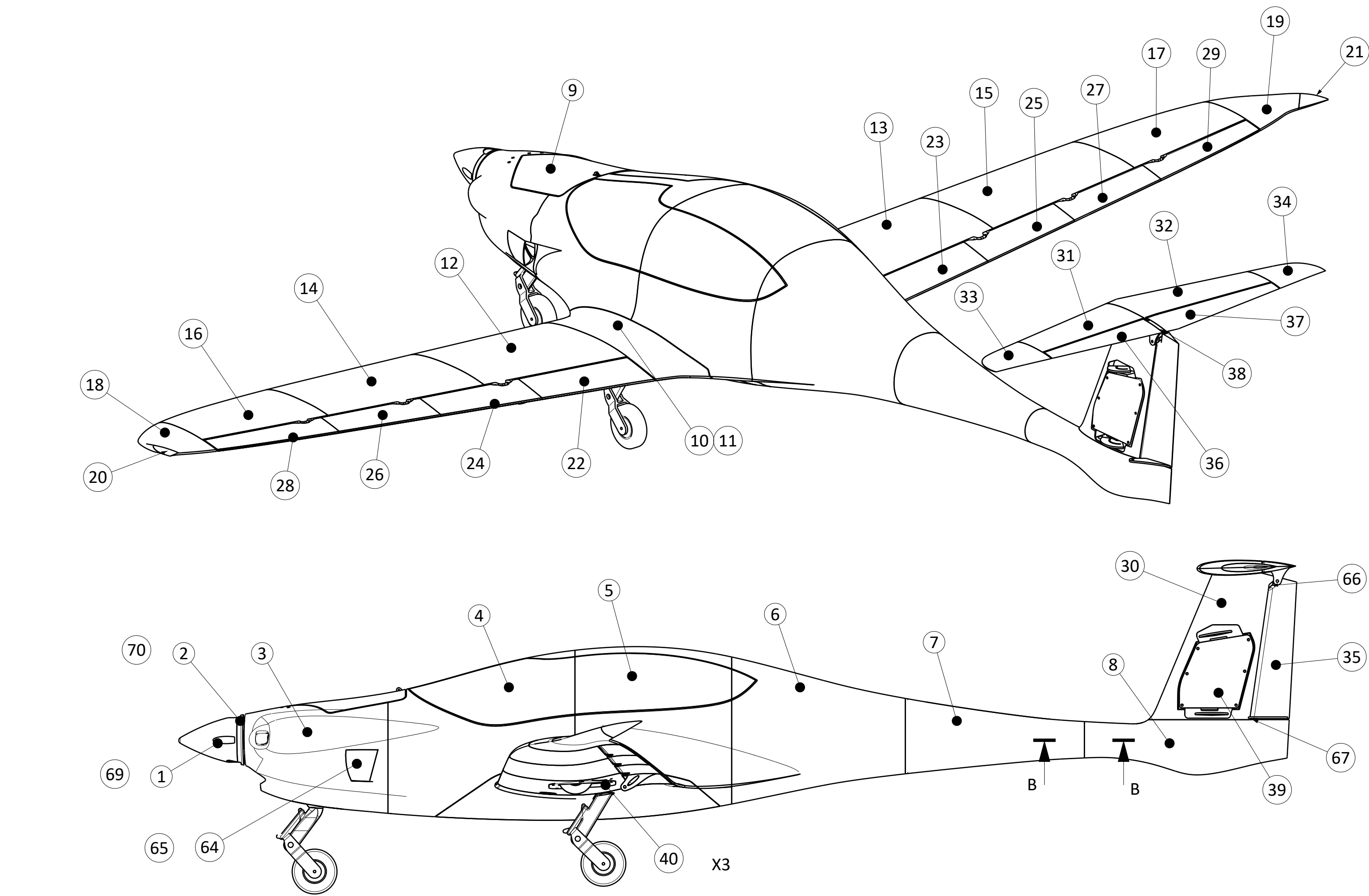
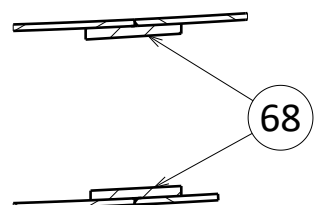
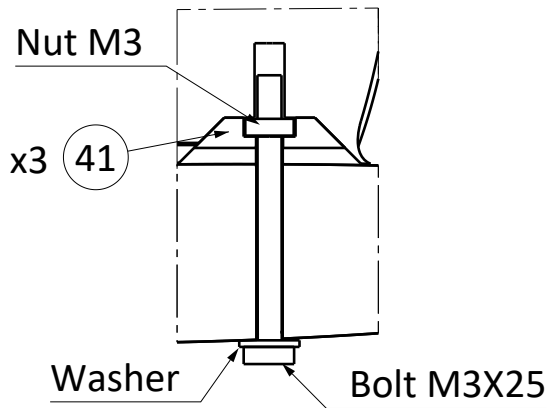
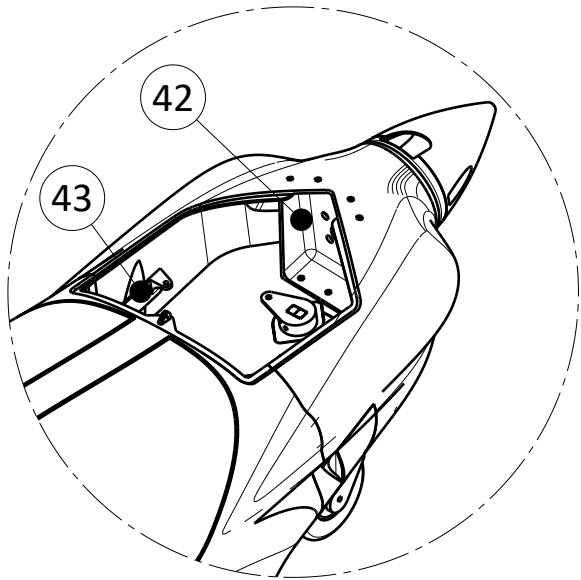


