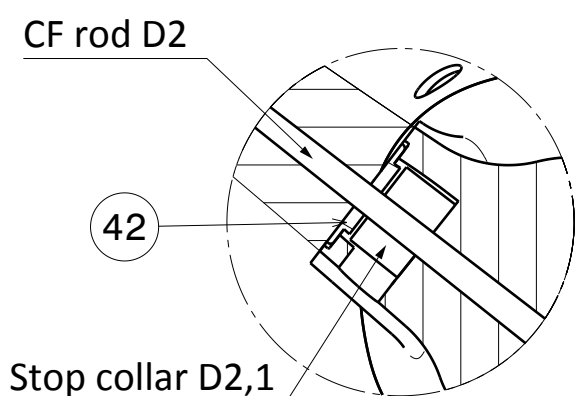
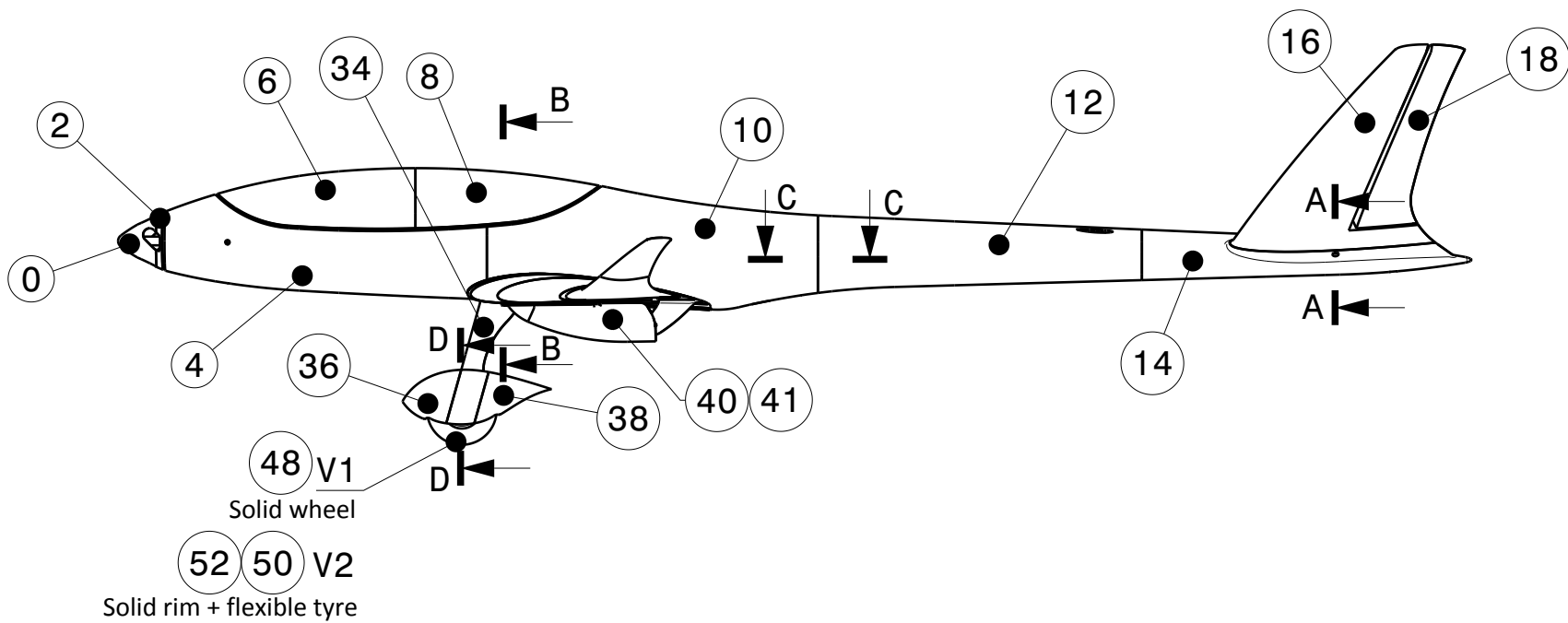
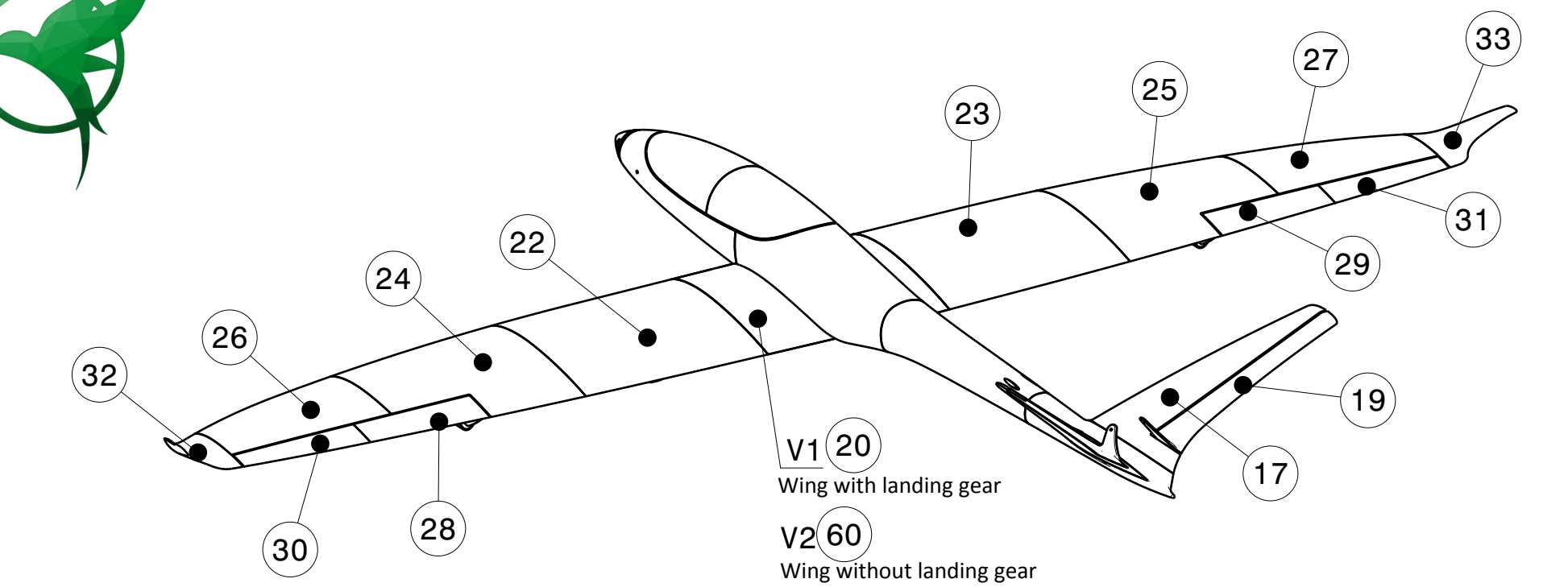
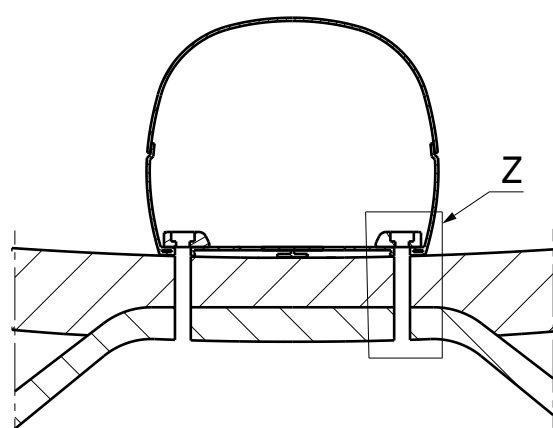
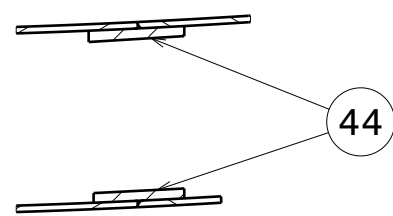




