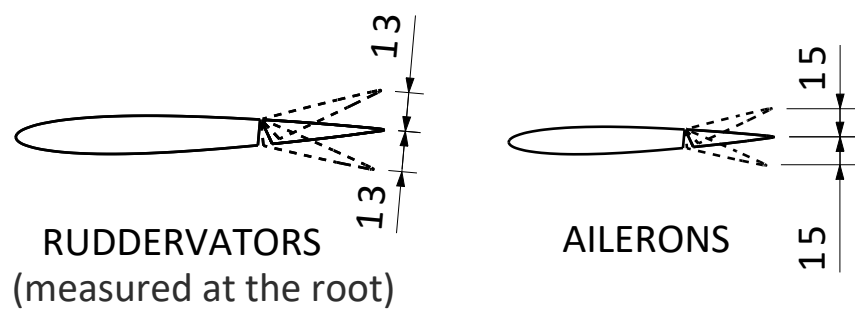
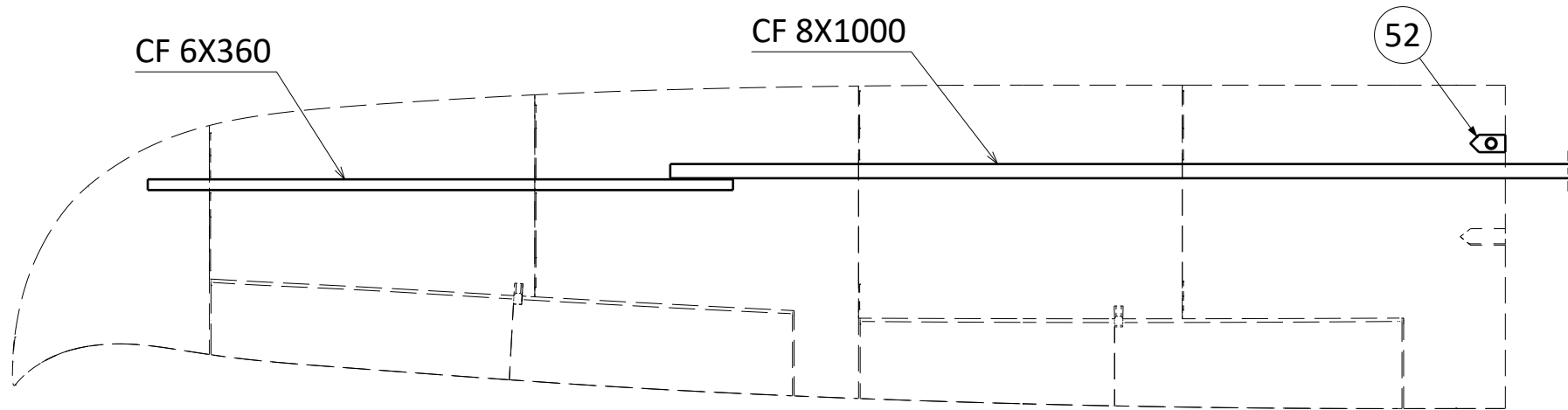
