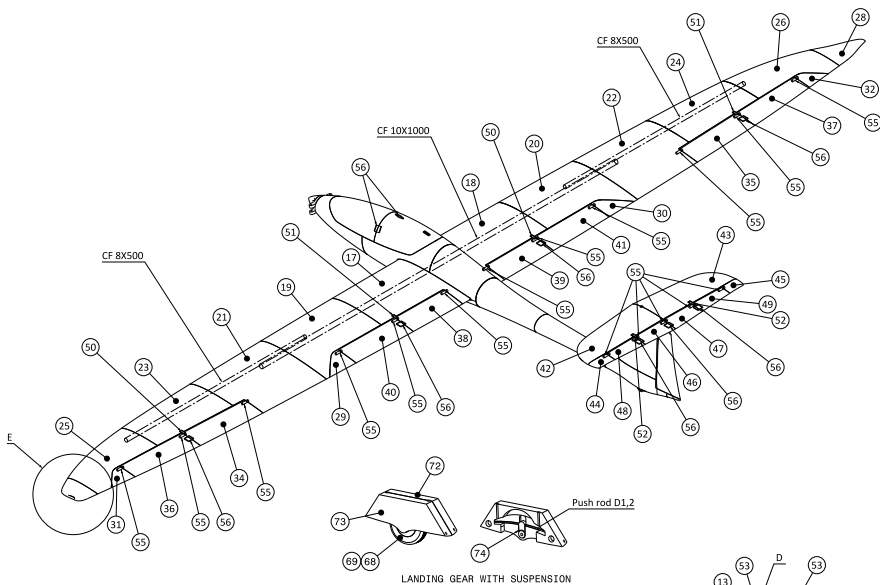
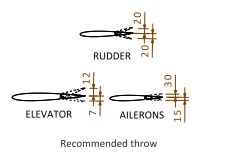


ITEM	NAME	CATEGORY
1	Spinner	C
2	Prop. hub	C
3	Canopy1	B2-LW
4	Canopy2	B2-LW
5	Fus1	D
6	Fus2	D
7	Fus3	D
8	Fus4	B2-LW
9	Fus5	B2-LW
10	Fus6	B2-LW
11	Fus7	C
12	VTP	B2-LW
13	VTP_Insert	C
14	Insert_Tail	C
15	Rudder	B2-LW
16	Rudder_insert	C
17	Wing1L	B2-LW / B2
18	Wing1R	B2-LW / B2
19	Wing2L	B2-LW / B2
20	Wing2R	B2-LW / B2
21	Wing3L	B2-LW / B2
22	Wing3R	B2-LW / B2
23	Wing4L	B2-LW / B2
24	Wing4R	B2-LW / B2
25	Wing5L	B2-LW / B2
26	Wing5R	B2-LW / B2
27	Wing6L	D
28	Wing6R	D
29	Wing7L	B2-LW / B2
30	Wing7R	B2-LW / B2
31	Wing8L	B2-LW / B2
32	Wing8R	B2-LW / B2
33	Wing_lock	C
34	Aileron1L	B2-LW
35	Aileron1R	B2-LW
36	Aileron2L	B2-LW
37	Aileron2R	B2-LW
38	Flap1L	B2-LW
39	Flap1R	B2-LW
40	Flap2L	B2-LW
41	Flap2R	B2-LW
42	HTP1L	B2-LW
43	HTP1R	B2-LW
44	HTP2L	B2-LW
45	HTP2R	B2-LW
46	Elev1L	B2-LW
47	Elev1R	B2-LW
48	Elev2L	B2-LW
49	Elev2R	B2-LW
50	Hinge_Aileron	C
51	Hinge_flap	C
52	Hinge_elevator	C
53	Guide_HTP	C
54	Insert_lock	C
55	Axis	C
56	Guide	C
57	Horn	C
58	Center tube	C
59	LG_Wing_Root	C
60	Tail_LG	C
61	Servo_holder_Wing	C
62	Motor_holder	C
63	Servo_holder_fus	C
64	Battery Mount	C
65	Lock_1	C
66	Lock_2	C
67	Cover_horn	C
68	TyreD40	C
69	RimD40	C
70	TyreD20	C
71	RimD20	C
72	Main_LG_sus_L	C
73	Main_LG_sus_R	C
74	SLG_CenterPin	C



PRINTING PARAMETER	CATEGORY			
	B2-LW LW-PLA (active)	B2 PLA+/PETG ABS..	C PLA/PETG TPU/ABS..	D PLA+/PETG ABS..
Material				
Layer height (mm)	0.25	0.2	0.13	0.2
Bottom layers	4	4	4	4
Top layers	0	0	6	4
Wall lines / perimeter	1	1	2	1
Infill density (%)	0	0	10	3 (Gyroid)
Printing temp (°C)	235	220	205 to 240	220
Speed (mm/s)	55	50 to 200	50 to 200	50 to 200
Flow (%)	53	100	100	100
Spiralize Outer Contour / vase mode	YES	YES	NO	NO
Printing Support	NO	NO	NO	NO
Nozzle diameter (mm)	0.4	0.4	0.4	0.4

- 78 - Use 7 bottom layers
- Carbon fiber tubes with a round cross-section D8 may be used; ensure that sufficient glue is applied to prevent any rotation.
- Print it with TPU.
- Center of gravity marking under the wing
- Use 4 wall lines and print at 220 °C. Ensure that balanced propellers are used. If there is any uncertainty regarding print quality consider using a commercially manufactured propeller hub for safety
- Print it with ABS or any other heat resistant material

0-If you print the wing in category B2 (PLA+PETG, etc.), it is recommended to use a 4S battery.

BOTTOM VIEW