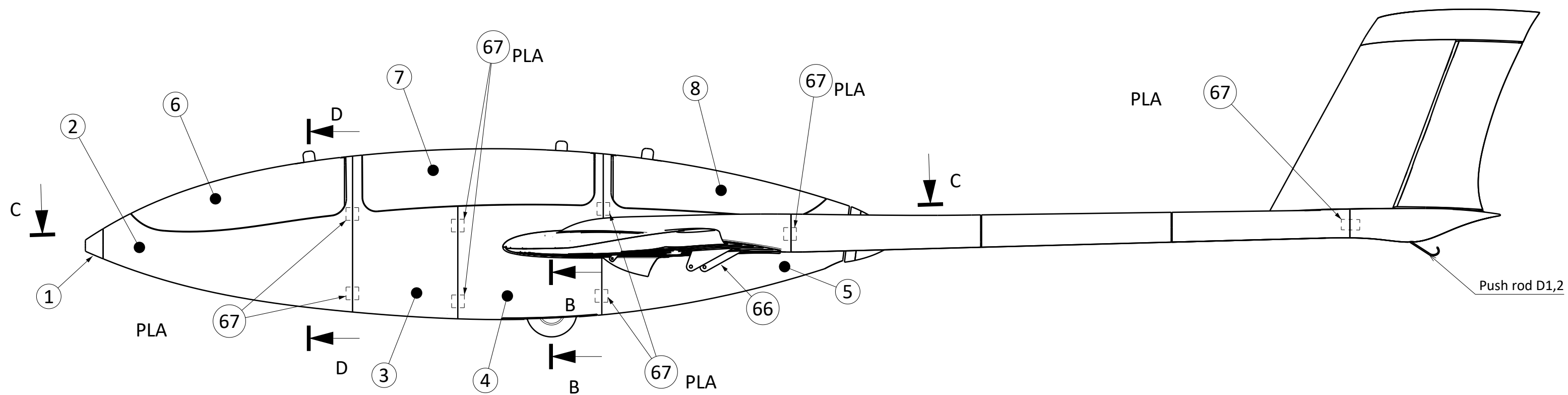
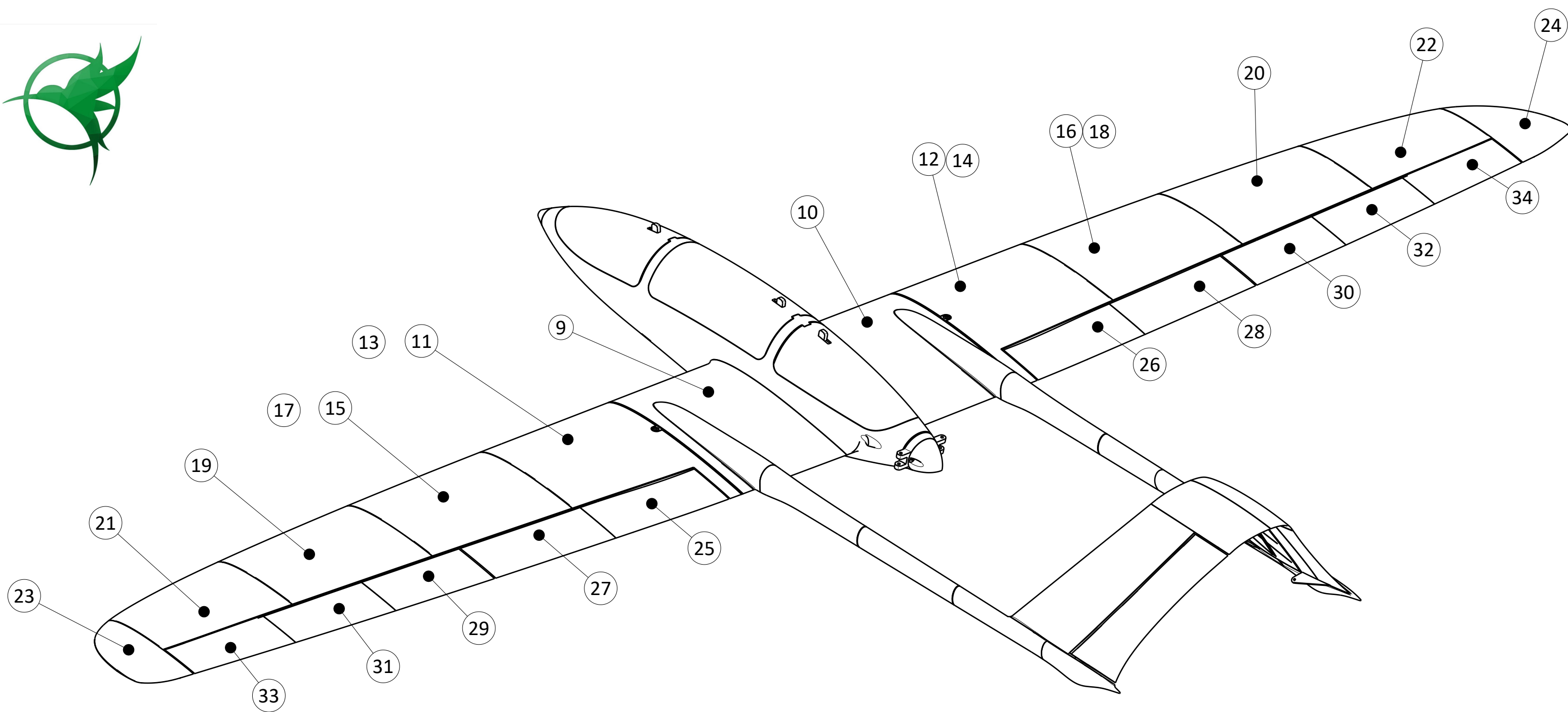
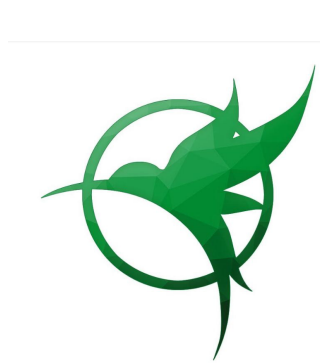
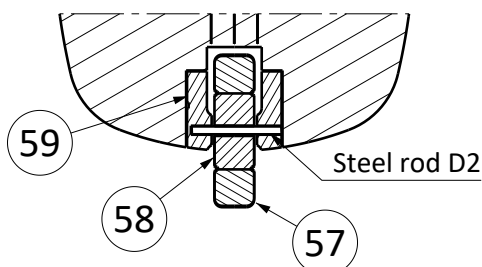
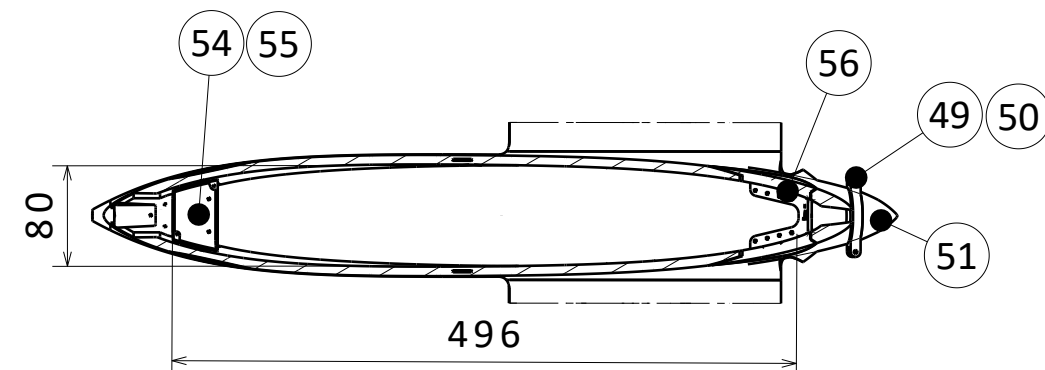


