



- 12 Add 2 top layers
- 11 Add 8 bottom layers
- 10 Add 2 bottom layers
- 8 Print "tyre" with flexible material.
- 6 If your motor reach temperatures over 50 °C use ABS or PETG

5-Landing Gear V2 is recomendable over V1  
 4-Center of gravity marking under the wing.  
 It is recommended to set the C.G. 5 mm forward for the maiden flight  
 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.

ITEM	NAME	CATEGORY
1	Spinner1	C
2	Spinner2	C
3	Fus1	A
4	Fus2	A / A-LW
5	Fus3	A / A-LW
6	Fus4	A / A-LW
7	Fus5	A / A-LW
8	Fus6	A / A-LW
9	Canopy	A / A-LW
10	Wing1L	A / A-LW
11	Wing1R	A / A-LW
12	Wing2L	A / A-LW
13	Wing2R	A / A-LW
14	Wing3L	A / A-LW
15	Wing3R	A / A-LW
16	Wing4L	A / A-LW
17	Wing4R	A / A-LW
18	Wing5L	A / A-LW
19	Wing5R	A / A-LW
20	WingtipL	A / A-LW
21	WingtipR	A / A-LW
22	Flaperon_1L	A / A-LW
23	Flaperon_1R	A / A-LW
24	Flaperon_2L	A / A-LW
25	Flaperon_2R	A / A-LW
26	Flaperon_3L	A / A-LW
27	Flaperon_3R	A / A-LW
28	Flaperon_4L	A / A-LW
29	Flaperon_4R	A / A-LW
30	VTP	A / A-LW
31	HTP_1L	A / A-LW
32	HTP_1R	A / A-LW
33	HTP_2L	A / A-LW
34	HTP_2R	A / A-LW
35	Rudder	A / A-LW
36	Elevator_L	A / A-LW
37	Elevator_R	A / A-LW
38	Elevator_horn	C
39	Servo_holder_tail	C / C-LW
x2	Servo_holder_wing	C
x3	Anchor_nut_M3_wing	C
6	Motor_mount	C
42	Servo_holder_fus	C
43	MLG_L_root	C
44	MLG_R_root	C
46	MLG_L	C
47	MLG_R	C
x3	LG_Fork	C
x3	LG_bolt	C
x3	Wheel	C / C-LW
x3	Rim	C / C-LW
8	x3 Tyre	C
53	NLG_root	C
54	NLG1	C
55	NLG2	C
56	NLG_horn	C
57	NLG_horn_V2	C
58	NLG_root_V2	C
x3	Wheel_fairing_1	C / C-LW
x3	Wheel_fairing_3	C / C-LW
x3	Wheel_fairing_2	C / C-LW
61	MLG_L_root_V2	C
62	MLG_R_root_V2	C
63	MLG_R_root_V2	C
64	Exhaust_L	C / C-LW
65	Exhaust_R	C / C-LW
66	Axis_hinge_rud_top	C
67	Axis_hinge_rud_bottom	C
x8	Guide	C
69	Spinner_1_3b	C
6	70 Spinner_2_3b	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 FLEX/ABS
Infill density (%)	0	0	10	10
Printing temp (°C)	235	220	235	205 to 240
Bed temp (°C)	60	60	60	60
Flow (%)	53	100	53	100
Retraction (mm)	0,5 to 6	0,5 to 6	0,5 to 6	0,5 to 6
Retraction extra prime amount (mm)	0 to 0,7	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