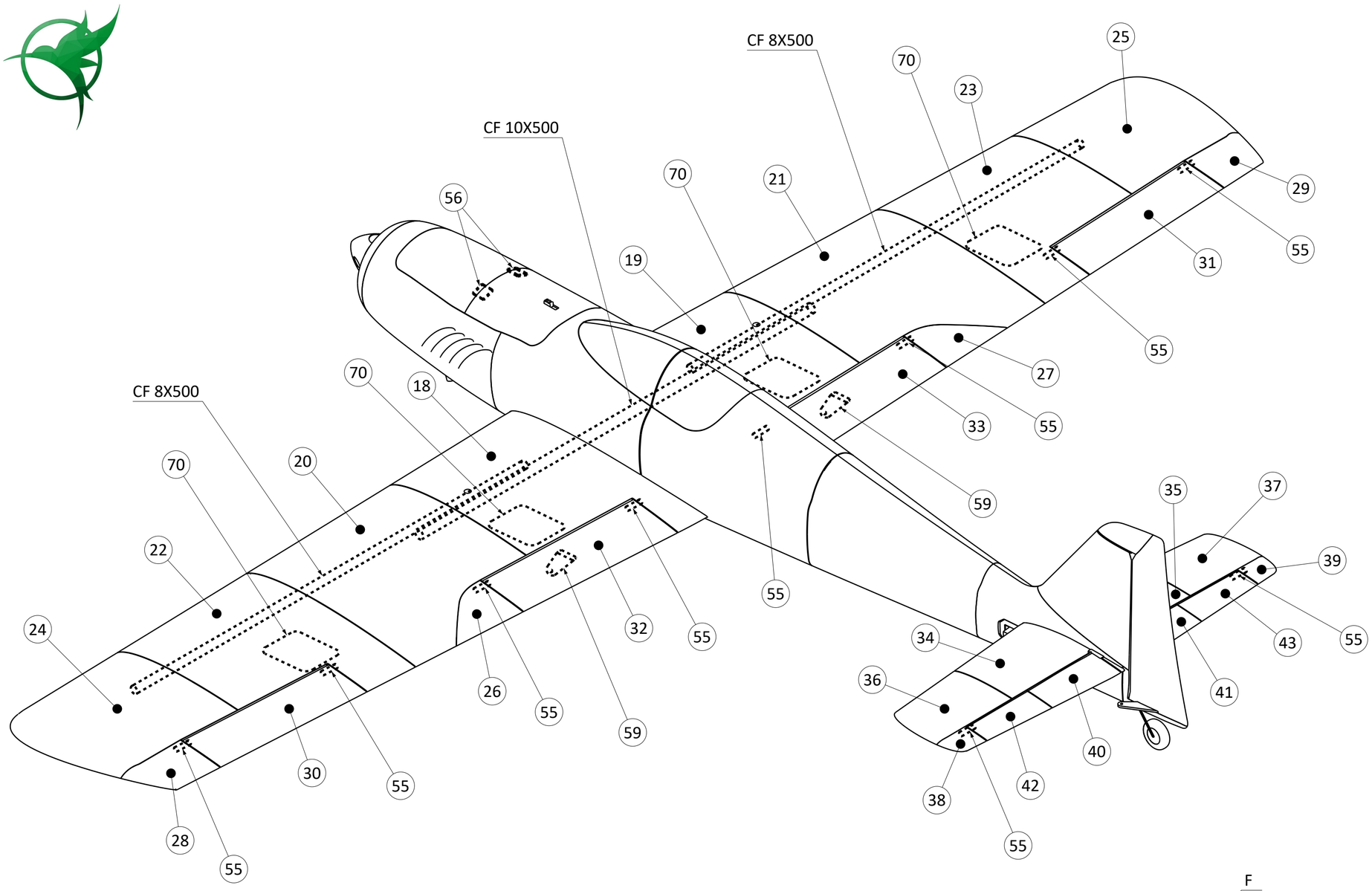
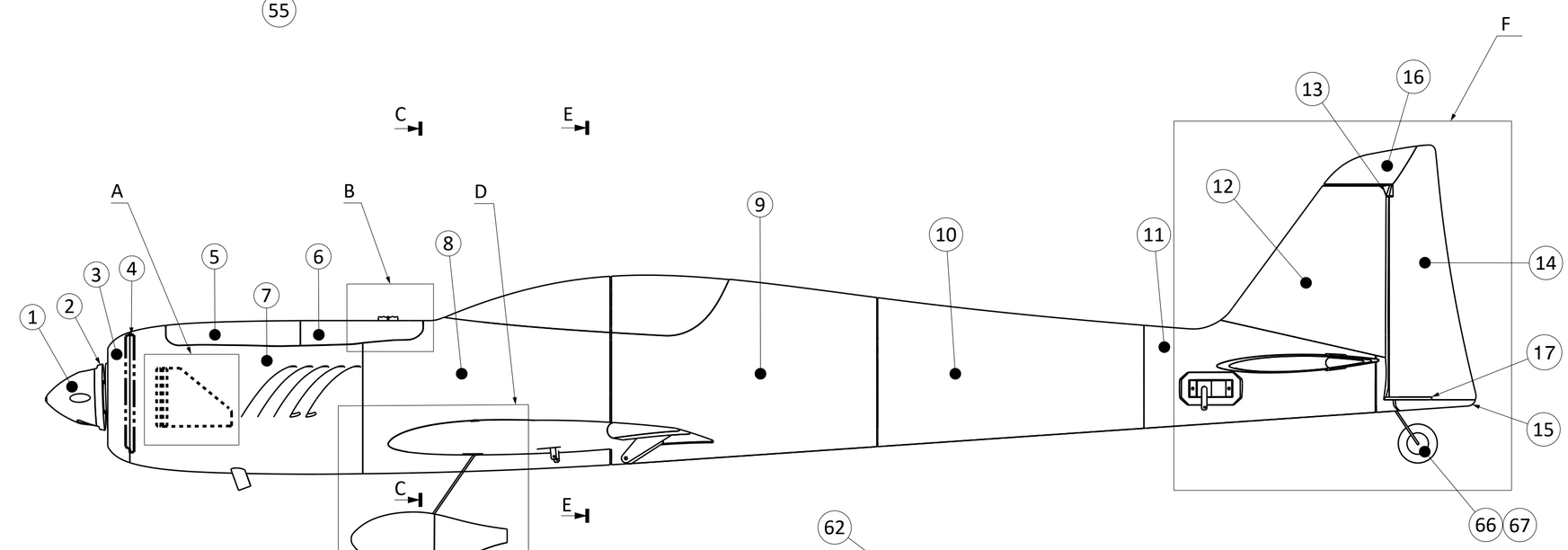
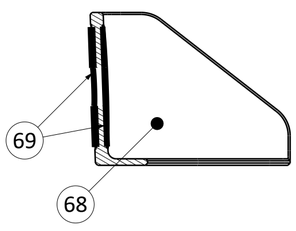
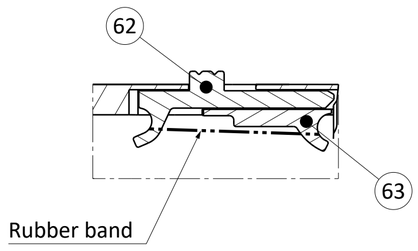


