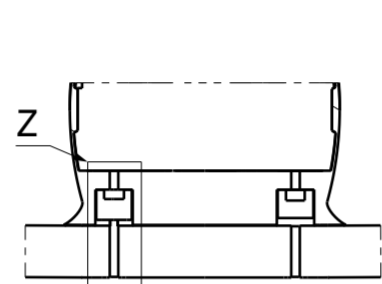
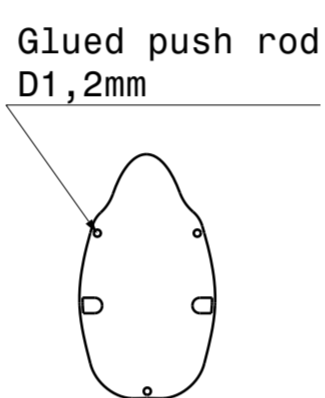


**Detail Z**

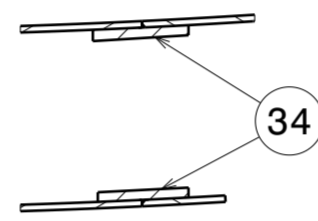
(Typical detail for interface between fuselage and wing)



**Section A-A**

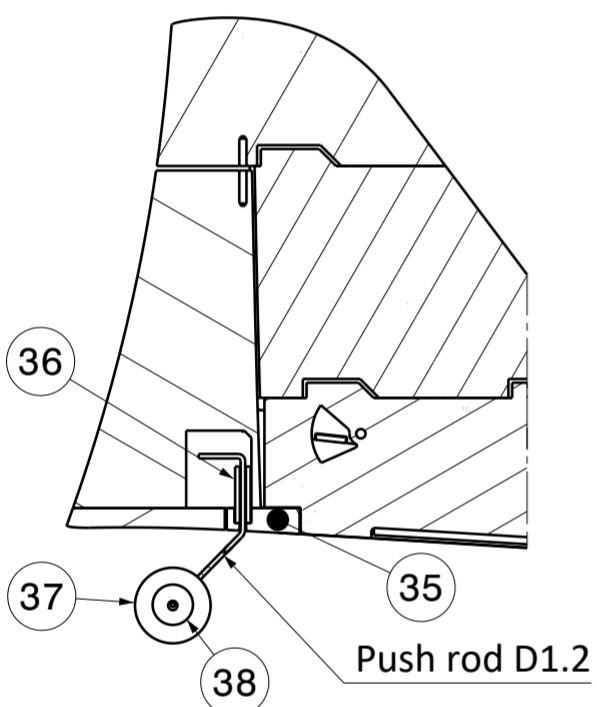


**Section C-C**

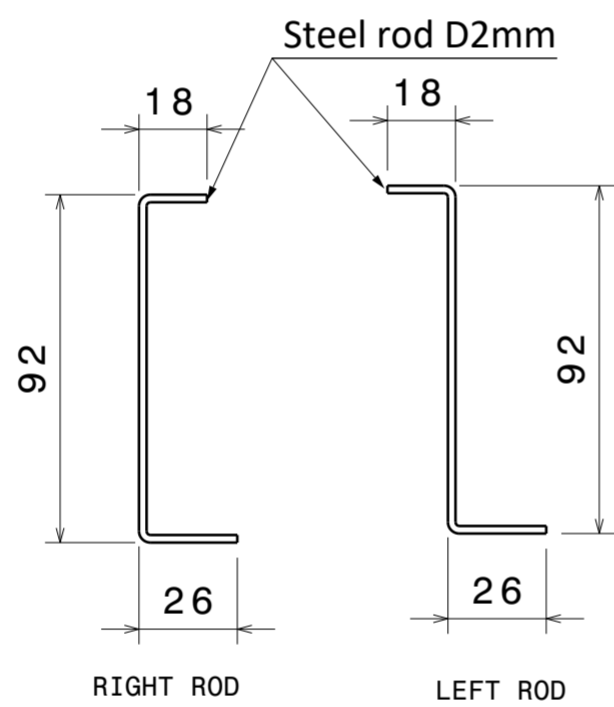


**Section B-B**

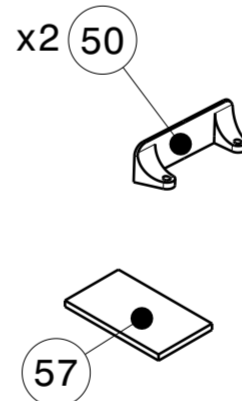
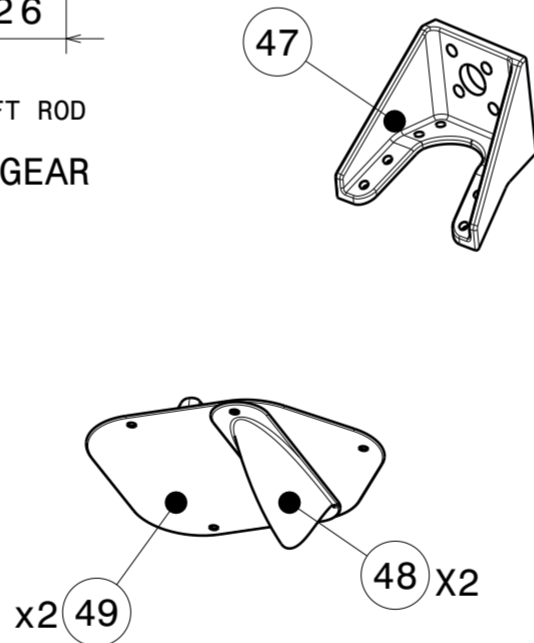
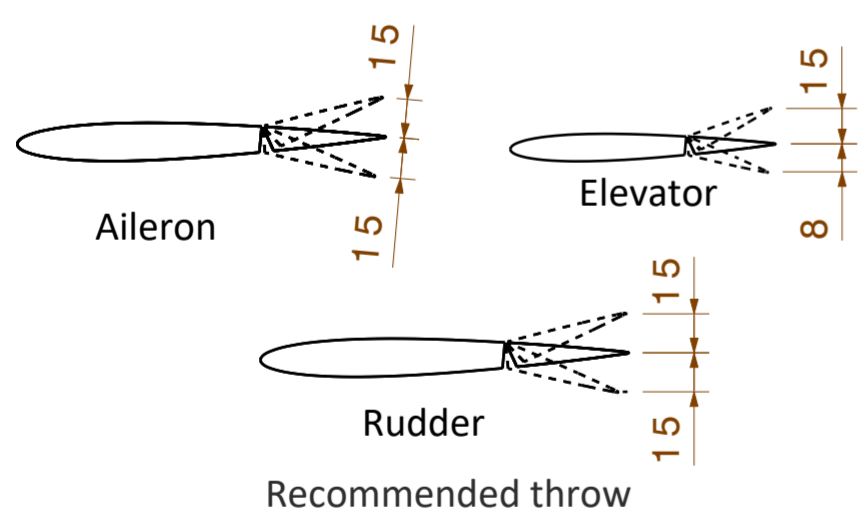
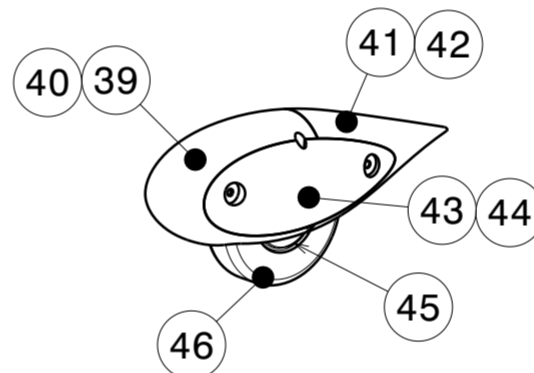
(Concept valid also for joint between WingC and Wing1R)



**TAIL SECTION**



**MAIN LANDING GEAR**



ITEM	NAME	CATEGORY
1	Spinner1	C
2	Spinner2	C
3	Canopy1	A / A-LW
4	Canopy2	A / A-LW
5	Fus1	A / A-LW
6	Fus2	A / A-LW
7	Fus3	A / A-LW
8	Fus4	A / A-LW
9	Fus5	A / A-LW
10	VTP_1	A / A-LW
11	VTP_2	A / A-LW
12	Rudder_2	A / A-LW
13	Rudder_1	A / A-LW
14	WingC	A / A-LW
15	Wing1L	A / A-LW
16	Wing1R	A / A-LW
17	Wing2L	A / A-LW
18	Wing2R	A / A-LW
19	Wing3L	A / A-LW
20	Wing3R	A / A-LW
21	Aileron1L	A / A-LW
22	Aileron1R	A / A-LW
23	Aileron2L	A / A-LW
24	Aileron2R	A / A-LW
25	Aileron3L	A / A-LW
26	Aileron3R	A / A-LW
27	HTP1L	A / A-LW
28	HTP1R	A / A-LW
29	HTP2L	A / A-LW
30	HTP2R	A / A-LW
31	Elev1L	A / A-LW
32	Elev1R	A / A-LW
33	Anchor_nut	C
34	Guide	C
35	Rudder_fitting	C
36	Axis_w_hole	C
37	Tyre_D20	C
38	RimD20	C
39	Wheel_fairing_1L	C / C-LW
