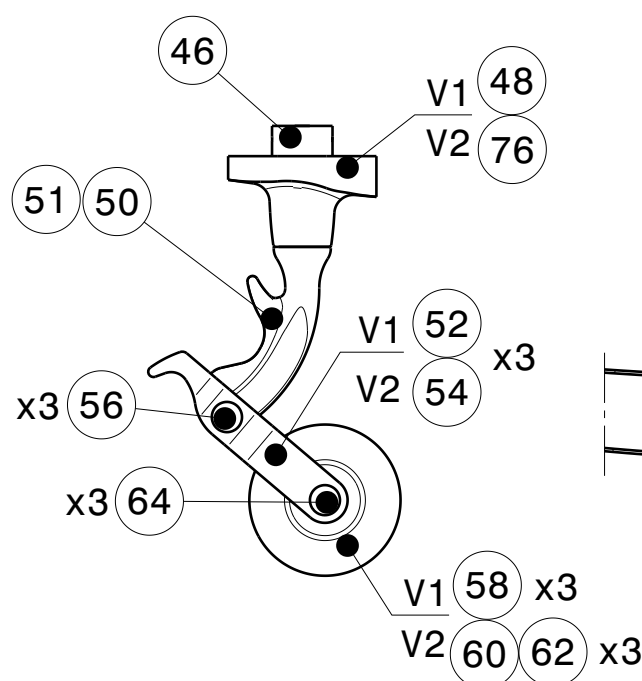
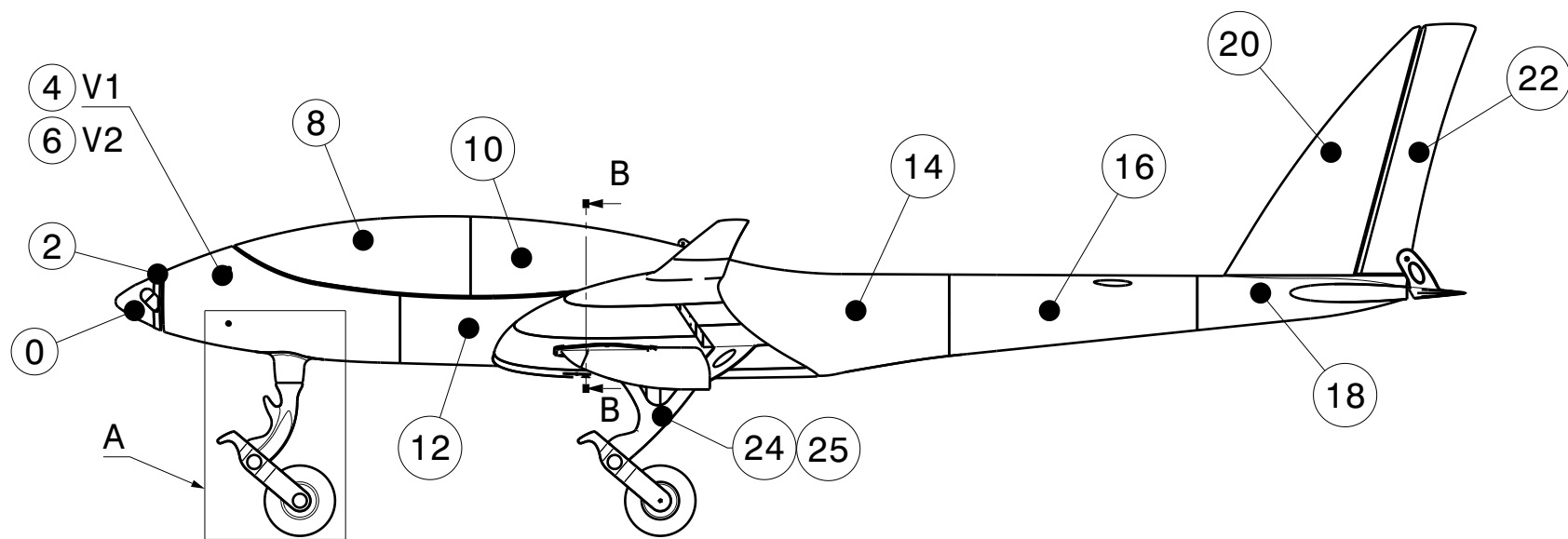
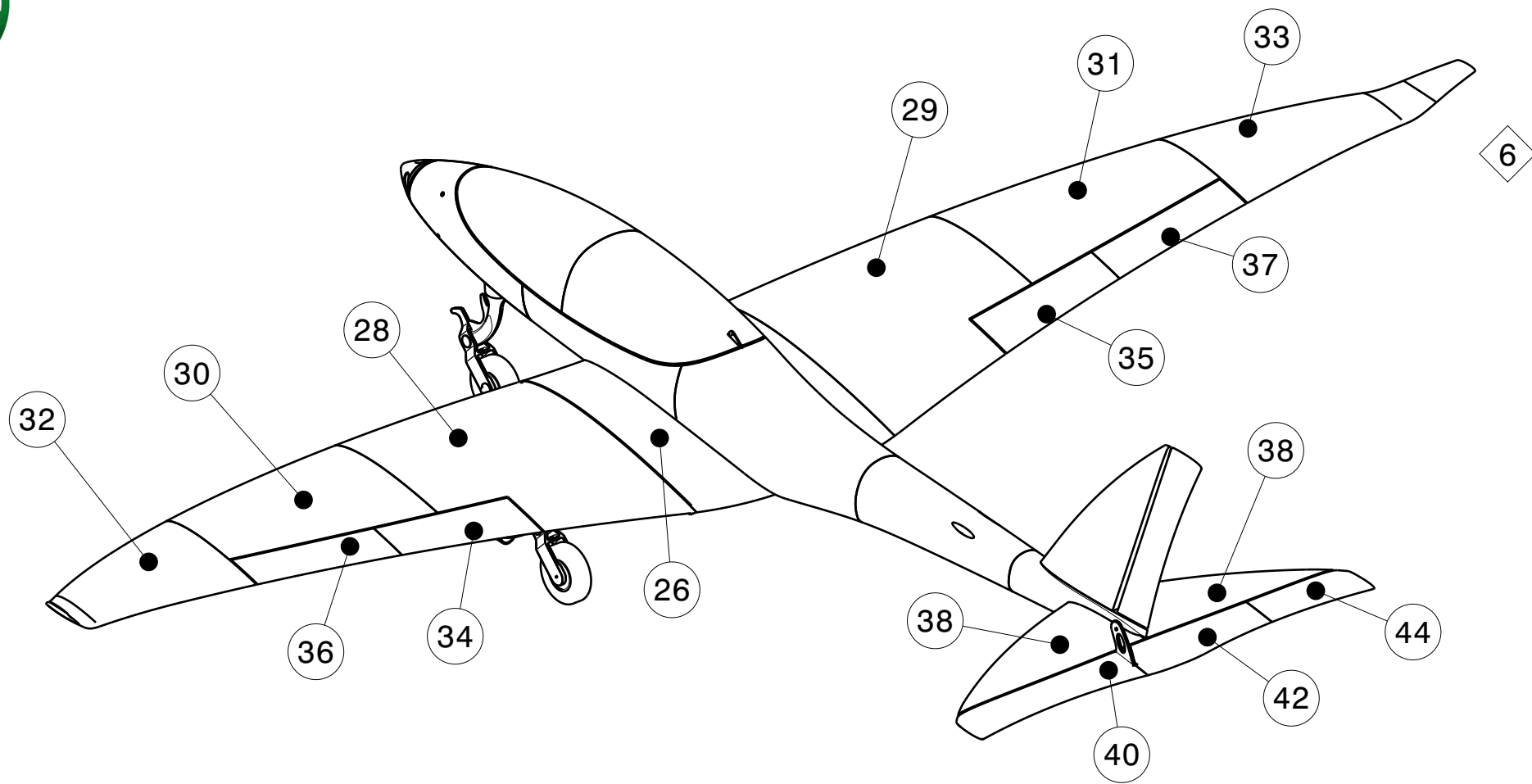
