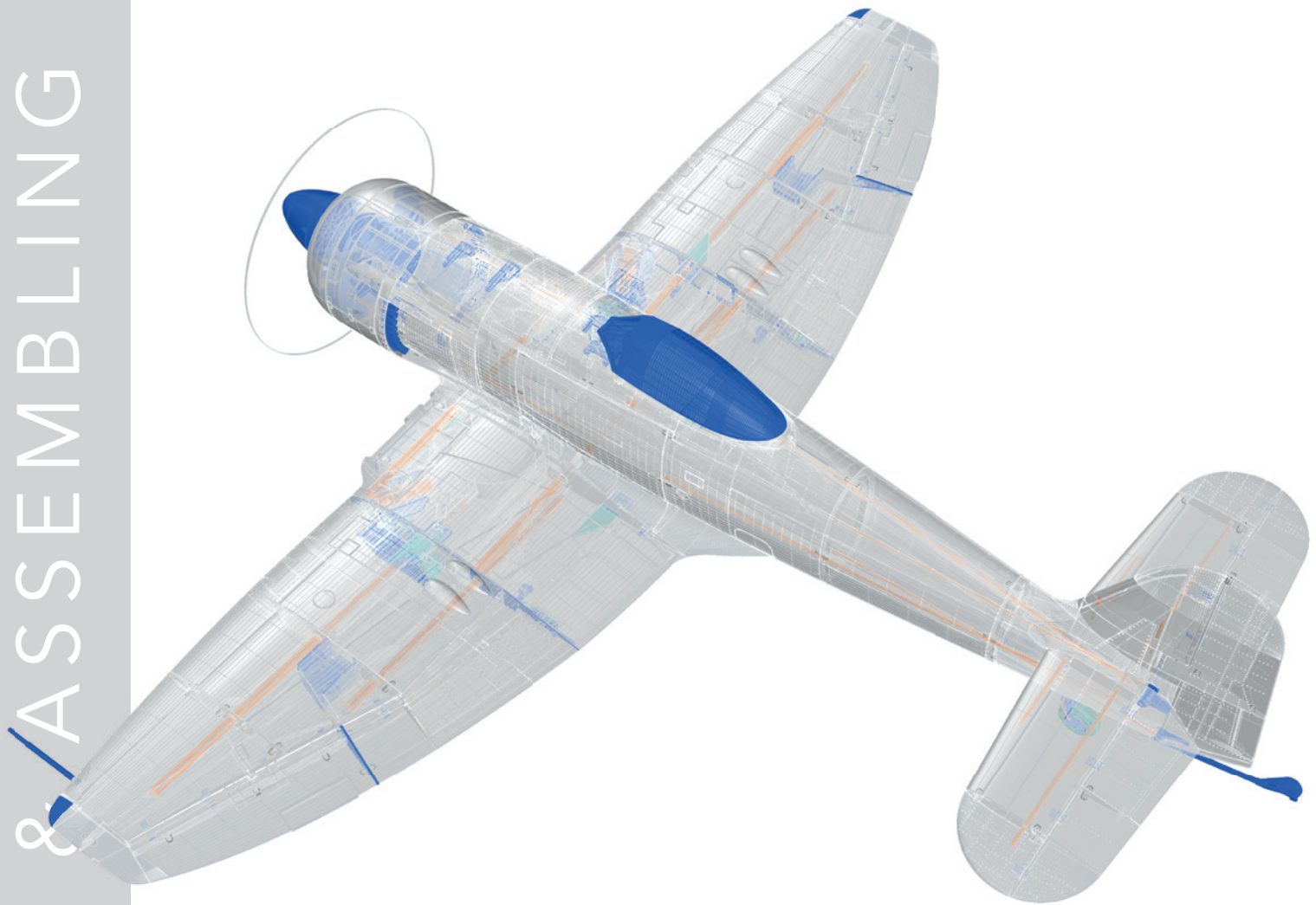


# PLANE PRINT



## PLANE PRINT *Sea Fury*

Single-engine, acro-capable RC plane



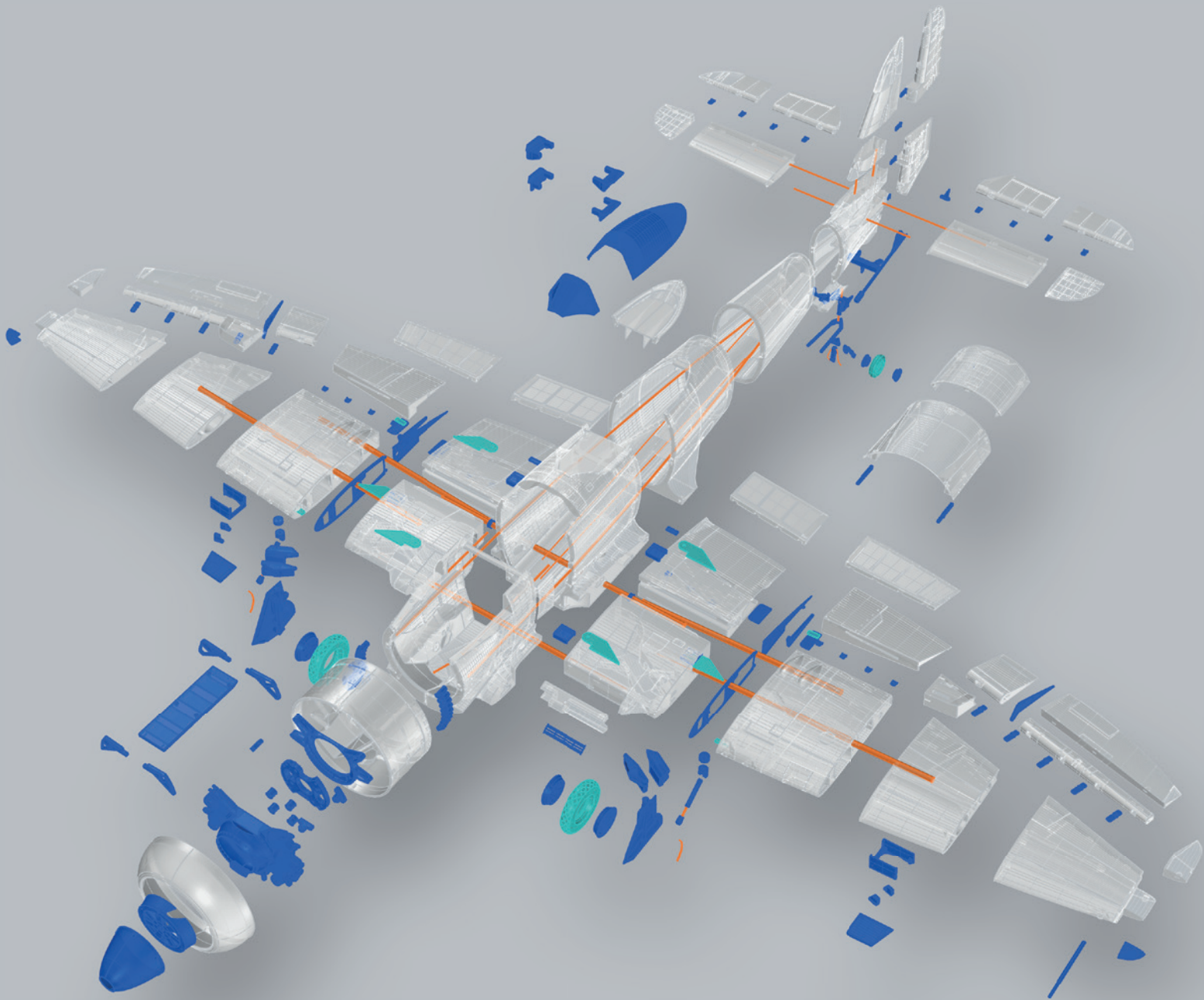
**NOTE:**  
Slicing works best  
with CURA!



[www.planeprint.com](http://www.planeprint.com)

the **ONLY** place where you can get  
original Planeprint STL files **legally!**

# PLANE PRINT *Sea Fury*



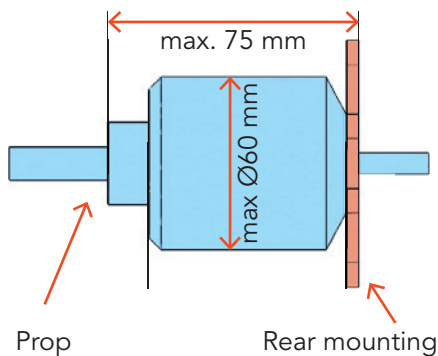
□ LW-PLA    ■ PLA    ■ TPU    ■ OTHER

# RC Components

**ENGINE** Motors mit 400 to 500 Kv, ideal weight 280 to 340 grams

we use the **ROXXY BL OUTRUNNER C50-55-480KV 3D PERFORMANCE**

**You can also use any other motor that fits a 14x7 3 blade propeller!**



**PROP** 14x7 3 blade (we use Master Airsrew), also possible 15x6 3 blade

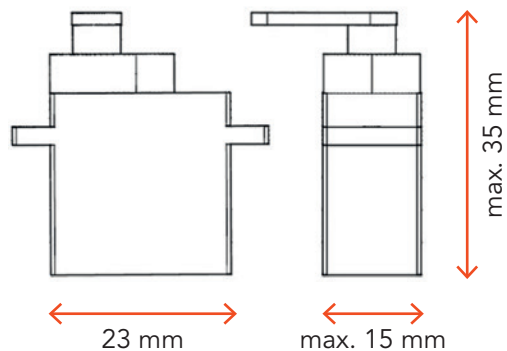
**BEC-CONTROLLER** min 80 A (must fit the engine!)

**RECEIVER** 7 Channel

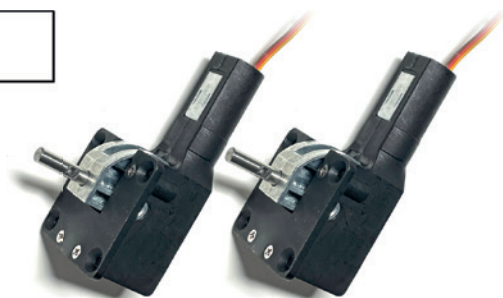
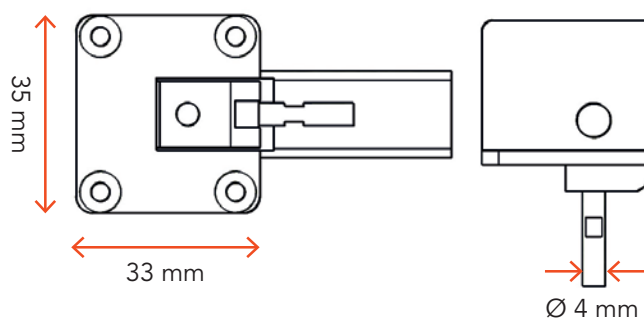
**BATTERY** 6S Lipo, 3000 – 4000 MaH (The battery should have a weight of 450 to 550 grams)

**SERVOS** 6 pieces like **KST Clubman CM509MG** or comparable  
(The servo should have metal gears, we advise against very cheap servos)

Dimensions:



**SERVOLESS RETRACTS** 2 pieces (we used: 40g Landing Gear, AliExpress – for 3.500g Models)



# Required accessoires – basic equipment

Links to recommended accessories can be found on [www.planeprint.com/seafury](http://www.planeprint.com/seafury) (scroll down)

- LW-PLA foaming! (**cannot be replaced by PLA!**), ~1600 grams
- Tough PLA, ~450 grams
- TPU A95 and LW-TPU Colorfabb VarioShore, ~100 grams

## Materials

- CA super glue (liquid and liquid medium)
- CA activator
- Sortiment of Tapping screws Ø2mm
- Sortiment of Metal Screws Ø3mm
- Metal screw Ø4\*40mm, 2 pieces
- Carbon tube Ø10mm\*1000mm (inside 8mm), **3 pieces**  
Cut the tubes to the following lengths (mm):  
1 tube = 500, 500  
1 tube = 480, 480  
1 tube = 361, 361
- Carbon rod Ø3\*1000mm, 4 pieces  
Cut the rods to the following lengths (mm):  
480, 240, 220, 220, 130, 100, 77, 62, 48, 48
- Steel wire Ø1\*1000mm, 4 pieces
- Steel wire Ø4\*80mm, 2 pieces
- Rod connection (hole for Ø1mm steel wire), 2 pieces
- Ball bearings 4x9x4mm, 4 pieces
- Servo extension cable 300mm, 2 pieces and 150mm, 4 pieces
- Self-adhesive Velcro tape
- Threaded inserts M3 (optional, see description gear)

## Tools

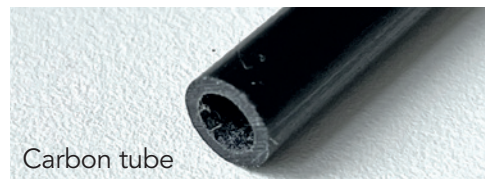
Cutter knife, small Philips screwdriver, Sandpaper grain ~150, Metal saw, Needle nose pliers



Tapping screws Ø2mm



Metal screws Ø3mm



Carbon tube

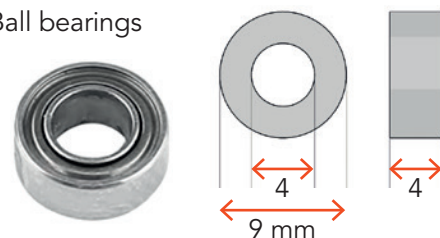


Carbon rod



Rod connection hole Ø 1 to 2mm

Ball bearings



Threaded insert



The development of a complex, airworthy RC flight model to express on any standard 3D printer is a very extensive process. **Therefore, we appeal to your fairness not to forward the STL data you have acquired to third parties.**

Thank you for your understanding and have fun with your PLANEPRINT MODEL!

## Printing the parts – Printing profiles

This manual is constantly being improved and supplemented, we recommend downloading the **latest version** from our website **before building**.

To print all **PLANEPRINT** models **you need to set some basic profiles in Cura** (If you use another slicer, please set the same parameters).

You can find the description at [www.planepprint.com/print](http://www.planepprint.com/print)

For this model you need the following profiles:

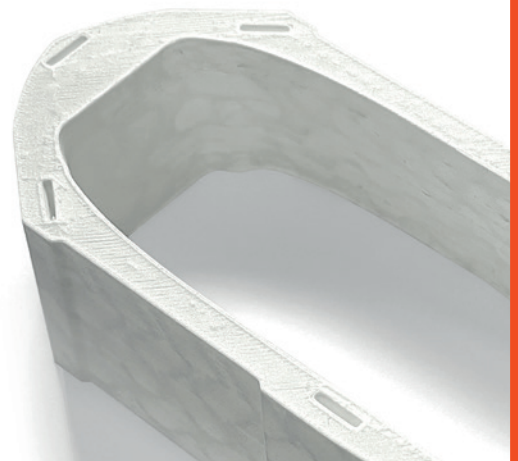


**NOTE** When printing the PLANEPRINT SEA FURY you should pay particular attention to a light weight of **each** individual part.

### PROFILE P5\_Gyroid

It is **essential for the necessary stability** of the **LW parts printed with PROFILE\_5 are as stable as possible**. Please use a test part to check the strength by fracture tests. It must not break along the layer lines under any circumstances! Also note that the printing temperature for LW-PLA is as low as possible to obtain a wall thickness of 0.4 to 0.6 mm at a flow of 55 to 65 % (depending on brand and printer).

**Caution: at too high temperatures, LW-PLA becomes brittle and breaks more easily.**



# PROFILE P1\_Fullbody Tough PLA or PLA



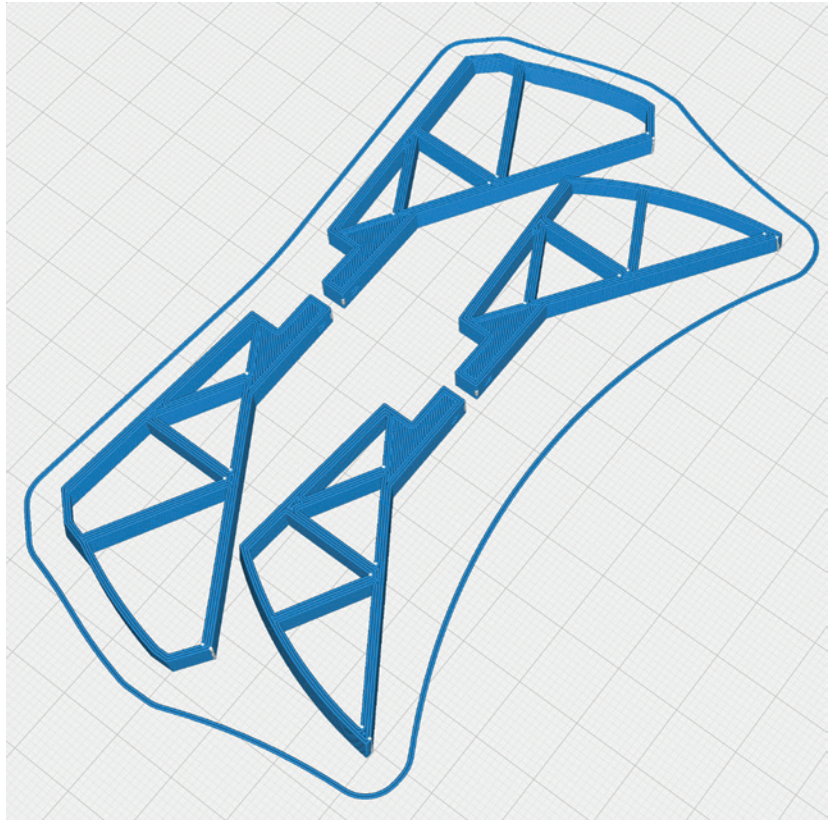
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Battery mount\_sf.stl

**MATERIAL** PLA, Weight: ~ 7 g

### ADDITIONAL SETTINGS

None required



## P1\_Canopy 1\_sf.stl

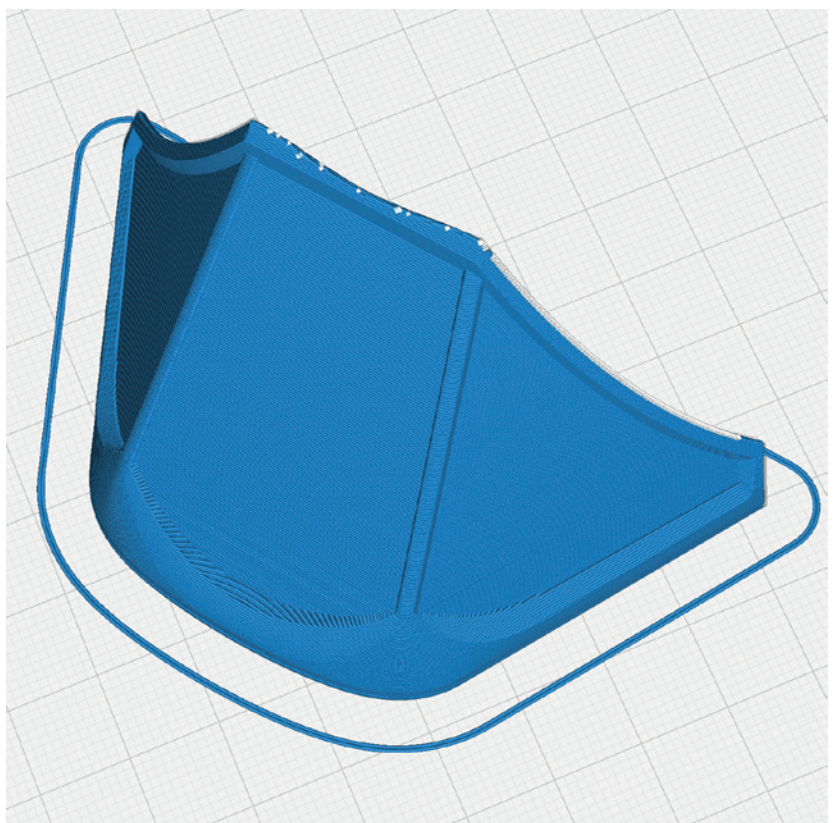
**MATERIAL** PLA, Weight: ~ 6 g

### ADDITIONAL SETTINGS

None required

**TIP** Use transparent filament

For optimum printing, transparent filaments should always be dried.



# PROFILE P1\_Fullbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Canopy 2\_sf.stl

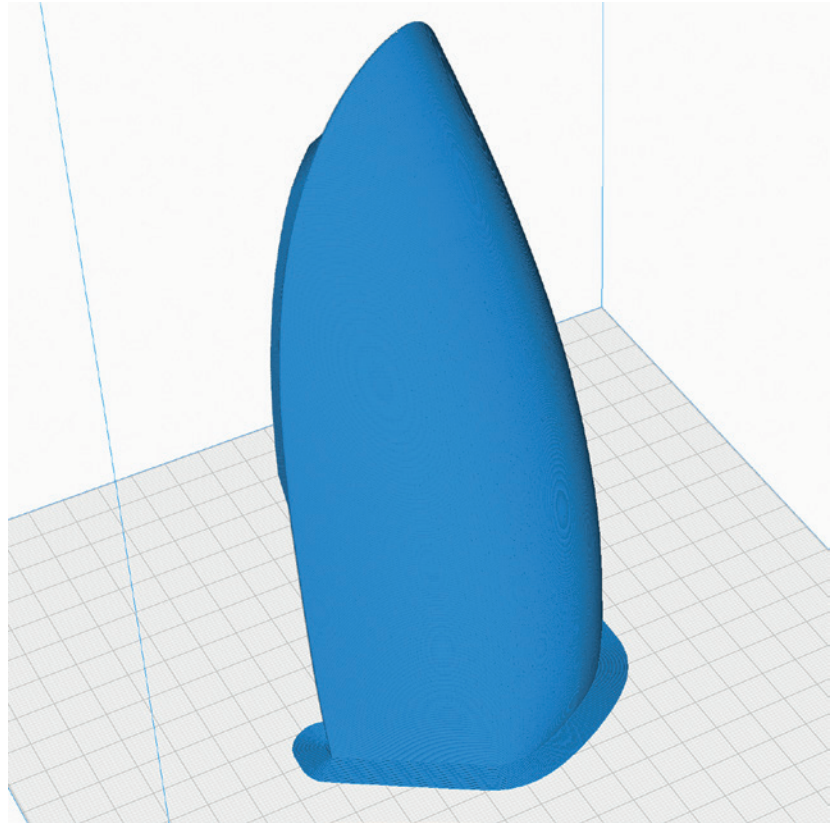
**MATERIAL** PLA, Weight: ~ 26 g

### ADDITIONAL SETTINGS

- use brim

**TIP** Use transparent filament

For optimum printing, transparent filaments should always be dried.

