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The material used is PLA, and the 3D printing process is Fused Deposition Modeling (FDM). The three parameters we studied are: Infill %: percentage of the object's volume (inside) that is filled with material.

30%_	50%	70%	90%	
10%			74	100%
	V			

	REQUIREMENTS			SETTINGS	
Strength	Quality	Low Cost	Speed	Infill %	Layer height
×				100	0.25
	×			10	0.1
		×		10	0.1
			×	10	0.3
×	×			90	0.15
×		×		70	0.2
×			×	90	0.3
	×	×		10	0.1
	×		*	10	0.15
		×	×	10	0.3
×	×	×		80	0.15
×	×		×	90	0.2
×		×	×	70	0.3
	×	×	×	10	0.15
×	×	×	×	70	0.2