

This is a very fast pylon racer, use a 3 cell battery for fast flying,
use 4 cell battery for extreme fast flying.
Use thick ca glue, with activator spray.

Wingspan: 720mm
Weight: 420 to 500 gram
Control throws: elevator:3mm up and down
Ailerons: 6mm up and 3mm down.

Minimum print area 220x220x250mm

Cura printer settings:

LWPLA

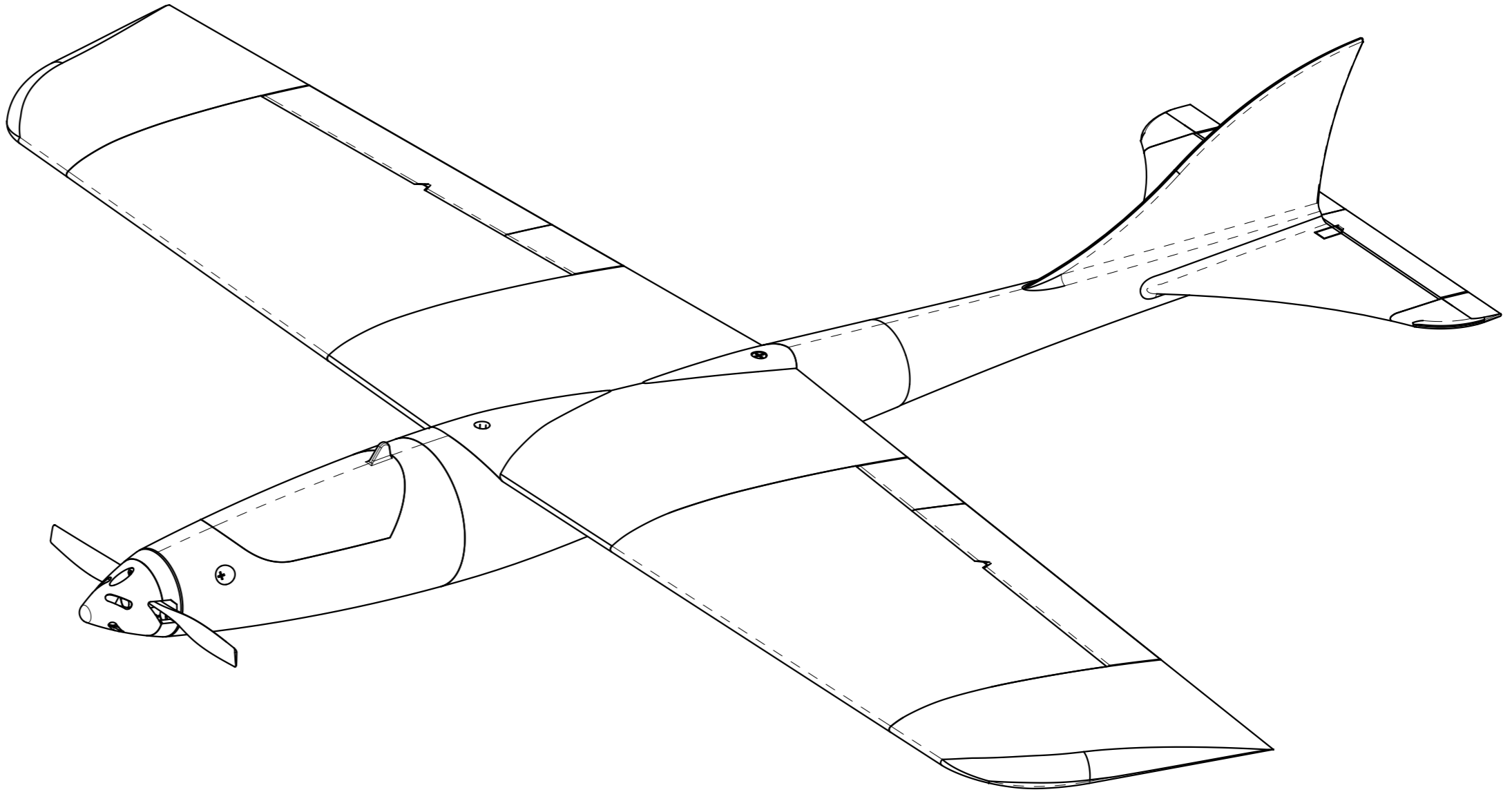
To prevent stringing, print only one part at a time.
Use Cura std quality 0,2 as a start setting, modify with:
Layer height: 0,2mm
Line width: 0,4mm
Wall line count: 1
Z seam alignment: User specified, back
Top/bottom layers: 3
Infill: Gyroid, 4mm line distance
Printing temperature: 235, build plate temperature: 60, Flow 55%
Speed: 40mm/s
No support
Build plate adhesion: Brim 3mm