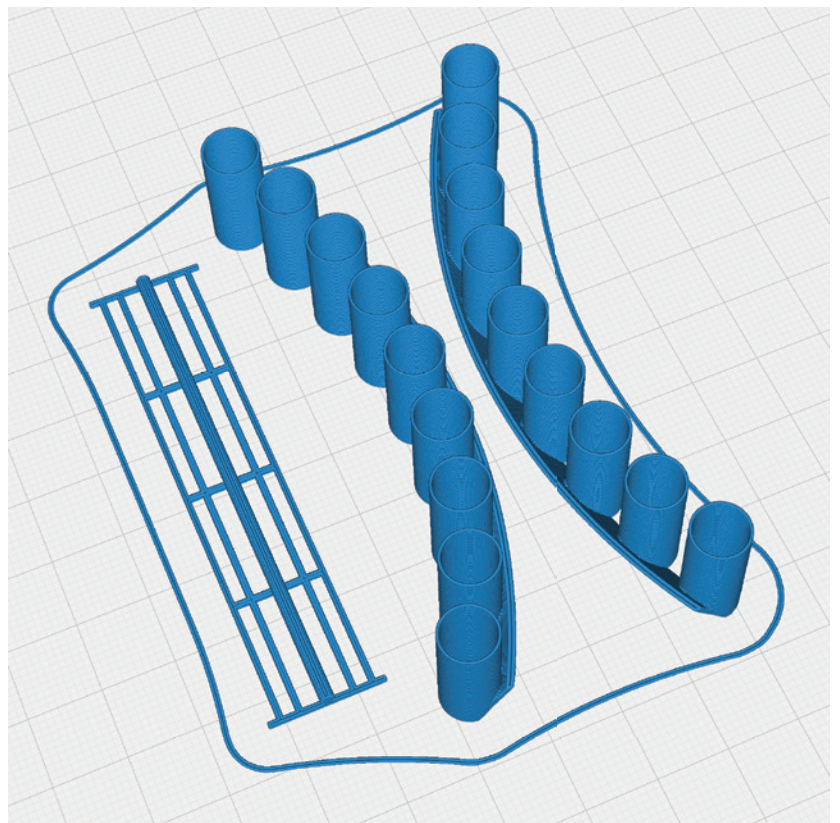


## P1\_Exhausts\_sf.stl

**MATERIAL** PLA, Weight: ~ 6 g

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody **Tough PLA or PLA**



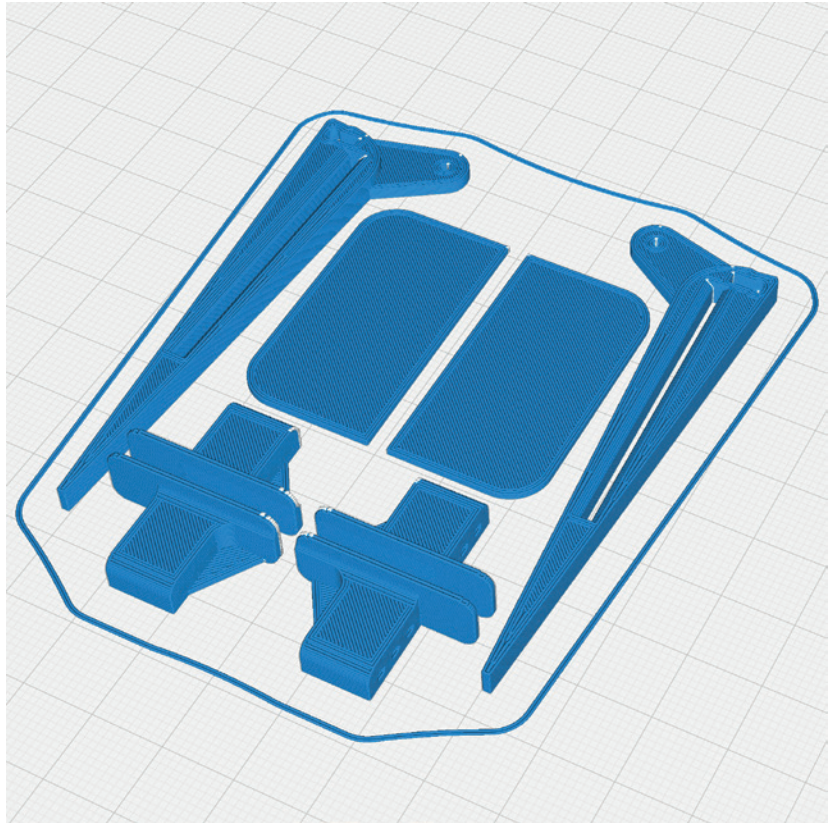
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Flap Parts\_sf.stl

**MATERIAL** PLA, Weight: ~ 11 g

### **ADDITIONAL SETTINGS**

None required

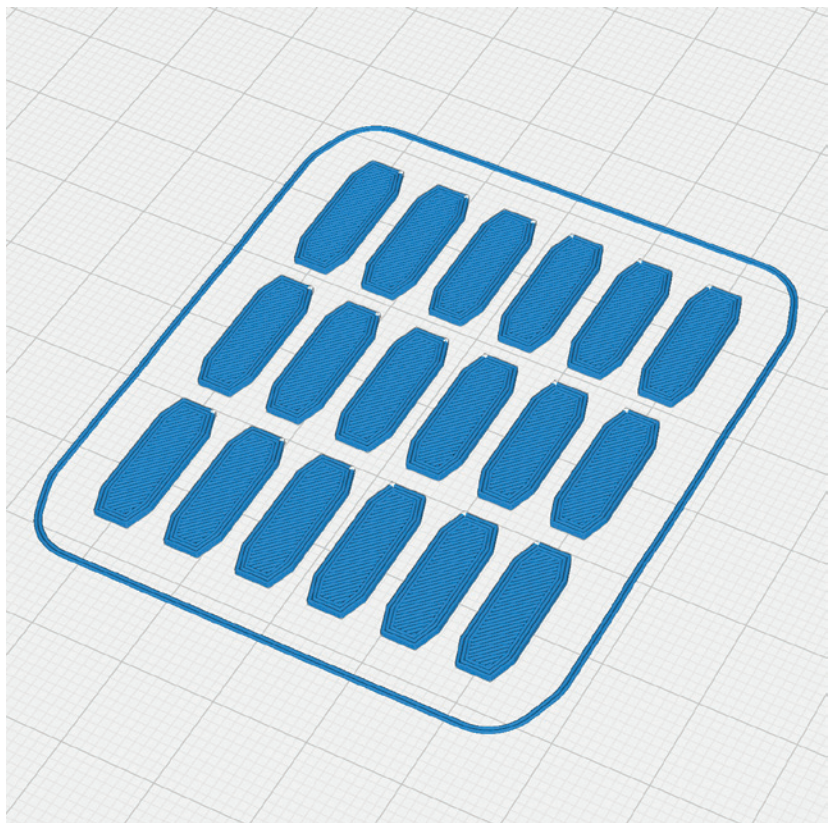


## P1\_flat-Connects\_sf.stl

**MATERIAL** PLA, Weight: ~ 2 g

### **ADDITIONAL SETTINGS**

None required





# PROFILE P1\_Fullbody Tough PLA or PLA



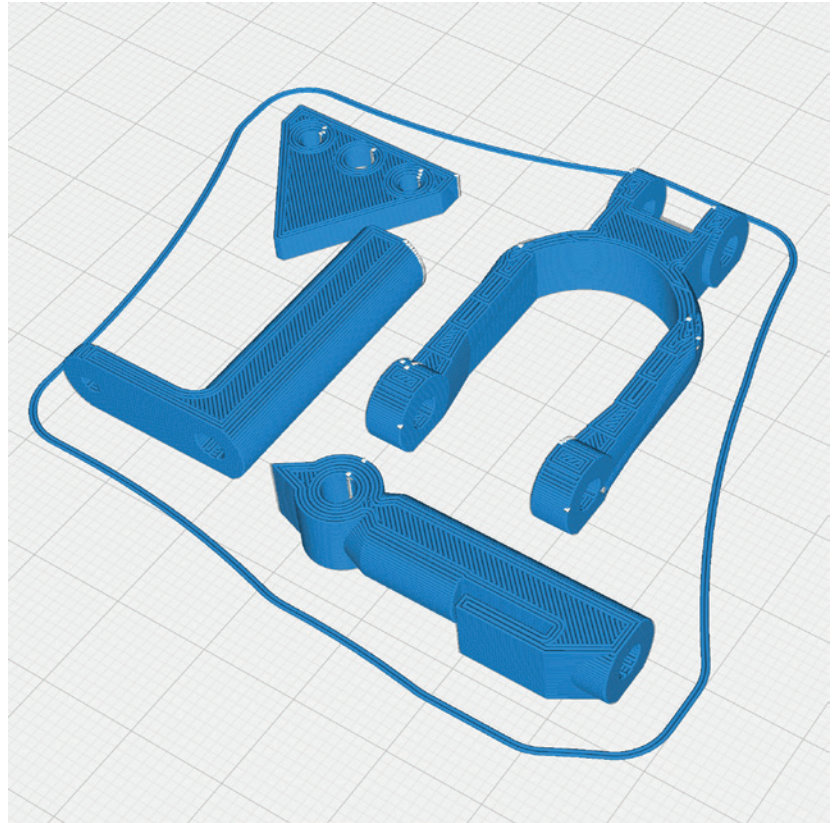
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Gear Tail\_sf.stl

**MATERIAL** PLA, Weight: ~ 6 g

### ADDITIONAL SETTINGS

None required

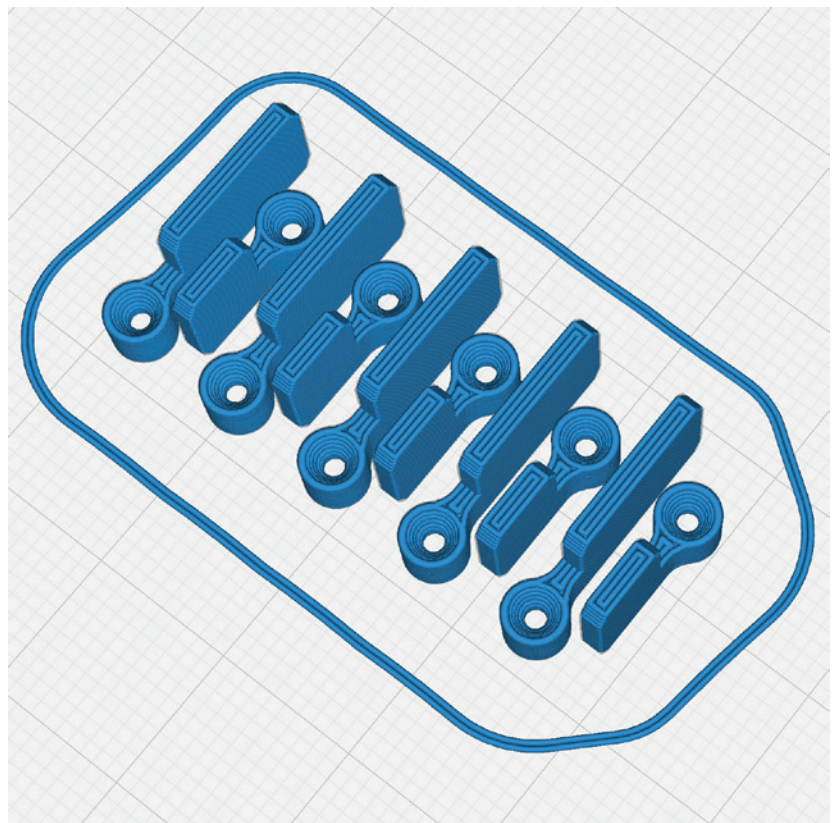


## P1\_Hinges Aileron\_sf.stl

**MATERIAL** PLA, Weight: ~ 2 g

### ADDITIONAL SETTINGS

- Print twice



# PROFILE P1\_Fullbody Tough PLA or PLA



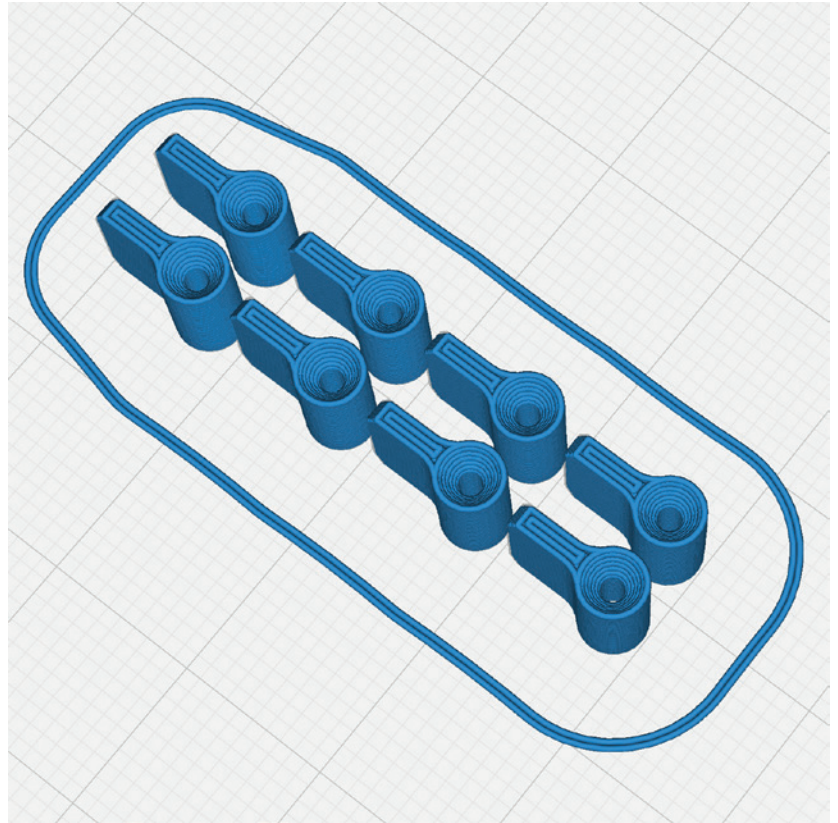
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Hinges Flap\_sf.stl

**MATERIAL** PLA, Weight: ~ 2 g

### ADDITIONAL SETTINGS

- Print twice

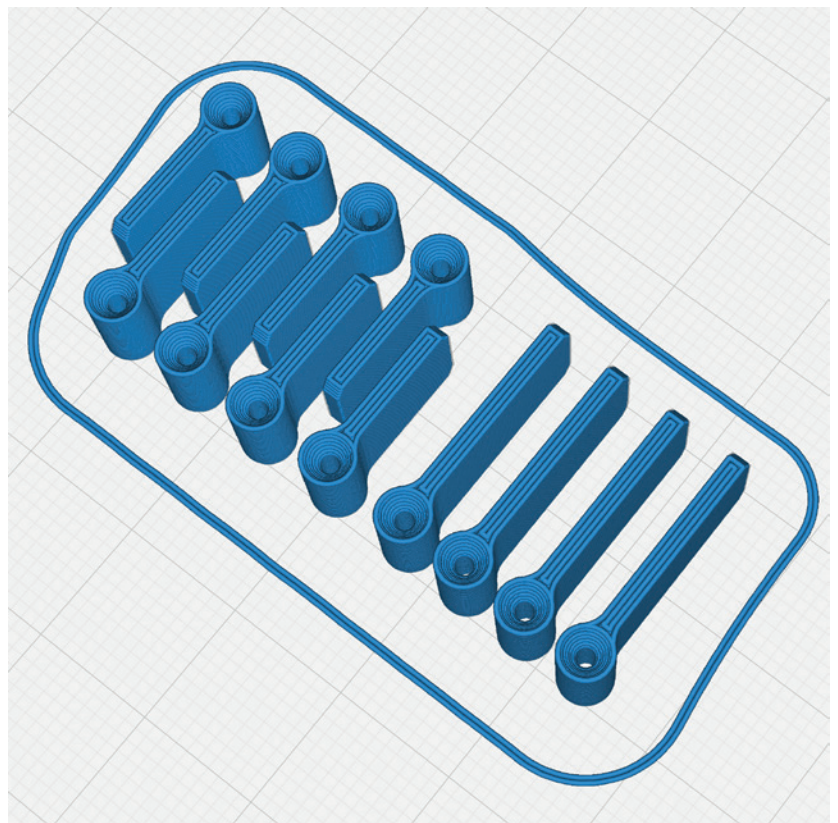


## P1\_Hinges Tail\_sf.stl

**MATERIAL** PLA, Weight: ~ 4 g

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Landing Light L\_sf.stl and P1\_Landing Light R\_sf.stl

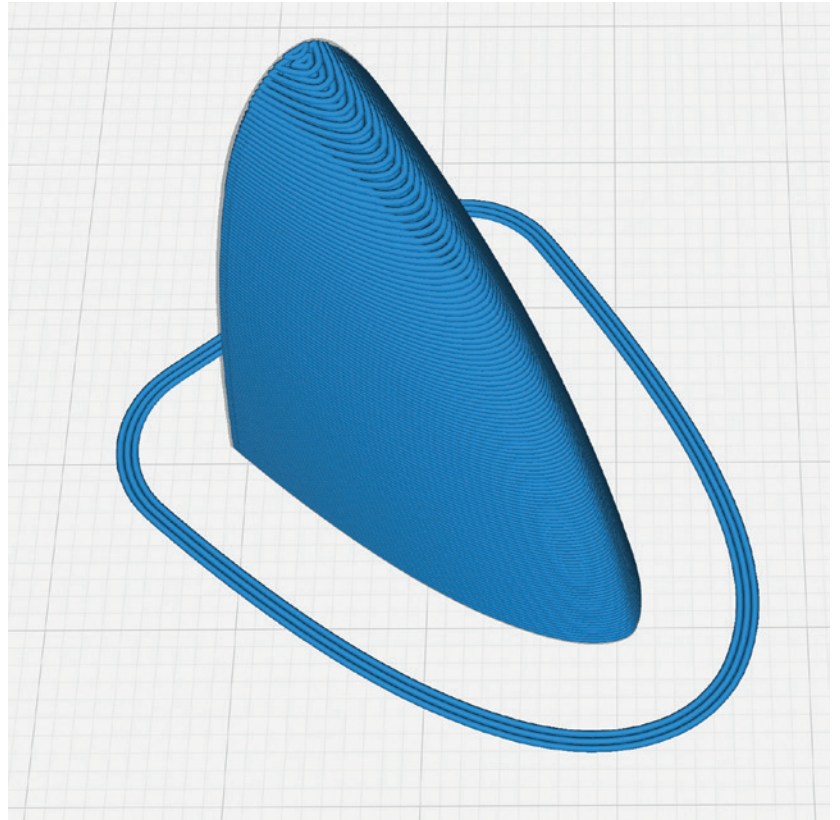
**MATERIAL** PLA, Weight: ~ 1 g

### ADDITIONAL SETTINGS

None required

**TIP** Use transparent filament

For optimum printing, transparent filaments should always be dried.

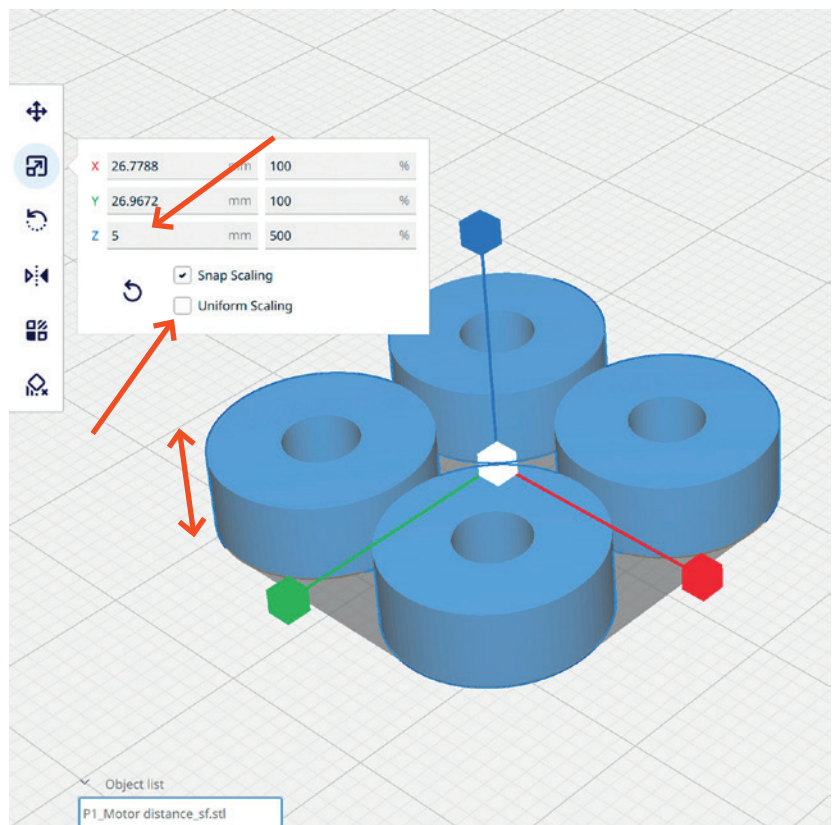


## P1\_Motor distance\_sf.stl

**MATERIAL** PLA

### ADDITIONAL SETTINGS

Depending on the length of your motor, change the Z-height (not X and Y!) in the slicer to achieve the correct motor position (see description Motor assembling)



# PROFILE P1\_Fullbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

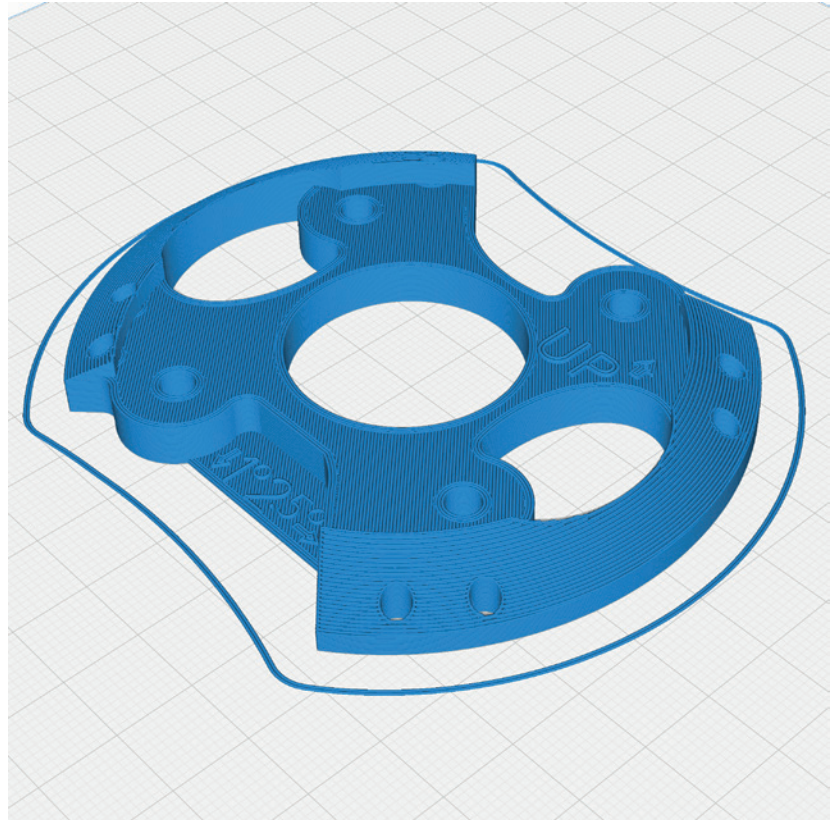
## P1\_Motor Plate\_sf.stl

**MATERIAL** Tough PLA, Weight: ~ 24 g

### ADDITIONAL SETTINGS

None required

**NOTE** These part hold the motor and must be **absolutely stable!** Ensure good layer adhesion.



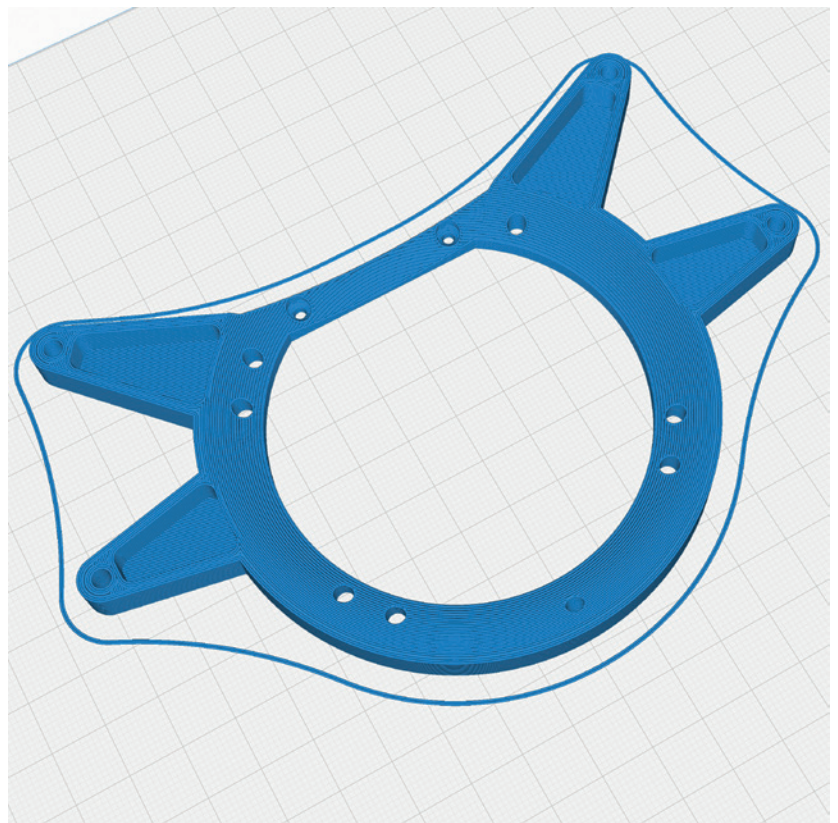
## P1\_Motormount\_sf.stl

**MATERIAL** Tough PLA, Weight: ~ 29 g

### ADDITIONAL SETTINGS

None required

**NOTE** These part hold the motor and must be **absolutely stable!** Ensure good layer adhesion.



# PROFILE P1\_Fullbody Tough PLA or PLA



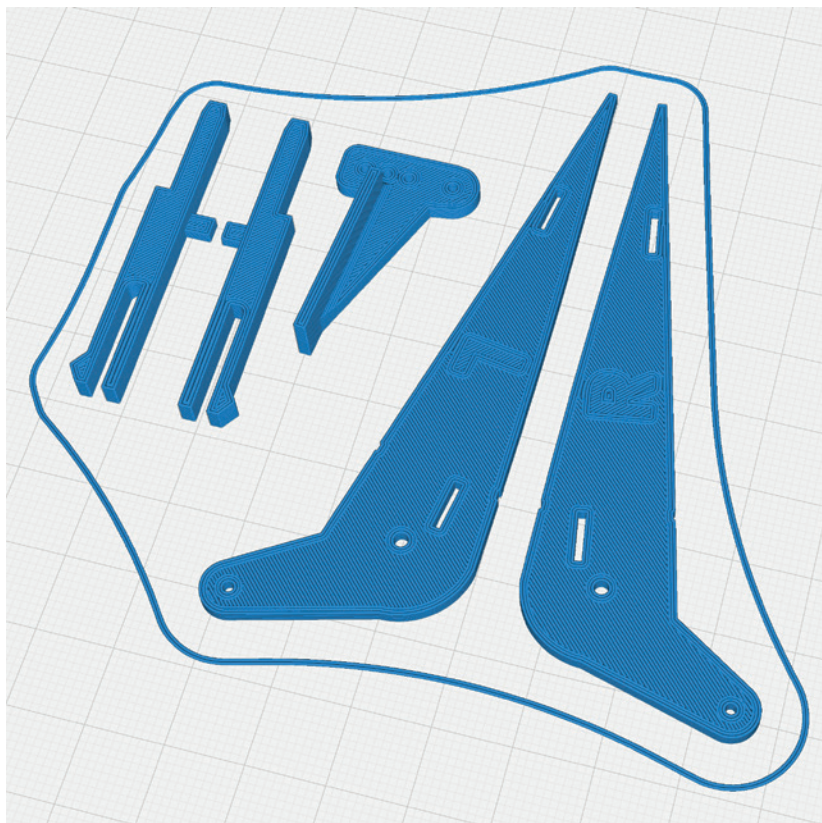
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Parts\_sf.stl

**MATERIAL** PLA, Weight: ~ 8 g

### ADDITIONAL SETTINGS

None required



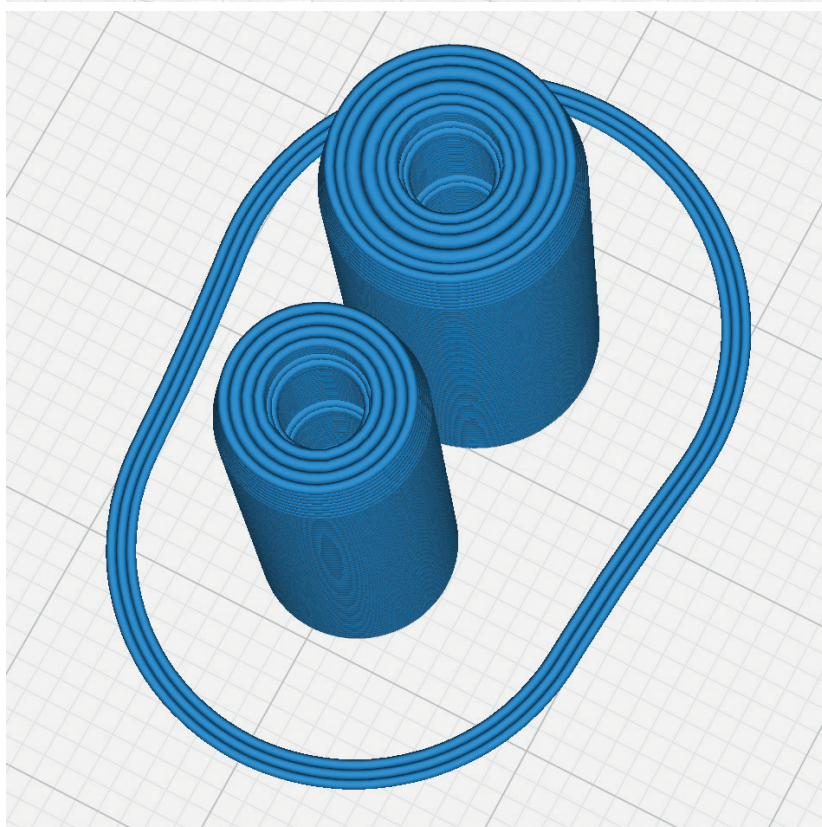
## P1\_Prop Balancer 8-10\_sf.stl

**MATERIAL** PLA

### ADDITIONAL SETTINGS

None required

To balance your prop perfectly, insert a piece of carbon rod  $\varnothing 3\text{mm}$  through the hole. Then place the prop on the balancer and check whether it is heavier on one side. Grind away some of the edge arc until the prop is absolutely balanced.



