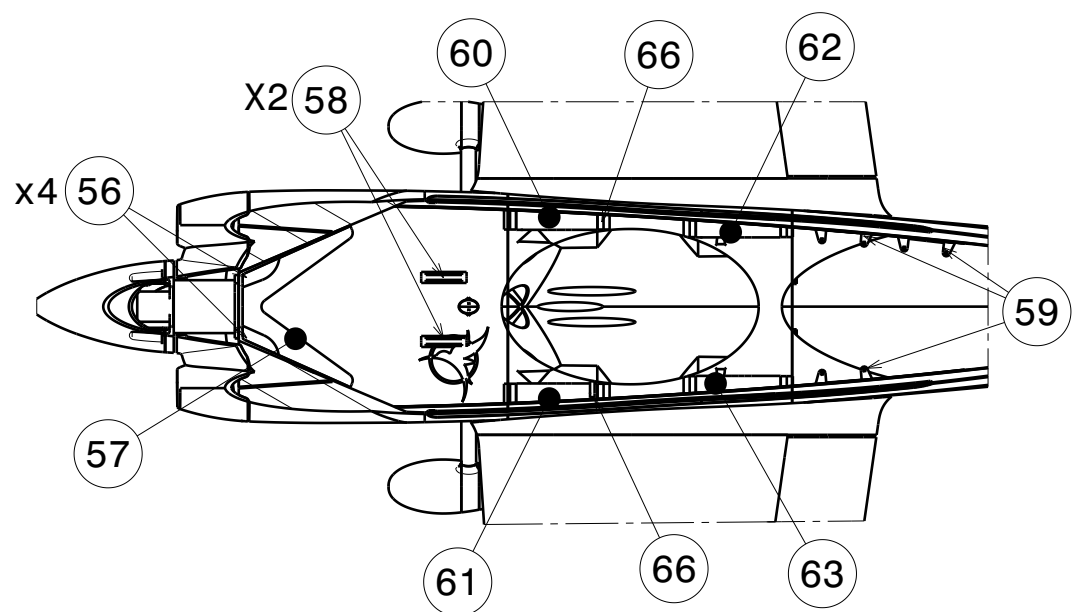
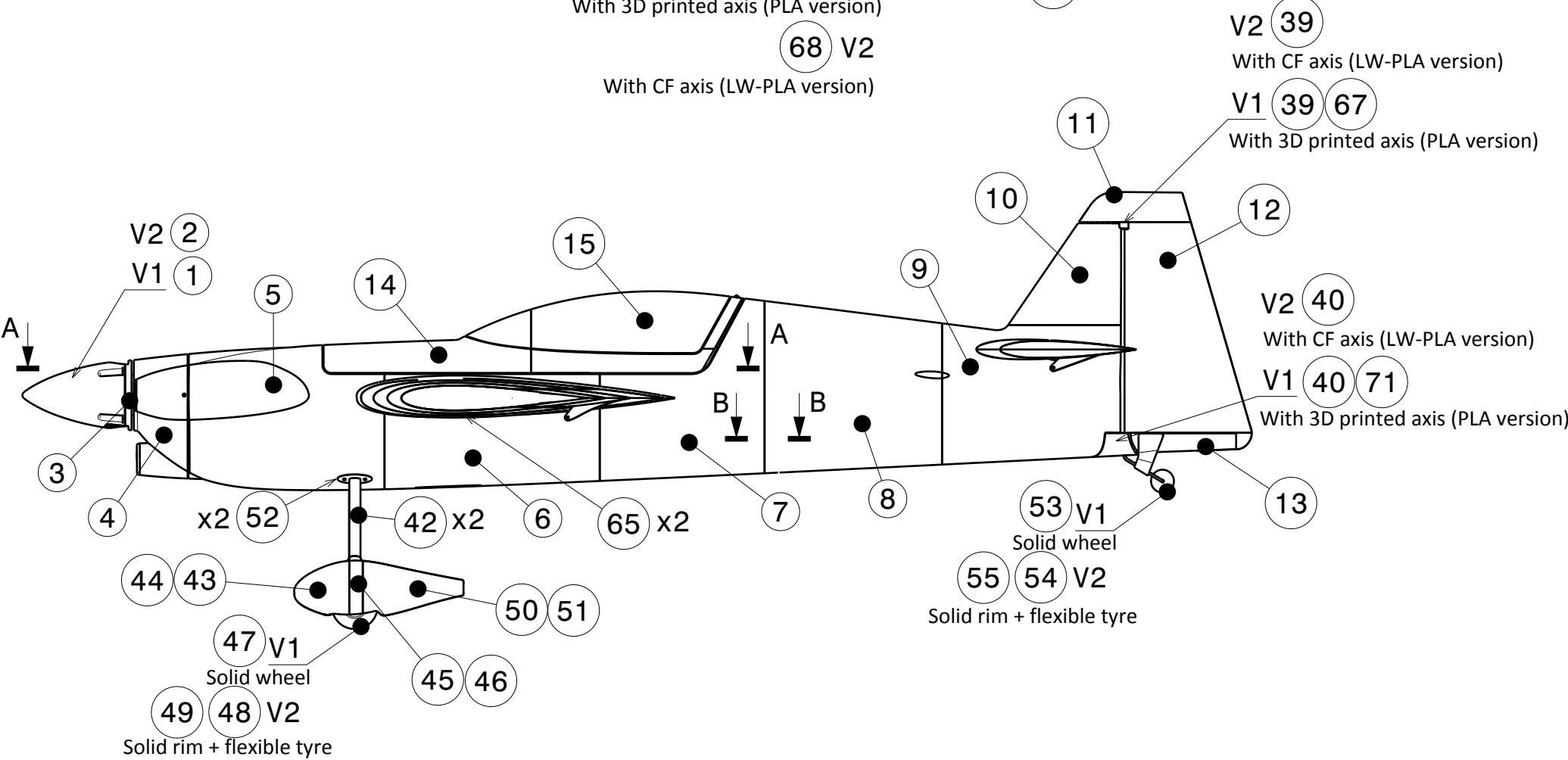
