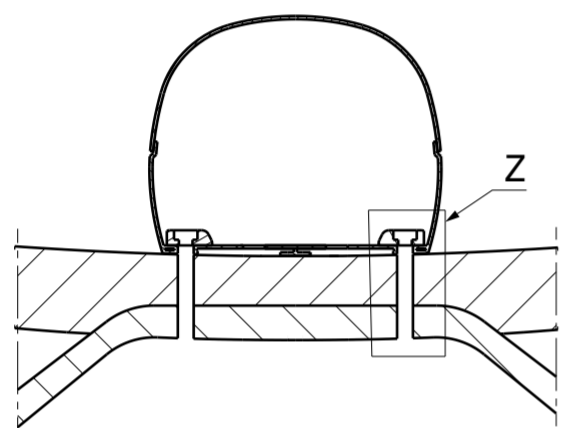
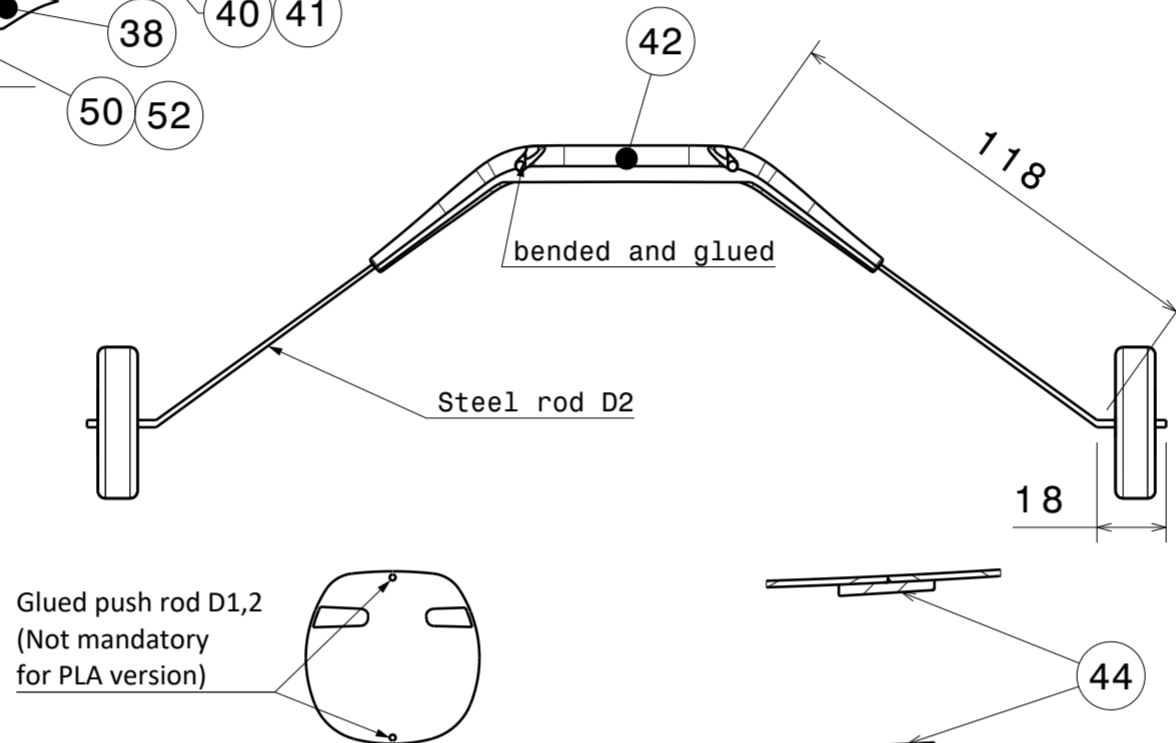


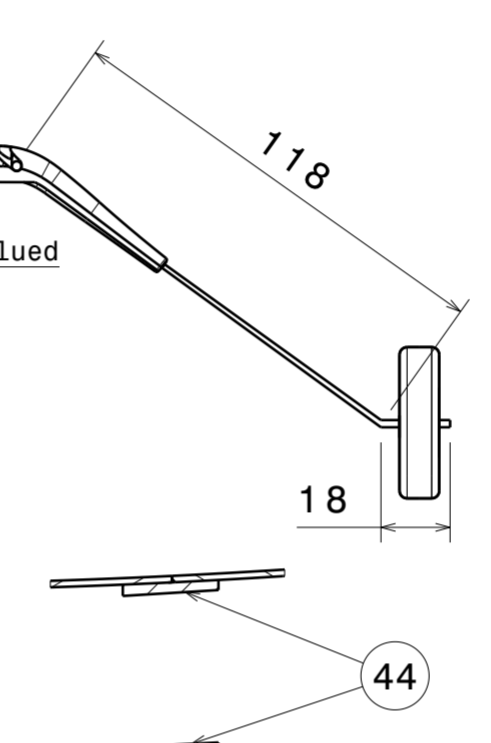
63 V1  
62 V2  
34 V2  
42 V3  
Keel  
LG with pants  
LG w/o pants