# PROFILE P1\_Fullbody Tough PLA or PLA



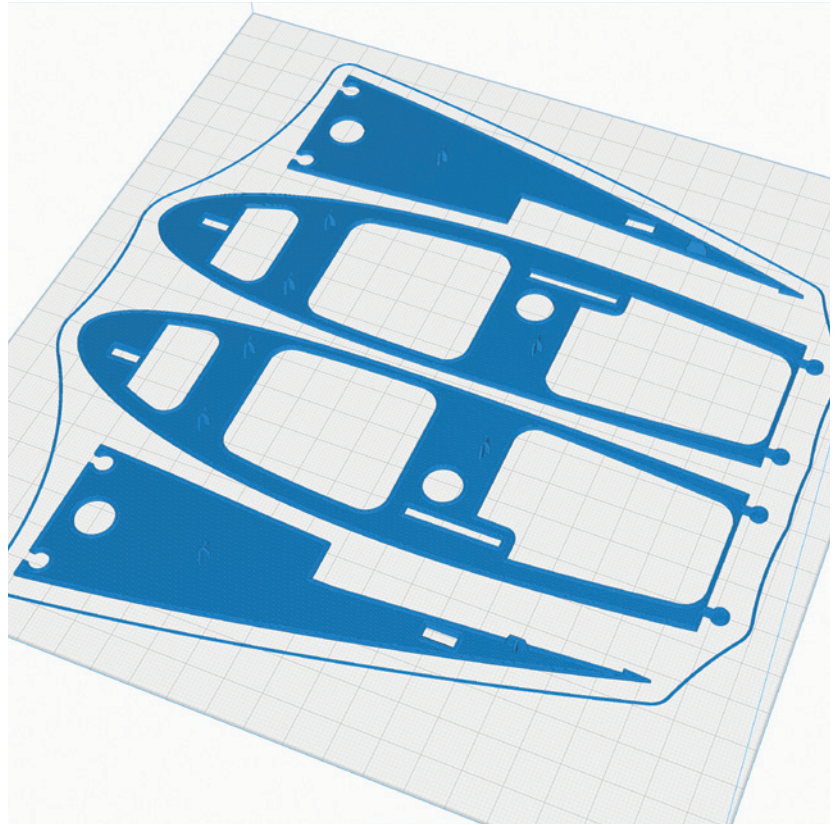
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Protectors\_sf.stl

**MATERIAL** PLA, Weight: ~ 16 g

### ADDITIONAL SETTINGS

None required

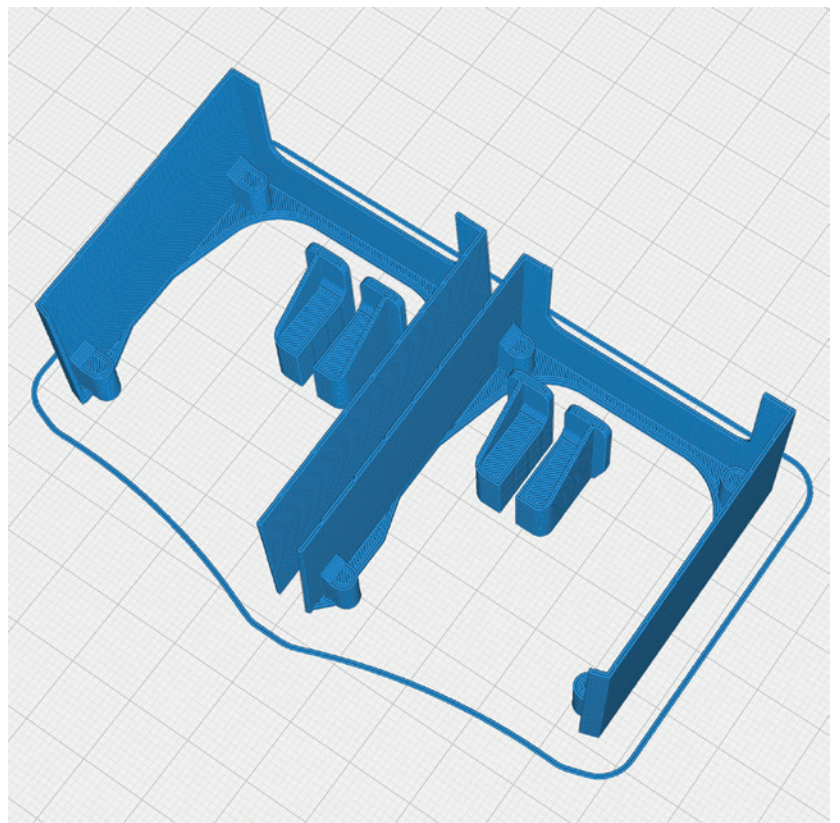


## P1\_Servomount AIL\_sf.stl

**MATERIAL** PLA, Weight: ~ 12 g

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

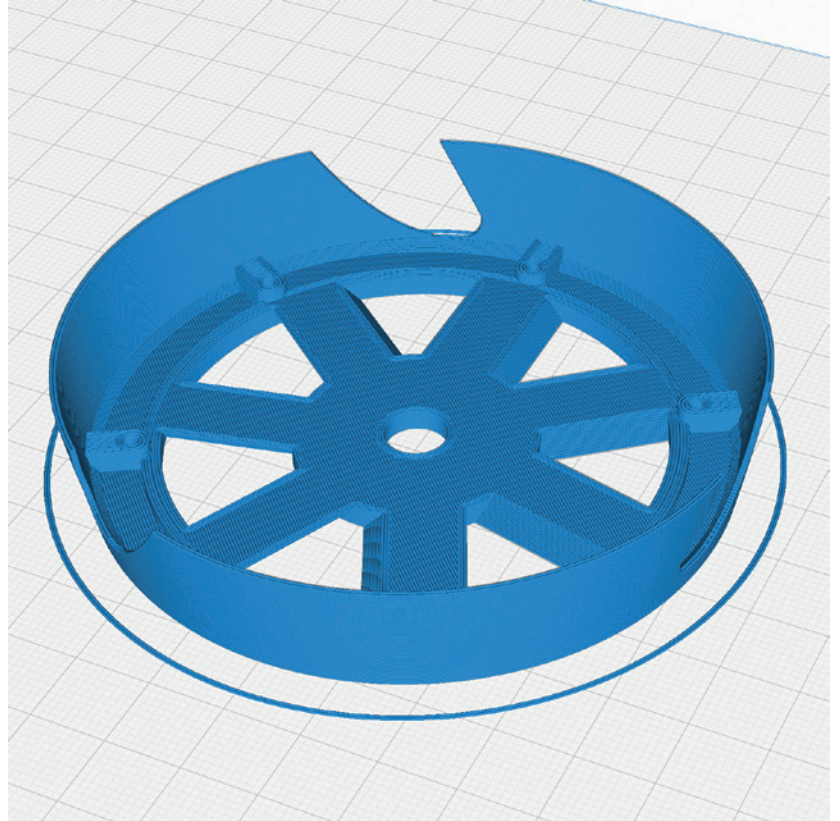
## P1\_Spinner X\*blade X\*\*\_sf.stl

**MATERIAL** PLA, Weight: ~ 18 g

### ADDITIONAL SETTINGS

None required

- \* for 3 or 2 blade Prop
- \*\* for 8 or 10 mm motor shaft

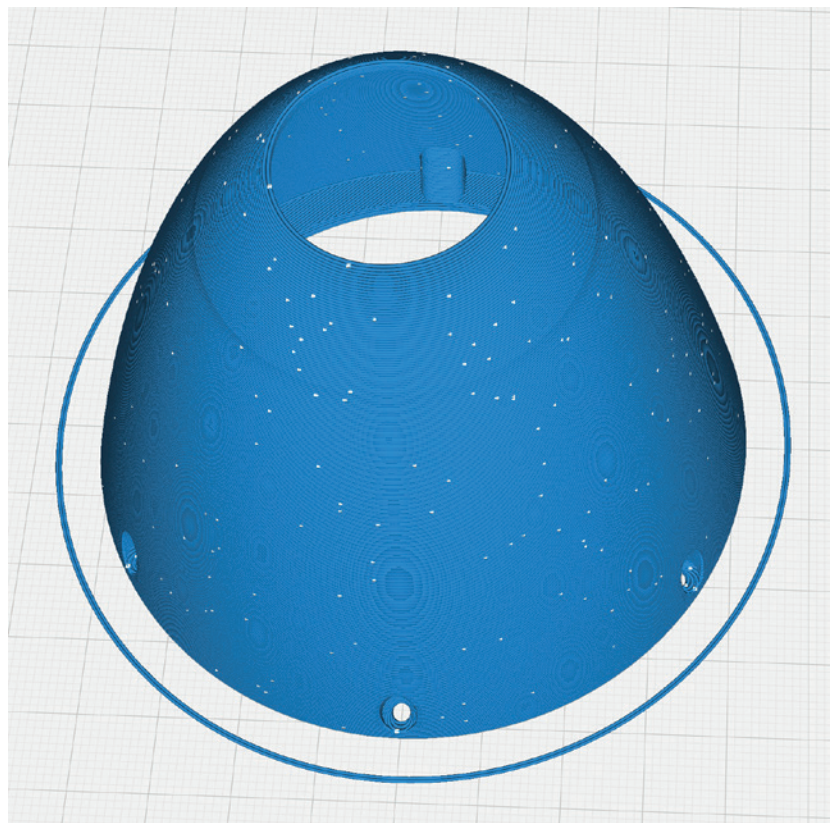


## P1\_Spinner\_sf.stl

**MATERIAL** PLA, Weight: ~ 15 g

### ADDITIONAL SETTINGS

- Set Z-Seam to Random so that the spinner does not generate vibrations!



# PROFILE P1\_Fullbody Tough PLA or PLA



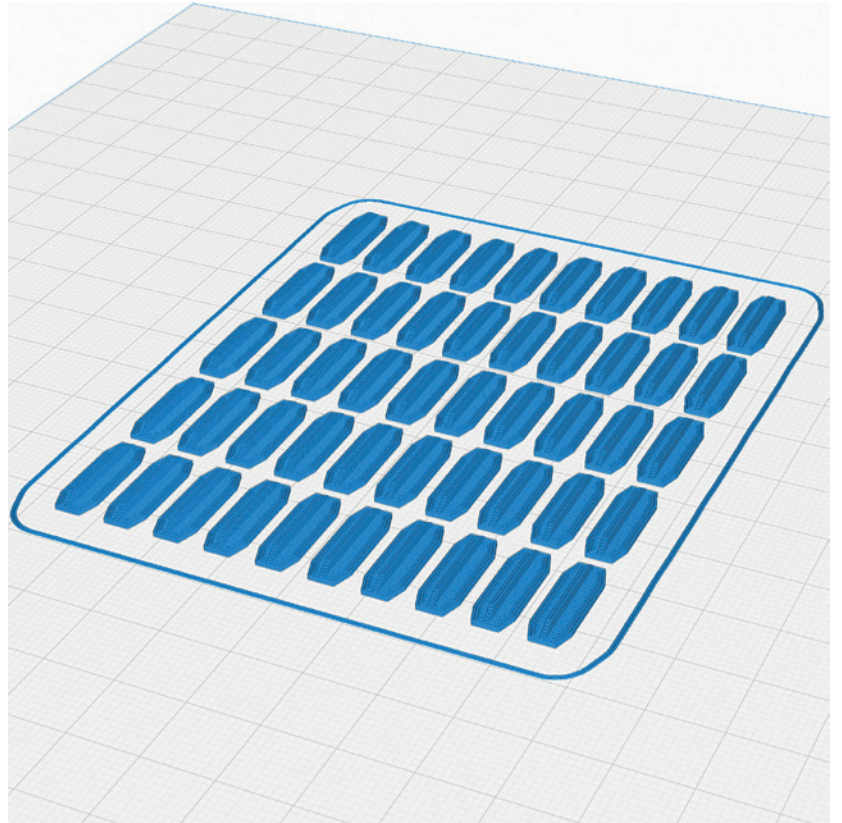
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_T-Connects\_sf.stl

**MATERIAL** PLA, Weight: ~ 5 g

### **ADDITIONAL SETTINGS**

None required





# PROFILE P2\_Hollowbody Tough PLA or PLA



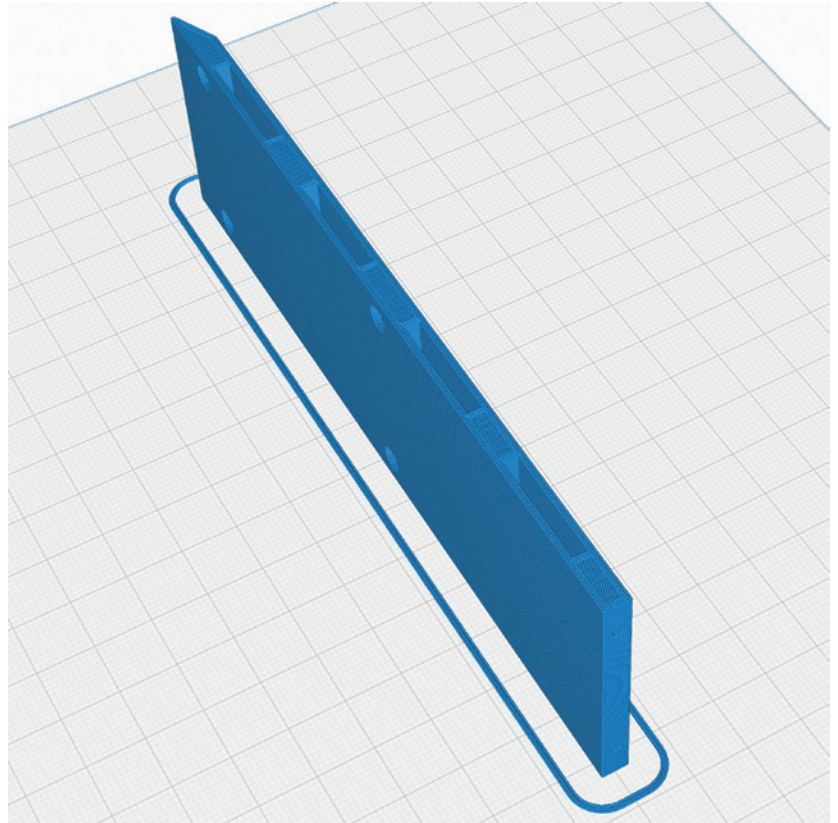
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Battery plate\_sf.stl

**MATERIAL** PLA, Weight: ~ 20 g

### ADDITIONAL SETTINGS

None required

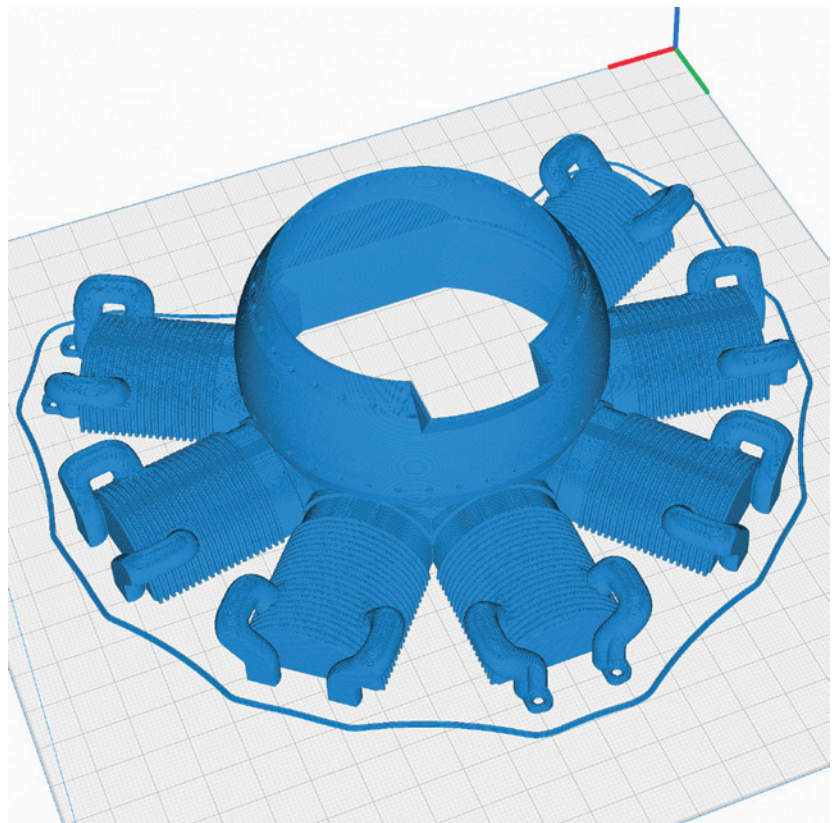


## P2\_Engine\_sf.stl

**MATERIAL** PLA, Weight: ~ 40 g

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 1
- Top Layers: 1
- Bottom Layers: 1
- Infill: 6 %



# PROFILE P2\_Hollowbody Tough PLA or PLA



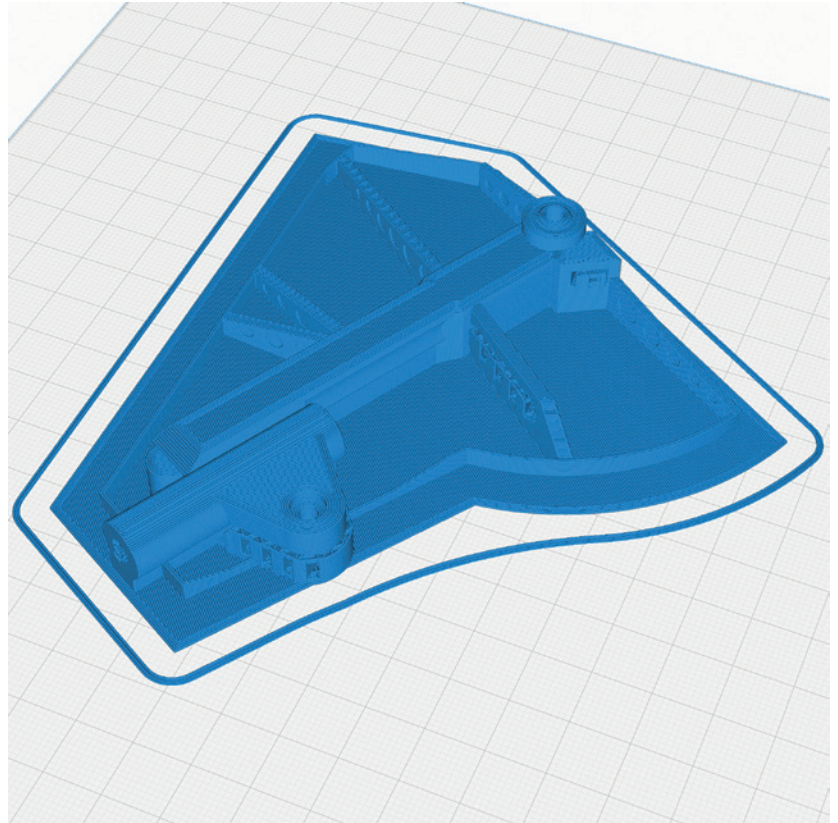
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Gear cover L\_sf.stl and P2\_Gear cover R\_sf.stl

**MATERIAL** Tough PLA, Weight: ~ 21 g

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 3
- Top Layers: 3
- Bottom Layers: 3
- activate Support (and remove later)

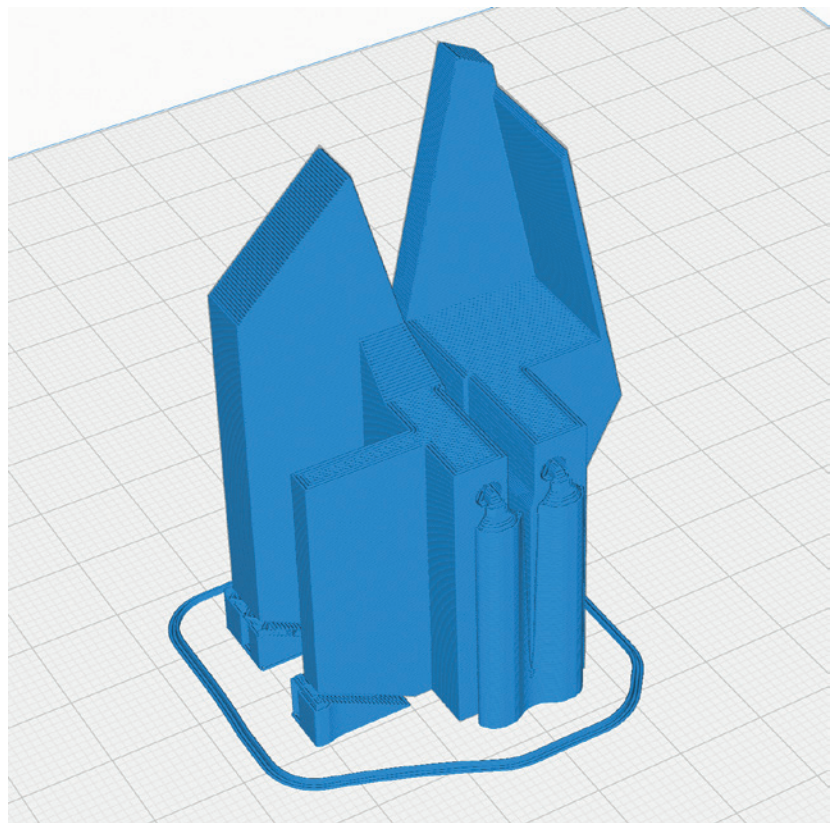


## P2\_Gear mount L\_sf.stl and P2\_Gear mount R\_sf.stl

**MATERIAL** PLA, Weight: ~ 12 g

### ADDITIONAL SETTINGS

- activate Support (and remove later)



