



ITEM	NAME	CATEGORY	
1	Spinner1_scale	C	
2	Spinner1_short	C	
3	Spinner2	C	
4	Nose	C	
5	Fus1	A	
6	Fus2	A-LW	
7	Fus3	A-LW	
8	Fus4	A-LW	
9	Fus5	A-LW	
10	Elev2R	A-LW	
11	Rudder3	A-LW	
12	Rudder2	A-LW	
13	Rudder1	A-LW	
14	Canopy1	A-LW	
15	Canopy2	A-LW	
16	Wing5L	A-LW	
17	Wing4L	A-LW	
18	Wing3L	A-LW	
19	Wing2L	A-LW	
20	Wing1L	A-LW	
21	Flaperon3L	A-LW	
22	Flaperon2L	A-LW	
23	Flaperon1L	A-LW	
24	Wing5R	A-LW	
25	Wing4R	A-LW	
26	Wing3R	A-LW	
27	Wing2R	A-LW	
28	Wing1R	A-LW	
29	Flaperon3R	A-LW	
30	Flaperon2R	A-LW	
31	Flaperon1R	A-LW	
32	Elev2L	A-LW	
33	HTP_L	A-LW	
34	HTP_R	A-LW	
35	Elev1L	A-LW	
36	Elev1R	A-LW	
x4	37	Hinge_wing	C
	38	Hinge_rudder2	C
	39	Hinge_rudder1	C
	40	Foot_root_L	C
	41	Foot_root_R	C
	42	MLG_fairing_1L	A-LW
	43	MLG_fairing_1R	A-LW
	44	MLG_fairing_2L	A-LW
	45	MLG_fairing_2R	A-LW
x2	46	RimD50	C
x2	47	TyreD50	C
	48	RimD25	C
	49	TyreD25	C
	50	Motor_mount	C
	51	D28_motor_adapt	C
x4	52	Anchor_nut_M3	C
x2	53	Servo_holder_fus	C
x2	54	Servo_holder_wing	C
	55	CF_fitting_front_R	C
	56	CF_fitting_front_L	C
	57	CF_fitting_rear_R	C
	58	CF_fitting_rear_L	C
x2	59	Hook	C
x2	60	hinge_elev	C
x11	61	Axis	C
	62	Axis_elev	C
	63	Winglet_L	A
	64	Winglet_R	A
x2	65	Battery_strap_fitting	C

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	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
Minimum layer time (s)	5	5	5	5
Support	NO	NO	NO	NO

- 2T Add 2 top layers
- 8B Add 8 bottom layers
- 2B Add 2 bottom layers
- 6 Add 4 wall lines/perimeters
- 5 The use of "tough PLA" is recommended
- 4 If your motor reach temperatures over 50 °C use ABS or PETG
- 3 Print it with flexible material

2-Center of gravity marking under the wing

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