



ITEM	NAME	CATEGORY
1	Canopy_1	A / A-LW
2	Canopy_2	A / A-LW
3	Canopy_1_VTX	A / A-LW
4	Canopy_2_VTX	A / A-LW
5	WingC_1	A / A-LW
6	WingC_2	A
7	WingC_3	A
8	Wing_1L	A
9	Wing_1R	A
10	Latch_1L	C
11	Latch_1R	C
12	Latch_2L	C
13	Latch_2R	C
14	Latch_bolt_1L	C
15	Latch_bolt_1R	C
16	Wing_2L	A / A-LW
17	Wing_2R	A / A-LW
18	Wing_3L	A / A-LW
19	Wing_3R	A / A-LW
20	Wing_4L	A / A-LW
21	Wing_4R	A / A-LW
22	Wingtip_1L	A / A-LW
23	Wingtip_1R	A / A-LW
24	Wingtip_2L	A / A-LW
25	Wingtip_2R	A / A-LW
26	Elevon_1L	A / A-LW
27	Elevon_1R	A / A-LW
28	Elevon_2L	A / A-LW
29	Elevon_2R	A / A-LW
30	VTX_antenna_holder_V2	C
31	VTX_clamp	C
32	Cover_V2	C/ C-LW
33	EDF_door	C
35	Servo_holder	C
37	Cam_holder	C
38	FC_holder_24X24	C/ C-LW
39	FC_holder_30X30	C/ C-LW
40	FC_clamp	C
41	Wheel	C/ C-LW
42	Tyre	C
43	Rim	C/ C-LW
44	LG_Fork	C
45	LG_bolt	C
46	MLG_L	C
47	MLG_R	C
48	MLG_L_root	C
49	MLG_R_root	C
50	NLG1	C
51	NLG2	C
52	NLG_block	C
53	NLG_fitting	C
54	Keel_1	C
55	Keel_2	C
56	Cover	C/ C-LW
57	Door_lock_1	C
58	Door_lock_2	C
59	Guide	C

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/ABS
Infill density (%)	0	0	10	10
Printing temp (°C)	235	220	230	205 to 240
Flow (%)	53	100	53	100
Speed (mm/s)	40	50	35	25 to 50
Support	NO	NO	NO	NO
Spiralize Outer Contour / vase mode	NO	NO	NO	NO

- 13 Add 2 top layers
- 12 Add 8 bottom layers
- 11 Add 2 bottom layers
- 10 Use flexible material
- 9 Use heat resistant material like ABS or PETG (parts marked with this flag note)
Not necessary for "motor holder" if you respect our prop /motor kv recommendation
- 8- The tension of the nose suspension should be low in order to reduce the risk of rebound when landing
- 7- The latching mechanism should be tight in order to reduce the risk of flutter.
If necessary, adjust the flow rate (extrusion multiplier) of latching parts and wing 1&2 in order to achieve that goal. The main tightness should be provided by the 2 carbon fiber tubes.
- 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 -This document shows the basic printing settings to be used and the final position of each part