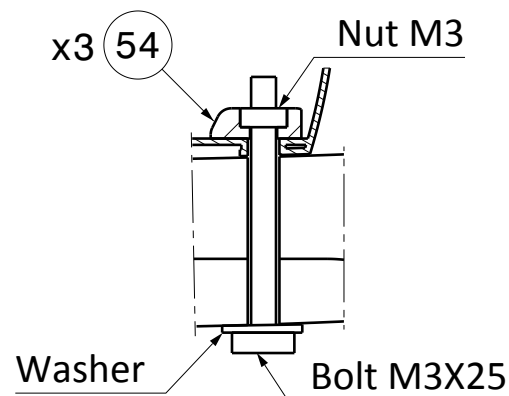
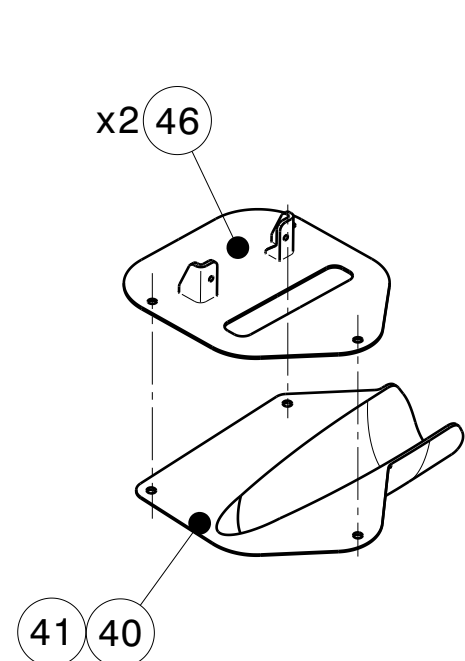
Section A-A
(Typical detail for interface
between Fuselage and stabilizer)