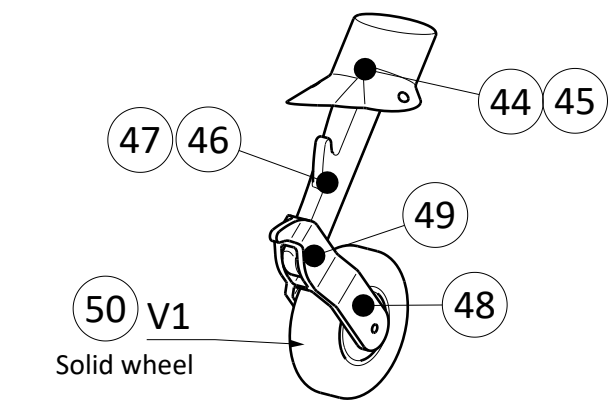
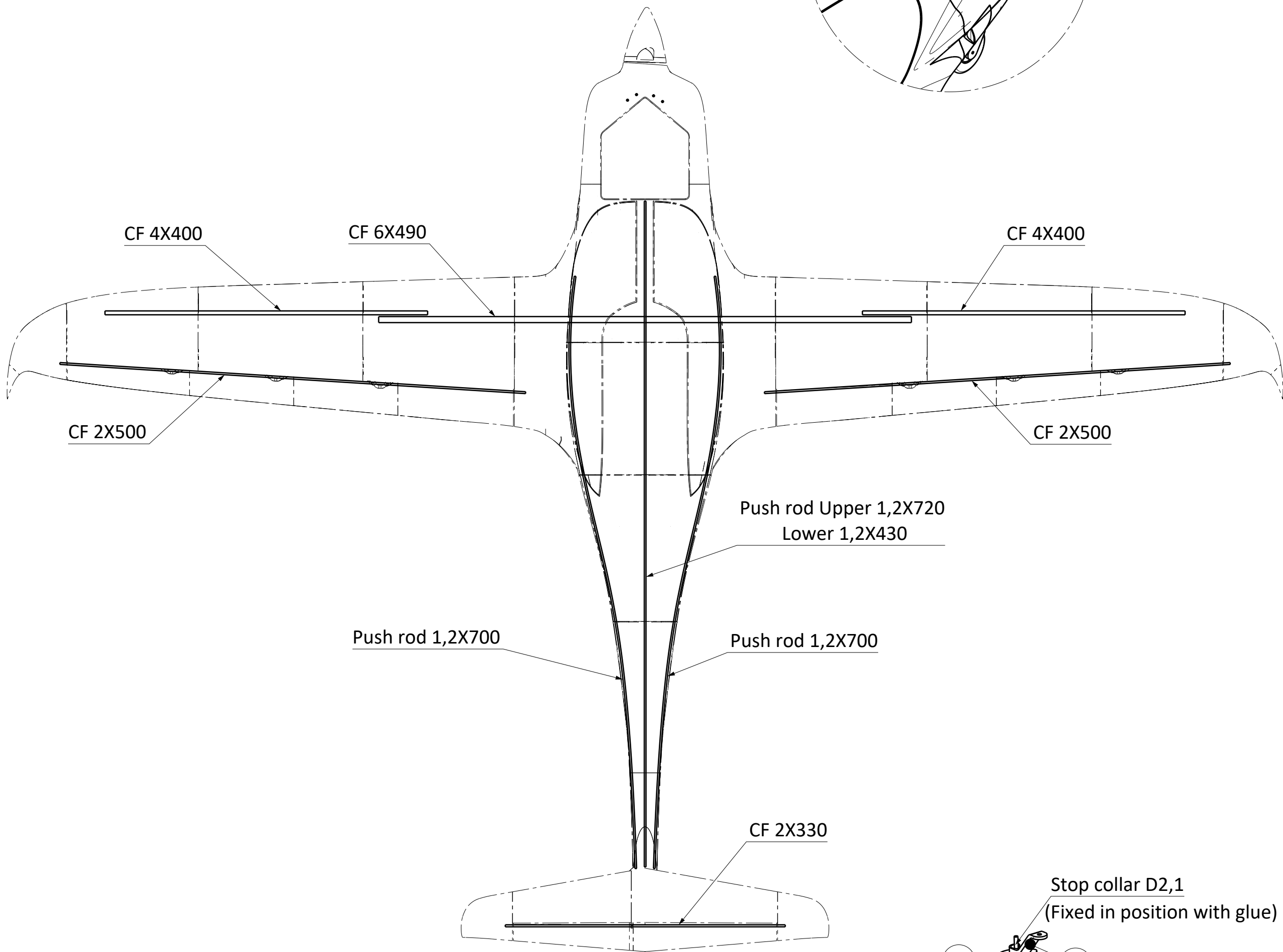
Section A-A



