



ITEM	NAME	CATEGORY
1	Spinner1	C
2	Spinner2	C
3	Fus1	A / A-LW
4	Canopy_1	A / A-LW
5	Canopy_2	A / A-LW
6	Fus2	A / A-LW
7	Fus3	A / A-LW
8	Fus4	A / A-LW
9	Fus5	A / A-LW
10	VTP	A / A-LW
11	Wing_C	A / A-LW
12	Wing1L	A / A-LW
13	Wing1R	A / A-LW
14	Wing2L	A / A-LW
15	Wing2R	A / A-LW
16	Wing3L	A / A-LW
17	Wing3R	A / A-LW
18	Flaperon1L	A / A-LW
19	Flaperon1R	A / A-LW
20	Flaperon2L	A / A-LW
21	Flaperon2R	A / A-LW
22	Flaperon3L	A / A-LW
23	Flaperon3R	A / A-LW
24	HTP_L	A / A-LW
25	Elev1L	A / A-LW
26	Elev2R	A / A-LW
27	Elev3R	A / A-LW
28	Fitting_rubber	C
29	Motor_holder	C
30	Servo_holder_fus	C
31	Servo_holder_Wing	C
32	LG_connector	C
33	LG_root_front	C
34	LG_root_rear	C
35	Fus1_intake	A / A-LW
36	Fus2_w/o LG	A / A-LW
37	Rudder	A / A-LW
38	Wheel	C / C-LW
39	Tyre	C
40	Rim	C / C-LW
41	Guide	C
42	HTP_R	A / A-LW

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

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