



ITEM	NAME	CATEGORY	
11	1	Canopy_1	A / A-LW
11	2	Canopy_2	A / A-LW
11	3	Canopy_1_p	A / A-LW
11	4	Canopy_2_p	A / A-LW
	5	WingC_1_p	A / A-LW
	6	WingC_2_p	A
	7	WingC_3_p	A
	8	Wing_1L	A
	9	Wing_1R	A
	10	Latch_1L	C
	11	Latch_1R	C
	12	Latch_2L	C
	13	Latch_2R	C
	14	Latch_bolt_1L	C
	15	Latch_bolt_1R	C
	16	Wing_2L	A / A-LW
	17	Wing_2R	A / A-LW
	18	Wing_3L	A / A-LW
	19	Wing_3R	A / A-LW
	20	Wing_4L	A / A-LW
	21	Wing_4R	A / A-LW
	22	Wingtip_1L	A / A-LW
	23	Wingtip_1R	A / A-LW
	24	Wingtip_2L	A / A-LW
	25	Wingtip_2R	A / A-LW
13	26	Elevon_1L	A / A-LW
13	27	Elevon_1R	A / A-LW
13	28	Elevon_2L	A / A-LW
13	29	Elevon_2R	A / A-LW
9	30	VTX_holder	C
9	31	VTX_clamp	C
	32	Cover_V2	C/ C-LW
	33	Spinner2	C
	34	Spinner1	C
	35	Servo_holder	C
	36	Motor_holder	C
	37	Cam_holder	C
	38	FC_holder_24X24	C/ C-LW
	39	FC_holder_30X30	C/ C-LW
	40	FC_clamp	C
	41	Wheel	C/ C-LW
10	42	Tyre	C
	43	Rim	C/ C-LW
	44	LG_Fork	C
	45	LG_bolt	C
	46	MLG_L	C
	47	MLG_R	C
	48	MLG_L_root	C
	49	MLG_R_root	C
	50	NLG1	C
	51	NLG2	C
	52	NLG_block	C
	53	NLG_fitting	C
	54	Keel_1	C
	55	Keel_2	C
	56	Cover	C/ C-LW
	57	Door_lock_1	C
	58	Door_lock_2	C
	59	Guide	C

- 13 Add 2 top layers
- 12 Add 8 bottom layers
- 11 Add 2 bottom layers
- 10 Use flexible material
- 9 Use heat resistant material like ABS or PETG (parts marked with this flag note)
Not necessary for "motor holder" if you respect our prop /motor kv recommendation

- 8- The tension of the nose suspension should be low in order to reduce the risk of rebound when landing
- 7- The latching mechanism should be tight in order to reduce the risk of flutter.
If necessary, adjust the flow rate (extrusion multiplier) of latching parts and wing 1&2 in order to achieve that goal. The main tightness should be provided by the 2 carbon fiber tubes.
- 6- Do not print LW-PLA parts at the same time with others to avoid stringing in the outer surface.
- 5- Do not use retraction values higher than 3mm for LW-PLA parts because the risk of clogging increases.
- 4- Stringing can not be eliminated for LW-PLA material.
- 3- 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	C-LW	C
Layer height (mm)	0.25	0,2	0,15	0,13
Bottom layers	0	0	4	4
Top layers	0	0	6	6
Wall lines / perimeter	1	1	2	2
Nozzle diameter (mm)	0,4	0,4	0,4	0,4
Material	LW-PLA	PLA/ PETG	LW-PLA	PLA/PETG /ABS
Infill density (%)	0	0	10	10
Printing temp (°C)	235	220	230	205 to 240
Bed temp (°C)	60	60	60	60
Flow (%)	53	100	53	100
Retraction (mm)	0,5 to 6	0,5 to 6	0,5 to 6	0,5 to 6
Retraction extra prime amount (mm)	0	0 to 0,7	0	0
Speed (mm/s)	40	50	35	25 to 50
Fan	YES	YES	YES	YES
Brim (mm)	3	3	0 to 3	0 to 3
Support	NO	NO	NO	NO