# PROFILE P2\_Hollowbody Tough PLA or PLA



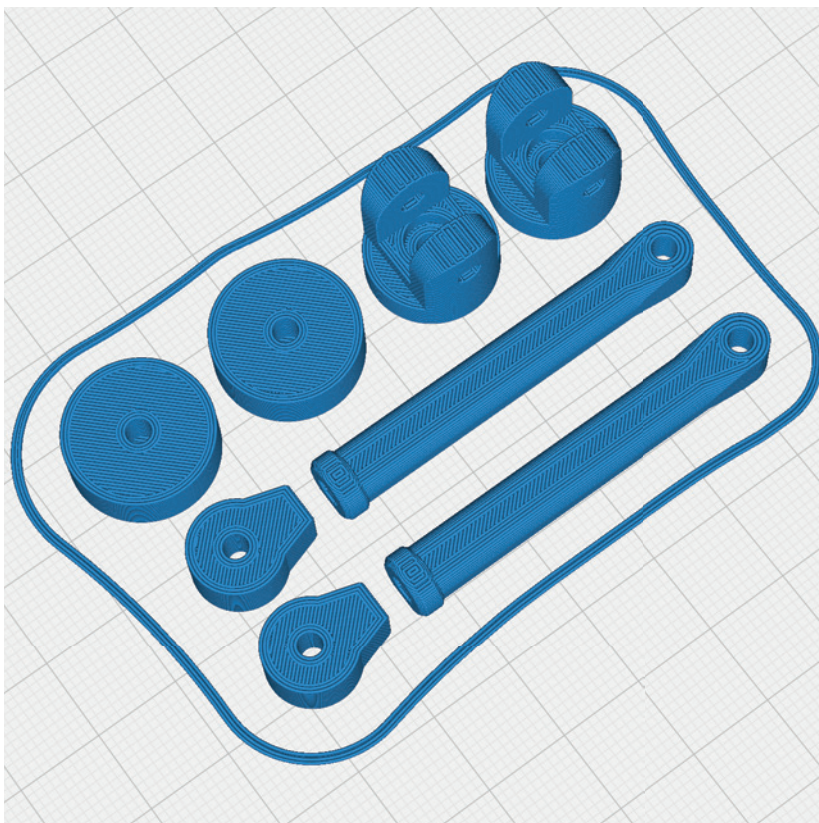
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Gear parts 1\_sf.stl

**MATERIAL** PLA, Weight: ~ 8 g

### ADDITIONAL SETTINGS

None required

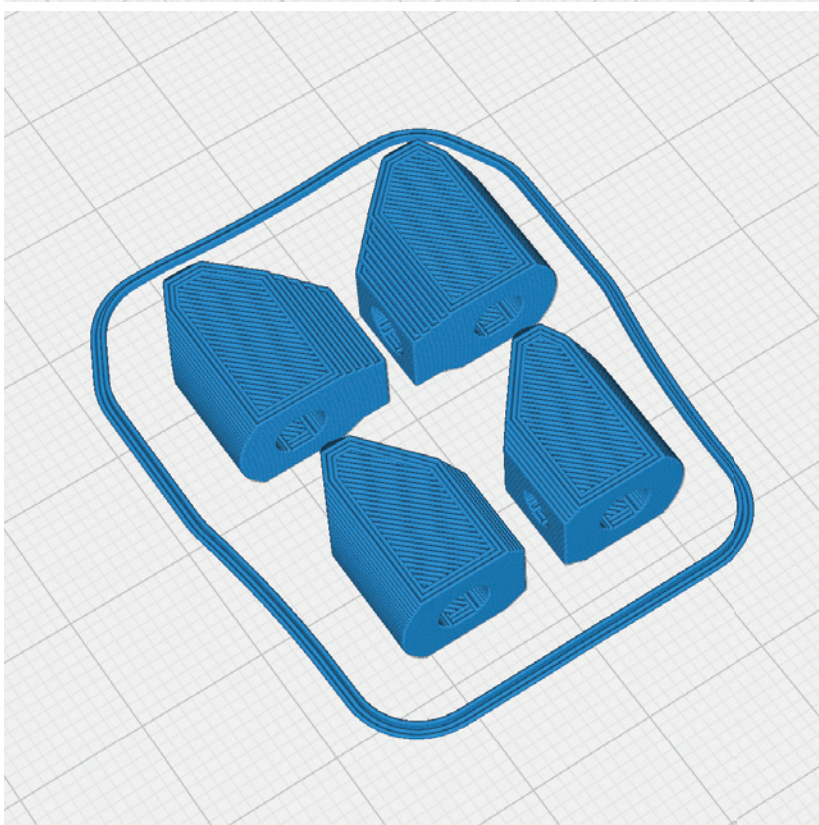


## P2\_Gear parts 2\_sf.stl

**MATERIAL** PLA, Weight: ~ 3 g

### ADDITIONAL SETTINGS

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Gear Tail\_sf.stl

**MATERIAL** PLA, Weight: ~ 6 g

### ADDITIONAL SETTINGS

None required

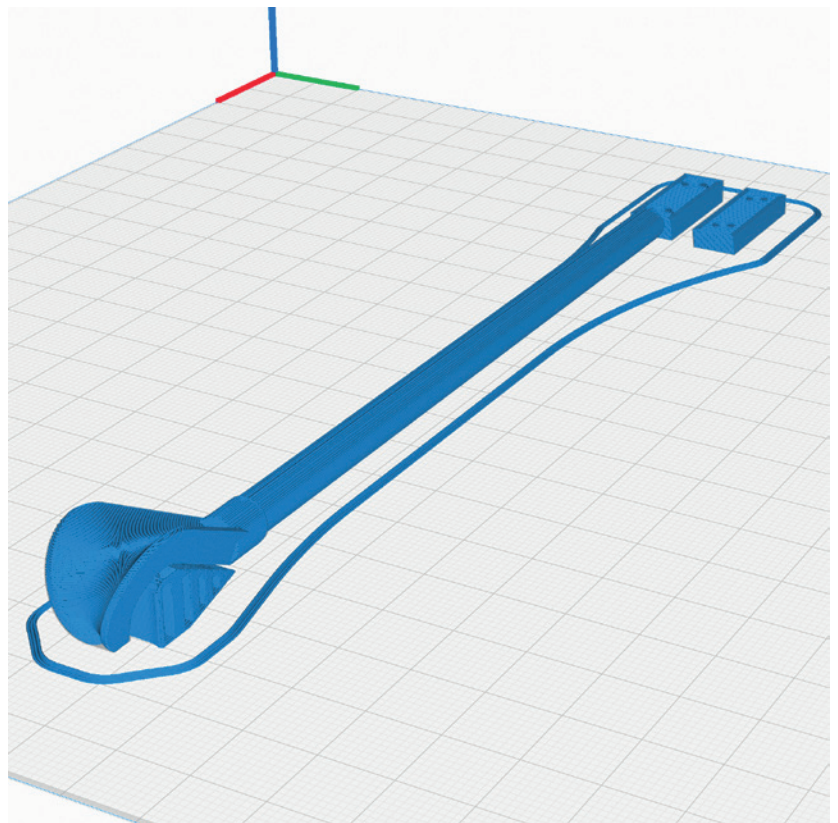


## P2\_Hook\_sf.stl

**MATERIAL** PLA, Weight: ~ 5 g

### ADDITIONAL SETTINGS

- activate Support



# PROFILE P2\_Hollowbody Tough PLA or PLA



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Parts\_sf.stl

**MATERIAL** PLA, Weight: ~ 14 g

### ADDITIONAL SETTINGS

None required

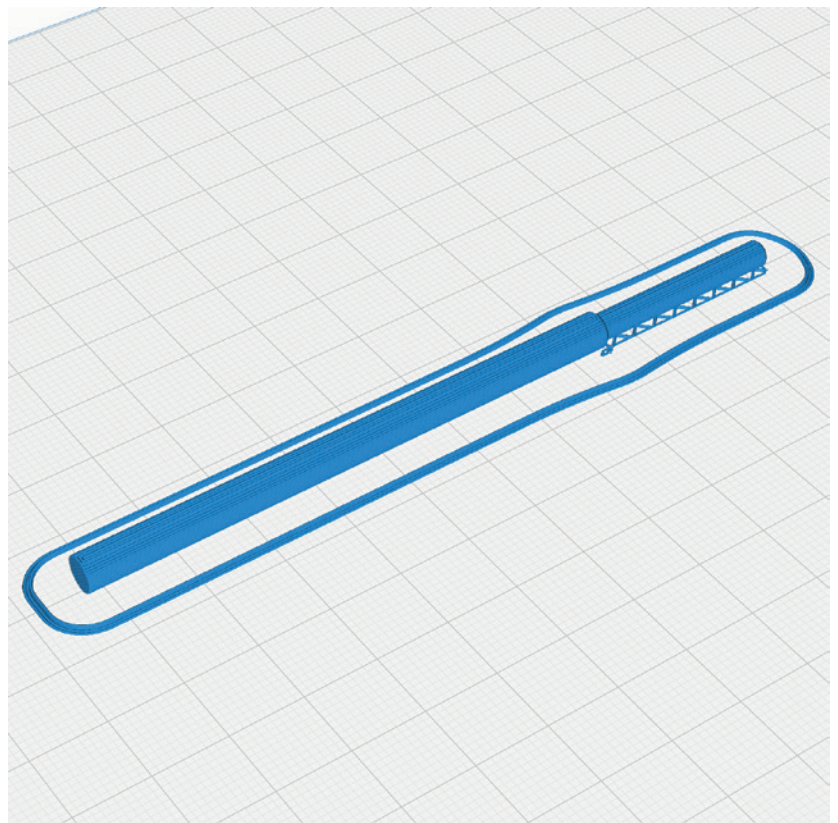


## P2\_Pilot tube\_sf.stl

**MATERIAL** PLA, Weight: ~ 2 g

### ADDITIONAL SETTINGS

- activate Support



# PROFILE P2\_Hollowbody Tough PLA or PLA



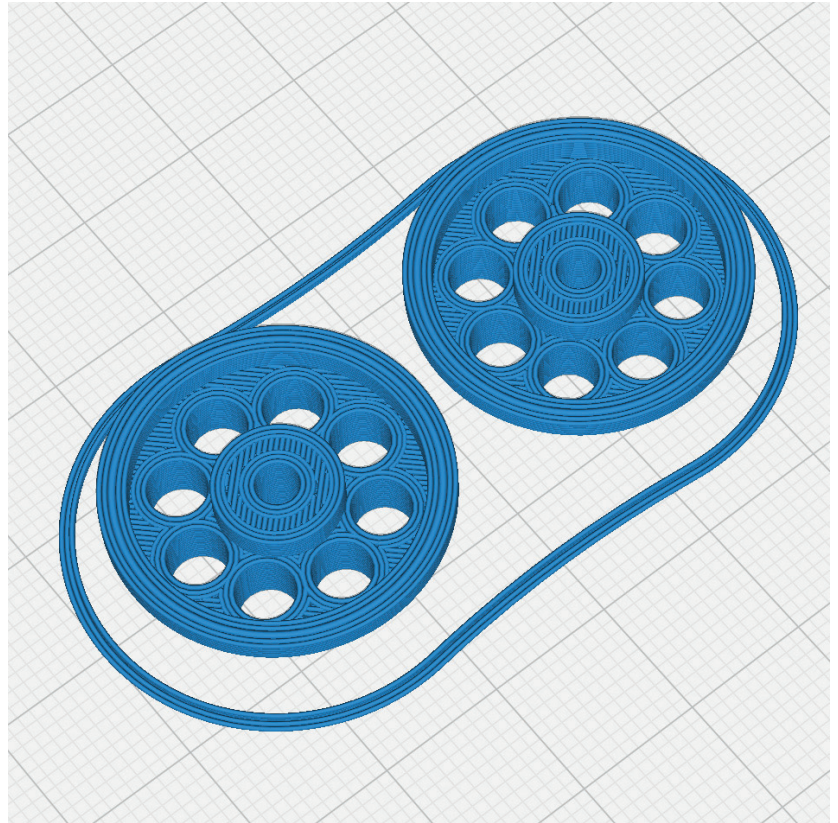
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Rim\_back\_sf.stl

**MATERIAL** PLA, Weight: ~ 3 g

### ADDITIONAL SETTINGS

None required

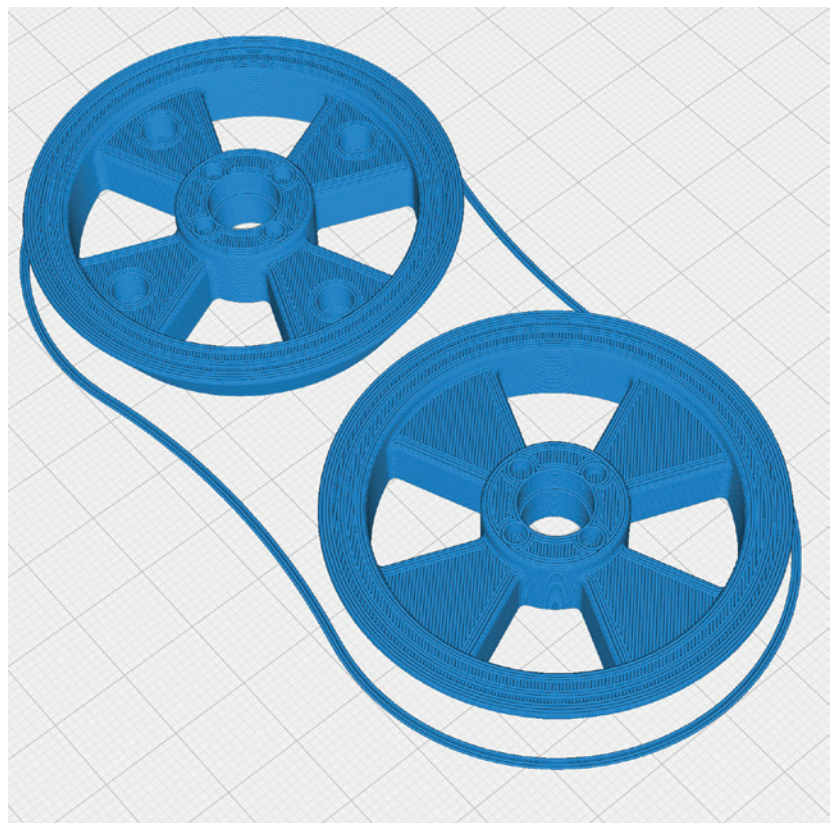


## P2\_Rim\_sf.stl

**MATERIAL** PLA, Weight: ~ 15 g

### ADDITIONAL SETTINGS

- Print twice



# PROFILE P2\_Hollowbody Tough PLA or PLA



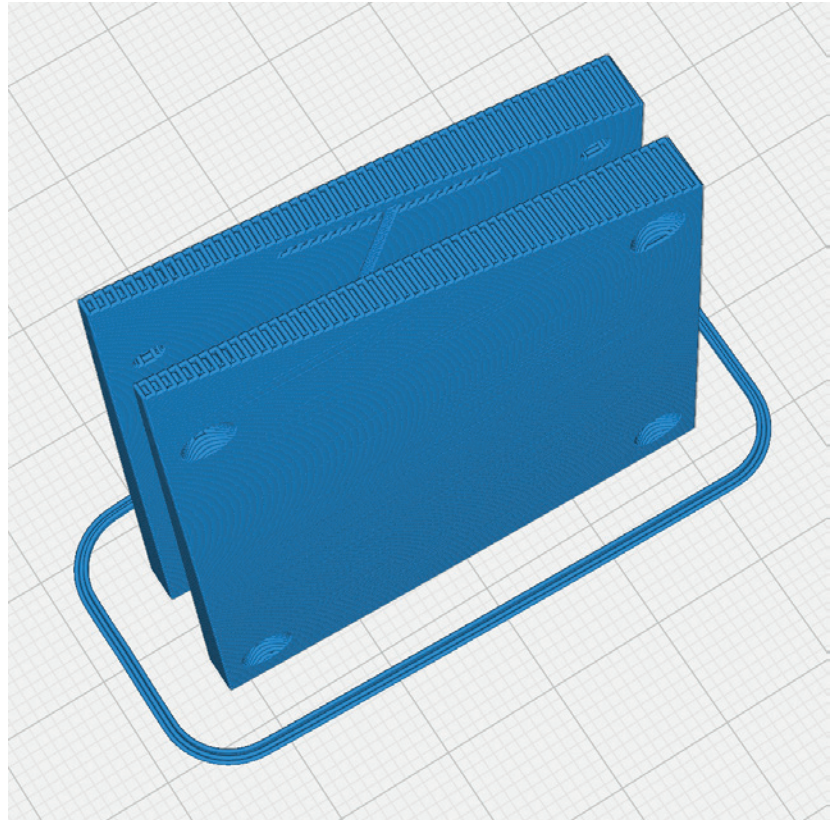
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Servocovers All\_sf.stl

**MATERIAL** PLA, Weight: ~ 12 g

### **ADDITIONAL SETTINGS**

None required

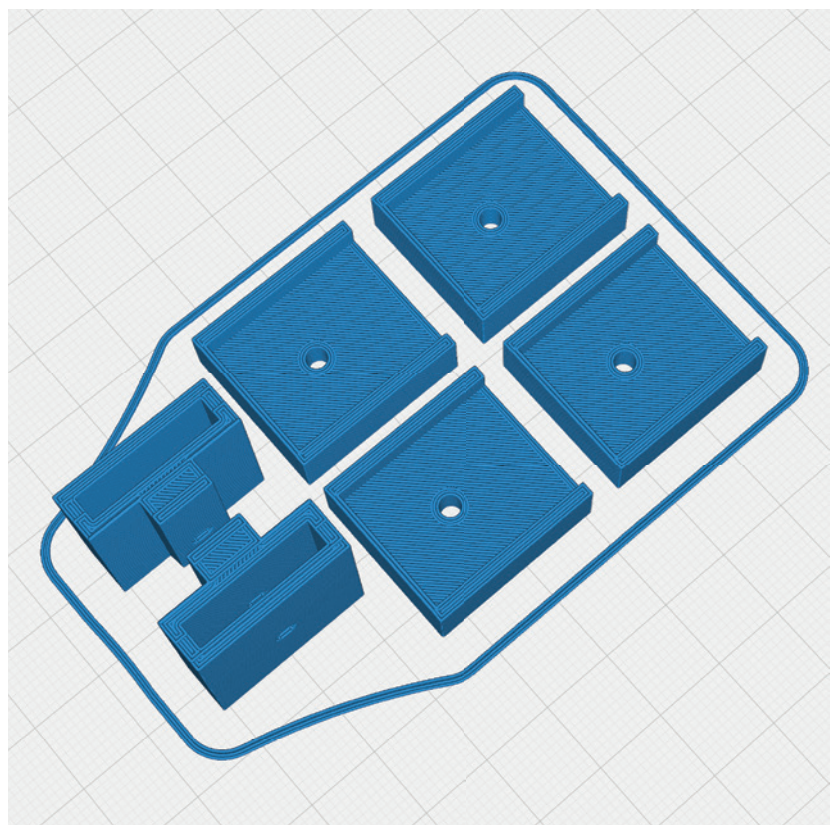


## P2\_Wingmount\_sf.stl

**MATERIAL** PLA, Weight: ~ 14 g

### **ADDITIONAL SETTINGS**

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



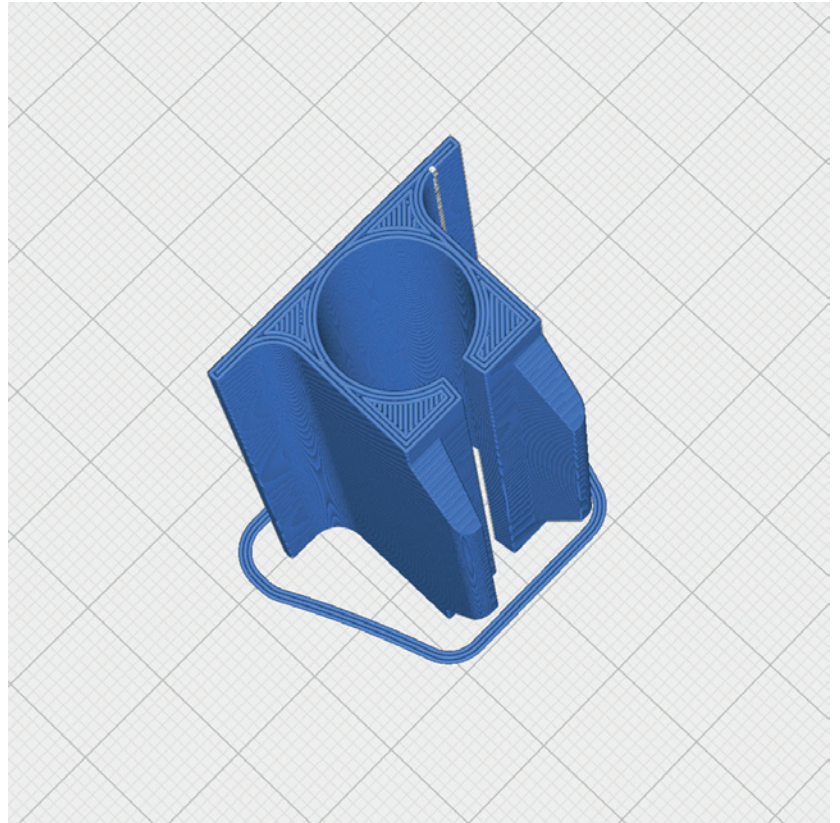
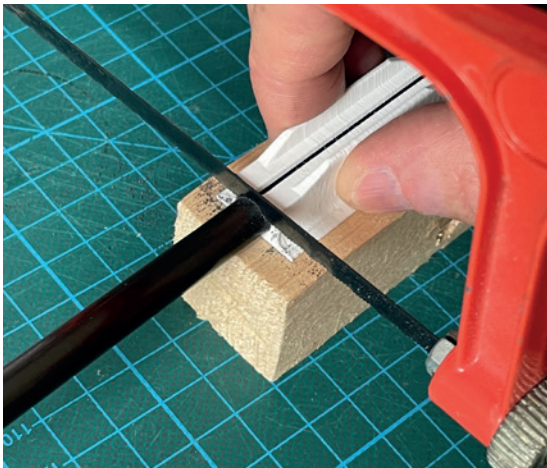
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

P2\_Carbon tool 10mm.stl and

**MATERIAL** PLA

**ADDITIONAL SETTINGS**

None required





# PROFILE P4\_Flex LW TPU (A95/VarioShore)



The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P4\_Tire back\_sf.stl

**MATERIAL** VarioShore or TPU A95  
Weight: ~ 6 g (VarioShore)

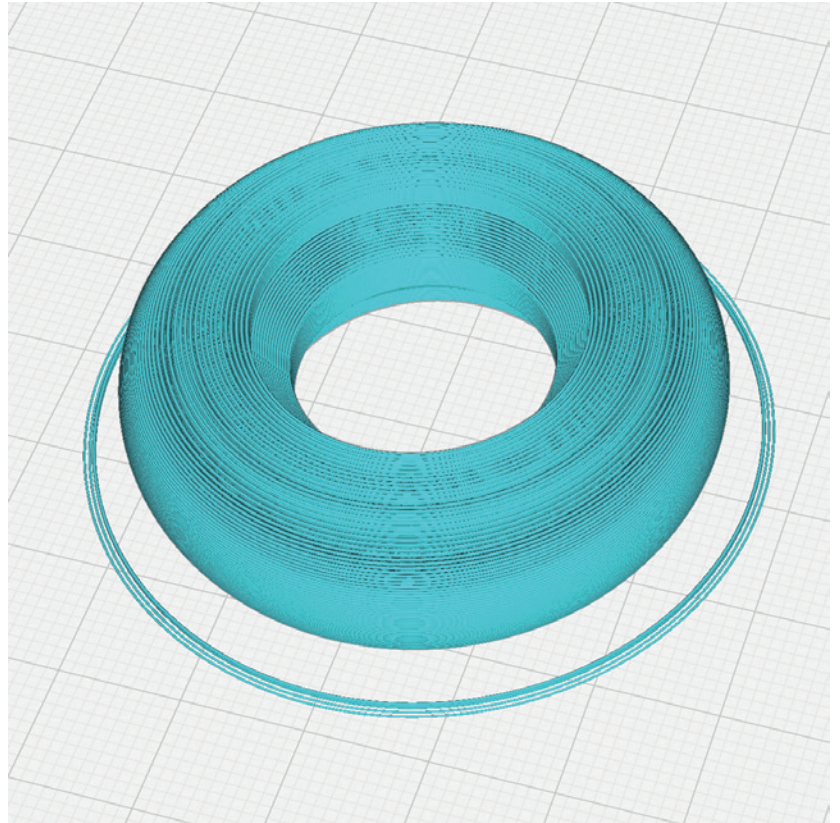
### ADDITIONAL SETTINGS

#### VarioShore with Flow 70 %:

- Wall Line Count: 5
- Top Layers: 5
- Bottom Layers: 5
- Infill Density: 10 %
- Infill Pattern: Gyroid

#### TPU A95:

- Wall Line Count: 3
- Top Layers: 3
- Infill Density: 6 %
- Infill Pattern: Gyroid



