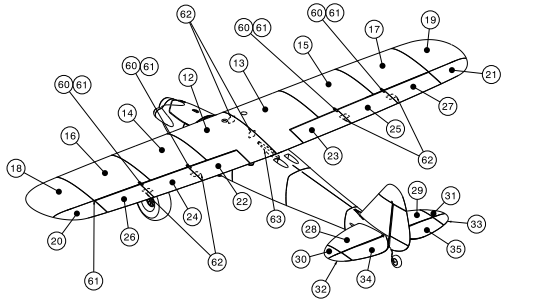
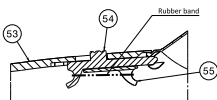
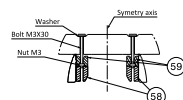


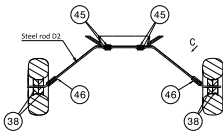
SECTION A-A



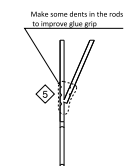
DETAIL F



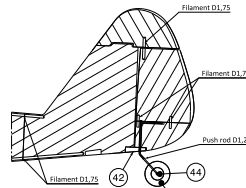
SECTION D-D



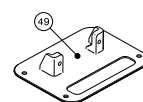
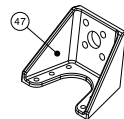
SECTION B-B



VIEW C
(Steel rod assembly detail)



DETAIL E



88 Add 8 bottom layers

6 Deactivate "spiralize open contour" / vase mode" and add 2 top layers

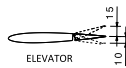
5 Alternatively you can also use the traditional Method to join landing gear rods: soldering both steel rods.

4 Use flexible material

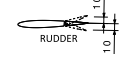
3 If your motor reach temperatures over 50°C use ABS or PETG for "Motor_holder"

2 - Center of gravity marking under the wing

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



ELEVATOR



RUDDER



AILERONS

Recommended throw

ITEM	NAME	CATEGORY
1	Spinner1	C
2	Spinner2	C
4	Fus1	B2-LW
5	Fus2	B2-LW
6	Fus3	B2-LW
7	Fus4	B2-LW
8	Fus5	B2-LW
9	VTP	B2-LW
10	Rudder_2	B2-LW
11	Rudder_1	B2-LW
12	Wing1L	B2-LW
13	Wing1R	B2-LW
14	Wing2L	B2-LW
15	Wing2R	B2-LW
16	Wing3L	B2-LW
17	Wing3R	B2-LW
18	Wing4L	B2-LW
19	Wing4R	B2-LW
20	Wing5L	B2-LW
21	Wing5R	B2-LW
22	Aileron_1L	B2-LW
23	Aileron_1R	B2-LW
24	Aileron_2L	B2-LW
25	Aileron_2R	B2-LW
26	Aileron_3L	B2-LW
27	Aileron_3R	B2-LW
28	HTP1L	B2-LW
29	HTP1R	B2-LW
30	HTP2L	B2-LW
31	HTP2R	B2-LW
32	HTP3L	B2-LW
33	HTP3R	B2-LW
34	Elev1L	B2-LW
35	Elev1R	B2-LW
36	Exhaust_1	C
37	Exhaust_2	C
38	Tundra_rim	C
39	Tundra tyre	C
40	Strut	C
41	Horn	C
42	Rudder_hinge	C
43	TyreD25	C
44	RimD25	C
45	Root_foot	C
46	LG_Fitting	C
47	Motor_holder	C
48	Servo_holder_fus	C
49	Servo_holder_wing	C
50	Pattern_LG2	C
51	Pattern_LG1_L	C
52	Pattern_LG1_R	C
53	Canopy	B2-LW
54	Lock_1	C
55	Lock_2	C
56	Axis_elevator	C
57	Tundra tyre alaskan	C
58	Anchor_nut_lower	C
59	Anchor_nut_top	C
60	Hinge_wing	C
61	Axis_wing	C
62	Guide	C
63	TE_lock	C

PRINTING PARAMETER	CATEGORY
	B2-LW C
Layer height (mm)	0.25 0.13
Bottom layers	4 4
Top layers	0 6
Wall lines / perimeter	1 2
Nozzle diameter (mm)	0.4 0.4
Material	LW-PLA PLA/PETG TPU/ABS
Infill density (%)	0 10
Printing temp (°C)	235 205 to 240
Bed temp (°C)	60 60
Spiralize Outer Contour / vase mode	YES NO
Flow (%)	53 100
Retraction (mm)	0.5 to 3 3
Retraction extra prime amount (mm)	0 to 0.7 0
Speed (mm/s)	55 25 to 50
Fan	YES YES
Brim (mm)	3 to 5 0 to 3
Minimum layer time (s)	5 5
Support	NO NO