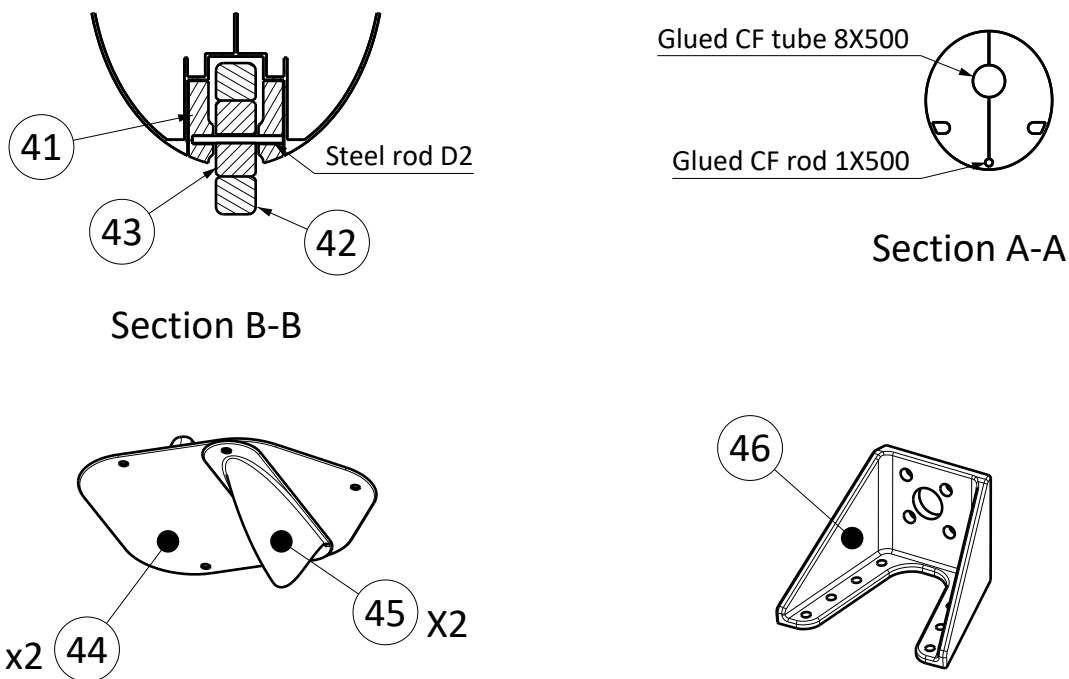
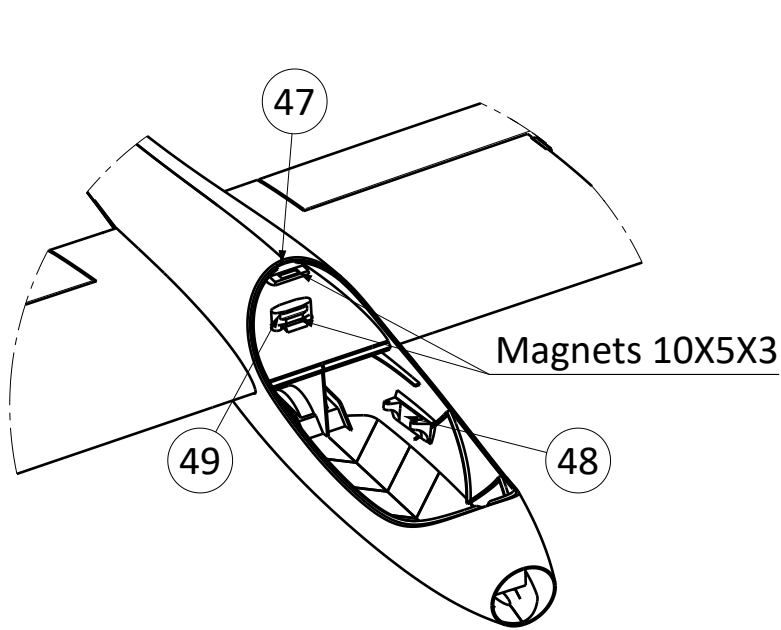
