13	Black	1.5	16	3	30	16	-	1.5	-
1	T14	Black	1.5	19	3	30	19	-	1.5	-
1	T15	Black	1.25	12	3	30	12	-	1.25	-
1	T16 & T16A	Black	5.5	64	3	30	64	-	5.5	-
1	T17 & T17A	Black	1.8	19	3	30	19	-	1.8	-
1	T18	Black	3.2	39	3	30	39	-	3.2	-
1	T19	Black	7.8	82	3	30	82	-	7.8	-
1	T20	White	1	9	3	30	-	9	-	1
CHEST (C)										
1	C1L	White	8.5	93	3	30	-	93	-	8.5
1	C1R	White	8.5	93	3	30	-	93	-	8.5
1	C2	White	2.5	27	3	30	-	27	-	2.5
1	C3L	White	5.5	67	3	30	-	67	-	5.5
1	C3R	White	5.5	67	3	30	-	67	-	5.5
1	C4L&C4R	White	3	32	3	30	-	32	-	3
1	C5L&C5R	White	0.5	5	3	30	-	5	-	0.5
1	C6L	Black	2.25	24	3	30	24	-	2.25	-
1	C6R	Black	2.25	25	3	30	25	-	2.25	-
1	C7	White	4	45	3	30	-	45	-	4
1	C8L	Black	2	21	3	30	21	-	2	-
1	C8R	Black	2	21	3	30	21	-	2	-
BACK (BK)										
1	BK1L	White	4	47	3	30	-	47	-	4
1	BK1R	White	3	33	3	30	-	33	-	3
1	BK2	White	4	47	3	30	-	47	-	4
1	BK3L	White	3.5	39	3	30	-	39	-	3.5
1	BK3R	White	3.5	39	3	30	-	39	-	3.5
1	BK4L	White	3.25	37	3	30	-	37	-	3.25
1	BK4R	White	1.33	14	3	30	-	14	-	1.33

Qty	Description	Color	Printing Hours	Grams	Walls	Infill %	Black Grams	White Grams	Black hours	White hours
1	BK5	White	3.25	37	3	30	-	37	-	3.25
1	BK6L	White	4.33	45	3	30	-	45	-	4.33
1	BK6R	White	2	22	3	30	-	22	-	2
1	BK7	White	4.33	45	3	30	-	45	-	4.33
1	BK8L	White	0.33	4	3	30	-	4	-	0.33
1	BK8R	White	0.33	4	3	30	-	4	-	0.33
1	BK9	Black	11	109	3	30	109	-	11	-
1	BK10L	White	0.66	8	3	30	-	8	-	0.66
1	BK10R	White	0.66	8	3	30	-	8	-	0.66
1	BK11	Black	12	153	3	30	153	-	12	-
TOTAL (Complete kit)			706.86	8144			3587	4555	306.13	400.48

BREAKDOWN

Head White	Grams	982	Hours	91.51
Head Black	Grams	267	Hours	23.13
Torso White	Grams	3573	Hours	308.97
Torso Black	Grams	3320	Hours	283

RECOMMENDATION

Black PLA for Complete	4	1kg spool	*Hours based on print speed of 60mm/s, no raft, no supports
White PLA for Complete	5	1kg spool	*Design files are pre-supported, no need to add supports
Black PLA for just Head	1	1kg spool	
White PLA for just Head	2	1kg spool	*When printing on heated bed rafts aren't needed
Black PLA for just Torso	4	1kg spool	*When printing on non-heated bed rafts are needed
White PLA for just Torso	4	1kg spool	