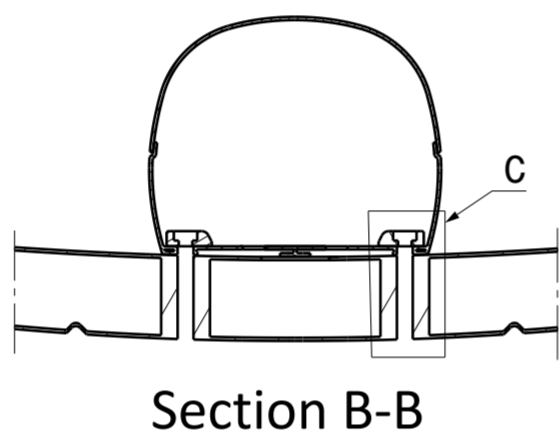
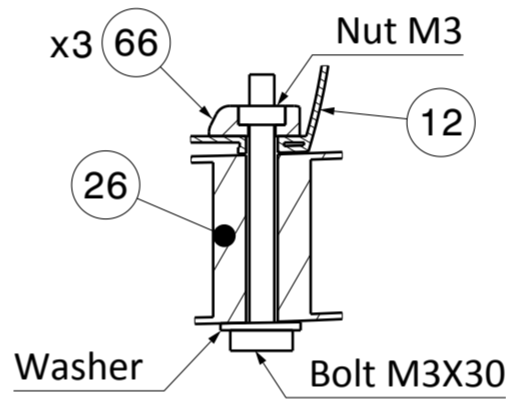


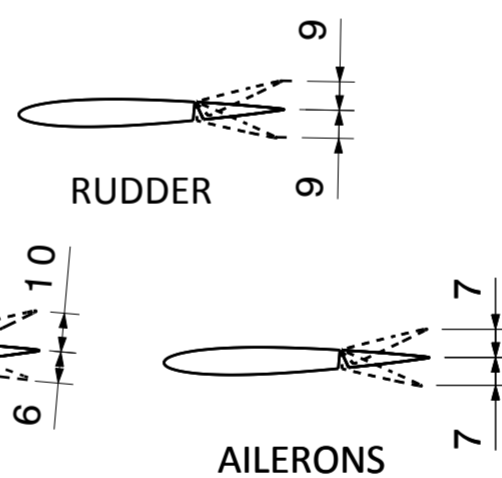
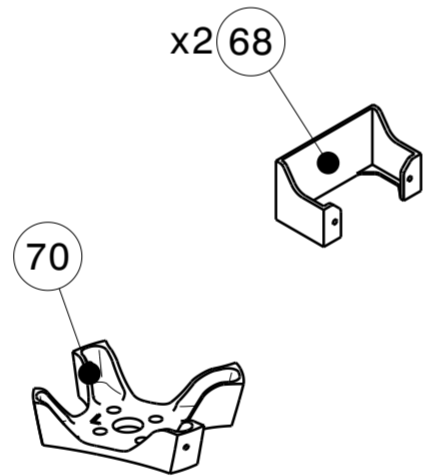
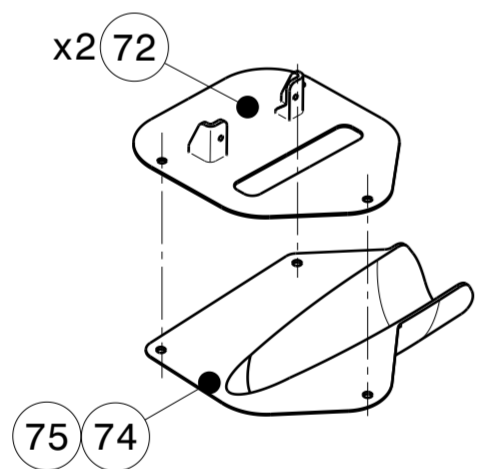
Detail A
(Item 4/6 hidden)



Section B-B



Detail C
(Typical detail for interface between fuselage and wing)



Recommended throw

ITEM	NAME	CATEGORY
0	Spinner1	B / B-LW
2	Spinner2	B
4	Fus1	A / A-LW
6	Fus1_intake	A / A-LW
8	Canopy1	B / B-LW
10	Canopy2	B / B-LW
12	Fus2	A / A-LW
14	Fus3	A / A-LW
16	Fus4	A / A-LW
18	Fus5	A / A-LW
20	VTP	B / B-LW
22	Rudder	B / B-LW
24	MLG_L	C
25	MLG_R	C
26	WingC	A / A-LW
28	Wing1L	A / A-LW
29	Wing1R	A / A-LW
30	Wing2L	A / A-LW
31	Wing2R	A / A-LW
32	Wing3L	A / A-LW
33	Wing3R	A / A-LW
34	Aileron1L	B / B-LW
35	Aileron1R	B / B-LW
36	Aileron2L	A / A-LW
37	Aileron2R	A / A-LW
38	HTP	B / B-LW
40	Elev1L	B / B-LW
42	Elev2R	B / B-LW
44	Elev3R	A / A-LW
46	NLG_fitting	C
48	NLG_bushing	C
50	NLG1	C
51	NLG2	C
52	Fork_D1,4	C
54	Fork_D2,3	C
56	NLG_bolt	C
58	Wheel	C / C-LW
60	Tyre	C
62	Rim	B / B-LW
64	Axis_locker	C
66	Anchor_nut_M3	C
68	Servo_holder_fus	C
70	Motor_holder	C
72	Servo_holder_Wing	B / B-LW
74	Horn_cover_L	C
75	Horn_cover_R	C
76	NLG_cap	B / B-LW

- 11 Print "tyre" with flexible material.
- 10 If you use the spinner is recommended to use "fus1_intake" if air temperature is greater than 25°C in order to cool down the electronic.
- 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-Center of gravity marking under the wing

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

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

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

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 FLEX/ABS
Infill density (%)	0	0	0	0	10	10
Printing temp (°C)	240	220	240	220	240	205 to 240
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
Fan	YES	YES	YES	YES	YES	YES
Brim (mm)	3	3	0 to 3	0 to 3	0 to 3	0 to 3
Minimum layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO