



- 4T Add 4 top layers.
- 8B Add 8 bottom layers.
- 2B Add 2 bottom layers.
- 4 Print "tyre" with flexible material.
- 3 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor_holder"

2-Center of gravity marking under the wing.

1- Red parameters are mandatory to ensure airplane functionality, assembly or weight target.

ITEM	NAME	CATEGORY		
1	Spinner1	C		
2	Spinner2	C		
3	Fus1	A / A-LW		
2B	4	Canopy1	A / A-LW	
2B	5	Cannopy2	A / A-LW	
6	Fus2	A / A-LW		
7	Fus2_wo_LG	A / A-LW		
2B	8	LG_fairing_1	A / A-LW	
2B	9	LG_fairing_2	A / A-LW	
X2	4	10	Tyre_D55	C
X2	11	Rim_D55_h3	C	
12	Frame	C		
13	Fus3	A / A-LW		
14	Fus4	A / A-LW		
15	Fus5	A / A-LW		
16	Fus6	A / A-LW		
4T	2B	17	VTP_1	A / A-LW
4T	2B	18	VTP_2	A / A-LW
4T	8B	19	Rudder_1	A / A-LW
4T	8B	20	Rudder_2	A / A-LW
4	21	TyreD25	C	
22	RimD25	C		
23	Wing_C	A / A-LW		
24	Wing1L	A / A-LW		
25	Wing1R	A / A-LW		
26	Wing2L	A / A-LW		
27	Wing2R	A / A-LW		
28	Wing3L	A / A-LW		
29	Wing3R	A / A-LW		
30	Wing4L	A / A-LW		
31	Wing4R	A / A-LW		
4T	2B	32	Flap1L	A / A-LW
4T	2B	33	Flap1R	A / A-LW
4T	8B	34	Flap2L	A / A-LW
4T	8B	35	Flap2R	A / A-LW
4T	8B	36	Aileron1L	A / A-LW
4T	8B	37	Aileron1R	A / A-LW
4T	2B	38	Aileron2L	A / A-LW
4T	2B	39	Aileron2R	A / A-LW
4T	2B	40	HTP1L	A / A-LW
4T	2B	41	HTP1R	A / A-LW
2B	42	HTP2L	A / A-LW	
2B	43	HTP2R	A / A-LW	
4T	8B	44	Elev1L	A / A-LW
4T	2B	45	Elev1R	A / A-LW
X15	46	Axis	C	
X6	47	hinge_wing	C	
X2	48	LG_fitting	C	
X4	49	Clamp_foot	C	
X2	50	Root_foot	C	
51	TE_lock	C		
3	52	Motor_holder	C	
X2	53	Servo_holder_fus	C	
X4	54	Servo_holder_Wing	C	
55	hinge_elev	C		
X2	56	Anchor_nut_top	C	
X2	57	Anchor_nut_lower	C	
58	Pattern_LG1_L	C		
59	Pattern_LG1_R	C		
60	Pattern_LG2_L	C		
61	Pattern_LG2_R	C		

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
Bed temp (°C)	60	60	60
Flow (%)	53	100	100
Retraction (mm)	0,5 to 3	0,5 to 3	3
Retraction extra prime amount (mm)	0 to 0,7	0 to 0,7	0
Speed (mm/s)	55	50	25 to 50
Fan	YES	YES	YES
Brim (mm)	3 to 5	3 to 5	0 to 3
Minimum layer time (s)	5	5	5
Support	NO	NO	NO