## P4\_Tire\_sf.stl

**MATERIAL** LW-TPU (recommended),  
Weight: ~ 25 g (VarioShore)

### ADDITIONAL SETTINGS

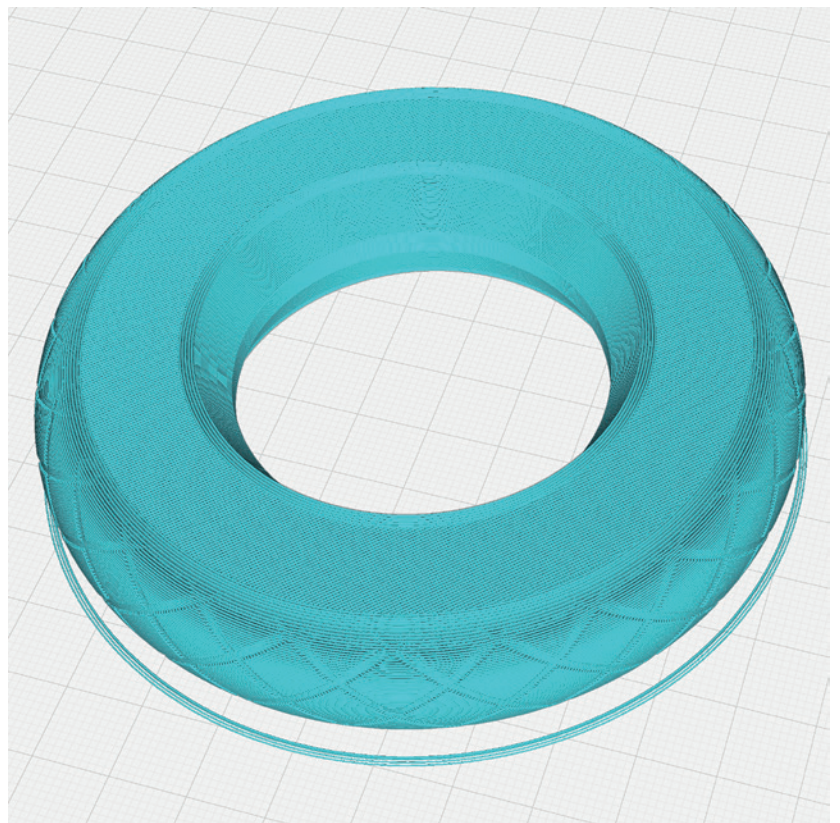
- Print twice

#### VarioShore with Flow 70 %:

- Wall Line Count: 5
- Top Layers: 5
- Bottom Layers: 5
- Infill Density: 10 %
- Infill Pattern: Gyroid

#### TPU A95:

- Wall Line Count: 3
- Top Layers: 3
- Infill Density: 6 %
- Infill Pattern: Gyroid



# PROFILE P4\_Flex LW TPU (A95/VarioShore)



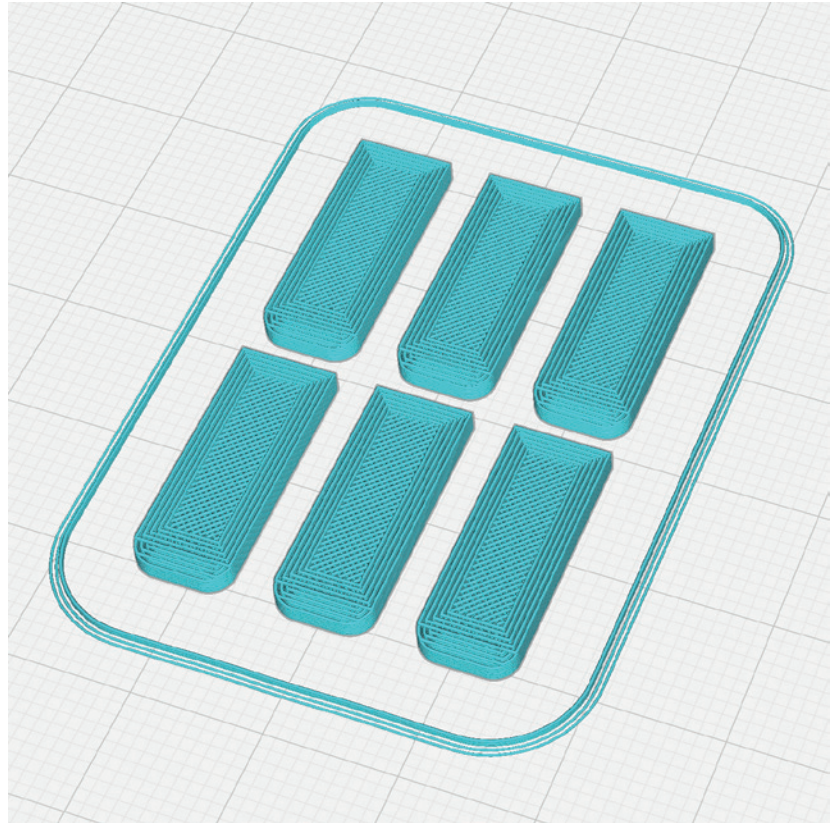
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P4\_Wing parts\_sf.stl

**MATERIAL** TPU, Weight: ~ 2 g

### ADDITIONAL SETTINGS

- Infill/Fill: 100 %

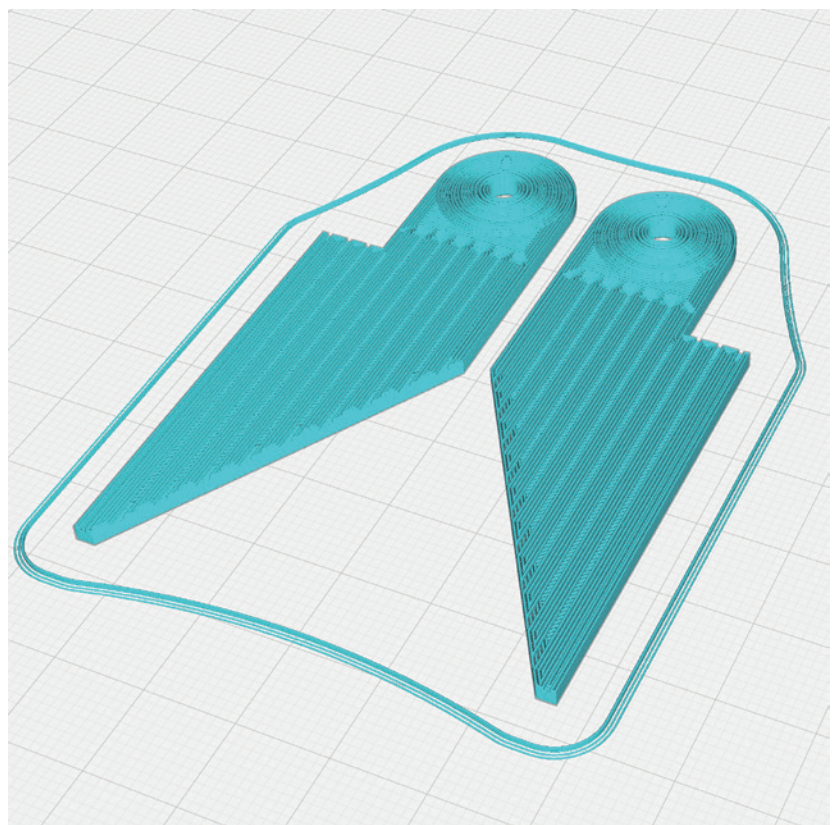


## P4\_Wingmount\_sf.stl

**MATERIAL** TPU, Weight: ~ 4 g

### ADDITIONAL SETTINGS

- Infill/Fill: 100 %
- Print 3 times



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

## P5\_Ail L 1\_sf.stl and P5\_Ail R 1\_sf.stl

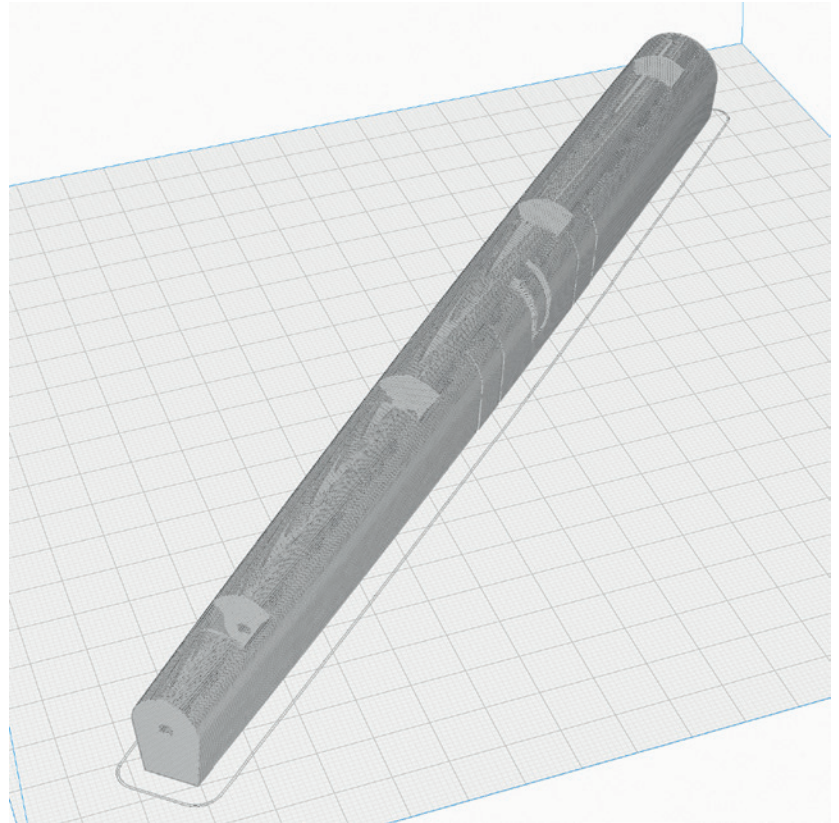
**MATERIAL** LW PLA, Weight: ~ 10 g

**TIME** ~ 1 hour 40 minutes

### ADDITIONAL SETTINGS

None required

Unfortunately, stringing is unavoidable with this part and it has to be reworked a little with a knife and sandpaper.



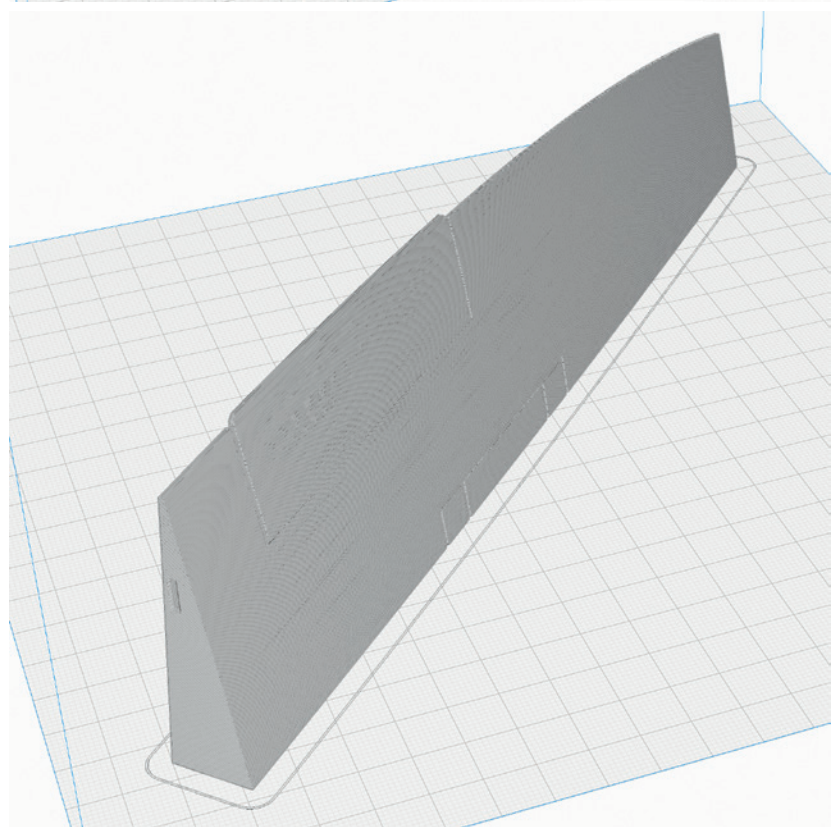
## P5\_Ail L 2\_sf.stl and P5\_Ail R 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 13 g

**TIME** ~ 2 hours

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

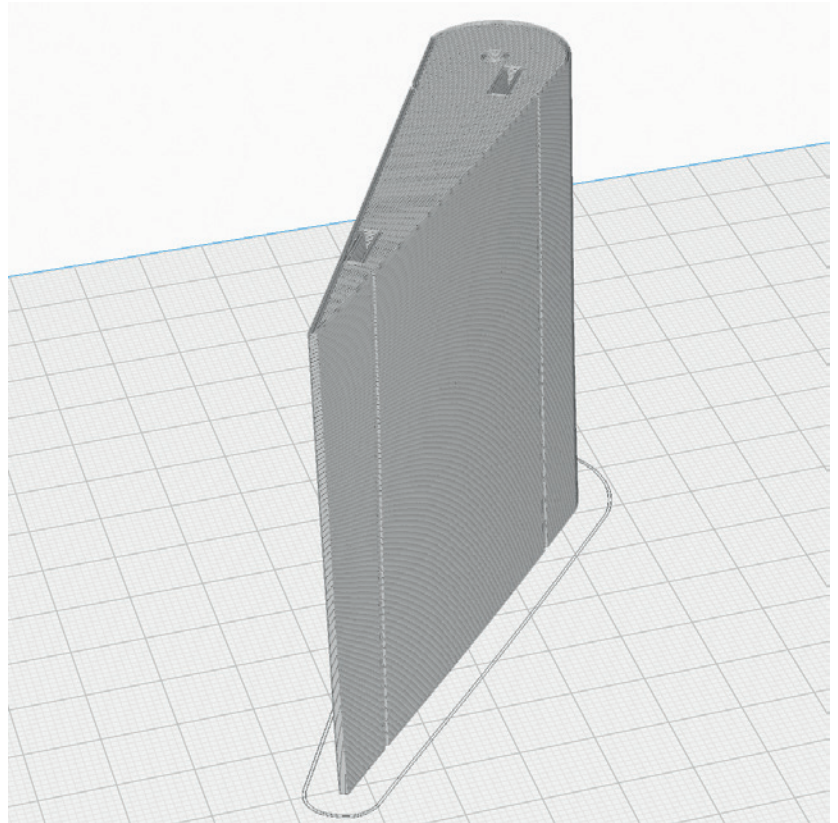
## P5\_Ail L 3\_sf.stl and P5\_Ail R 3\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 7 g

**TIME** ~ 1 hour

### ADDITIONAL SETTINGS

None required



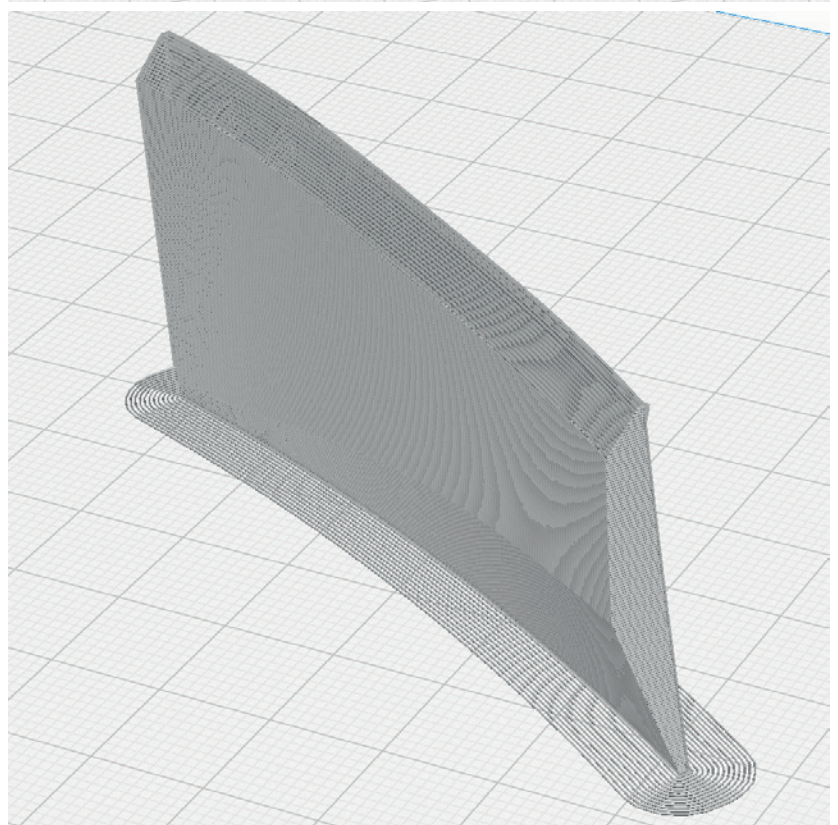
## P5\_Air flap L\_sf.stl and P5\_Air flap R\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 2 g

**TIME** ~ 20 minutes

### ADDITIONAL SETTINGS

- use brim



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

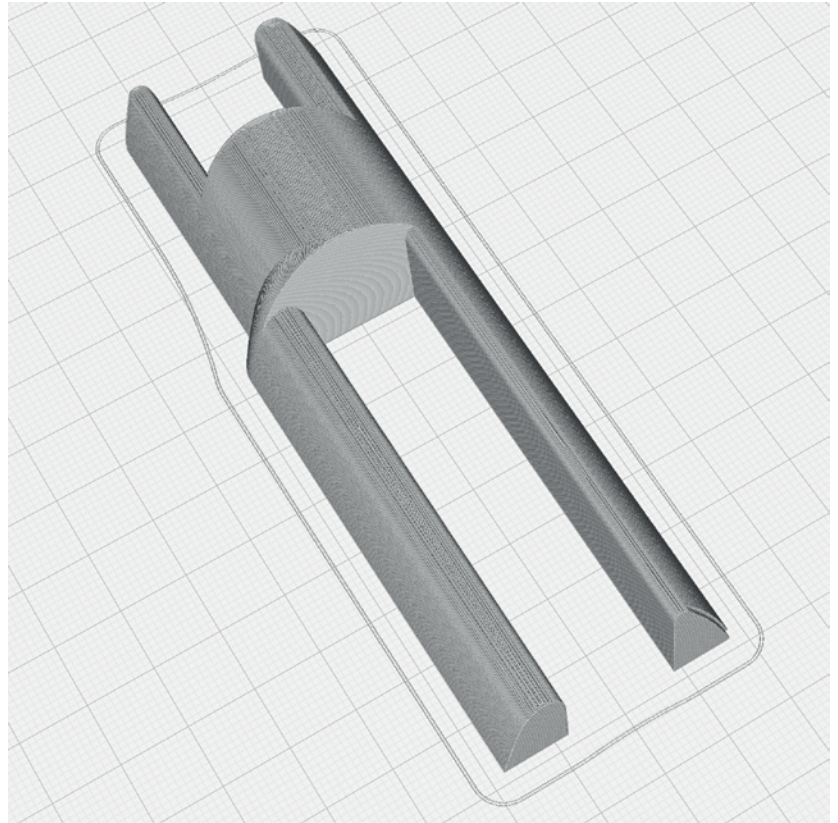
## P5\_Air Intake 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 5 g

**TIME** ~ 50 minutes

### **ADDITIONAL SETTINGS**

None required



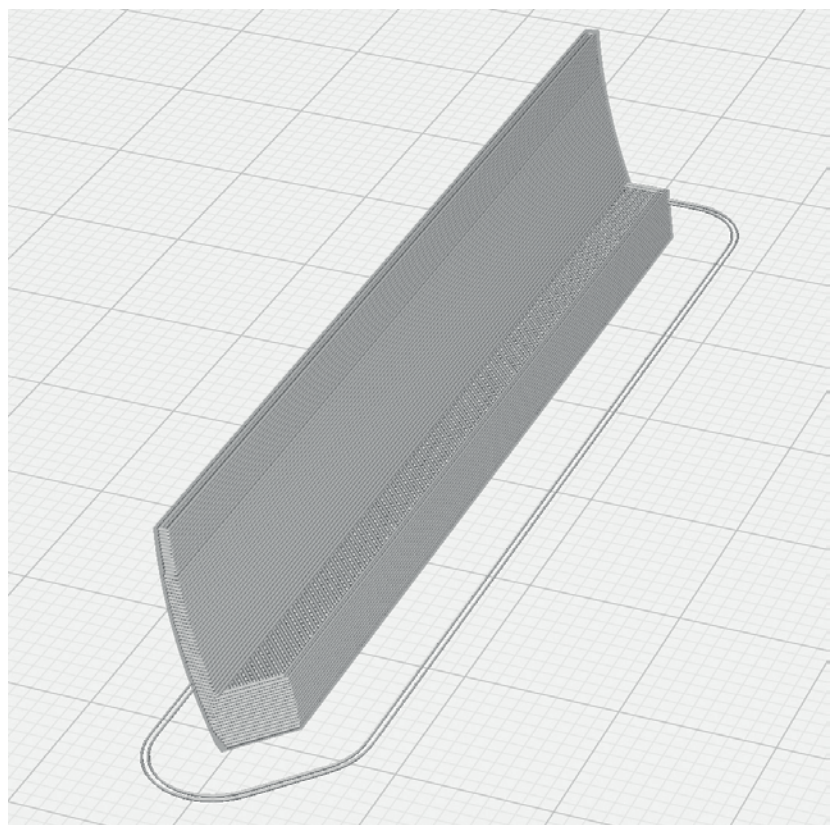
## P5\_Air Intake 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 1 g

**TIME** ~ 8 minutes

### **ADDITIONAL SETTINGS**

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

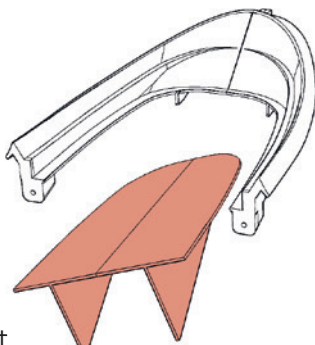
## P5\_Canopy Frame\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 11 g

**TIME** ~ 2 hours

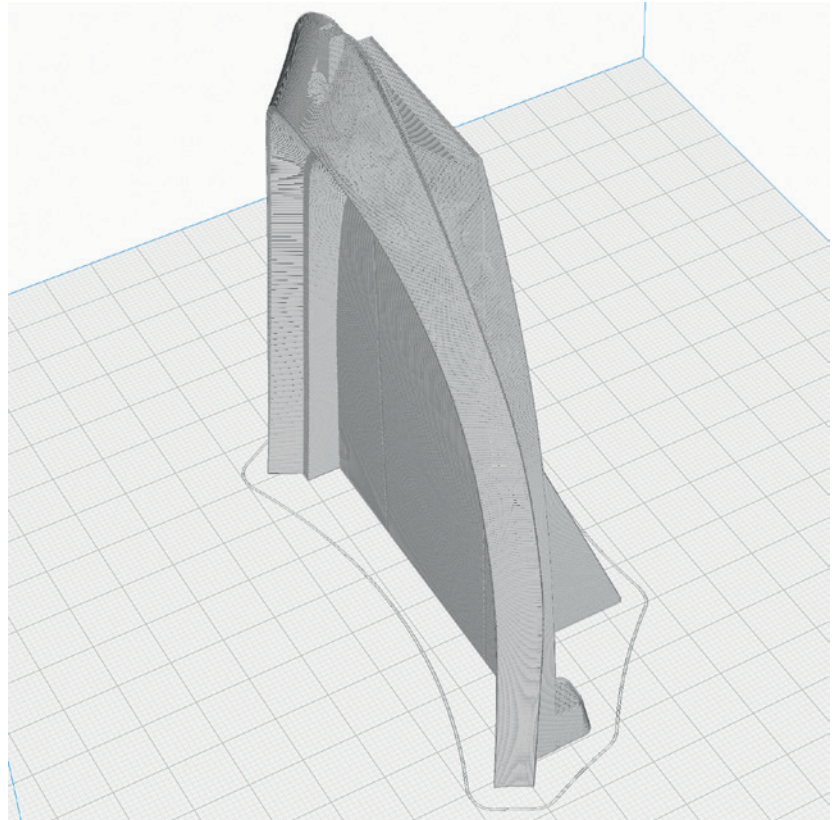
### ADDITIONAL SETTINGS

None required



Remove support.

Please be careful with the knife!