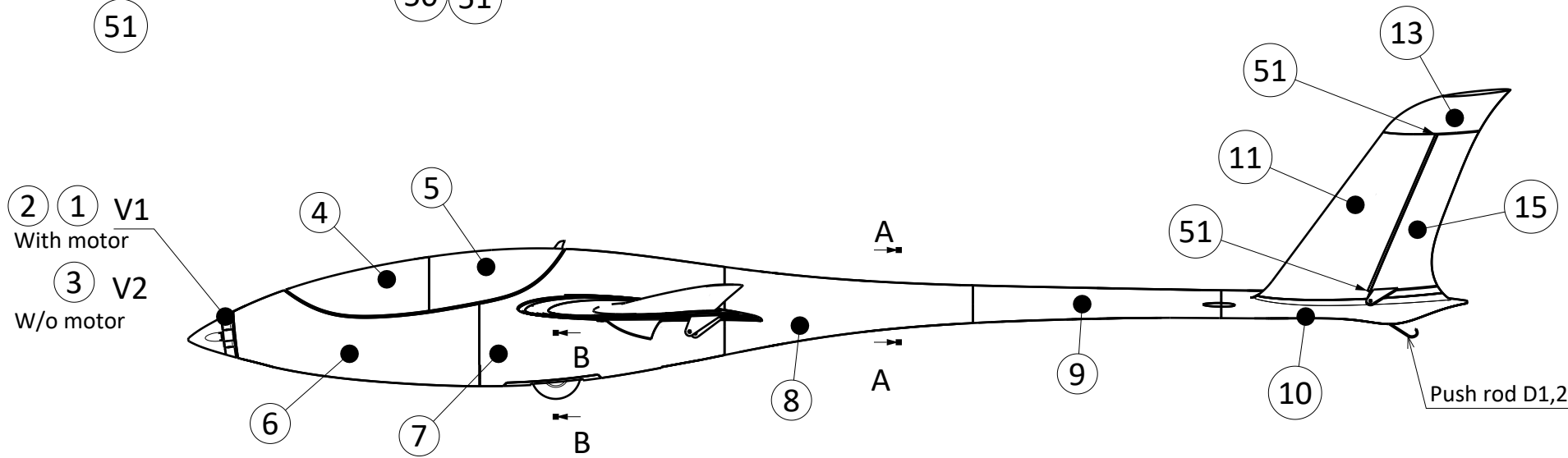
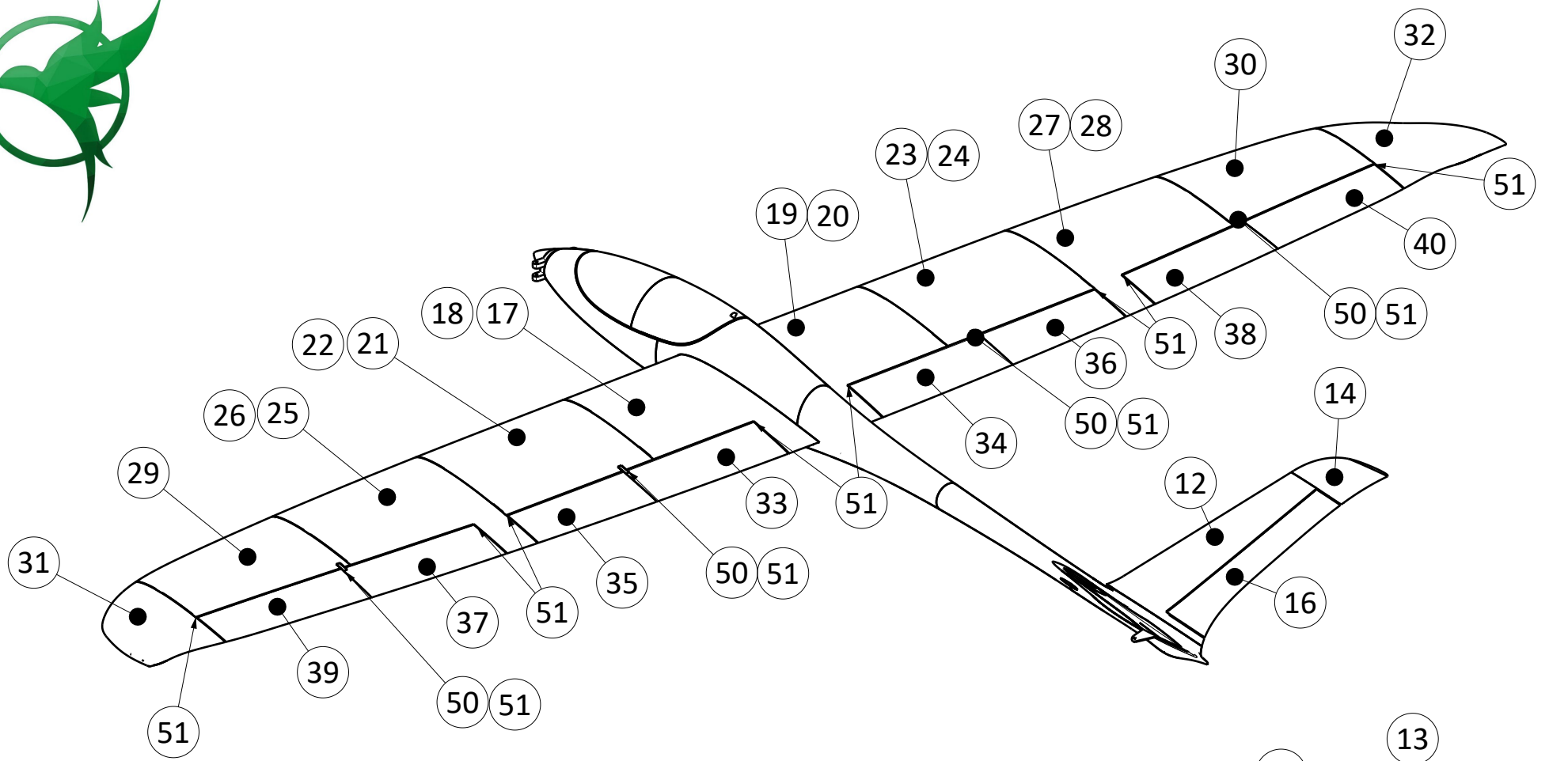




