



Recommended throw

| ITEM | NAME | CATEGORY | |
|------|-------------------|-------------------|------|
| 1 | Nose | C | |
| 2 | Fus1 | A | |
| 3 | Fus2 | A | |
| 4 | Fus3 | A | |
| 5 | Fus4 | A-LW | |
| 6 | Canopy_1 | A | |
| 7 | Canopy_2 | A-LW | |
| 8 | Canopy_3 | A-LW | |
| 9 | Wing1L | A | |
| 10 | Wing1R | A | |
| 11 | Wing2L | A | |
| 12 | Wing2R | A | |
| 13 | Wing2L_F | A | |
| 14 | Wing2R_F | A | |
| 15 | Wing3L | A-LW | |
| 16 | Wing3R | A-LW | |
| 17 | Wing3L_F | A-LW | |
| 18 | Wing3R_F | A-LW | |
| 19 | Wing4L | A-LW | |
| 20 | Wing4R | A-LW | |
| 21 | Wing5L | A-LW | |
| 22 | Wing5R | A-LW | |
| 23 | Wing6L | A-LW | |
| 24 | Wing6R | A-LW | |
| 25 | Flap1L | A-LW | |
| 26 | Flap1R | A-LW | |
| 27 | Flap2L | A-LW | |
| 28 | Flap2R | A-LW | |
| 29 | Aileron1L | A-LW | |
| 30 | Aileron1R | A-LW | |
| 31 | Aileron2L | A-LW | |
| 32 | Aileron2R | A-LW | |
| 33 | Aileron3L | A-LW | |
| 34 | Aileron3R | A-LW | |
| x2 | 35 | Boom_1 | A-LW |
| x2 | 36 | Boom_2 | A-LW |
| x2 | 37 | Boom_3 | A-LW |
| 38 | Boom_4L | A-LW | |
| 39 | Boom_4R | A-LW | |
| 40 | Boom_5L | A-LW | |
| 41 | Boom_5R | A-LW | |
| 42 | Stab_1L | A-LW | |
| 43 | Stab_1R | A-LW | |
| 44 | Stab_2L | A-LW | |
| 45 | Stab_2R | A-LW | |
| 46 | Ruddervator_LH | A-LW | |
| 47 | Ruddervator_RH | A-LW | |
| 48 | Stab_spar | C | |
| 49 | Prop_hub | C | |
| 50 | Prop_hub_stoppers | C | |
| 51 | Spinner | C | |
| x3 | 52 | Lock_1 | C |
| x3 | 53 | Lock_2 | C |
| 54 | Ballast_box | C | |
| 55 | Ballast_box_cover | C | |
| 56 | Motor_holder | C | |
| 57 | TyreD40 | C | |
| 58 | RimD40 | C | |
| 59 | LG_root | C | |
| 60 | Latch1L | C | |
| 61 | Latch1R | C | |
| 62 | Latch2L | C | |
| 63 | Latch2R | C | |
| x6 | 64 | Servo_holder_wing | C |
| x6 | 65 | Cover_horn | C |
| x2 | 66 | Horn | C |
| x32 | 67 | Hinge | C |
| x2 | 68 | Fitting_boom_1 | C |
| x2 | 69 | Fitting_boom_2 | C |
| x2 | 70 | Fitting_boom_3 | C |
| x2 | 71 | Push_rod_guide | C |

| PRINTING PARAMETER | CATEGORY | | |
|------------------------------------|----------|----------|-------------------|
| | A-LW | A | C |
| Layer height (mm) | 0.25 | 0.2 | 0.13 |
| Bottom layers | 0 | 0 | 4 |
| Top layers | 0 | 0 | 6 |
| Wall lines / perimeter | 1 | 1 | 2 |
| Nozzle diameter (mm) | 0.4 | 0.4 | 0.4 |
| Material | LW-PLA | PLA/PETG | PLA/PETG FLEX/ABS |
| Infill density (%) | 0 | 0 | 10 |
| Printing temp (°C) | 235 | 220 | 205 to 240 |
| Bed temp (°C) | 60 | 60 | 60 |
| Flow (%) | 53 | 100 | 100 |
| Retraction (mm) | 0.5 to 3 | 0.5 to 3 | 3 |
| Retraction extra prime amount (mm) | 0 to 0.7 | 0 to 0.7 | 0 |
| Speed (mm/s) | 55 | 50 | 25 to 50 |
| Fan | YES | YES | YES |
| Brim (mm) | 3 to 5 | 3 to 5 | 0 to 3 |
| Minimum layer time (s) | 5 | 5 | 5 |
| Support | NO | NO | NO |

- 27 Add 2 top layers.
- 48 Add 8 bottom layers.
- 28 Add 2 bottom layers.
- 5 Ballast box is not needed if you use a battery heavier than 300g.
- 5 Version without flaps.
- 4 Print with flexible material.
- 5 If your motor reach temperatures over 50 °C use ABS.

2-Center of gravity marking under the wing.

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