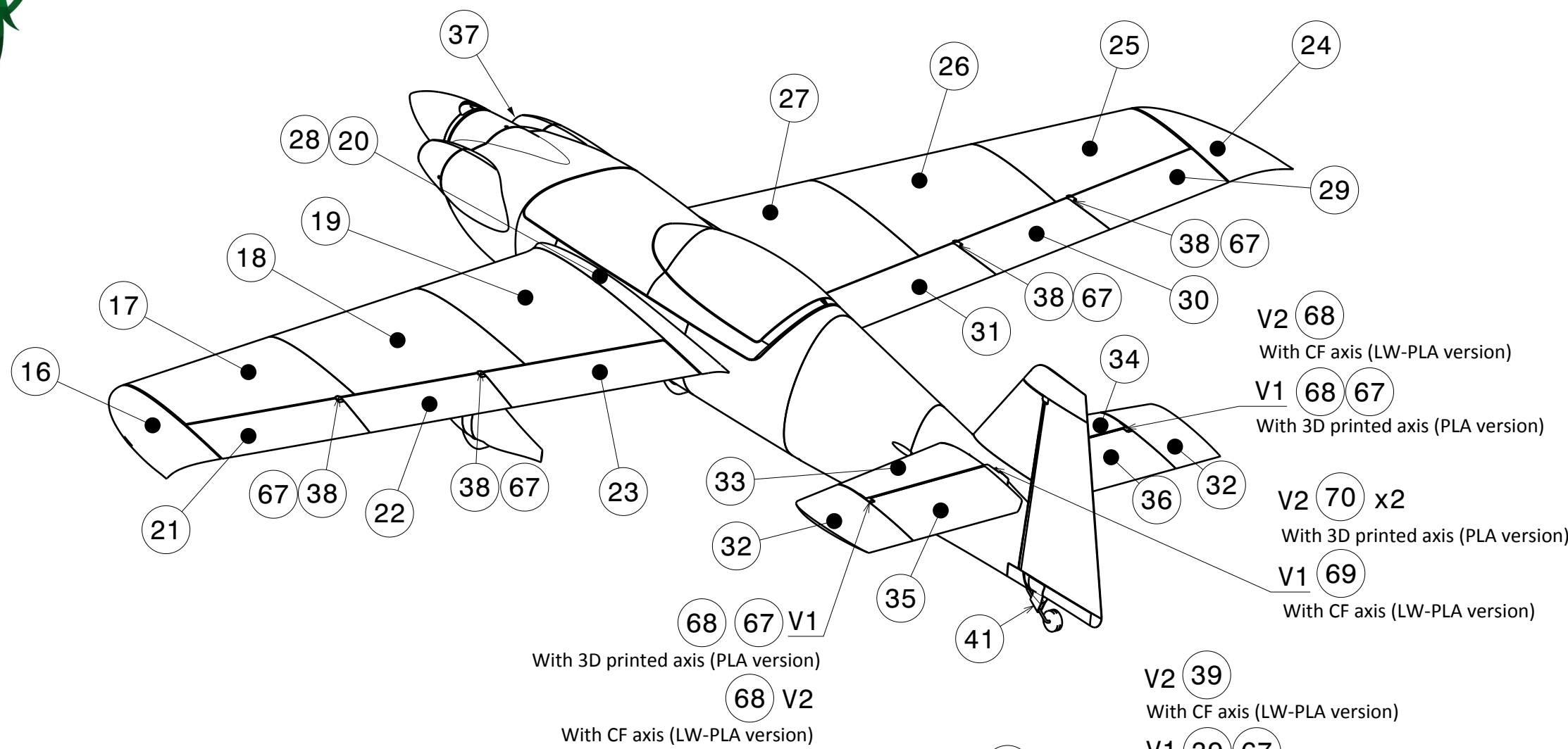
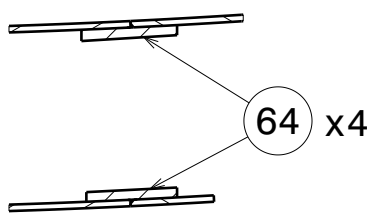




