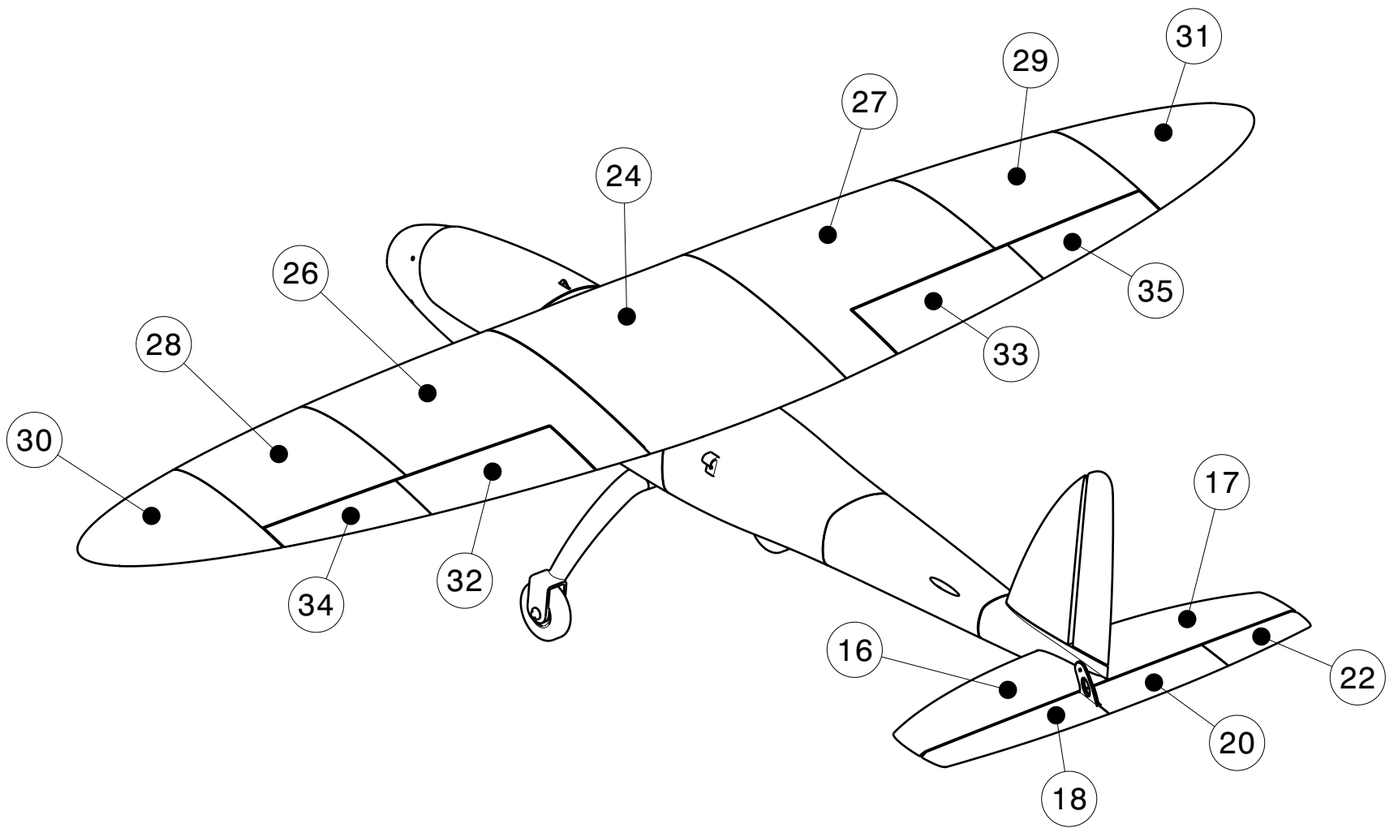
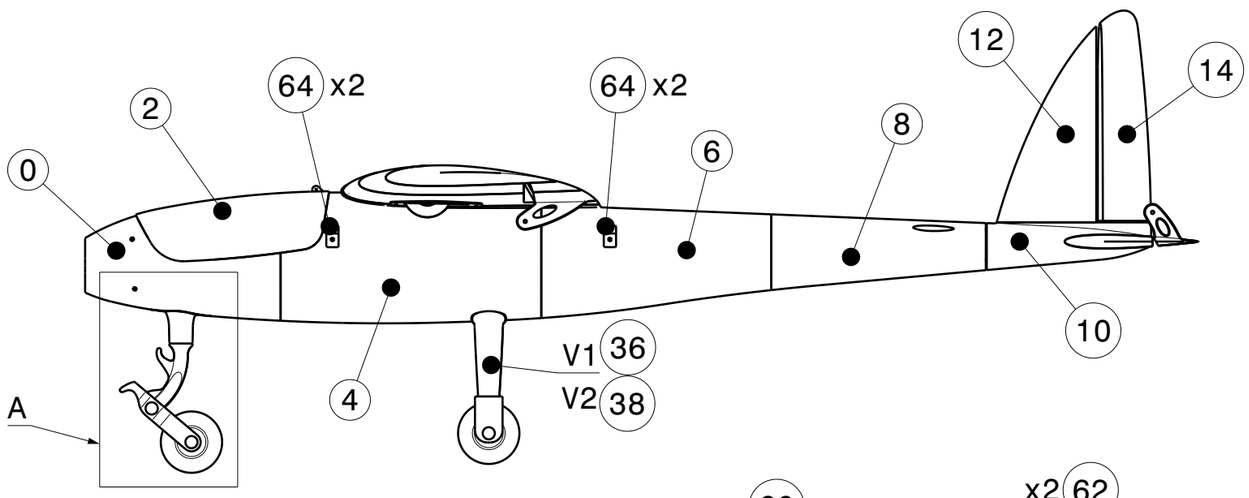
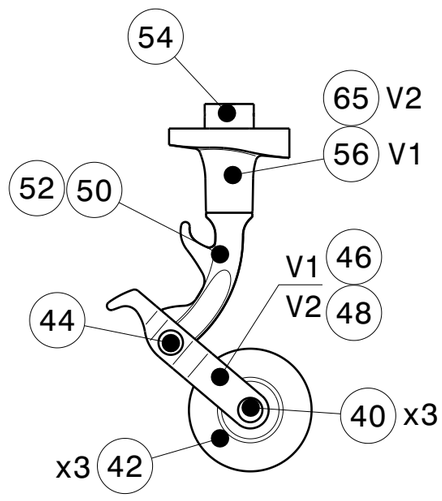
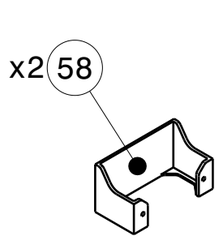
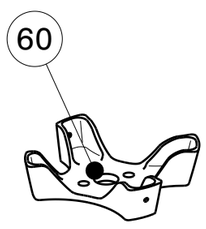


