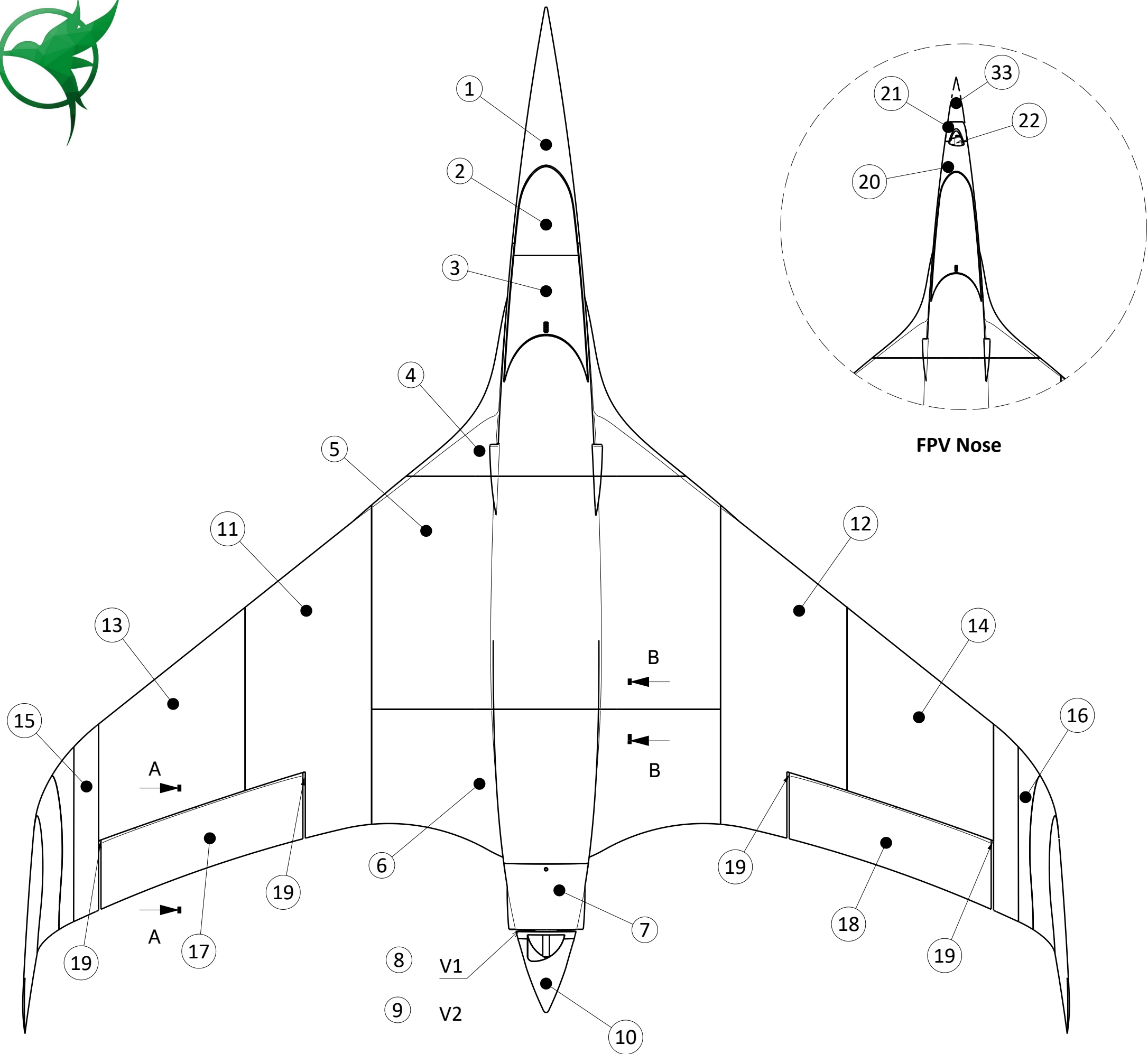
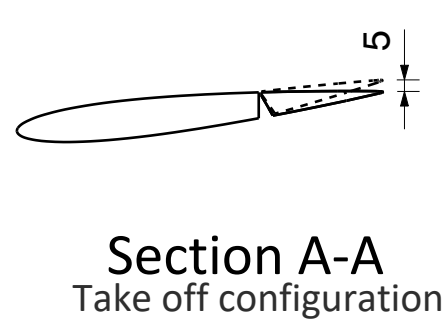
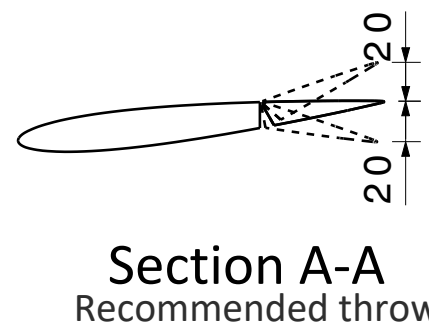
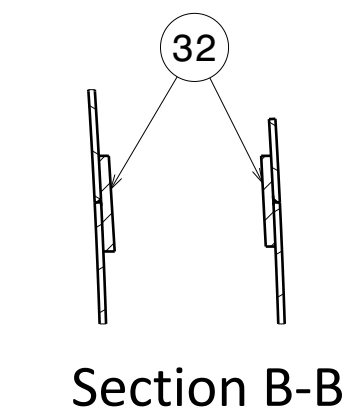
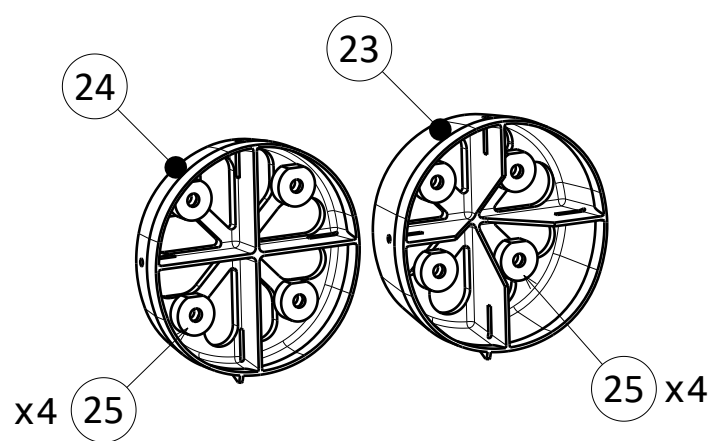
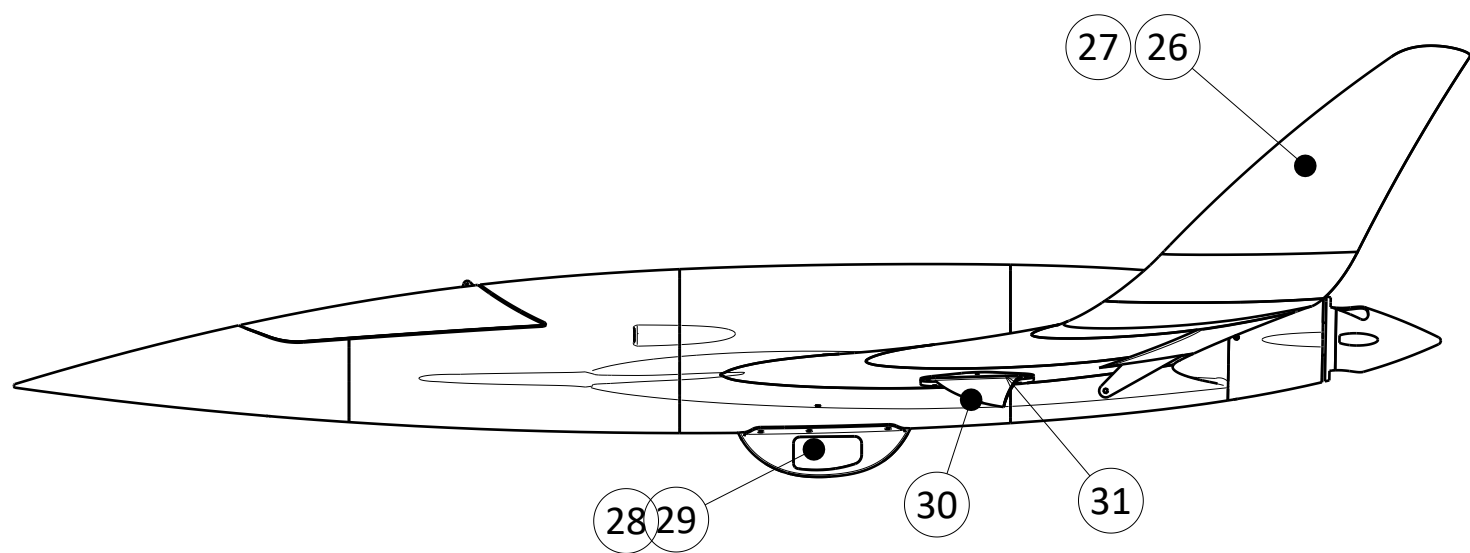