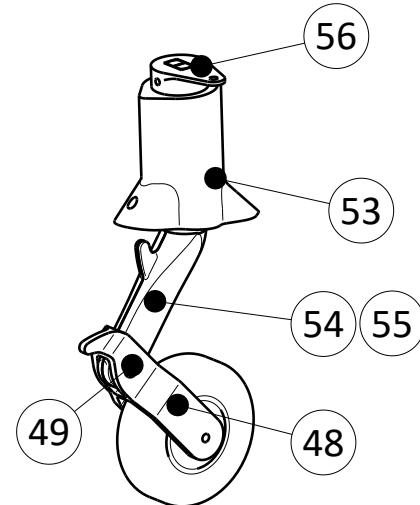
Section B-B



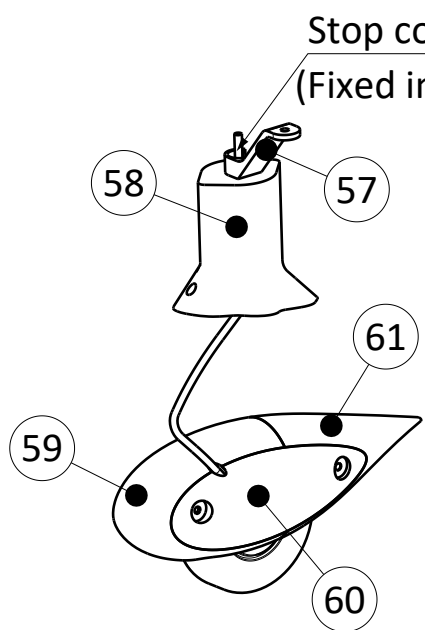
Detail Z
(Typical detail for interface
between fuselage and wing)