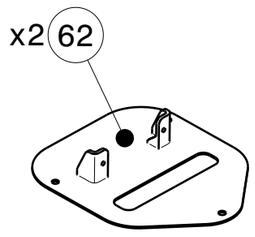


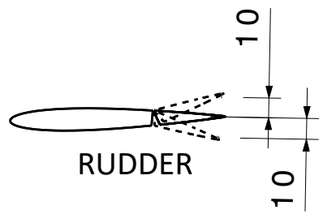


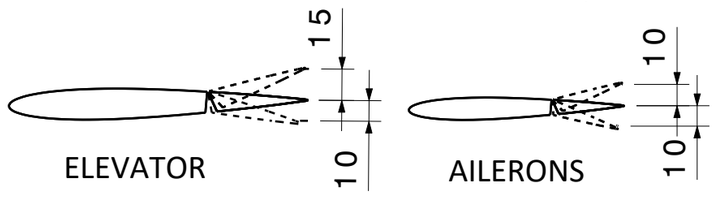
Detail A
(Item 0 hidden)











Recommended throw

ITEM	NAME	CATEGORY
0	Fus1	A / A-LW
2	Canopy	A / A-LW
4	Fus2	A / A-LW
6	Fus3	A / A-LW
8	Fus4	A / A-LW
10	Fus5	A / A-LW
12	VTP	B / B-LW
14	Rudder	B / B-LW
16	HTP1L	B / B-LW
17	HTP1R	B / B-LW
18	Elev1L	B / B-LW
20	Elev2R	B / B-LW
22	Elev3R	A / A-LW
24	WingC	A / A-LW
26	Wing1L	A / A-LW
27	Wing1R	A / A-LW
28	Wing2L	A / A-LW
29	Wing2R	A / A-LW
30	Wing3L	A / A-LW
31	Wing3R	A / A-LW
32	Aileron1L	B / B-LW
33	Aileron1R	B / B-LW
34	Aileron2L	A / A-LW
35	Aileron2R	A / A-LW
10 36	MLG	C
38	MLG_2	C
9 40	Axis_locker	C
42	Wheel	C / C-LW
9 44	NLG_bolt	C
46	NLG_Fork_D1.4	C
48	NLG_Fork_D2.3	C
50	NLG1	C
52	NLG2	C
54	NLG_fitting	C
9 56	NLG_bushing	C
58	Servo_holder_fus	C
6 60	Motor_holder	C
62	Servo_holder_wing	C / C-LW
64	Fitting_rubber	C
65	NLG_Cap	C / C-LW

10 Support needed only for MLG

9 Do not print this part at the same time with others, print it alone to achieve good quality.

8 If you can not use fan, ensure enough time between layers to cool down material

7 If you can not heat the bed use Spray Adhesive

6 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor_holder"

5- Do not print LW-PLA parts at the same time with others to avoid stringing in the outer surface.

4- Do not use retraction values higher than 3mm for LW-PLA parts because the risk of clogging increases.

3- Stringing can not be eliminated for LW-PLA material.

2- Center of gravity marking placed under the wing

1- Red parameters are mandatory to ensure airplane functionality, assembly or weight target.

PRINTING PARAMETER	CATEGORY					
	A-LW	A	B-LW	B	C-LW	C
Layer height (mm)	0.25	0,2	0,25	0,2	0,15	0,13
Bottom layers	0	0	7	6	4	4
Top layers	0	0	0	0	6	6
Wall lines / perimeter	1	1	1	1	2	2
Nozzle diameter (mm)	0,4	0,4	0,4	0,4	0,4	0,4
Material	LW-PLA	PLA/ PETG	LW-PLA	PLA/ PETG	LW-PLA	PLA/PETG /ABS
Infill density (%)	0	0	0	0	10	10
Printing temp (°C)	240	220	240	220	240	205 to 240
7 Bed temp (°C)	60	60	60	60	60	60
Flow (%)	55	100	55	100	55	100
Retraction (mm)	0,5 to 3	0,5 to 3	0,5 to 3	0,5 to 3	0,5 to 3	3
Retraction extra prime amount (mm)	0	0 to 0,7	0	0 to 0,7	0	0
Speed (mm/s)	40	50	40	50	35	25 to 50
8 Fan	YES	YES	YES	YES	YES	YES
Brim (mm)	3	3	0 to 3	0 to 3	0 to 3	0 to 3
Minimun layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO