



ITEM	NAME	CATEGORY
1	WingC	A
2	Wing1L	A / A-LW
3	Wing1R	A / A-LW
4	Wing2L	A / A-LW
5	Wing2R	A / A-LW
6	Wing3L	A / A-LW
7	Wing3R	A / A-LW
8	Wing4L	A / A-LW
9	Wing4R	A / A-LW
10	Elevon_1L	B / B-LW
11	Elevon_1R	B / B-LW
12	Elevon_2L	A / A-LW
13	Elevon_2R	A / A-LW
14	Elevon_3L	A / A-LW
15	Elevon_3R	A / A-LW
16	Keel_R	C
17	Keel_L	C
18	Canopy_FPV_1	B
19	Canopy_FPV_2	B
20	Canopy_motor_1	B
21	Canopy_motor_2	B
22	Canopy_1	B
23	Canopy_2	B
24	Guide	C
25	TX02_holder	C
26	Spinner2	C
27	Spinner1	C
28	Motor_holder	C
29	Servo_holder_fus	C
30	Servo_holder_Wing	C
31	I_canopy_1	B
32	I_canopy_2	B
33	I_canopy_fpv_1	B
34	I_canopy_fpv_2	B
35	I_canopy_motor_1	B
36	I_canopy_motor_2	B

- 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- 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	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
Bed temp (°C)	60	60	60	60	60	60
Flow (%)	53	100	53	100	53	100
Retraction (mm)	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
Minimun layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO