



Recommended throw

ITEM	NAME	CATEGORY
1	Spinner	C
2	Prop_hub	C
3	Nose	A / A-LW
4	Canopy_1	A / A-LW
5	Canopy_2	A / A-LW
6	Fus1	A / A-LW
7	Fus2	A / A-LW
8	Fus3	A / A-LW
9	Fus4	A / A-LW
10	Fus5	A / A-LW
11	Stab_1L	A / A-LW
12	Stab_1R	A / A-LW
13	Stab_2L	A / A-LW
14	Stab_2R	A / A-LW
15	Ruddervator_LH	A / A-LW
16	Ruddervator_RH	A / A-LW
17	Wing1L	A / A-LW
18	Wing1L_F	A / A-LW
19	Wing1R	A / A-LW
20	Wing1R_F	A / A-LW
21	Wing2L	A / A-LW
22	Wing2L_F	A / A-LW
23	Wing2R	A / A-LW
24	Wing2R_F	A / A-LW
25	Wing3L	A / A-LW
26	Wing3L_F	A / A-LW
27	Wing3R	A / A-LW
28	Wing3R_F	A / A-LW
29	Wing4L	A / A-LW
30	Wing4R	A / A-LW
31	Wing5L	A / A-LW
32	Wing5R	A / A-LW
33	Flap1L	A / A-LW
34	Flap1R	A / A-LW
35	Flap2L	A / A-LW
36	Flap2R	A / A-LW
37	Aileron1L	A / A-LW
38	Aileron1R	A / A-LW
39	Aileron2L	A / A-LW
40	Aileron2R	A / A-LW
41	LG_root	C
42	TyreD40	C
43	RimD40	C
x4	Servo_holder_wing	C
x4	Cover_horn	C
3	Motor_holder	C
47	Magnet_support	C
x2	Servo_holder_fus	C
49	LG_Pin	C
x4	Hinge_wing	C
x16	Axis	C
x2	LG_pin_box	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

- 8 Version without flaps.
- 7 Add 4 top layers.
- 6 Add 8 bottom layers.
- 5 Add 2 bottom layers.
- 4 Print "tyre" with flexible material.
- 3 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.