PLA (P1)

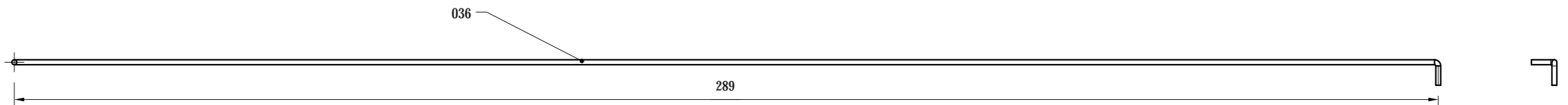
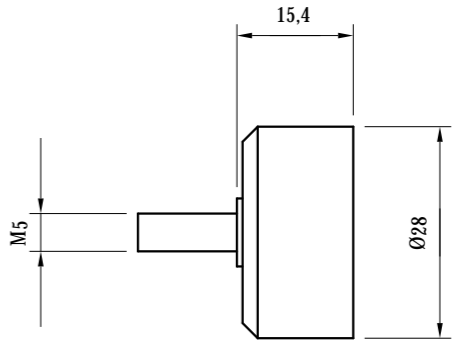
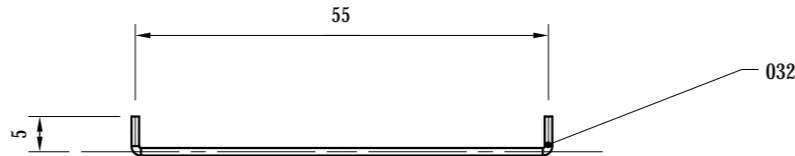
Use Cura std quality 0,2 as a start setting, modify with:
Layer height: 0,2mm
Line width: 0,4mm
Wall line count: 1
Z seam alignment: User specified, back
Top/bottom layers: 4
Infill: Gyroid, 3mm line distance
Printing temperature: 215, build plate temperature: 50
Speed: 40mm/s
No support
Build plate adhesion: Brim 3mm

PLA (P2)

Use Cura std quality 0,2 as a start setting, modify with:
Layer height: 0,2mm
Line width: 0,4mm
Wall line count: 4
Top/bottom layers: 4
Infill: Grid, 100%
Printing temperature: 215, build plate temperature: 50
Speed: 40mm/s
No support
Build plate adhesion: skirt 3mm