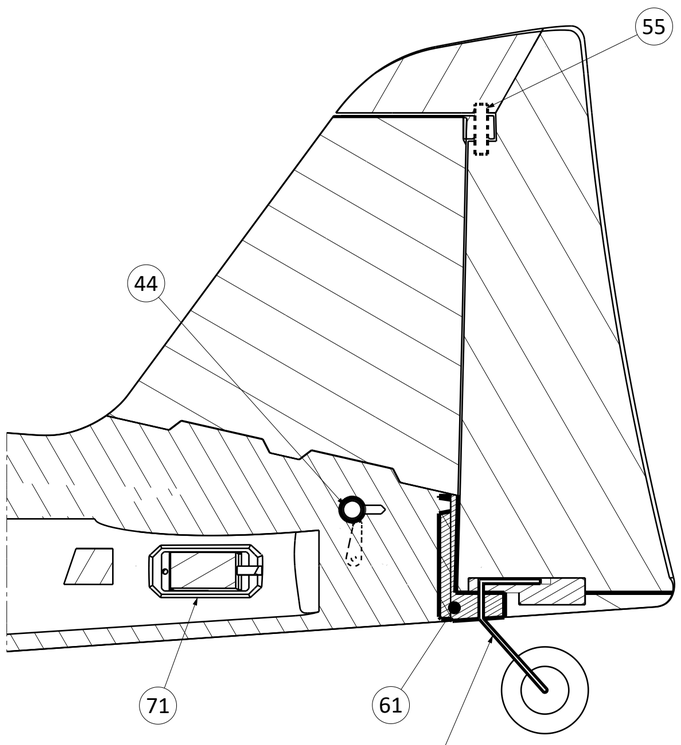



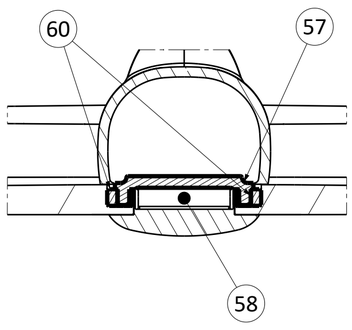

DETAIL A



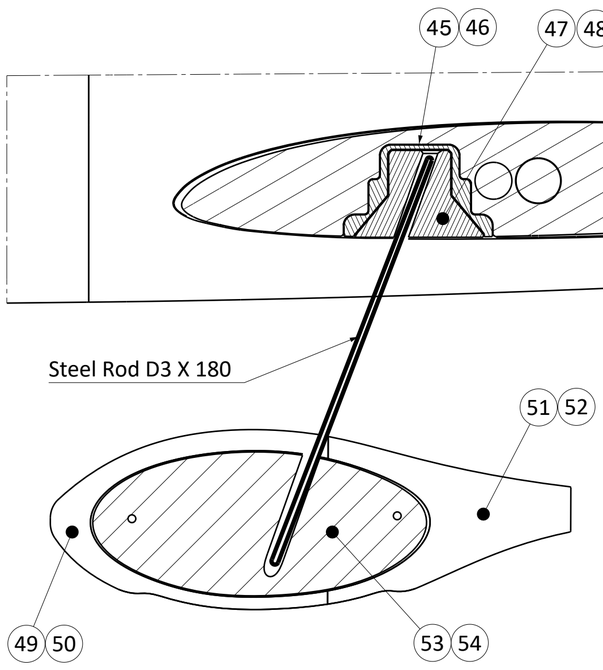

DETAIL B



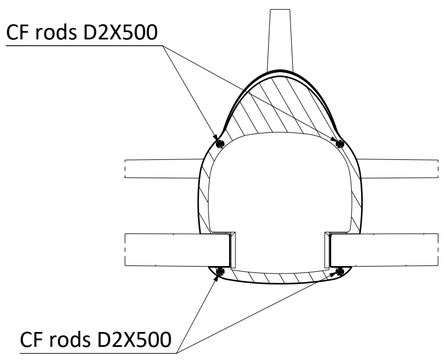

DETAIL F



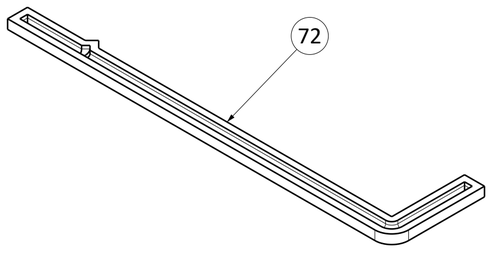

SECTION C-C

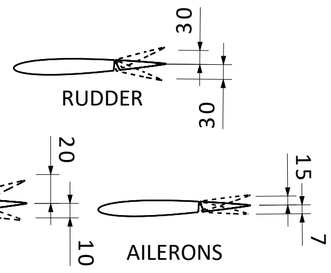



DETAIL D




SECTION E-E




Recommended throw

| ITEM | NAME | CATEGORY |
|---|---|---|
| 1 | Spinner1 | C |
| 1 3 | Spinner2 | C |
| 3 | Fus_Nose | D |
| 4 | Fus_Nose_Insert | D |
| 5 | Canopy_1 | D |
| 6 | Canopy_2 | D |
| 7 | Fus_1 | D |
| 8 | Fus_2 | D |
| 9 | Fus_3 | B2-LW |
| 10 | Fus_4 | B2-LW |
| 11 | Fus_5 | B2-LW |
| 12 | VTP_1 | B2-LW |
| 13 | Rudder_Hinge | C |
| 14 | Rudder_1 | B2-LW |
| 3 | Rudder_2 | D |
| 16 | Rudder_3 | B2-LW |
| 17 | Rudder_Horn_Insert | C |
| 18 | Wing_1L | B2-LW |
| 19 | Wing_1R | B2-LW |
| 20 | Wing_2L | B2-LW |
| 21 | Wing_2R | B2-LW |
| 22 | Wing_3L | B2-LW |
| 23 | Wing_3R | B2-LW |
| 24 | Wing_4L | B2-LW |
| 25 | Wing_4R | B2-LW |
| 26 | Wing_5L | B2-LW |
| 27 | Wing_5R | B2-LW |
| 28 | Wing_6L | B2-LW |
| 29 | Wing_6R | B2-LW |
| 7B | Aileron_1L | B2-LW |
| 7B | Aileron_1R | B2-LW |
| 32 | Flap_1L | B2-LW |
| 33 | Flap_1R | B2-LW |
| 34 | HTP_1L | B2-LW |
| 35 | HTP_1R | B2-LW |
| 36 | HTP_2L | B2-LW |
| 37 | HTP_2R | B2-LW |
| 38 | HTP_3L | B2-LW |
| 39 | HTP_3R | B2-LW |
| 40 | Elev_1L | B2-LW |
| 41 | Elev_1R | B2-LW |
| 42 | Elev_2L | B2-LW |
| 43 | Elev_2R | B2-LW |
| 44 | Elev_Axle_Horn | C |
| 45 | LG1_Root_L | C |
