



ITEM	NAME	CATEGORY
0	Wing1_C	A / A-LW
1	Wing2_C	A / A-LW
2	Wing3_L	A / A-LW
3	Wing3_R	A / A-LW
4	Wing4_L	A / A-LW
5	Wing4_R	A / A-LW
6	Wing5_L	A / A-LW
7	Wing5_R	A / A-LW
8	Wing6_L	A / A-LW
9	Wing6_R	A / A-LW
10	Wing7_L	A / A-LW
11	Wing7_R	A / A-LW
18	Elevon1L	B / B-LW
19	Elevon1R	B / B-LW
20	Elevon2L	A / A-LW
21	Elevon2R	A / A-LW
22	Motor_fairing_1	A / A-LW
24	Motor_fairing_2	A / A-LW
26	Prop_hub	C
28	Spinner	B / B-LW
30	Door_L	B / B-LW
31	Door_R	B / B-LW
32	Door_lock_1	C
34	Door_lock_2	C
42	Servo_holder	C / C-LW
44	Prop_7X4	C
46	Prop_8X6	C
48	Prop_10X4,7	C
56	Motor_holder	C
58	Guide	C
68	Keel_L	C
69	Keel_R	C
70	Prop_stopper	C



- 10 Use infill 100% for propellers
- 9 If you can not use fan, ensure enough time between layers to cool down material
- 8 If you can not heat the bed use Spray Adhesive
- 7 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor_holder"
- 6- Do not print LW-PLA parts at the same time with others to avoid stringing in the outer surface.
- 5- Do not use retraction values higher than 3mm for LW-PLA parts because the risk of clogging increases.
- 4- Stringing can not be eliminated for LW-PLA material.
- 3- Center of gravity marking placed under the wing
- 2- Be aware that using 3d printed propellers might be dangerous if they are not properly balanced
Use commercial folding or fix propellers if vibration can't be eliminated
- 1- Red parameters are mandatory to ensure airplane functionality, assembly or weight target.



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
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
Fan	YES	YES	YES	YES	YES	YES
Brim (mm)	3	3	0 to 3	0 to 3	0 to 3	0 to 3
Minimum layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO