



Detail A
(Item 0 hidden)

ITEM	NAME	CATEGORY
0	Fus1	A
2	Canopy	A
4	Fus2	A
6	Fus3	A
8	Fus4	A
10	Fus5	A
12	VTP	B
14	Rudder	B
16	HTP1L	B
17	HTP1R	B
18	Elev1L	B
20	Elev2R	B
22	Elev3R	A
24	WingC	A
26	Wing1L	A
27	Wing1R	A
28	Wing2L	A
29	Wing2R	A
30	Wing3L	A
31	Wing3R	A
32	Aileron1L	B
33	Aileron1R	B
34	Aileron2L	A
35	Aileron2R	A
36	MLG	C
38	MLG_2	C
40	Axis_locker	C
42	Wheel	C
44	NLG_bolt	C
46	NLG_Fork_D1.4	C
48	NLG_Fork_D2.3	C
50	NLG1	C
52	NLG2	C
54	NLG_fitting	C
56	NLG_bushing	C
58	Servo_holder_fus	C
60	Motor_holder	C
62	Servo_holder_wing	C
64	Fitting_rub	C

PRINTING PARAMETER	CATEGORY		
	A	B	C
Layer height (mm)	0,2	0,2	0,13
Bottom layers	0	6	4
Top layers	0	0	6
Wall lines / perimeter	1	1	2
Nozzle diameter (mm)	0,4	0,4	0,4
Material	PLA	PLA	ABS/PLA
Infill density (%)	0	0	10
Printing temp (°C)	220	220	210
Bed temp (°C)	60	60	60
Flow	100	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)	50	50	25 to 50
Fan	YES	YES	YES
Brim (mm)	3	0 to 2	0 to 2
Minimum layer time (s)	5	5	5
Support	NO	NO	3

6 Do not print this part at the same time with others, print it alone to achieve good quality.

5 If you can not use fan, ensure enough time between layers to cool down material.

4 If you can not heat the bed use Spray Adhesive

3 Support needed only for MLG

2 If your motor reach temperatures over 50 °C use ABS

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