| 46 | LG1_Root_R | C |
| 47 | LG2_Base_L | C |
| 48 | LG2_Base_R | C |
| 49 | Wheel_fairing_1L | C |
| 50 | Wheel_fairing_1R | C |
| 51 | Wheel_fairing_2L | C |
| 52 | Wheel_fairing_2R | C |
| 53 | Wheel_fairing_3L | C |
| 54 | Wheel_fairing_3R | C |
| X11 55 | Axis | C |
| X2 56 | Guide | C |
| 57 | Central_Pin | C |
| 58 | Central_Tube | C |
| X2 59 | Horn | C |
| X2 60 | Pinbox | C |
| 61 | Tail_EndCap | C |
| 62 | Lock_1 | C |
| 63 | Lock_2 | C |
| 2 X2 64 | Tyre_D55_W12 | C |
| X2 65 | Rim_D55_W12 | C |
| 2 66 | TyreD25 | C |
| 67 | RimD25 | C |
| 68 | Motor_Holder | C |
| X2 69 | MotorHolder_ABSDisc | C |
| X4 70 | Servo_Holder_wing | C |
| X2 71 | Servo_Holder | C |
| 72 | Pattern_Main_LG | C |

7B - Use 7 bottom layers

3 - Remove spiral vase, add 3 top layers

2 - Print it with TPU 95A. Use 4 walls lines and 0% infill

1 - If your motor gets too hot, print this part using ABS or another heat-resistant material

| PRINTING PARAMETER | CATEGORY | | |
|---|---|---|---|
| | B2-LW | C | D |
| Material | LW-PLA | PLA/PETG TPU/ABS | PLA+/ PETG |
| Layer height (mm) | 0.25 | 0,13 | 0,2 |
| Bottom layers | 4 | 4 | 4 |
| Top layers | 0 | 6 | 4 |
| Wall lines / perimeter | 1 | 2 | 1 |
| Infill density (%) | 0 | 10 | 3 |
| Printing temp (°C) | 235 | 205 to 240 | 220 |
| Speed (mm/s) | 55 | 50 to200 | 50 to 200 |
| Flow (%) | 53 | 100 | 100 |
| Spiralize Outer Contour / vase mode | YES | NO | NO |
| Printing Support | NO | NO | NO |
| Nozzle diameter (mm) | 0,4 | 0,4 | 0,4 |