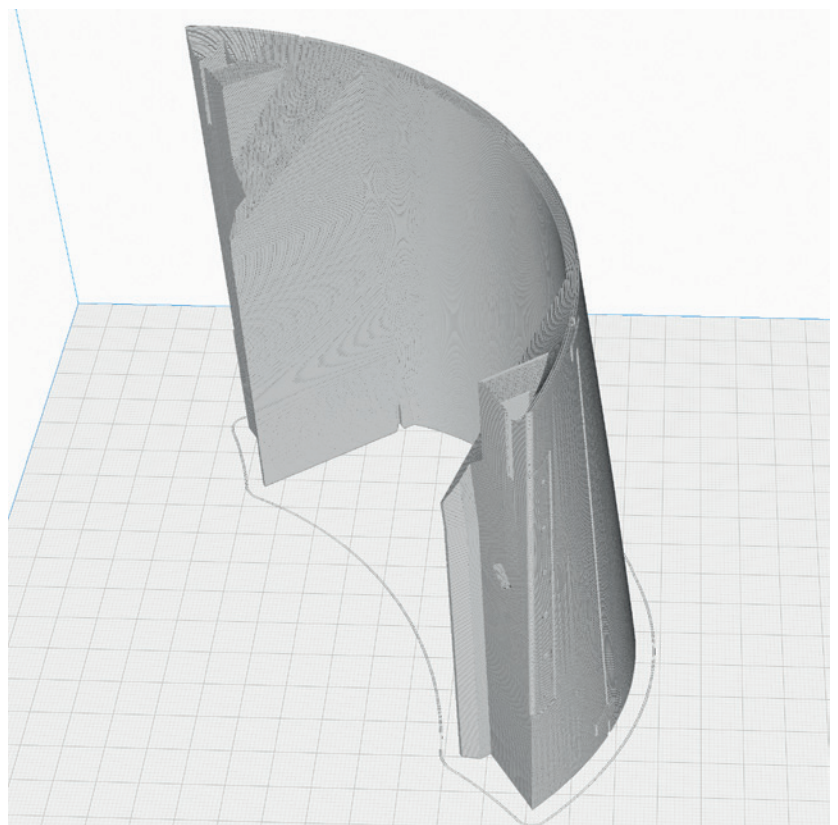
## P5\_Cover 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 24 g

**TIME** ~ 4 hours 30 minutes

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

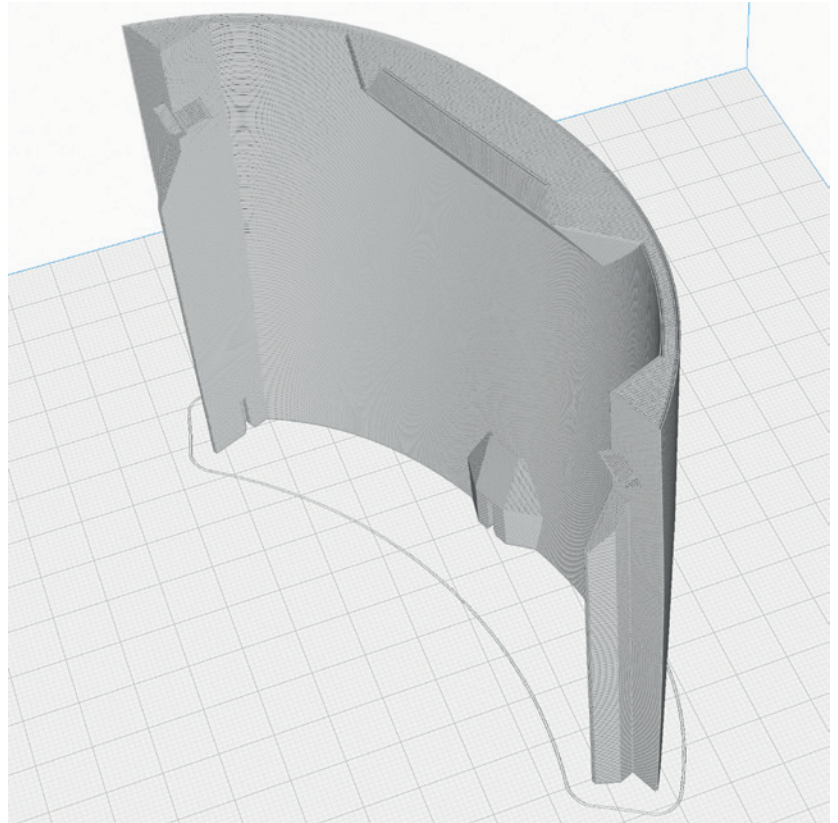
## P5\_Cover 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 12 g

**TIME** ~ 2 hours 20 minutes

### **ADDITIONAL SETTINGS**

None required



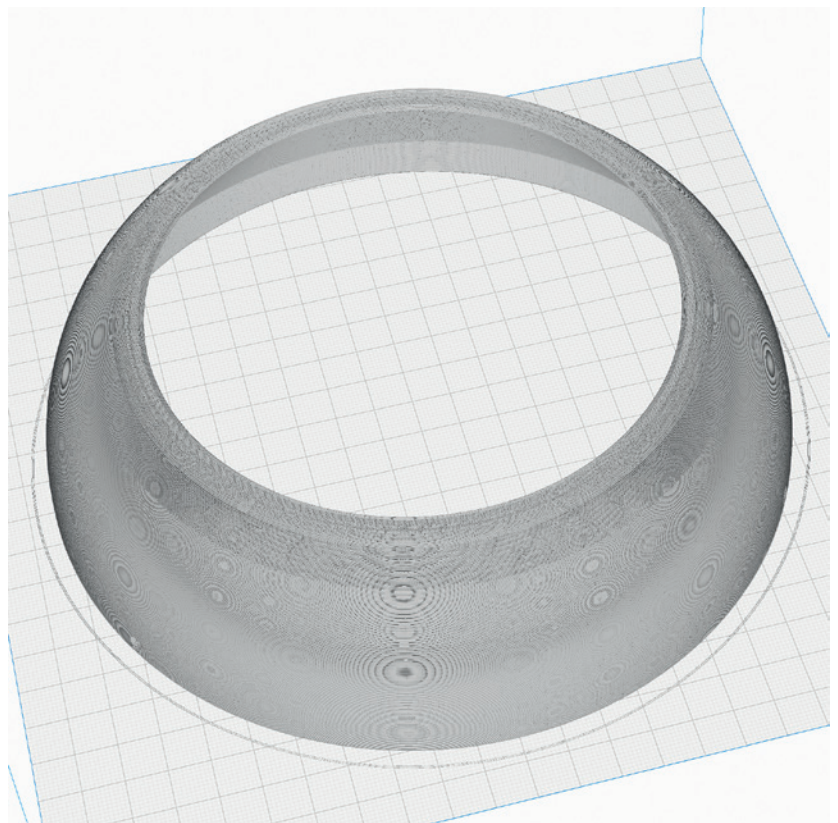
## P5\_Cowling\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 27 g

**TIME** ~ 4 hours 30 minutes

### **ADDITIONAL SETTINGS**

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

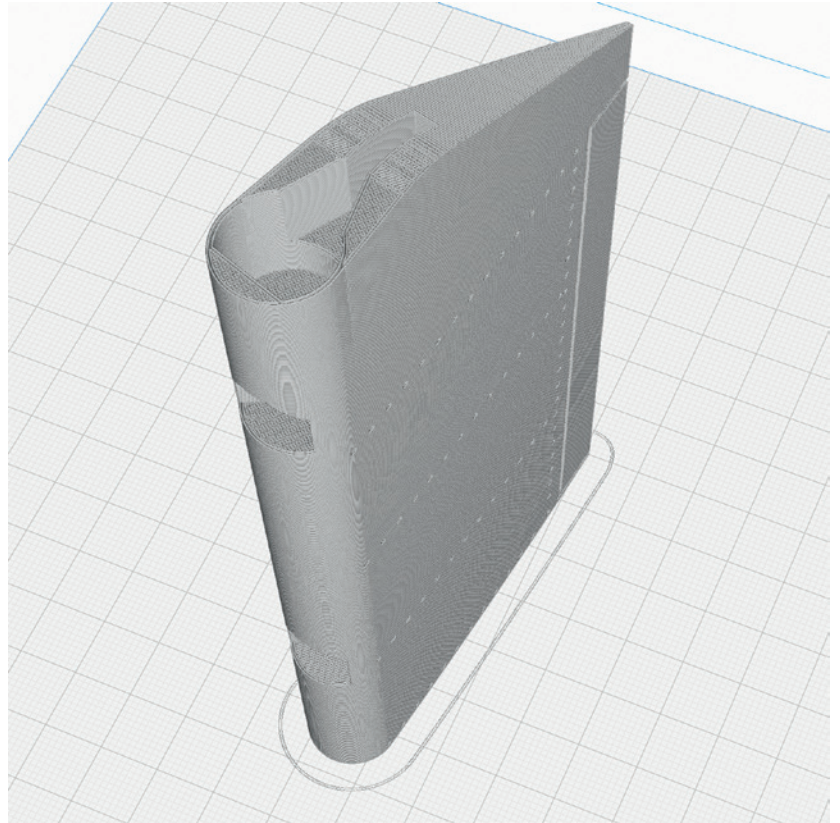
**P5\_ELE L 1\_sf.stl and  
P5\_ELE R 1\_sf.stl**

**MATERIAL** LW PLA, Weight: ~ 12 g

**TIME** ~ 2 hours

**ADDITIONAL SETTINGS**

None required



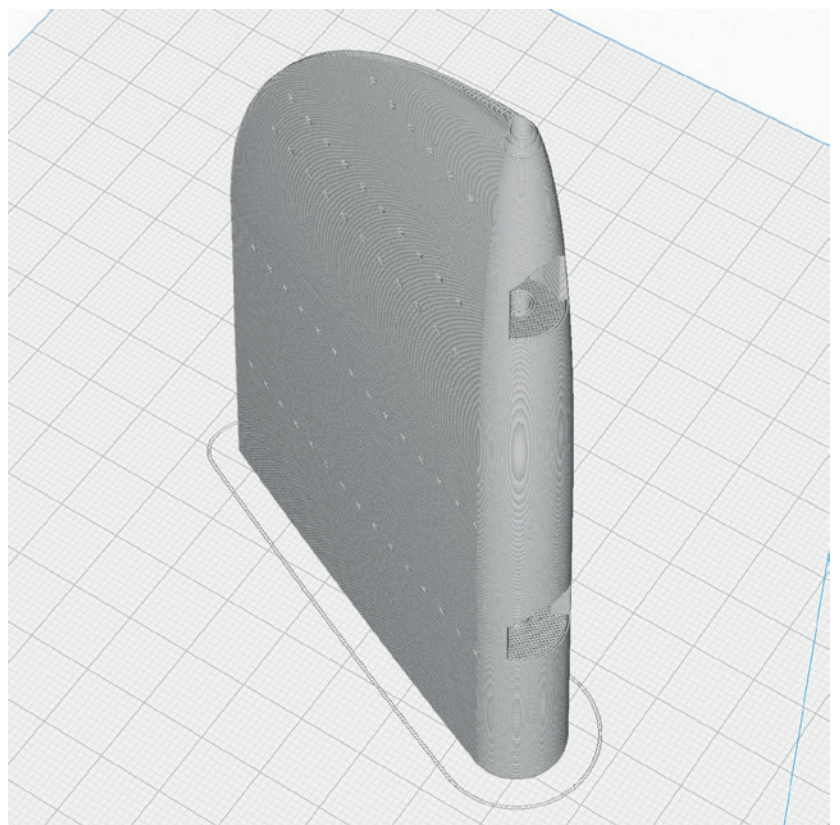
**P5\_ELE L 2\_sf.stl and  
P5\_ELE R 2\_sf.stl**

**MATERIAL** LW PLA, Weight: ~ 8 g

**TIME** ~ 1 hour 20 minutes

**ADDITIONAL SETTINGS**

None required





# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

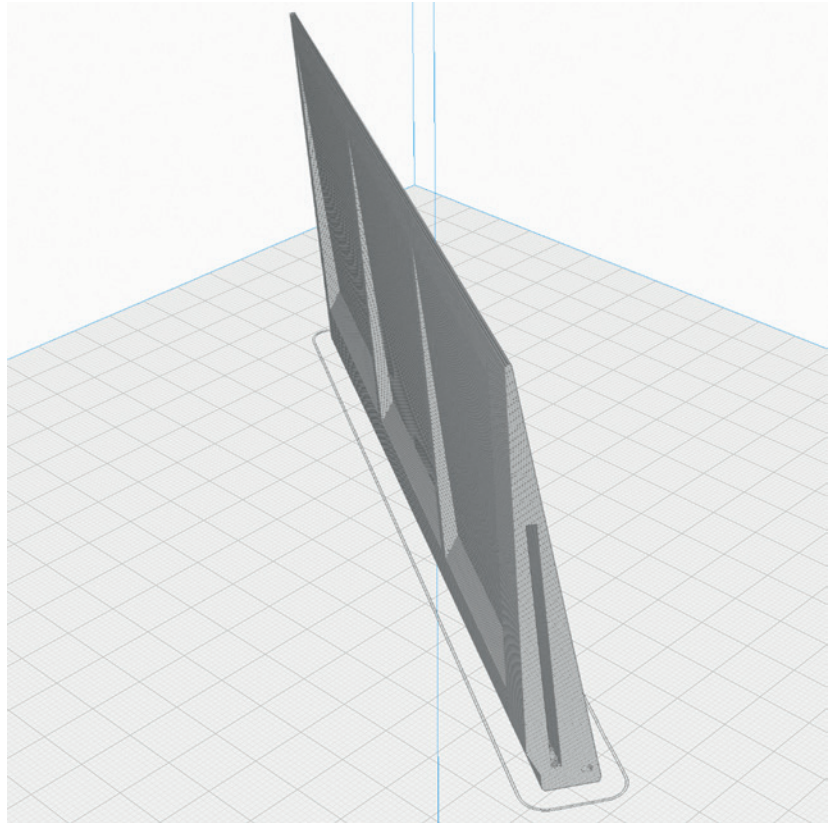
## P5\_Flap L 1\_sf.stl and P5\_Flap R 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 11 g

**TIME** ~ 2 hours

### ADDITIONAL SETTINGS

None required



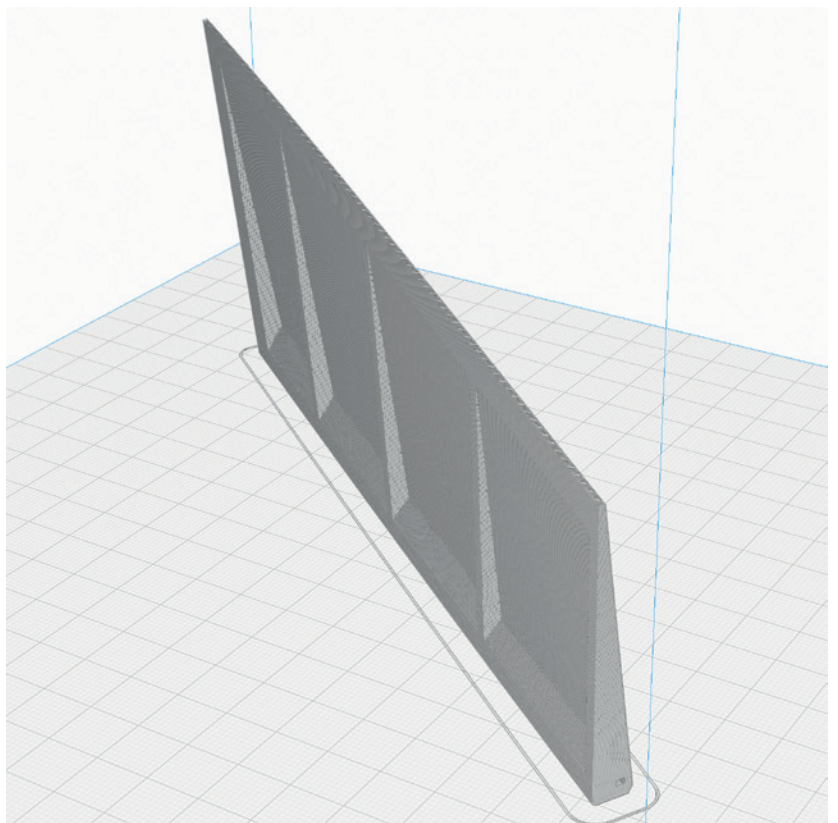
## P5\_Flap L 2\_sf.stl and P5\_Flap R 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 10 g

**TIME** ~ 2 hours

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

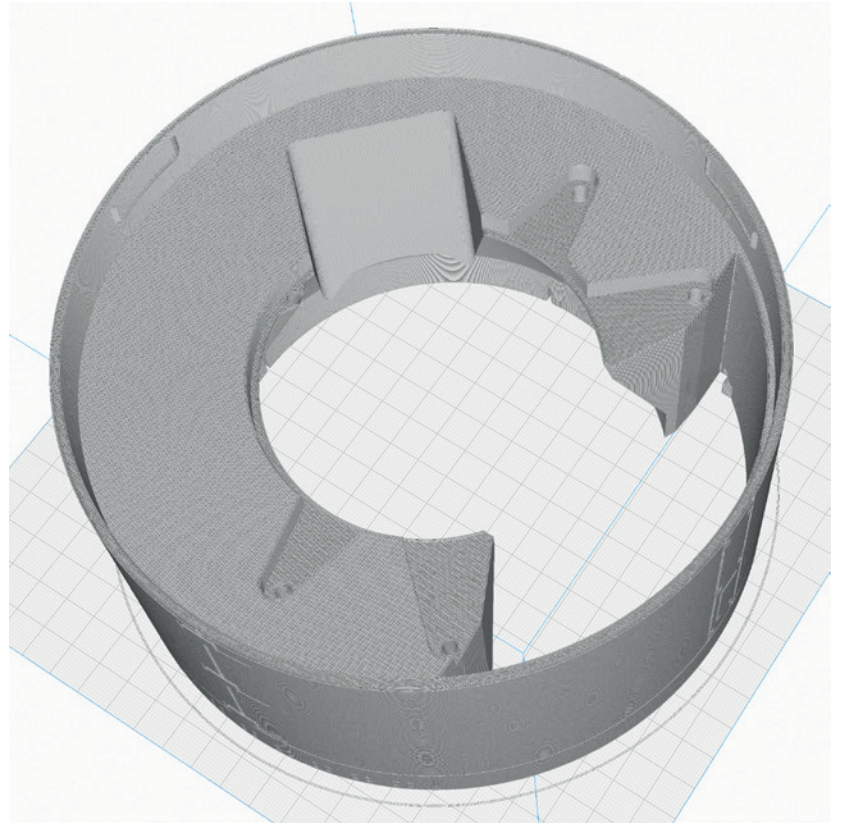
## P5\_FUS 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 80 g

**TIME** ~ 13 hours

### ADDITIONAL SETTINGS

None required



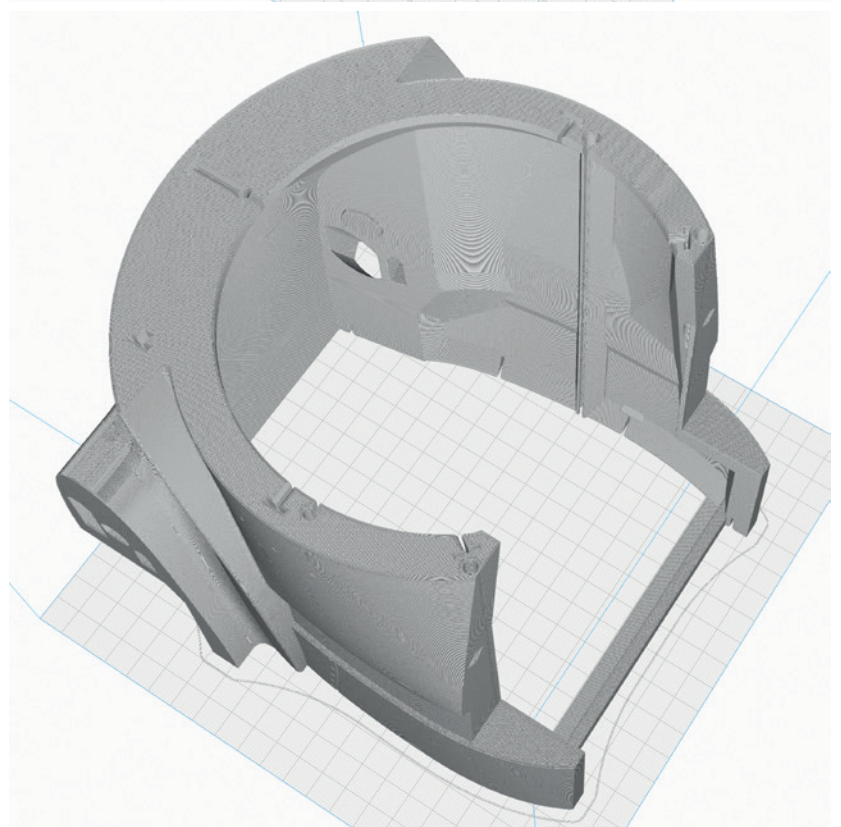
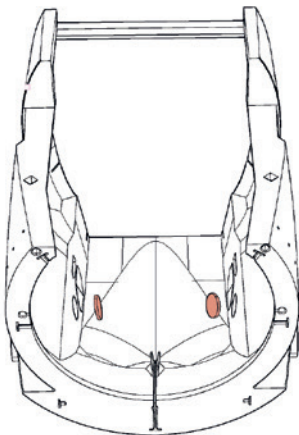
## P5\_FUS 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 90 g

**TIME** ~ 15 hours 30 minutes

### ADDITIONAL SETTINGS

None required



Remove support.

Please be careful with the knife!

# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

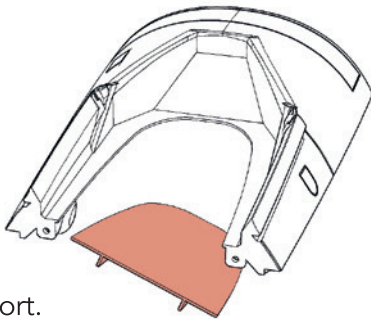
## P5\_FUS 3 up\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 25 g

**TIME** ~ 4 hours

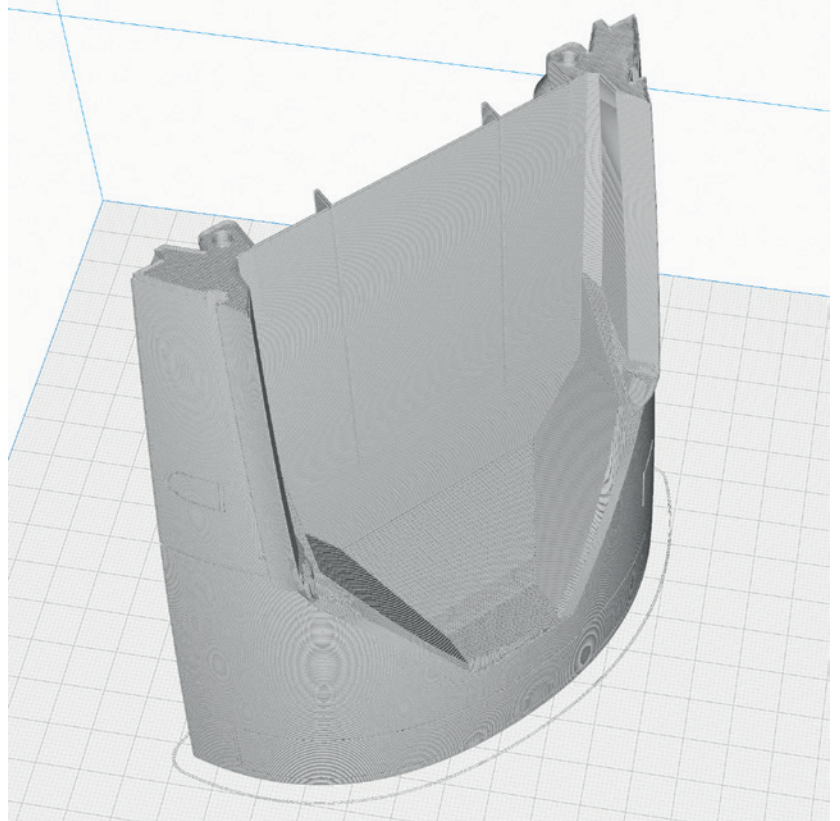
### ADDITIONAL SETTINGS

None required



Remove support.

Please be careful with the knife!



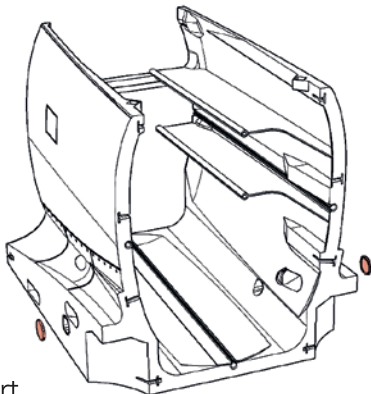
## P5\_FUS 3\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 110 g

**TIME** ~ 19 hours

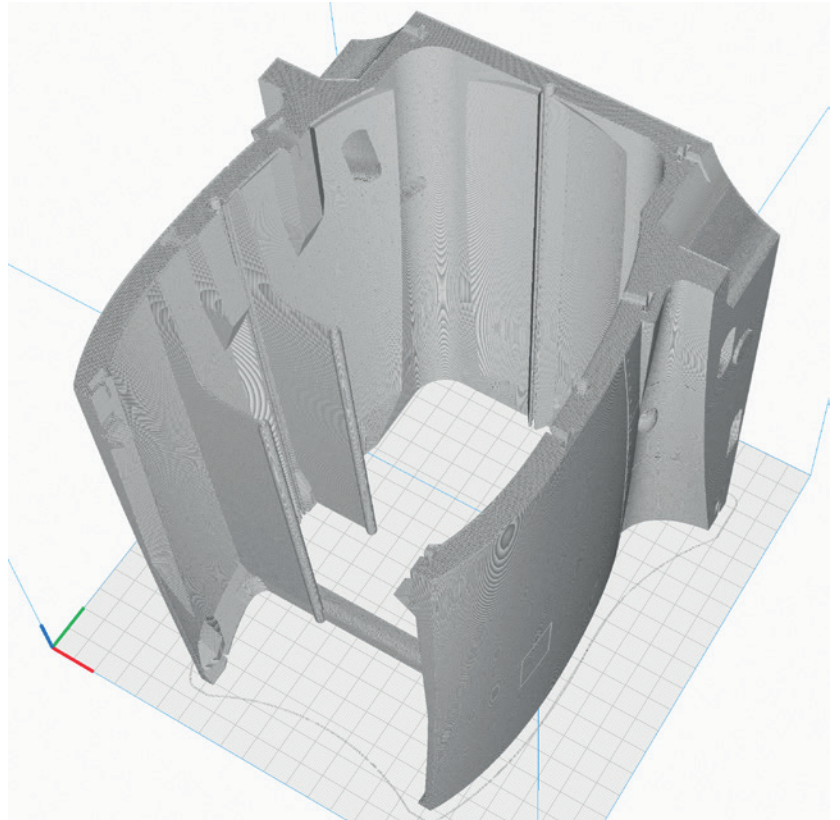
### ADDITIONAL SETTINGS

None required



Remove support.

