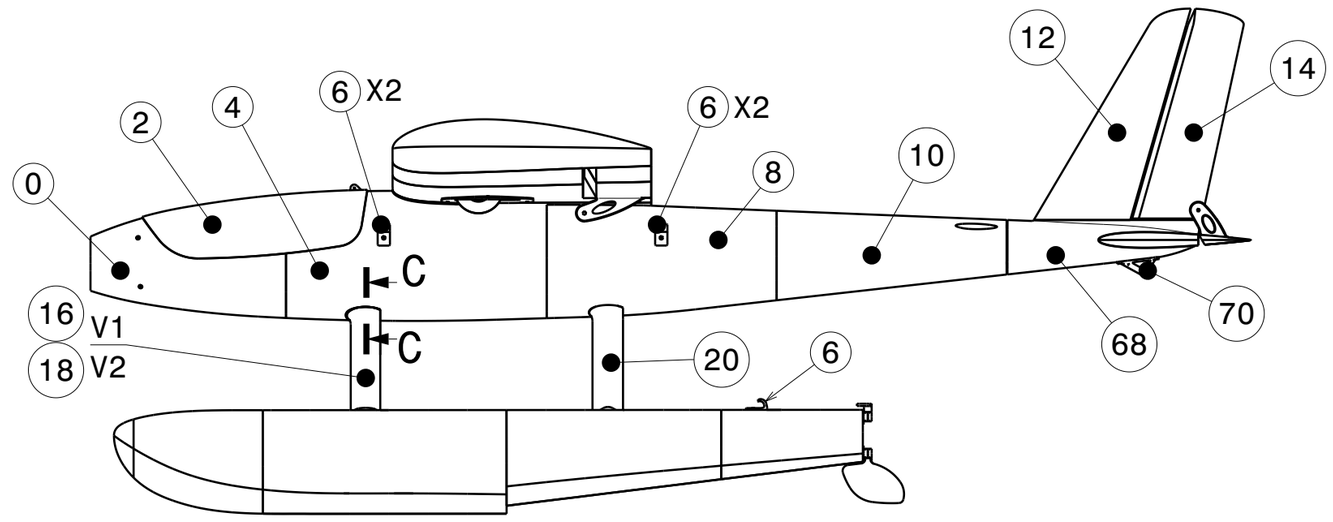
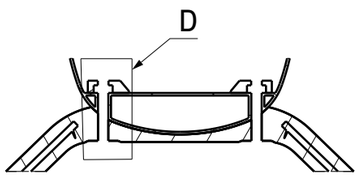
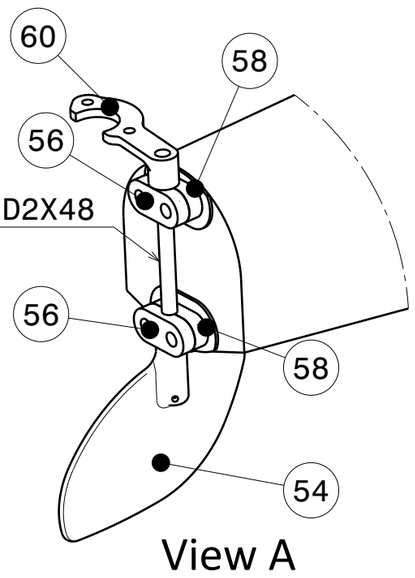
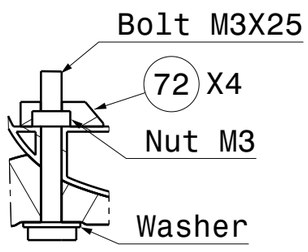




Section C-C



View A



Detail D

(Typical detail for interface between foots and fuselage)

Section B-B

Recommended throw

ITEM	NAME	CATEGORY
0	Fus1	A / A-LW
2	Canopy	A / A-LW
4	Fus2	A / A-LW
6	Fitting_rub	C
8	Fus3	A / A-LW
10	Fus4	A / A-LW
12	VTP	B / B-LW
14	Rudder	B / B-LW
16	Float_foot1	C / C-LW
18	MLG	C / C-LW
20	Float_foot2	C / C-LW
22	WingC	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	Aileron1L	B / B-LW
31	Aileron1R	B / B-LW
32	Aileron2L	A / A-LW
33	Aileron2R	A / A-LW
34	Float1	C
36	Float2	B
38	Float3L	B
39	Float3R	B
40	Float4L	B
41	Float4R	B
42	Float5L	B
43	Float5R	B
44	HTP1L	B / B-LW
45	HTP1R	B / B-LW
46	Elev1L	B / B-LW
48	Elev2R	B / B-LW
50	Elev3R	A / A-LW
52	Guide	C
54	Water_rudder	C
56	Rudder_clamp2	C
58	Rudder_clamp	C
60	Horn	C
62	Servo_holder_Wing	C / C-LW
64	Servo_holder_Fus	C
6	66 Motor_holder	C
68	Fus5	A / A-LW
70	Skid	C
72	Anchor_nut	C

PRINTING PARAMETER	CATEGORY					
	A-LW	A	B-LW	B	C-LW	C
Layer height (mm)	0.25	0,2	0,25	0,2	0,15	0,13
Bottom layers	0	0	7	6	4	4
Top layers	0	0	0	0	6	6
Wall lines / perimeter	1	1	1	1	2	2
Nozzle diameter (mm)	0,4	0,4	0,4	0,4	0,4	0,4
Material	LW-PLA	PLA/ PETG	LW-PLA	PLA/ PETG	LW-PLA	PLA/PETG /ABS
Infill density (%)	0	0	0	0	10	10
Printing temp (°C)	240	220	240	220	240	205 to 240
7 Bed temp (°C)	60	60	60	60	60	60
Flow (%)	55	100	55	100	55	100
Retraction (mm)	0,5 to 3	0,5 to 3	0,5 to 3	0,5 to 3	0,5 to 3	3
Retraction extra prime amount (mm)	0	0 to 0,7	0	0 to 0,7	0	0
Speed (mm/s)	40	50	40	50	35	25 to 50
8 Fan	YES	YES	YES	YES	YES	YES
Brim (mm)	3	3	0 to 3	0 to 3	0 to 3	0 to 3
Minimun layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO

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

7 If you can not heat the bed use Spray Adhesive

6 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor_holder"

5- Do not print LW-PLA parts at the same time with others to avoid stringing in the outer surface.

4- Do not use retraction values higher than 3mm for LW-PLA parts because the risk of clogging increases.

3- Stringing can not be eliminated for LW-PLA material.

2- Center of gravity marking placed under the wing

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