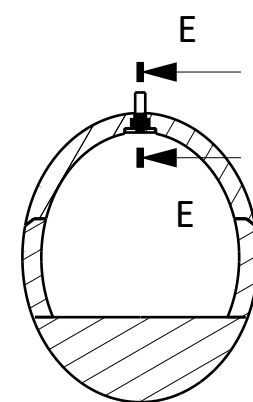
Section A-A



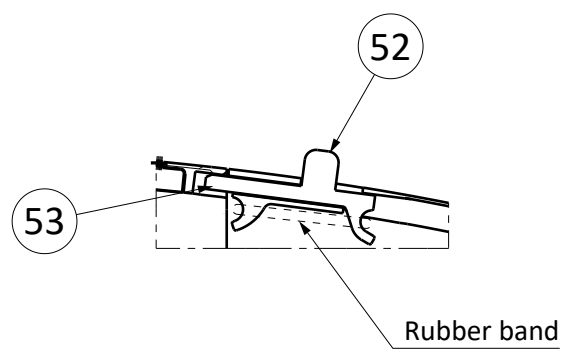
Section B-B



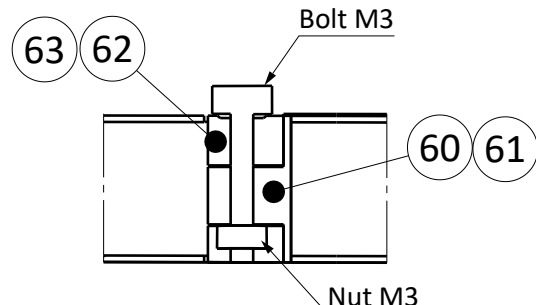
Section C-C
(Internal space available, measured in mm)