Please be careful with the knife!



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

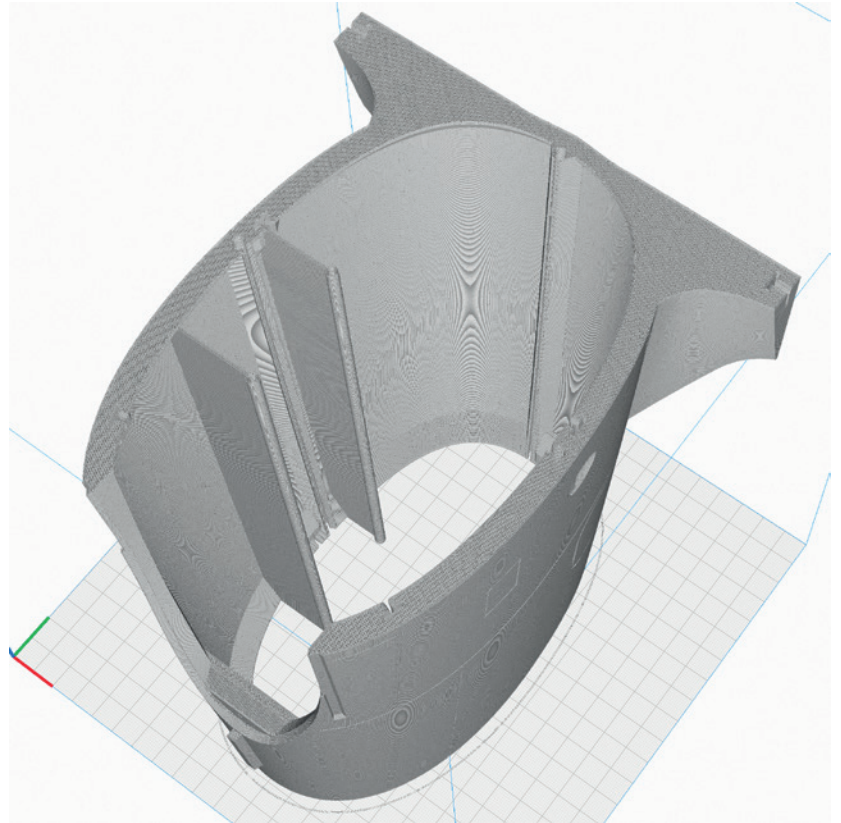
## P5\_FUS 4\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 100 g

**TIME** ~ 17 hours

### ADDITIONAL SETTINGS

- use brim



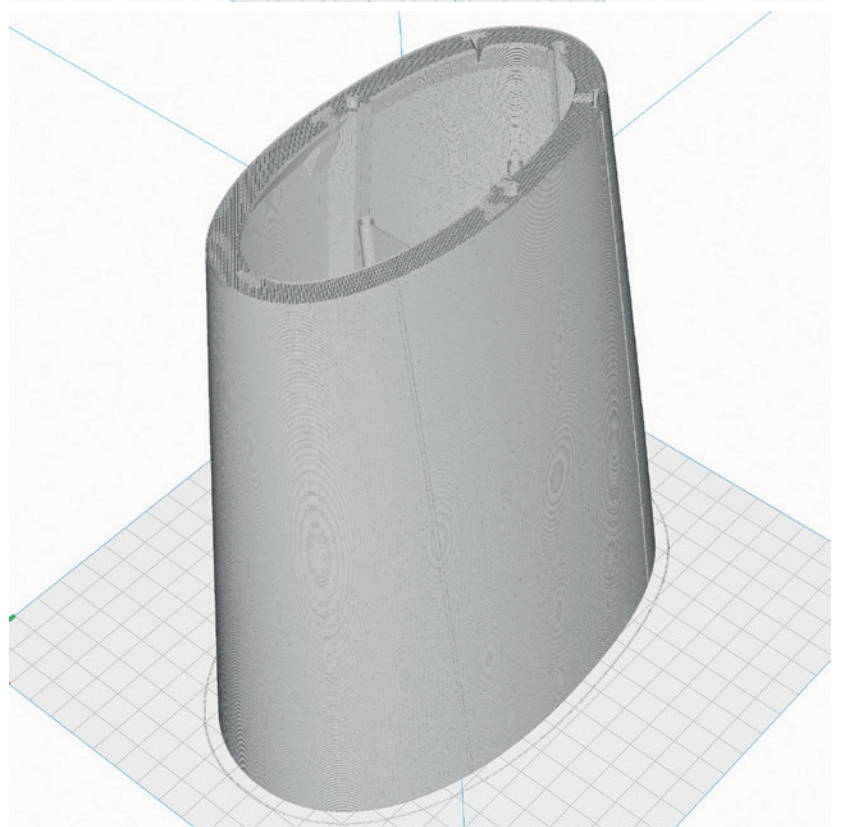
## P5\_FUS 5\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 65 g

**TIME** ~ 13 hours

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

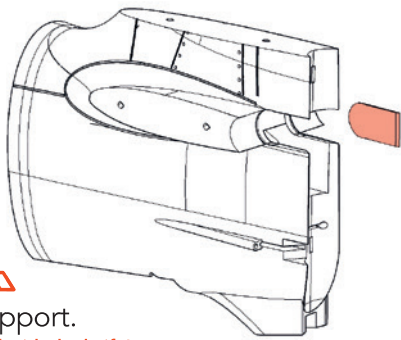
## P5\_FUS 6\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 55 g

**TIME** ~ 10 hours

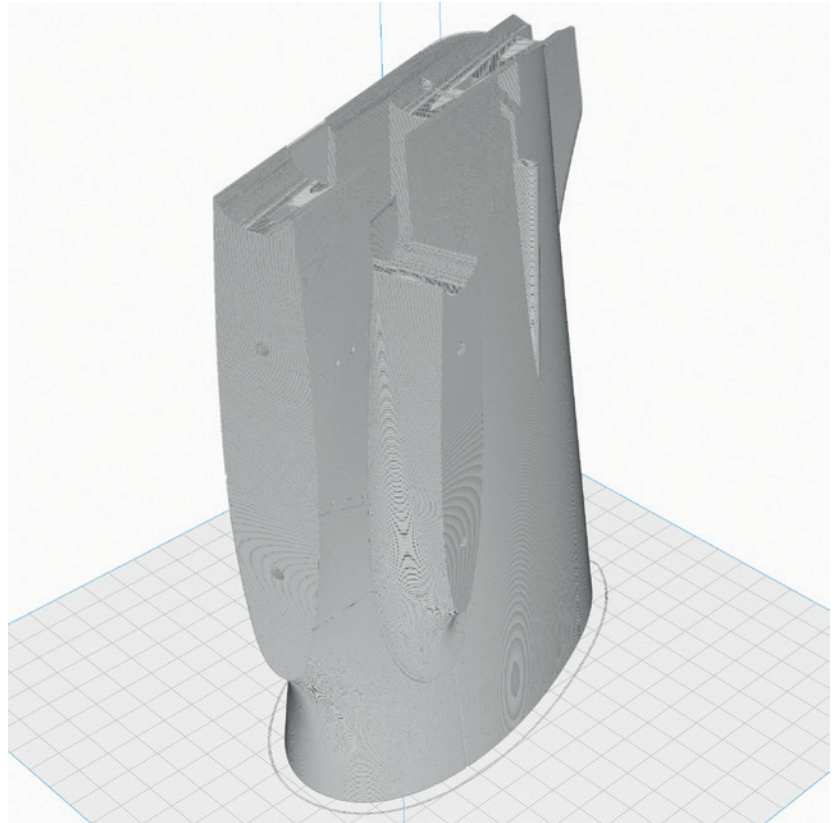
### ADDITIONAL SETTINGS

None required



Remove support.

**Please be careful with the knife!**



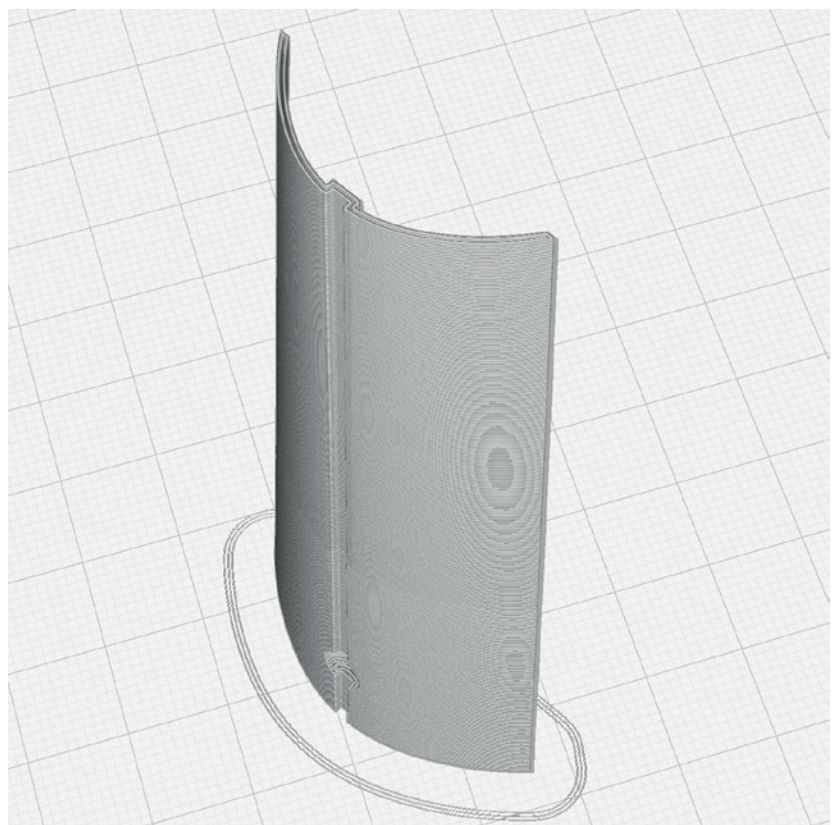
## P5\_Gear Doors\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 3 g

**TIME** ~ 20 minutes

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

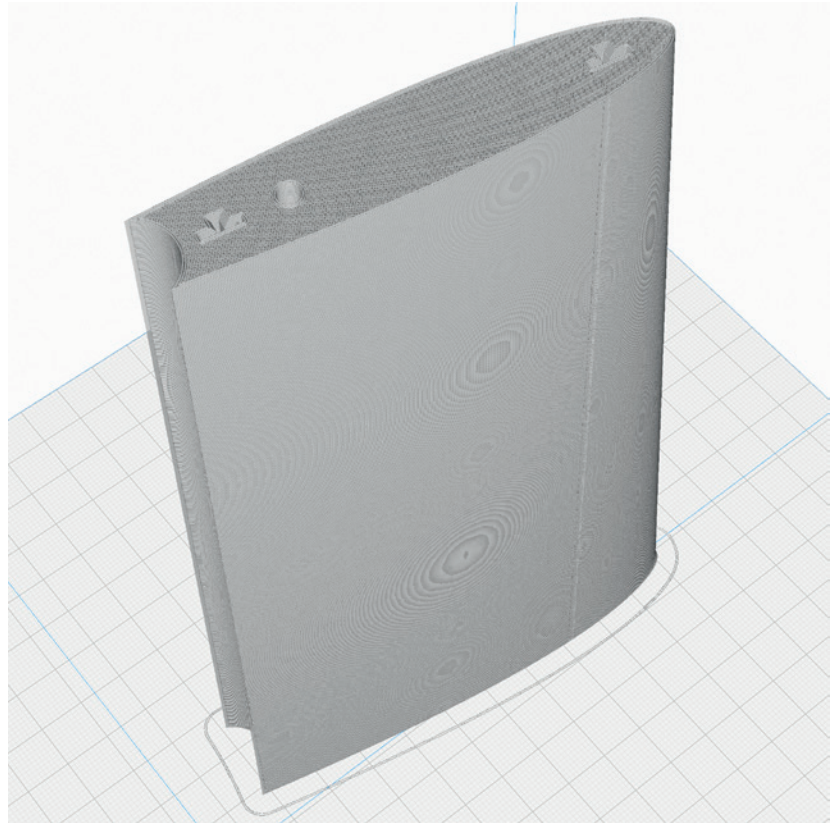
## P5\_HS L 1\_sf.stl and P5\_HS R 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 27 g

**TIME** ~ 4 hours

### ADDITIONAL SETTINGS

None required



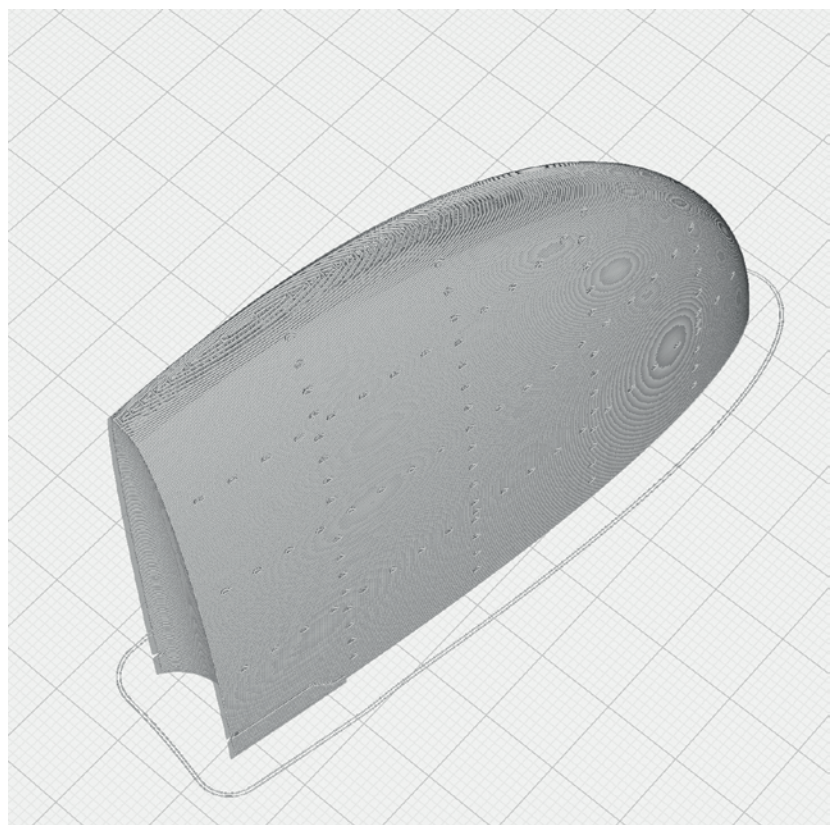
## P5\_HS L 2\_sf.stl and P5\_HS R 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 7 g

**TIME** ~ 1 hour

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

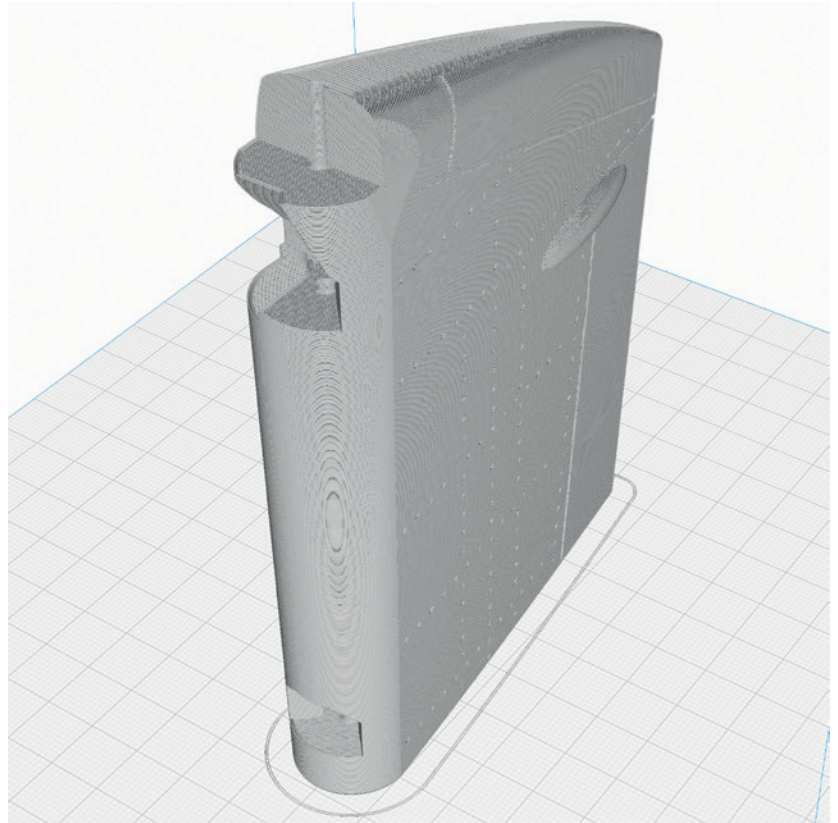
## P5\_Rudder 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 18 g

**TIME** ~ 2 hours 30 minutes

### **ADDITIONAL SETTINGS**

None required



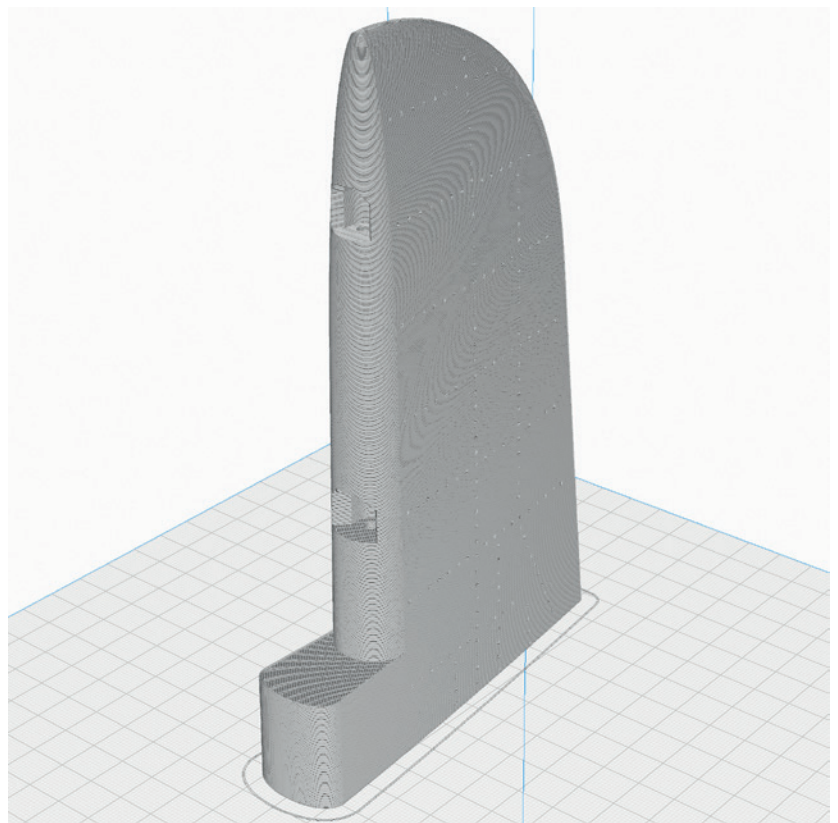
## P5\_Rudder 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 17 g

**TIME** ~ 3 hours

### **ADDITIONAL SETTINGS**

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

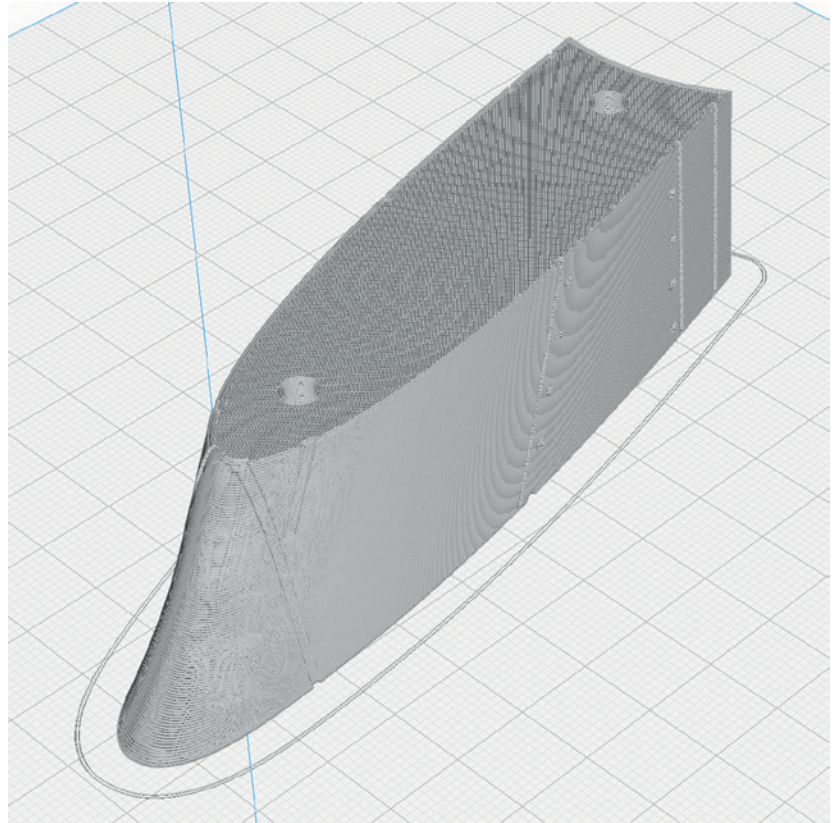
## P5\_VS 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 7 g

**TIME** ~ 1 hour

### **ADDITIONAL SETTINGS**

None required



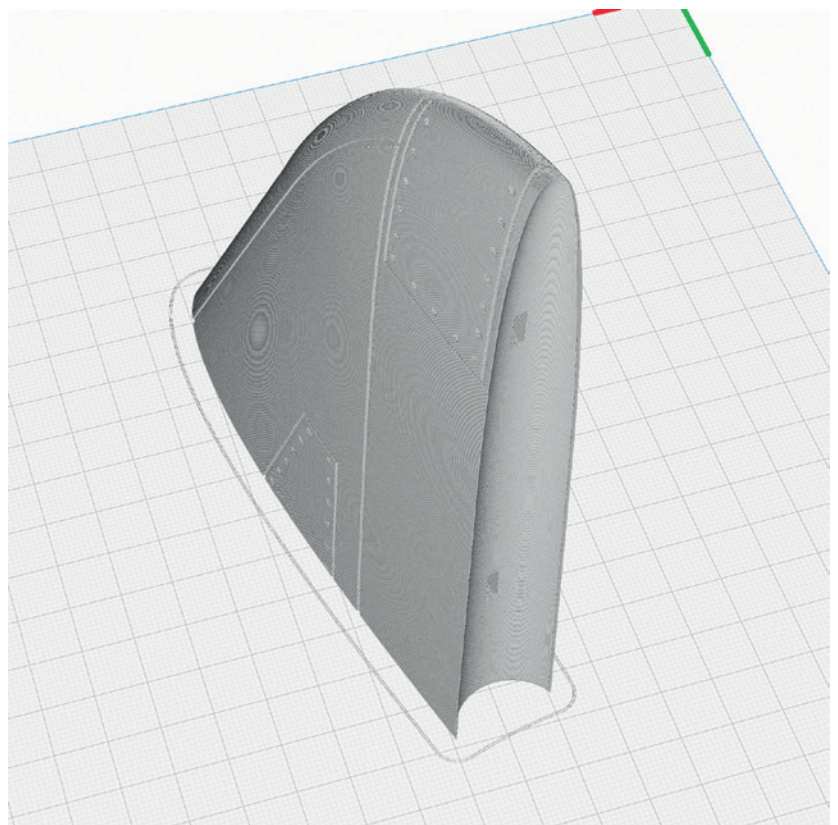
## P5\_VS 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 17 g

**TIME** ~ 2 hours 30 minutes

### **ADDITIONAL SETTINGS**

None required





# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

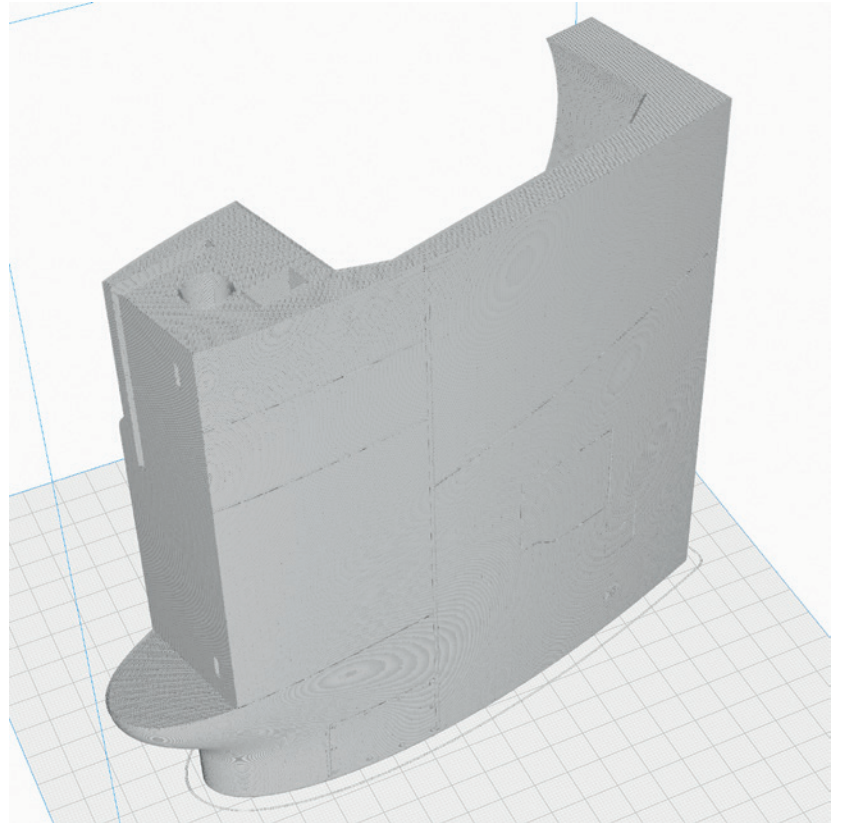
## P5\_Wing inside L 1\_sf.stl and P5\_Wing inside R 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 70 g