Section A-A



Section B-B

- 10 Add 2 top layers
- 9 Add 7 bottom layers
- 8 Add 2 bottom layers (parts marked with this flag note)
- 7 Print it with flexible material (parts marked with this flag note)
- 6 If you can not use fan, ensure enough time between layers to cool down material.
- 5 If you can not heat the bed use Spray Adhesive
- 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.

6

5

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	230	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	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

ITEM	NAME	CATEGORY
1	Spinner1_scale	A
2	Spinner1_short	A
3	Spinner2	C
4	Nose	C
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	A / A-LW
11	Rudder3	A / A-LW
12	Rudder2	A / A-LW
13	Rudder1	A / A-LW
14	Canopy1	A / A-LW
15	Canopy2	A / A-LW
16	Wing5L	A / A-LW
17	Wing4L	A / A-LW
18	Wing3L	A / A-LW
19	Wing2L	A / A-LW
20	Wing1L	A / A-LW
21	Flaperon3L	A / A-LW
22	Flaperon2L	A / A-LW
23	Flaperon1L	A / A-LW
24	Wing5R	A / A-LW
25	Wing4R	A / A-LW
26	Wing3R	A / A-LW
27	Wing2R	A / A-LW
28	Wing1R	A / A-LW
29	Flaperon3R	A / A-LW
30	Flaperon2R	A / A-LW
31	Flaperon1R	A / A-LW
32	Elev2	A / A-LW
33	HTP_L	A / A-LW
34	HTP_R	A / A-LW
35	Elev1L	A / A-LW
36	Elev1R	A / A-LW
37	Weight_cap	C
38	Hinge_wing	C / C-LW
39	Hinge_rudder2	C / C-LW
40	Hinge_rudder1	C / C-LW
41	Tail_wheel_fitting	C
42	MLG_fairing_4	C / C-LW
43	MLG_fairing_1L	A / A-LW
44	MLG_fairing_1R	A / A-LW
45	MLG_fairing_2L	C
46	MLG_fairing_2R	C
47	Wheel	C
48	Rim	C
49	Tyre	C
50	MLG_fairing_3L	A / A-LW
51	MLG_fairing_3R	A / A-LW
52	Foot_root	C
53	WheelD20	C
54	RimD20	C
55	TyreD20	C
56	Anchor_nut_M3	C
57	Motor_mount	C
58	Battery_strap_fitting	C
59	Servo_holder_fus	C
60	CF_fitting_front_R	C
61	CF_fitting_front_L	C
62	CF_fitting_rear_R	C
63	CF_fitting_rear_L	C
64	Guide	C
65	Servo_holder_wing	C / C-LW
66	Hook	C
67	Axis_hinge	C
68	hinge_elev2	C / C-LW
69	hinge_elev1	C / C-LW
70	Hinge_elev1_V2	C
71	Axis_hinge_rudder1	C