8 - Version without flaps

7 - Add 4 top layers

6 - Add 8 bottom layers

5 - Add 2 bottom layers

4 - Print "tyre" with flexible material

3 - If your motor reach temperatures over 50 °C use ABS

2 - Center of gravity marking under the wing

1 - This document shows the basic printing settings to be used and the final position of each part

Recommended throw

| PRINTING PARAMETER                  | CATEGORY |              |                      |
|-------------------------------------|----------|--------------|----------------------|
|                                     | A-LW     | A            | C                    |
| Layer height (mm)                   | 0.25     | 0,2          | 0,13                 |
| Bottom layers                       | 0        | 0            | 4                    |
| Top layers                          | 0        | 0            | 6                    |
| Wall lines / perimeter              | 1        | 1            | 2                    |
| Nozzle diameter (mm)                | 0,4      | 0,4          | 0,4                  |
| Material                            | LW-PLA   | PLA/<br>PETG | PLA/PETG<br>FLEX/ABS |
| Infill density (%)                  | 0        | 0            | 10                   |
| Printing temp (°C)                  | 235      | 220          | 205 to 240           |
| Flow (%)                            | 53       | 100          | 100                  |
| Speed (mm/s)                        | 55       | 50           | 25 to 50             |
| Support                             | NO       | NO           | NO                   |
| Spiralize Outer Contour / vase mode | NO       | NO           | NO                   |

| ITEM | NAME             | CATEGORY |
|------|------------------|----------|
| 1    | Spinner          | C        |
| 2    | Prop_hub         | C        |
| 3    | Nose             | A / A-LW |
| 4    | Canopy_1         | A / A-LW |
| 5    | Canopy_2         | A / A-LW |
| 6    | Fus1             | A / A-LW |
| 7    | Fus2             | A / A-LW |
| 8    | Fus3             | A / A-LW |
| 9    | Fus4             | A / A-LW |
| 10   | Fus5             | A / A-LW |
| 11   | Stab_1L          | A / A-LW |
| 12   | Stab_1R          | A / A-LW |
| 13   | Stab_2L          | A / A-LW |
| 14   | Stab_2R          | A / A-LW |
| 15   | Ruddervator_LH   | A / A-LW |
| 16   | Ruddervator_RH   | A / A-LW |
| 17   | Wing1L           | A / A-LW |
| 18   | Wing1L_F         | A / A-LW |
| 19   | Wing1R           | A / A-LW |
| 20   | Wing1R_F         | A / A-LW |
| 21   | Wing2L           | A / A-LW |
| 22   | Wing2L_F         | A / A-LW |
| 23   | Wing2R           | A / A-LW |
| 24   | Wing2R_F         | A / A-LW |
| 25   | Wing3L           | A / A-LW |
| 26   | Wing3L_F         | A / A-LW |
| 27   | Wing3R           | A / A-LW |
| 28   | Wing3R_F         | A / A-LW |
| 29   | Wing4L           | A / A-LW |
| 30   | Wing4R           | A / A-LW |
| 31   | Wing5L           | A / A-LW |
| 32   | Wing5R           | A / A-LW |
| 33   | Flap1L           | A / A-LW |
| 34   | Flap1R           | A / A-LW |
| 35   | Flap2L           | A / A-LW |
| 36   | Flap2R           | A / A-LW |
| 37   | Aileron1L        | A / A-LW |
| 38   | Aileron1R        | A / A-LW |
| 39   | Aileron2L        | A / A-LW |
| 40   | Aileron2R        | A / A-LW |
| 41   | LG_root          | C        |
| 42   | TyreD40          | C        |
| 43   | RimD40           | C        |
| x4   | Servo_holde_wing | C        |
| x4   | Cover_horn       | C        |
| 3    | Motor_holder     | C        |
| 47   | Magnet_support   | C        |
| x2   | Servo_holder_fus | C        |
| 49   | LG_Pin           | C        |
| x4   | Hinge_wing       | C        |
| x16  | Axis             | C        |
| x2   | LG_pin_box       | C        |