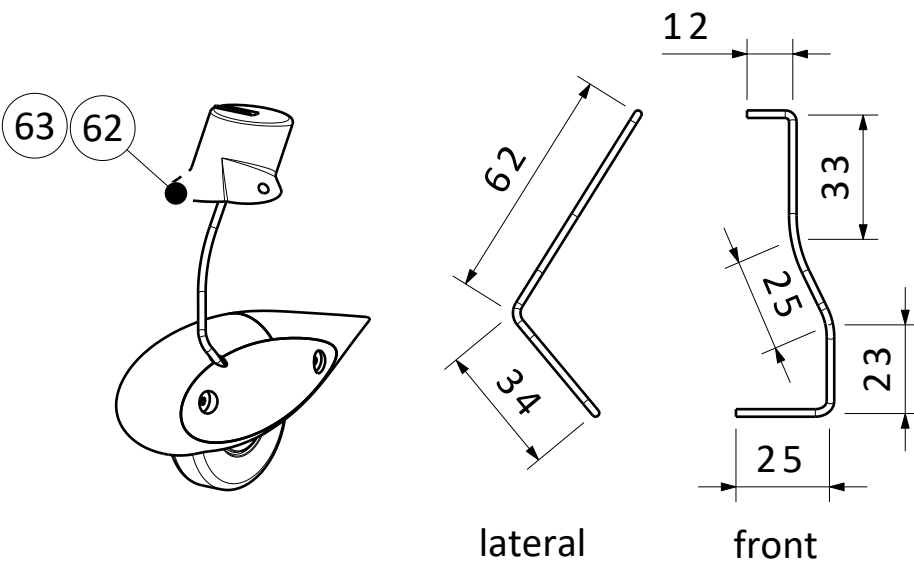
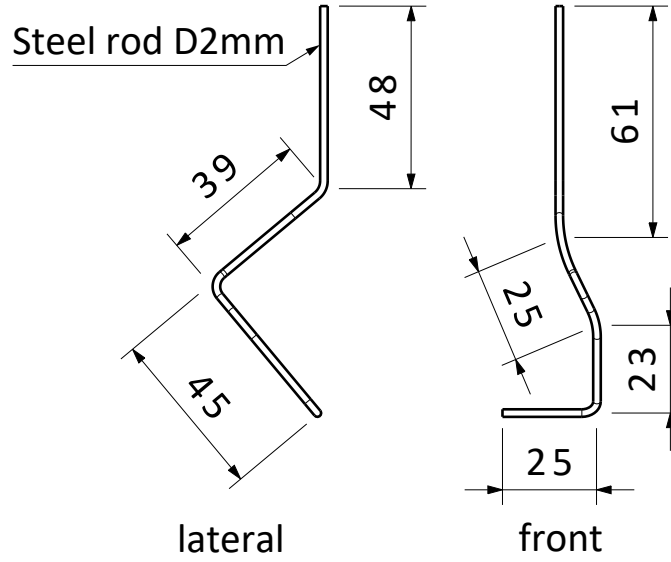
MAIN LANDING GEAR V1