7

ITEM	NAME	CATEGORY
1	Fus1	A / A-LW
2	Canopy1	B / B-LW
3	Canopy2	B / B-LW
4	Fus2	A / A-LW
5	Fus3	A / A-LW
6	Fus4	A / A-LW
7	Motor_cowling	A / A-LW
8	Spinner2_D5	C
9	Spinner2_D6	C
10	Spinner1	B
11	Wing1L	A / A-LW
12	Wing1R	A / A-LW
13	Wing2L	A / A-LW
14	Wing2R	A / A-LW
15	Wingtip_1L	A / A-LW
16	Wingtip_1R	A / A-LW
17	ElevonL	B / B-LW
18	ElevonR	B / B-LW
19	Axis_hinge	C
20	Fus1_FPV	A / A-LW
21	Camera cowling	A / A-LW
22	TX02_holder	C
23	Motor_mount_D28	C
24	Motor_mount_D35	C
25	Anchor_nut_M3	C
26	Wingtip_2L	A / A-LW
27	Wingtip_2R	A / A-LW
28	Keel_1	C
29	Keel_2	C
30	Cover horn	C
31	Servo_holder_5h	C
32	Guide	C
33	Cone	A / A-LW



9 - If you can not use fan, ensure enough time between layers to cool down material

8 - If you can not heat the bed use Spray Adhesive

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

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

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	6	7	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 /ABS
Infill density (%)	0	0	0	0	10	10
Printing temp (°C)	235	220	235	220	230	205 to 240
Flow (%)	53	100	53	100	53	100
Speed (mm/s)	40	50	40	50	35	25 to 50
Support	NO	NO	NO	NO	NO	NO
Spiralize Outer Contour / vase mode	NO	NO	NO	NO	NO	NO