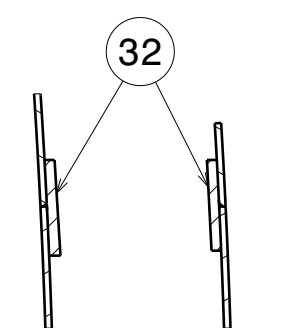
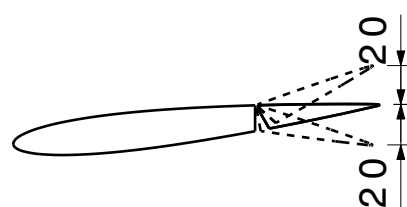
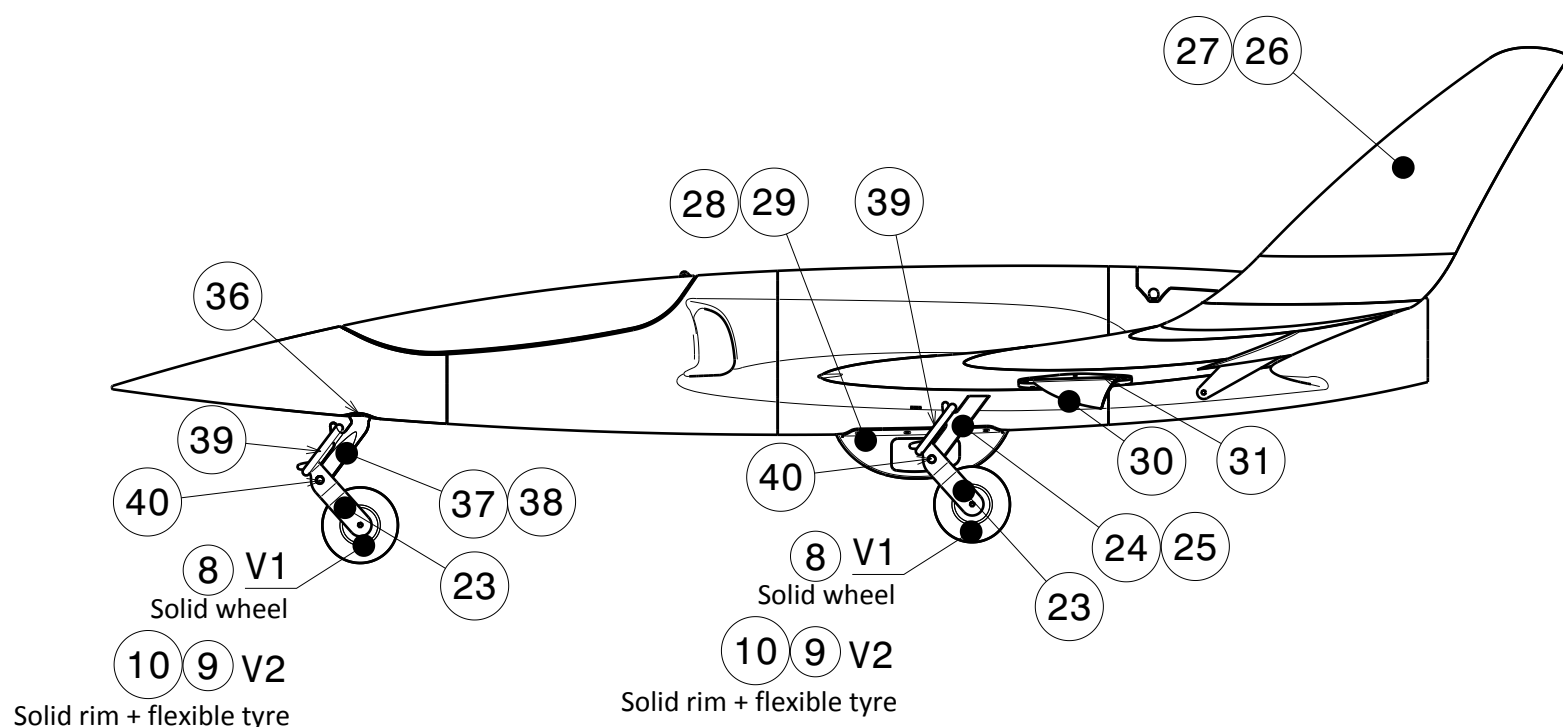


FPV Nose



Section B-B



Section A-A
Recommended throw



Section A-A
Take off configuration

7

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ITEM	NAME	CATEGORY
1	Fus1	A / A-LW
2	Canopy1	B / B-LW
3	Canopy2	B / B-LW
4	Fus2	A / A-LW
5	Fus3	A / A-LW
6	Fus4	A / A-LW
7	EDF_door	A / A-LW
8	Wheel	C
9	Rim	C
10	Tyre	B
11	Wing1L	A / A-LW
12	Wing1R	A / A-LW
13	Wing2L	A / A-LW
14	Wing2R	A / A-LW
15	Wingtip_1L	A / A-LW
16	Wingtip_1R	A / A-LW
17	ElevonL	B / B-LW
18	ElevonR	B / B-LW
19	Axis_hinge	C
20	Fus1_FPV	A / A-LW
21	Camera cowling	A / A-LW
22	TX02_holder	C
23	Fork	C
24	MLG_L	C
25	MLG_R	C
26	Wingtip_2L	A / A-LW
27	Wingtip_2R	A / A-LW
28	Keel_1	C
29	Keel_2	C
30	Cover horn	C
31	Servo_holder_5h	C
32	Guide	C
33	Cone	A / A-LW
34	Servo_holder_fus	C
35	NLG_fitting	C
36	NLG_bushing	C
37	NLG1	C
38	NLG2	C
39	Rubber_band	C
40	NLG_bolt	C

- 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 Print this part with flexible material
- 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
- 1- Red parameters are mandatory to ensure airplane functionality, assembly or weight target.

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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	6	7	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)	235	220	235	220	230	205 to 240
Bed temp (°C)	60	60	60	60	60	60
Flow (%)	53	100	53	100	53	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
Minimun layer time (s)	5	5	5	5	5	5
Support	NO	NO	NO	NO	NO	NO