

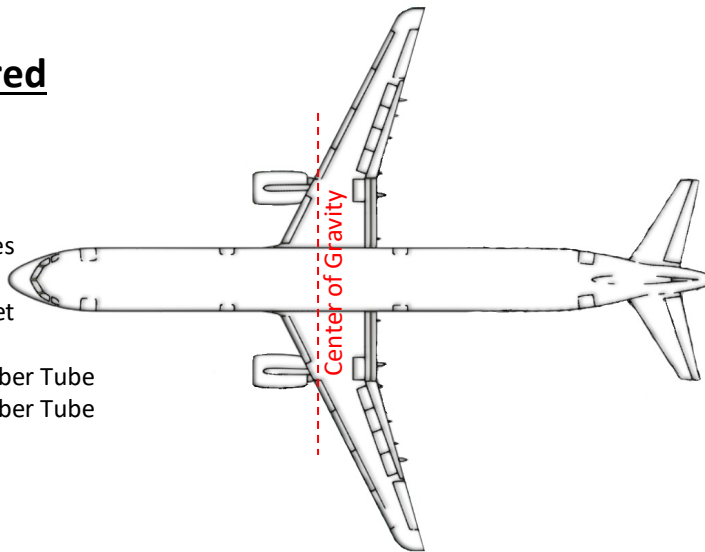
## 321 AIRLINER



- Wingspan – 1.6m
- Length – 2m
- RTF Weight – 3,360g

### Materials Required

- 2x 70mm EDF
- 2x 80amp ESC
- 1x 4s 5200mah Battery
- 6x 9g Servos
- Servo Wire Extension Cables
- 8x 10x5x3 Magnets
- M3 Brass Threaded Heat Set
- 2x8mm Screws
- 2x 8mmx482mm Carbon Fiber Tube
- 2x 8mmx457mm Carbon Fiber Tube
- 1.19mm Music Wire
- Velcro



### PARTS LIST

#### PROFILE #1

F1-F8

#### PROFILE #2

F9

#### PROFILE #3

Battery Door  
Front Cowl  
Tail Pipe

#### PROFILE #4

Rear Cowl

#### PROFILE #5

L&R Wing 1  
L&R Wing 2  
L&R Wing 3  
L&R Wing 4  
L&R Wing Tip  
L&R Ailerons  
L&R H Stab 1  
L&R H Stab 2  
L&R Elevator 1  
L&R Elevator 2  
Vertical Stab 1  
Vertical Stab 2  
Rudder 1  
Rudder 2  
All Flap Track Beams

#### PROFILE #6

Nose  
All Windows  
Battery Trays  
Battery Door Frames  
All L/G Parts  
All EDF Mount Brackets  
L&R Inside Wing Mount  
L&R Outside Wing Mount  
Servo Covers & Mounts  
Control Horns

Print Settings	Profile #1	Profile #2	Profile #3	Profile #4	Profile #5	Profile #6	Hinge & Tire
	PLA	PLA	PLA	PLA	PLA	PLA	TPU
Layer Height	0.2	0.2	0.2	0.2	0.2	0.2	0.2
Initial Layer Height	0.15	0.15	0.15	0.15	0.15	0.15	0.15
Wall Line Count	1	1	1	1	1	3	3
Print Thin Walls	YES	YES	YES	YES	YES	YES	YES
Minimum Feature Size	0.001	0.001	0.001	0.001	0.001	0.001	0.001
Top Layers	0	4	6	0	6	6	4
Bottom Layers	4	0	4	0	4	4	4
Initial Bottom Layer	0	0	4	0	4	4	4
Extra Skin Wall Count	5	5	5	N/A	5	5	5
Skin Removal Width	2.5mm	2.0mm	3.0mm	3.0mm	0.42mm	.42mm	.42mm
Infill Density	0%	0%	0%	0%	4% Gyroid	15% Grid	15% Grid
Printing Temp	215	215	215	215	215	215	210
Flow	102%	102%	102%	102%	102%	102%	115%
Print Speed	55	55	55	55	55	55	55
Generate Support	NO	NO	NO	NO	NO	NO	NO
Surface Mode	Normal	Normal	Normal	Normal	Normal	Normal	Normal
Spiralize Outer Contour	NO	NO	NO	NO	NO	NO	NO