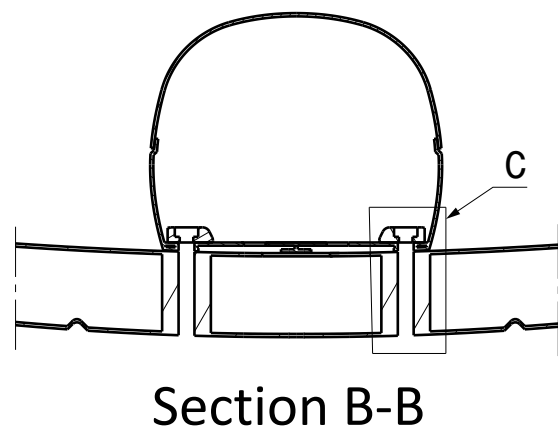
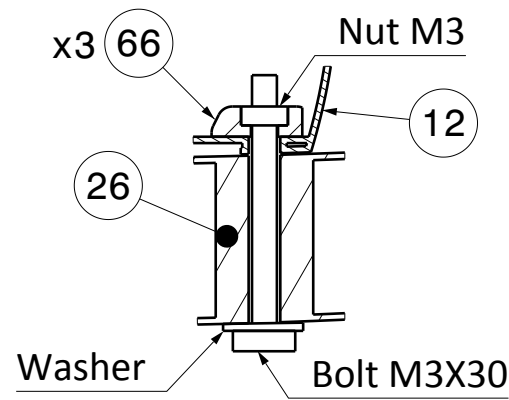