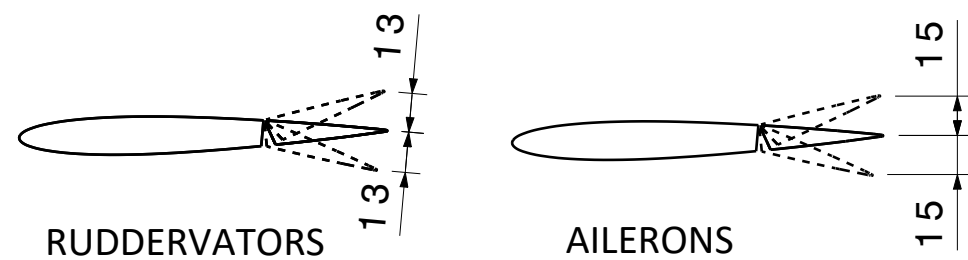
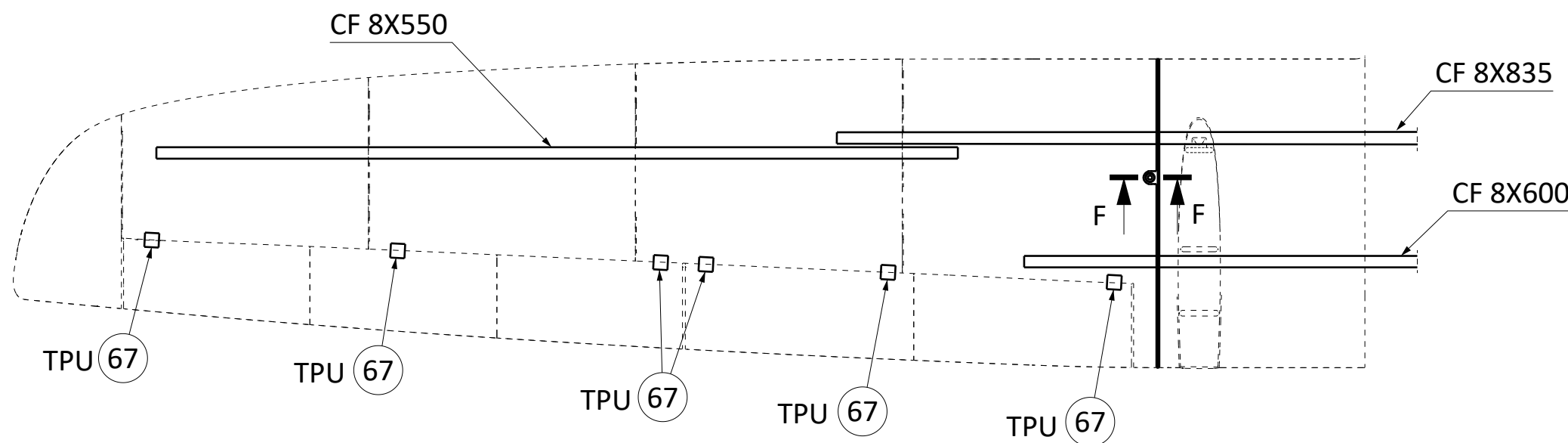
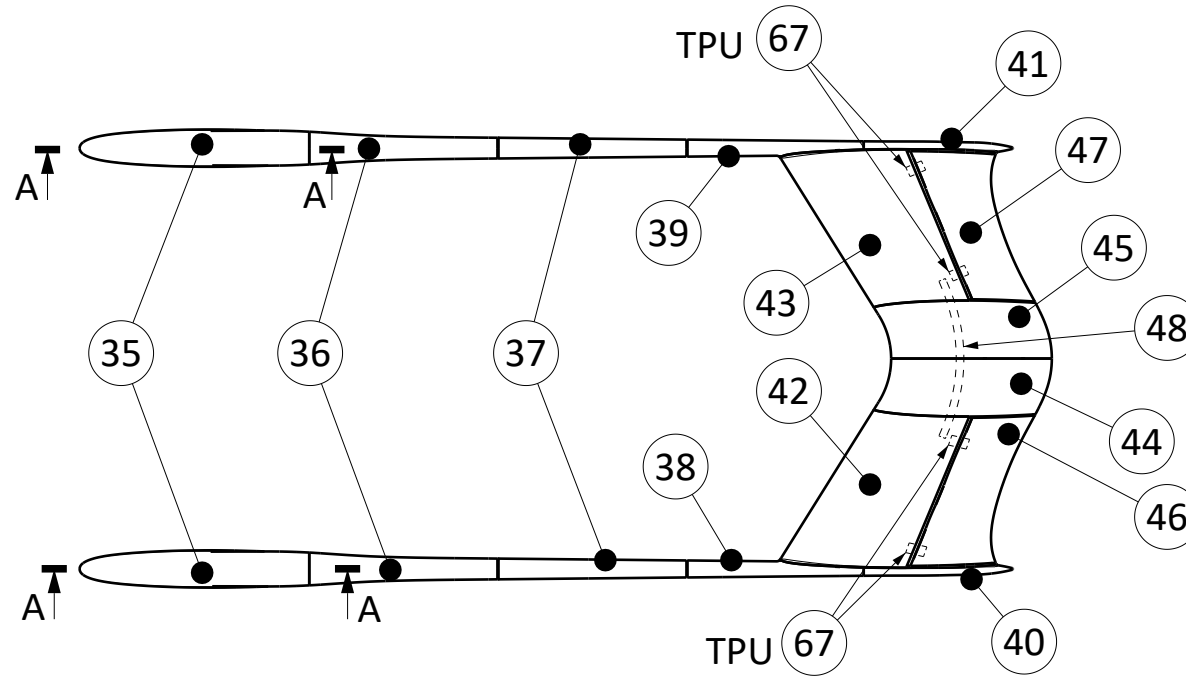
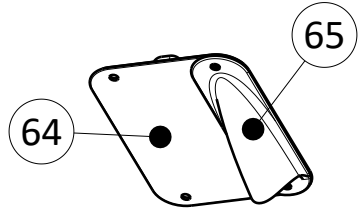
Section D-D