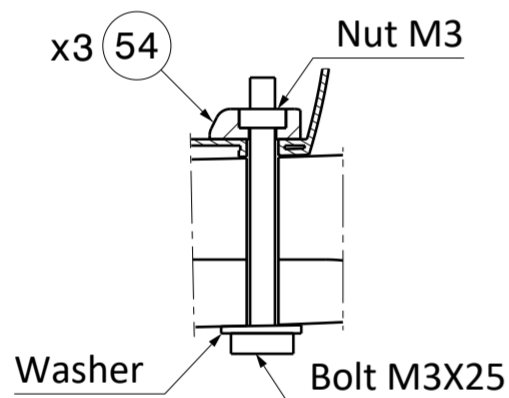
Section B-B



Section A-A

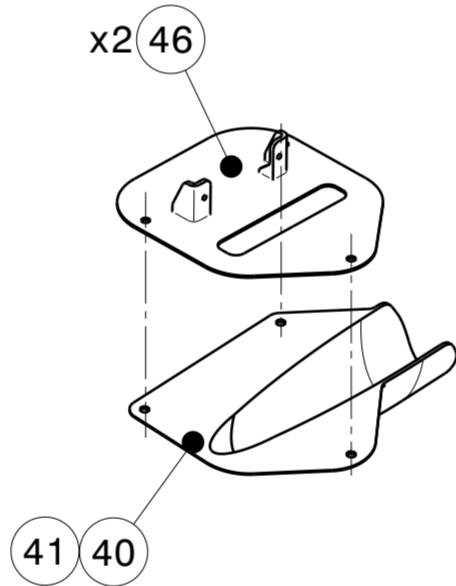


Section C-C  
(Concept valid also for join between WingC and Wing1R)

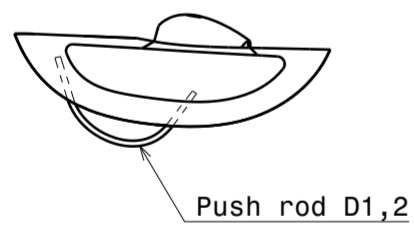


Detail Z

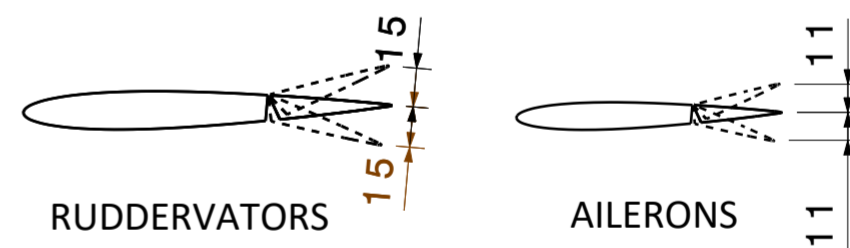
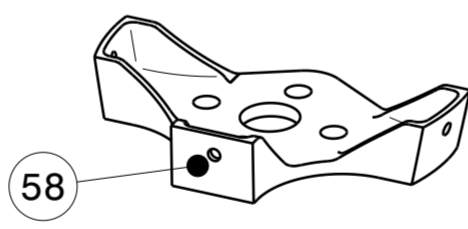
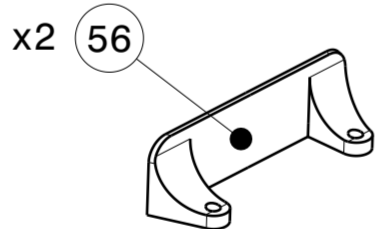
(Typical detail for interface between fuselage and wing)



Section D-D



KEEL DETAIL



Recommended throw

ITEM	NAME	CATEGORY
0	Spinner1	C
2	Spinner2	C
4	Fus1	A / A-LW
6	Canopy1	A / A-LW
8	Canopy2	A / A-LW
10	Fus2	A / A-LW
12	Fus3	A / A-LW
14	Fus4	A / A-LW
16	Stabilizer_1L	A / A-LW
17	Stabilizer_1R	A / A-LW
18	Ruddervator_LH	A / A-LW
19	Ruddervator_RH	A / A-LW
20	WingC	A / A-LW
22	Wing1L	A / A-LW
23	Wing1R	A / A-LW
24	Wing2L	A / A-LW
25	Wing2R	A / A-LW
26	Wing3L	A / A-LW
27	Wing3R	A / A-LW
28	Aileron1L	A / A-LW
29	Aileron1R	A / A-LW
30	Aileron2L	A / A-LW
31	Aileron2R	A / A-LW
32	Winglet_L	A / A-LW
33	Winglet_R	A / A-LW
34	MLG	C
36	Wheel_fairing_1	C / C-LW
38	Wheel_fairing_2	C / C-LW
40	Horn_cover_L	C
41	Horn_cover_R	C
42	MLG_2	C
44	Guide	C
46	Servo_holder_Wing	C
50	Tyre	C
52	Rim	C
54	Anchor_nut_M3	C
56	Servo_holder_fus	C
58	Motor_holder	C
60	Stabilizer_2L	A / A-LW
61	Stabilizer_2R	A / A-LW
62	Keel_L	C
63	Keel_R	C
64	Hinge_aileron	C

- 10 Add 4 top layers
- 9 Add 8 bottom layers
- 8 Add 2 bottom layers (parts marked with this flag note)
- 7 Print "tyre" with flexible material.
- 6 If your motor reach temperatures over 50 °C use ABS or PETG for "Motor\_holder"

5-Center of gravity marking under the wing

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

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

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

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

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 3	0,5 to 3	0,5 to 3	3
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