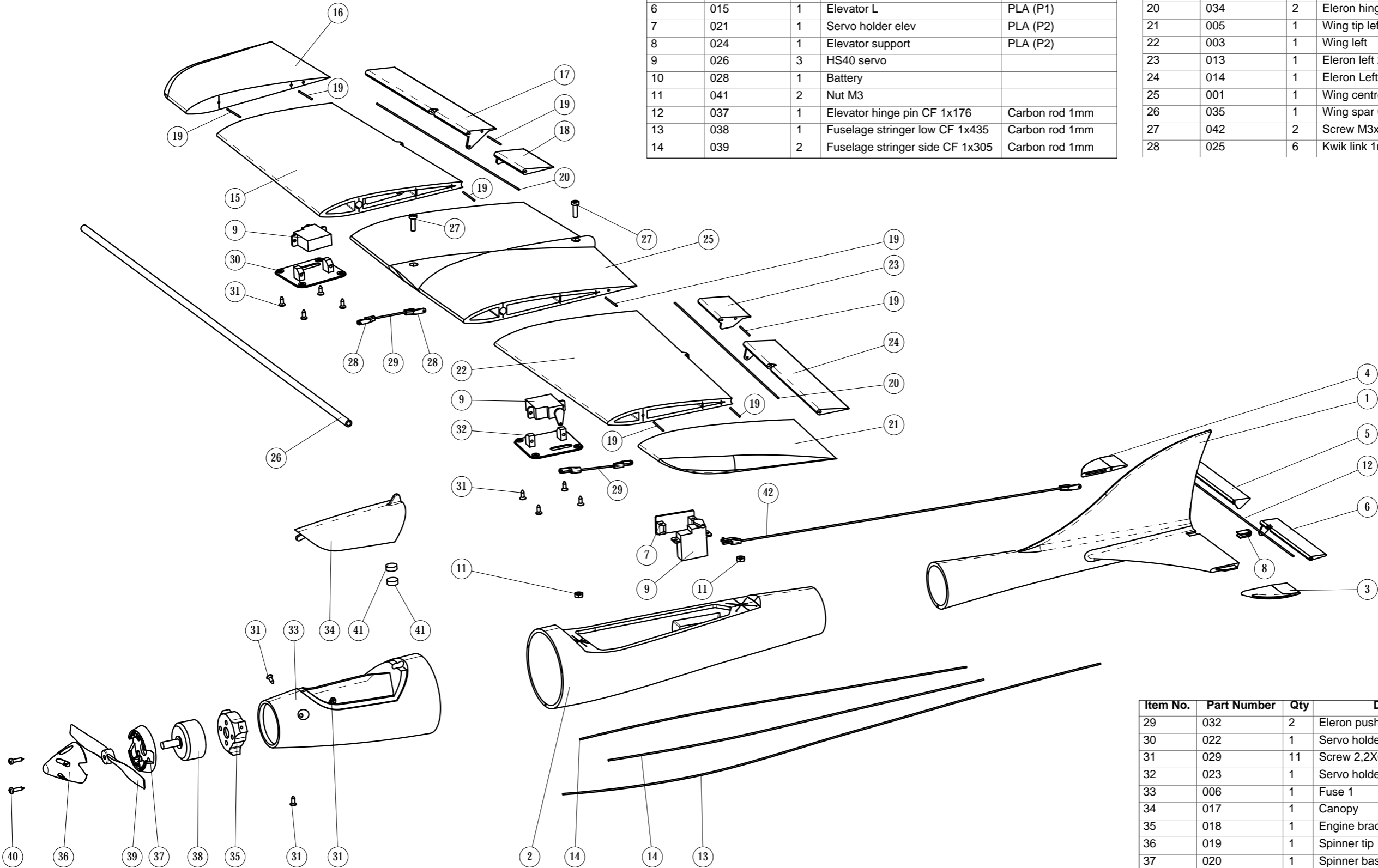


Motor: Emax 2205 2600tpv
Or equivalent



Item No.	Part Number	Qty	Description	Material
1	008	1	Fuse 3	LW PLA
2	007	1	Fuse 2	LW PLA
3	009	1	Stab tip L	LW PLA
4	010	1	Stab tip R	LW PLA
5	016	1	Elevator R	PLA (P1)
6	015	1	Elevator L	PLA (P1)
7	021	1	Servo holder elev	PLA (P2)
8	024	1	Elevator support	PLA (P2)
9	026	3	HS40 servo	
10	028	1	Battery	
11	041	2	Nut M3	
12	037	1	Elevator hinge pin CF 1x176	Carbon rod 1mm
13	038	1	Fuselage stringer low CF 1x435	Carbon rod 1mm
14	039	2	Fuselage stringer side CF 1x305	Carbon rod 1mm

Item No.	Part Number	Qty	Description	Material
15	002	1	Wing right	LW PLA
16	004	1	Wing tip right	LW PLA
17	011	1	Eleron right 1	PLA (P1)
18	012	1	Eleron right 2	PLA (P1)
19	033	8	Connection pin CF 1x18	Carbon rod 1mm
20	034	2	Eleron hinge pin CF 1x200	Carbon rod 1mm
21	005	1	Wing tip left	LW PLA
22	003	1	Wing left	LW PLA
23	013	1	Eleron left 2	PLA (P1)
24	014	1	Eleron Left 1	PLA (P1)
25	001	1	Wing centre	LW PLA
26	035	1	Wing spar CF 5x3x430	Carbon tube 5x3mm
27	042	2	Screw M3x10	
28	025	6	Kwik link 1mm	PLA (P2)



Item No.	Part Number	Qty	Description	Material
29	032	2	Eleron pushrod	Piano wire 1mm
30	022	1	Servo holder eleron R	PLA (P2)
31	029	11	Screw 2,2X6,5 DIN7982C	
32	023	1	Servo holder eleron R	PLA (P2)
33	006	1	Fuse 1	LW PLA
34	017	1	Canopy	PLA (P1)
35	018	1	Engine bracket	PLA (P2)
36	019	1	Spinner tip	PLA (P2)
37	020	1	Spinner base	PLA (P2)
38	027	1	Motor Emax 2205 2600tpv	
39	040	1	Prop 4,7x4,7	
40	030	2	Screw 2,2X9,5 DIN7981C	
41	031	2	Magnet 3x8	
42	036	1	Elevator pushrod	Piano wire 1mm