Section E-E
(Same concept for all the canopies)



Section F-F



RUDDERVATORS
(measured at the root)

AILERONS

Recommended throw

ITEM	NAME	CATEGORY
1	Nose	C
2B	2 Fus1	A
2B	3 Fus2	A
2B	4 Fus3	A
2B	5 Fus4	A-LW
6	Canopy_1	A
7	Canopy_2	A-LW
8	Canopy_3	A-LW
9	Wing1L	A
10	Wing1R	A
5	11 Wing2L	A
5	12 Wing2R	A
13	Wing2L_F	A
14	Wing2R_F	A
5	15 Wing3L	A-LW
5	16 Wing3R	A-LW
17	Wing3L_F	A-LW
18	Wing3R_F	A-LW
19	Wing4L	A-LW
20	Wing4R	A-LW
21	Wing5L	A-LW
22	Wing5R	A-LW
23	Wing6L	A-LW
24	Wing6R	A-LW
21 2B	25 Flap1L	A-LW
21 2B	26 Flap1R	A-LW
21 2B	27 Flap2L	A-LW
21 2B	28 Flap2R	A-LW
21 8B	29 Aileron1L	A-LW
21 8B	30 Aileron1R	A-LW
21 2B	31 Aileron2L	A-LW
21 2B	32 Aileron2R	A-LW
21 2B	33 Aileron3L	A-LW
21 2B	34 Aileron3R	A-LW
x2 2B	35 Boom_1	A-LW
x2 2B	36 Boom_2	A-LW
x2	37 Boom_3	A-LW
38	Boom_4L	A-LW
39	Boom_4R	A-LW
40	Boom_5L	A-LW
41	Boom_5R	A-LW
21 2B	42 Stab_1L	A-LW
21 2B	43 Stab_1R	A-LW
21 2B	44 Stab_2L	A-LW
2B	45 Stab_2R	A-LW
21 8B	46 Ruddervator_LH	A-LW
21 8B	47 Ruddervator_RH	A-LW
48	Stab_spar	C
49	Prop_hub	C
50	Prop_hub_stoppers	C
51	Spinner	C
x3	52 Lock_1	C
x3	53 Lock_2	C
6	54 Ballast_box	C
6	55 Ballast_box_cover	C
3	56 Motor_holder	C
4	57 TyreD40	C
58	RimD40	C
59	LG_root	C
60	Latch1L	C
61	Latch1R	C
62	Latch2L	C
63	Latch2R	C
x6	64 Servo_holder_wing	C
x6	65 Cover_horn	C
x2	66 Horn	C
x32	67 Hinge	C
x2	68 Fitting_boom_1	C
x2	69 Fitting_boom_2	C
x2	70 Fitting_boom_3	C
x2	71 Push_rod_guide	C

2T - Add 2 top layers

8B - Add 8 bottom layers

2B - Add 2 bottom layers

6 - Ballast box is not needed if you use a battery heavier than 300g.

5 - Version without flaps

4 - Print 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

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/ PETG	PLA/PETG 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