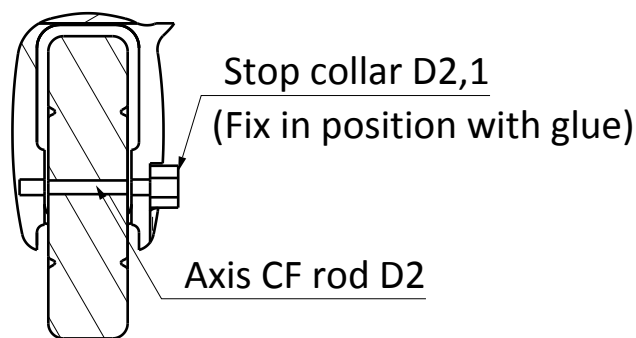
Section B-B



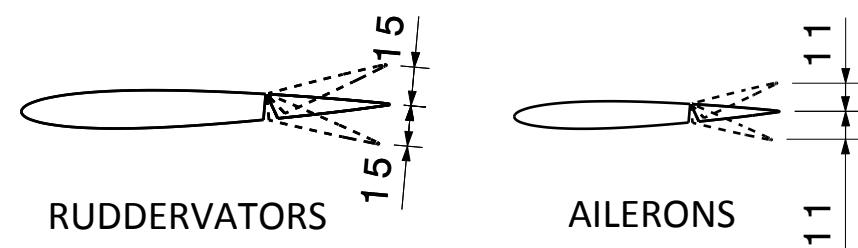
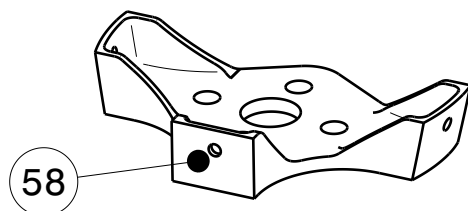
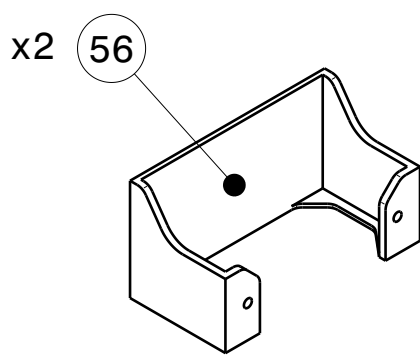
Section C-C
(Concept valid also for join
between WingC and Wing1R)



Detail Z
(Typical detail for interface
between fuselage and wing)



Section D-D



Recommended throw

ITEM	NAME	CATEGORY
0	Spinner1	B / B-LW
2	Spinner2	C
4	Fus1	A / A-LW
6	Canopy1	B / B-LW
8	Canopy2	B / B-LW
10	Fus2	A / A-LW
12	Fus3	A / A-LW
14	Fus4	A / A-LW
16	Stabilizer_LH	B / B-LW
17	Stabilizer_RH	B / B-LW
18	Ruddervator_LH	B / B-LW
19	Ruddervator_RH	B / B-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	B / B-LW
29	Aileron1R	B / B-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 / C-LW
36	Wheel_fairing_1	B / B-LW
38	Wheel_fairing_2	B / B-LW
40	Horn_cover_L	C / C-LW
41	Horn_cover_R	C / C-LW
42	Tail_cap	C
44	Guide	C
46	Servo_holder_Wing	C / C-LW
48	Wheel	C / C-LW
50	Tyre	C
52	Rim	C / C-LW
54	Anchor_nut_M3	C
56	Servo_holder_fus	C
58	Motor_holder	C
60	WingC_wo_landing_G	A / A-LW

11 If printed with LW-PLA use flow 60% for winglets and wheel fairing.

10 Use layer heigh 0,15 for Fus4, winglets and wheel fairing.

9 Print "tyre" with flexible material.

8 If you can not use fan, ensure enough time between layers to cool down material.

7 If you can not heat the bed use Spray Adhesive

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	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	7	6	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 FLEX/ABS
Infill density (%)	0	0	0	0	10	10
Printing temp (°C)	245	220	245	220	240	205 to 240
Bed temp (°C)	60	60	60	60	60	60
Flow (%)	45	100	45	100	45	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