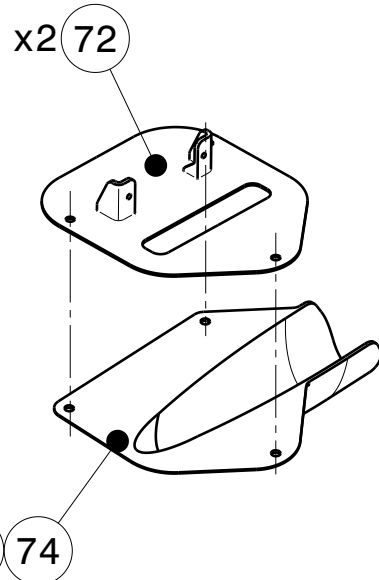
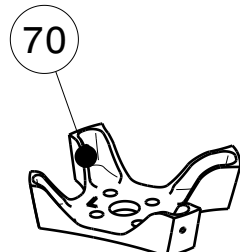
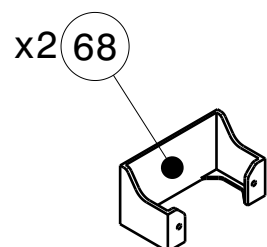
Detail A
(Item 4/6 hidden)



Section B-B



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



- 8 Adjust flow to ensure actual wall thickness of 0,5 mm (tol $\pm 0,05$)
- 7 Print "tyre" with flexible material.
- 6 It is recommended to use "fus1_intake" if air temperature is greater than 25°C in order to cool down the electronic.
- 5 Do not print this part at the same time with others, print it alone to achieve good quality.
- 4 If you can not use fan, ensure enough time between layers to cool down material.
- 3 If you can not heat the bed use Spray Adhesive
- 2 If your motor reach temperatures over 50 °C use ABS for "Motor_holder"

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

ITEM	NAME	CATEGORY
0	Spinner1	B
2	Spinner2	B
4	Fus1	A
6	Fus1_intake	A
8	Canopy1	B
10	Canopy2	B
12	Fus2	A
14	Fus3	A
16	Fus4	A
18	Fus5	A
20	VTP	B
22	Rudder	B
24	MLG_L	C
25	MLG_R	C
26	WingC	A
28	Wing1L	A
29	Wing1R	A
30	Wing2L	A
31	Wing2R	A
32	Wing3L	A
33	Wing3R	A
34	Aileron1L	B
35	Aileron1R	B
36	Aileron2L	A
37	Aileron2R	A
38	HTP	B
40	Elev1L	B
42	Elev2R	B
44	Elev3R	A
46	NLG_fitting	C
48	NLG_bushing	C
50	NLG1	C
51	NLG2	C
52	Fork_D1,4	C
54	Fork_D2,3	C
56	NLG_bolt	C
58	Wheel	C
60	Tyre	C
62	Rim	C
64	Axis_locker	C
66	Anchor_nut_M3	C
68	Servo_holder_fus	C
70	Motor_holder	C
72	Servo_holder_Wing	C
74	Horn_cover_L	C
75	Horn_cover_R	C
76	NLG_cap	C

PRINTING PARAMETER	CATEGORY		
	A	B	C
Layer height (mm)	0,2	0,2	0,13
Bottom layers	0	6	4
Top layers	0	0	6
Wall lines / perimeter	1	1	2
Nozzle diameter (mm)	0,4	0,4	0,4
Material	PLA/PETG	PLA/PETG	PLA/PETG FLEX/ABS
Infill density (%)	0	0	10
Printing temp (°C)	215 to 230	215 to 230	205 to 240
Bed temp (°C)	60	60	60
Flow	100 to 105	100 to 105	100 to 105
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)	50	50	25 to 50
Fan	YES	YES	YES
Brim (mm)	3	0 to 2	0 to 2
Minimun layer time (s)	5	5	5
Support	NO	NO	NO