40	Wheel_fairing_1R	C / C-LW
41	Wheel_fairing_2L	C / C-LW
42	Wheel_fairing_2R	C / C-LW
43	Wheel_fairing_3L	C / C-LW
44	Wheel_fairing_3R	C / C-LW
45	RimD40	C
46	TyreD40	C
47	Motor_holder	C
48	Cover_horn	C
49	Servo_holder_wing	C
50	Servo_holder_fus	C
51	Root_LG	C
52	Wing1L_woLG	A / A-LW
53	Wing1R_woLG	A / A-LW
54	Hinge_wing	C
55	Elevator_fitting	C
56	Spinner1_short	C
57	ESC_iso_plate	C

- 11 Add 6 top layers
- 10 Add 8 bottom layers
- 9 Add 2 bottom layers (parts marked with this flag note)
- 8 Print "tyres" with flexible material.
- 6 Print the Item 57 with ABS and place it between the ESC and fuselage to avoid melting the PLA
- 5 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor\_holder"

- 4-Center of gravity marking under the wing.
- 3-Do not print LW-PLA parts at the same time with others to avoid stringing in the outer surface.
- 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	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 FLEX/ABS
Infill density (%)	0	0	10	10
Printing temp (°C)	235	220	235	205 to 240
Bed temp (°C)	60	60	60	60
Flow (%)	53	100	53	100
Retraction (mm)	0,5 to 3	0,5 to 3	0,5 to 3	3
Retraction extra prime amount (mm)	0 to 0,7	0 to 0,7	0	0
Speed (mm/s)	55	50	35	25 to 50
Fan	YES	YES	YES	YES
Brim (mm)	3 to 5	3 to 5	0 to 3	0 to 3
Minimun layer time (s)	5	5	5	5
Support	NO	NO	NO	NO