NOSE LANDING GEAR V1



NOSE LANDING GEAR V2



MAIN LANDING GEAR V2

12 - Add 2 top layers

11 - Add 8 bottom layers

10 - Add 2 bottom layers

8 - Print "tyre" with flexible material

6 - If your motor reach temperatures
over 50 °C use ABS or PETG

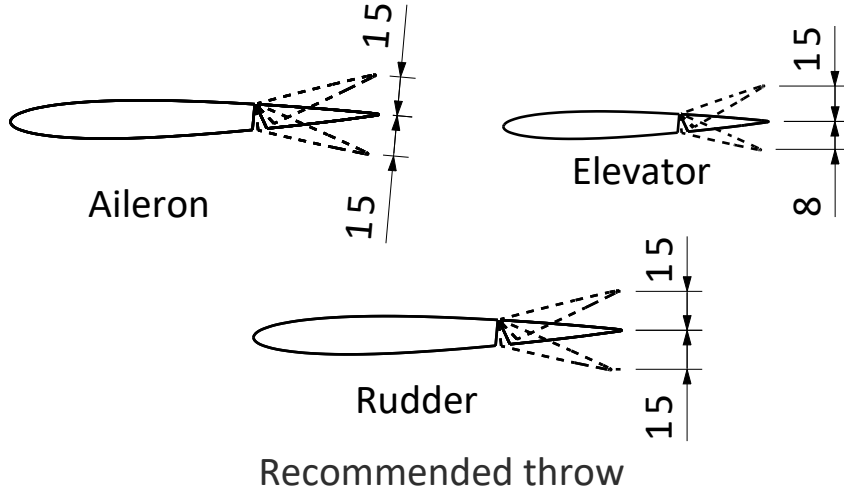
5 - Landing Gear V2 is recomandable over V1

4 - Center of gravity marking under the wing.
It is recommended to set the C.G. 5 mm forward for the maiden flight

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



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
Flow (%)	53	100	53	100
Speed (mm/s)	55	50	35	25 to 50
Support	NO	NO	NO	NO
Spiralize Outer Contour / vase mode	NO	NO	NO	NO

ITEM	NAME	CATEGORY
1	Spinner1	C
2	Spinner2	C
3	Fus1	A
4	Fus2	A / A-LW
5	Fus3	A / A-LW
6	Fus4	A / A-LW
7	Fus5	A / A-LW
8	Fus6	A / A-LW
9	Canopy	A / A-LW
10	Wing1L	A / A-LW
11	Wing1R	A / A-LW
12	Wing2L	A / A-LW
13	Wing2R	A / A-LW
14	Wing3L	A / A-LW
15	Wing3R	A / A-LW
16	Wing4L	A / A-LW
17	Wing4R	A / A-LW
18	Wing5L	A / A-LW
19	Wing5R	A / A-LW
20	WingtipL	A / A-LW
21	WingtipR	A / A-LW
22	Flaperon_1L	A / A-LW
23	Flaperon_1R	A / A-LW
24	Flaperon_2L	A / A-LW
25	Flaperon_2R	A / A-LW
26	Flaperon_3L	A / A-LW
27	Flaperon_3R	A / A-LW
28	Flaperon_4L	A / A-LW
29	Flaperon_4R	A / A-LW
30	VTP	A / A-LW
31	HTP_1L	A / A-LW
32	HTP_1R	A / A-LW
33	HTP_2L	A / A-LW
34	HTP_2R	A / A-LW
35	Rudder	A / A-LW
36	Elevator_L	A / A-LW
37	Elevator_R	A / A-LW
38	Elevator_horn	C
39	Servo_holder_tail	C / C-LW
40	Servo_holder_wing	C
41	Anchor_nut_M3_wing	C
42	Motor_mount	C
43	Servo_holder_fus	C
44	MLG_L_root	C
45	MLG_R_root	C
46	MLG_L	C
47	MLG_R	C
48	LG_Fork	C
49	LG_bolt	C
50	Wheel	C / C-LW
51	Rim	C / C-LW
52	Tyre	C
53	NLG_root	C
54	NLG1	C
55	NLG2	C
56	NLG_horn	C
57	NLG_horn_V2	C
58	NLG_root_V2	C
59	Wheel_fairing_1	C / C-LW
60	Wheel_fairing_3	C / C-LW
61	Wheel_fairing_2	C / C-LW
62	MLG_L_root_V2	C
63	MLG_R_root_V2	C
64	Exhaust_L	C / C-LW
65	Exhaust_R	C / C-LW
66	Axis_hinge_rud_top	C
67	Axis_hinge_rud_bottom	C
68	Guide	C
69	Spinner_1_3b	C
70	Spinner_2_3b	C