**TIME** ~ 11 hours

### ADDITIONAL SETTINGS

None required



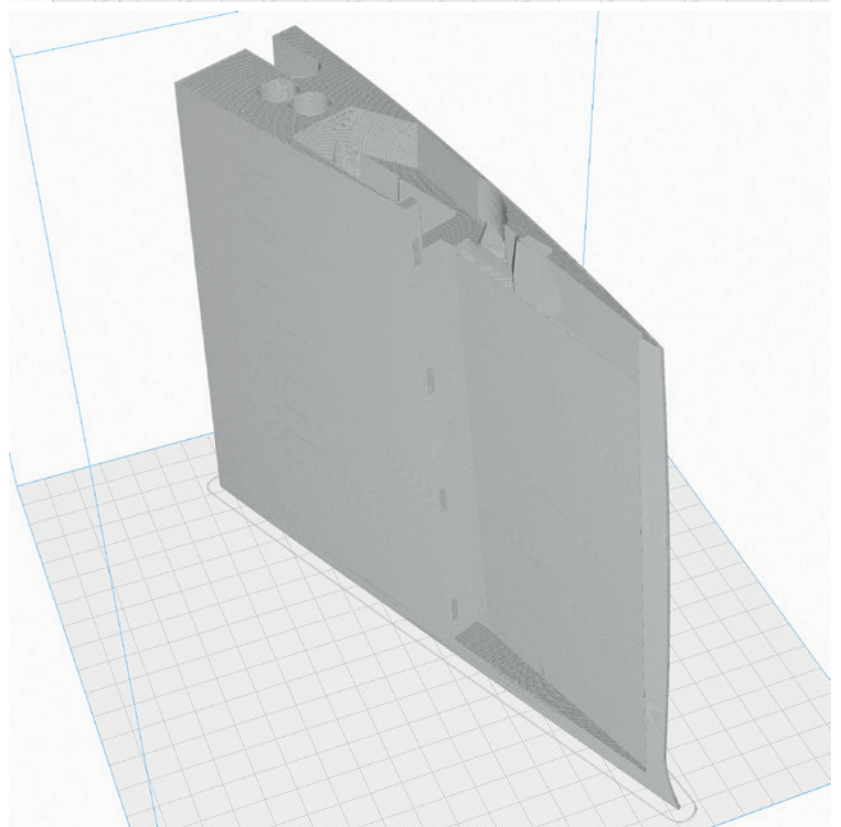
## P5\_Wing inside L 2\_sf.stl and P5\_Wing inside R 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 60 g

**TIME** ~ 10 hours

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

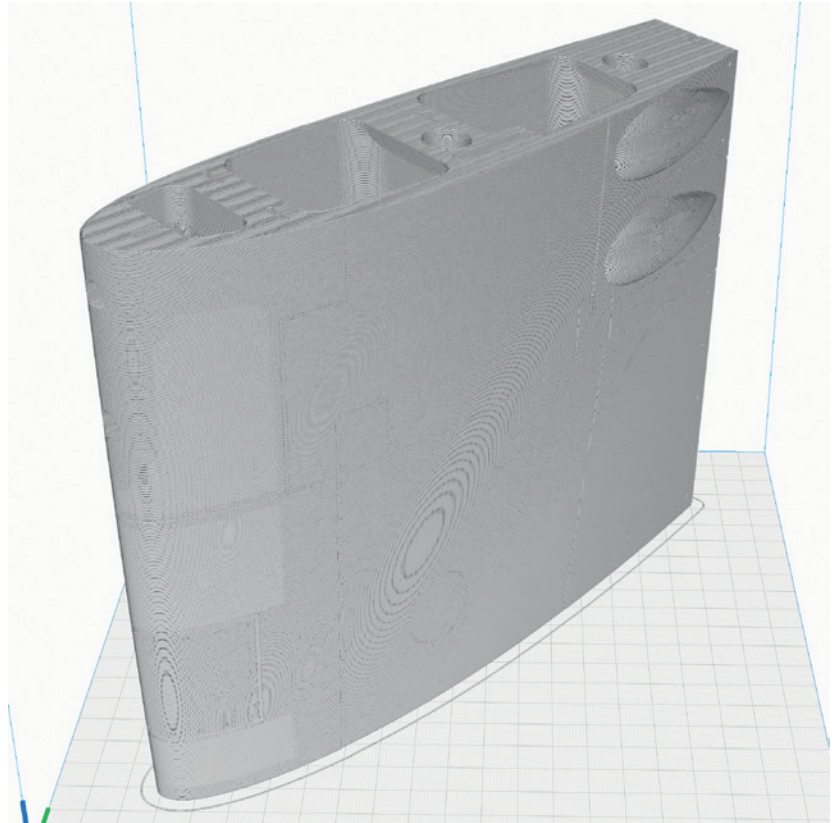
## P5\_Wing L 1\_sf.stl and P5\_Wing R 1\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 78 g

**TIME** ~ 13 hours

### **ADDITIONAL SETTINGS**

None required



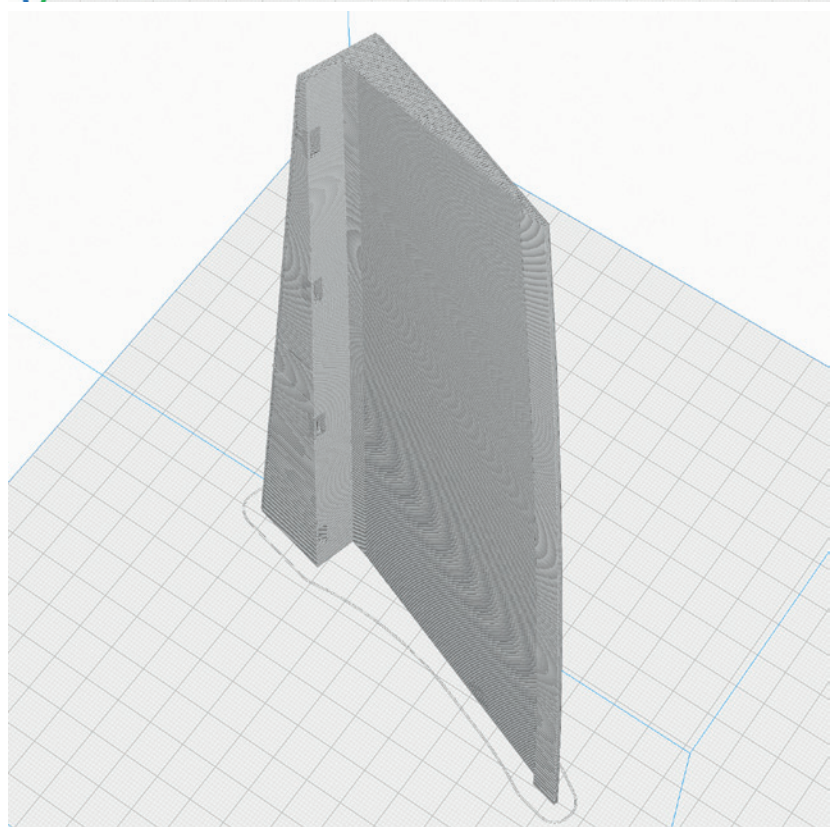
## P5\_Wing L 2\_sf.stl and P5\_Wing R 2\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 19 g

**TIME** ~ 3 hours

### **ADDITIONAL SETTINGS**

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

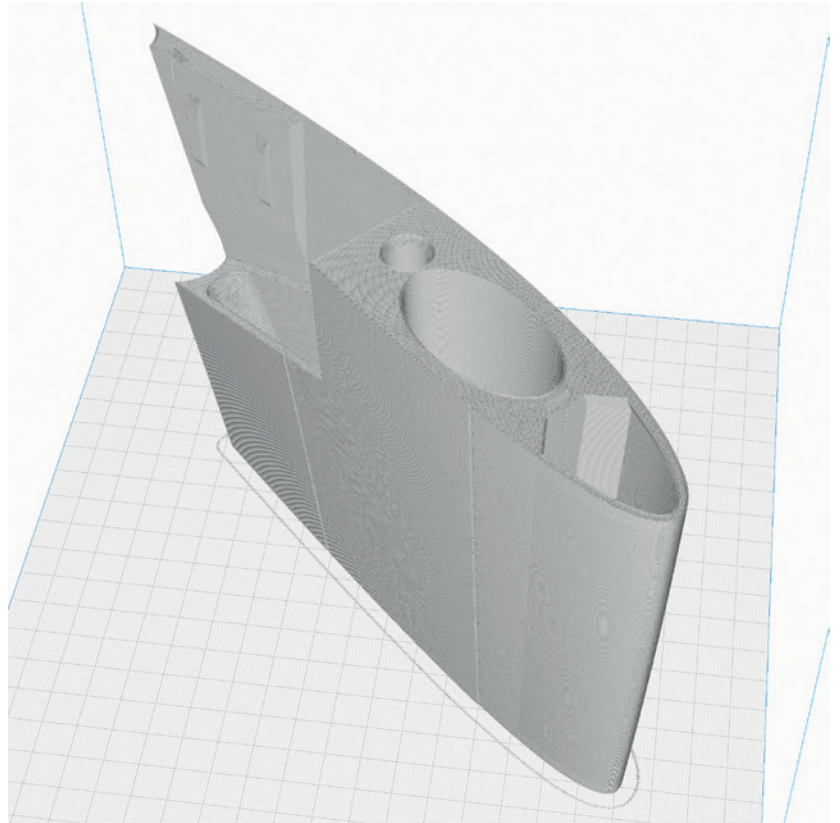
## P5\_Wing L 3\_sf.stl and P5\_Wing R 3\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 45 g

**TIME** ~ 7 hours

### ADDITIONAL SETTINGS

None required



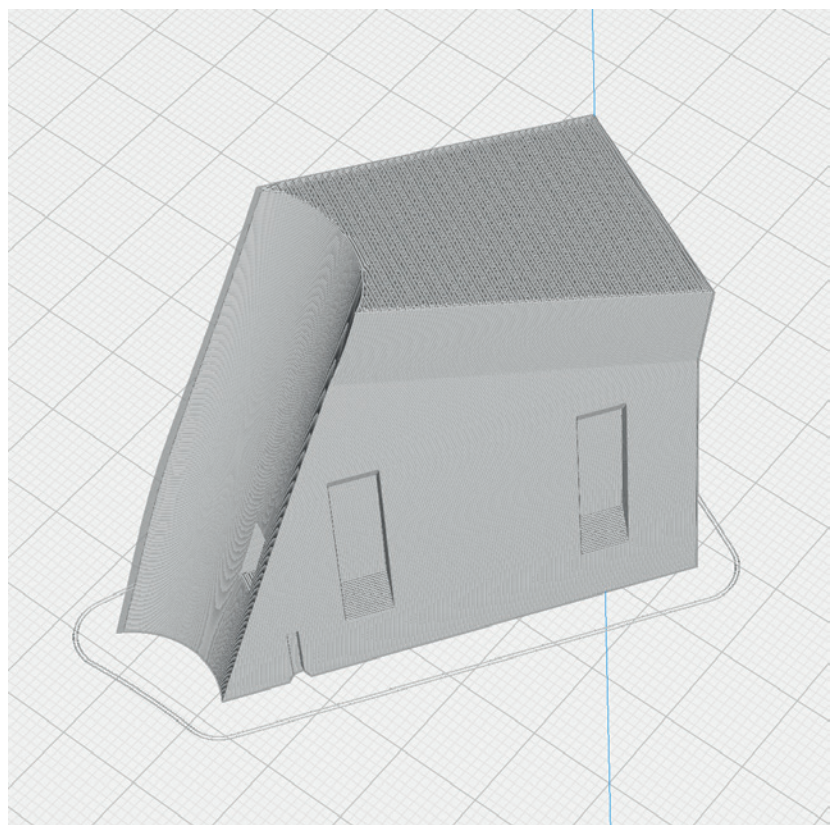
## P5\_Wing L 4\_sf.stl and P5\_Wing R 4\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 5 g

**TIME** ~ 50 minutes

### ADDITIONAL SETTINGS

None required



# PROFILE P5\_Gyroid LW-PLA (foaming)!



The information about the basic settings you can find on our website at PRINT.

**Please note the additional settings for the individual parts!**

**It is essential to print these parts with foaming LW-PLA (pre-foamed is heavier)!**

**Basic settings for LW-PLA:** Please follow the instructions in our **WINGTEST AND CALIBRATION TOOL** on our website for correct adjustment! Print only one STL at a time!

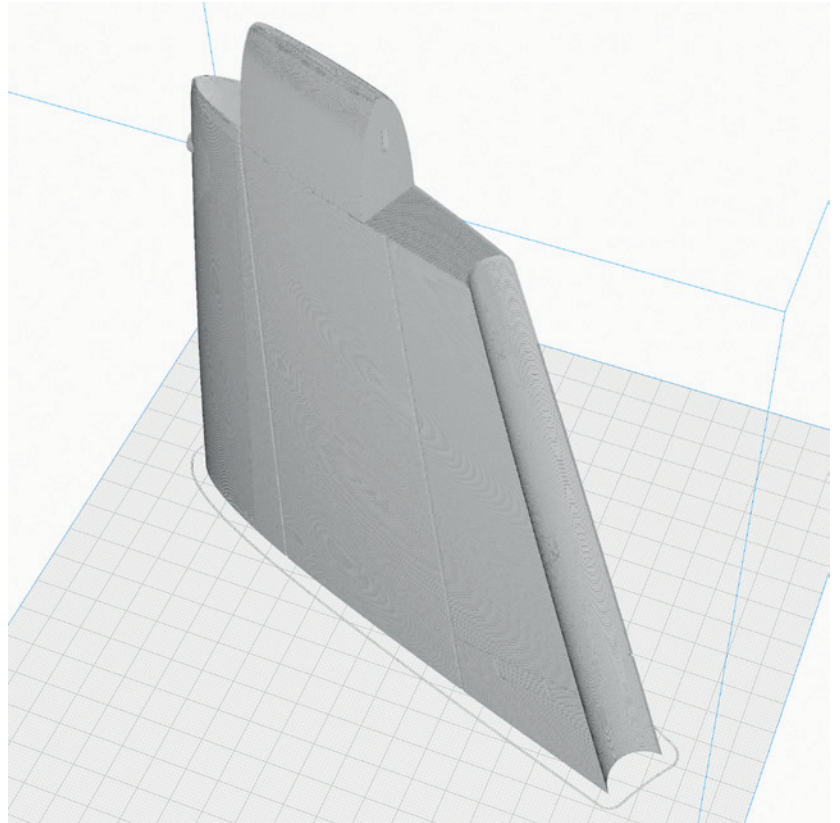
## P5\_Wing L 5\_sf.stl and P5\_Wing R 5\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 40 g

**TIME** ~ 6 hours

### ADDITIONAL SETTINGS

None required



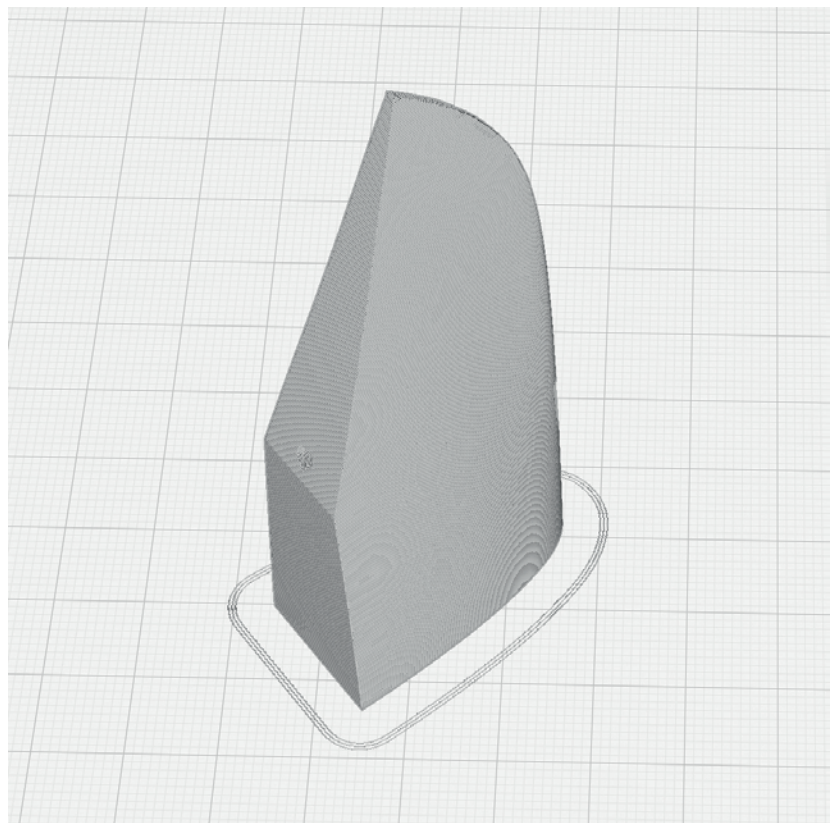
## P5\_Winglet L\_sf.stl and P5\_Winglet R\_sf.stl

**MATERIAL** LW PLA, Weight: ~ 3 g

**TIME** ~ 25 minutes

### ADDITIONAL SETTINGS

None required



## Gluing the parts printed with PROFILE P5

- STEP 1** As a first step, it is important to **roughen and smooth the adhesive surfaces** with sandpaper.
- STEP 2** Insert the **interconnects into the slots** provided on one side.
- STEP 3** Apply a **lot of glue** to the side with the interconnects. It is important that there is glue everywhere, especially on the outside and inside of the wall surfaces, in order to achieve a perfect connection. The interconnects only serve to align the parts to each other. It is better **not** to apply glue here, otherwise it can happen that the glue suddenly hardens while the parts are being put together and stops the process.

Use **medium viscosity CA glue**, thinner glue would run down the parts too easily.

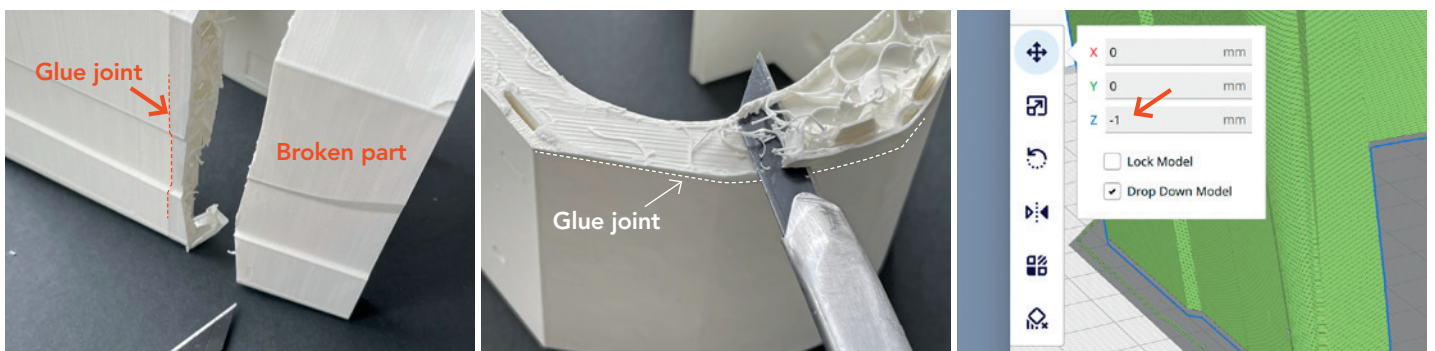
After assembly, **align the two parts exactly** and wipe off the excess CA glue from the surface with a cloth. Now spray with activator spray along the gluing surface and carefully press the parts together.

- STEP 4** Clean the glued areas slightly with a **sharp-bladed cutter**.



## PROFILES 5 parts are easy to repair

- STEP 1** Using the knife, carefully remove the damaged part about 3 mm from the glue joint between two parts.
- STEP 2** Cut wall and infill and clean the surface with sandpaper. **The top surface of the damaged part remains!**
- STEP 3** The remaining top surface is about 1 mm thick. To compensate for this, you can move the new part to be printed down the Z axis in Cura by 1 mm.

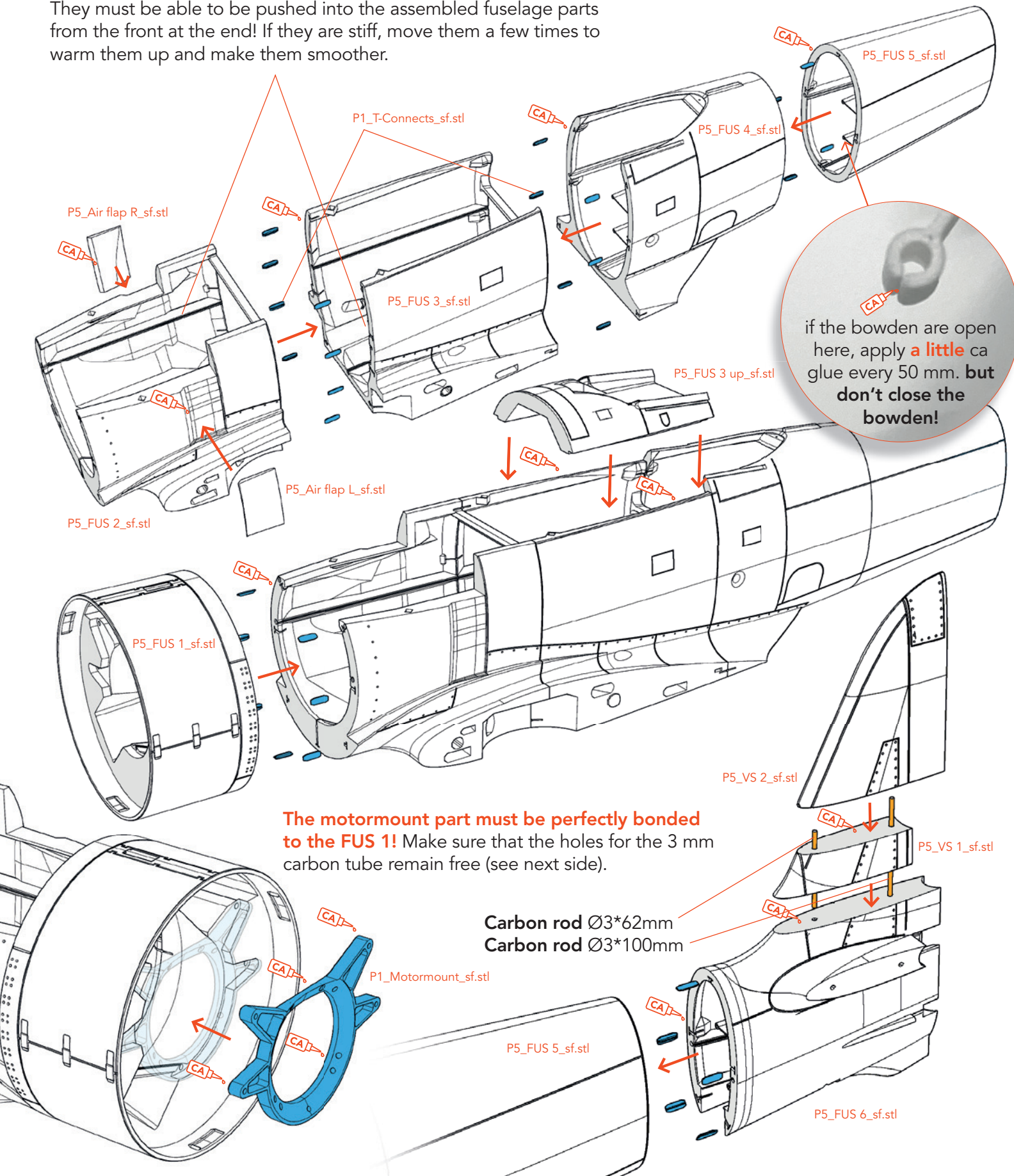


# Fuselage assembly

**TIP** Always put all parts together **BEFORE** gluing and check that everything runs smoothly and fits exactly.

Glue the parts as shown here:

Before gluing, check that the 3 mm carbon rods fit into these tubes. They must be able to be pushed into the assembled fuselage parts from the front at the end! If they are stiff, move them a few times to warm them up and make them smoother.



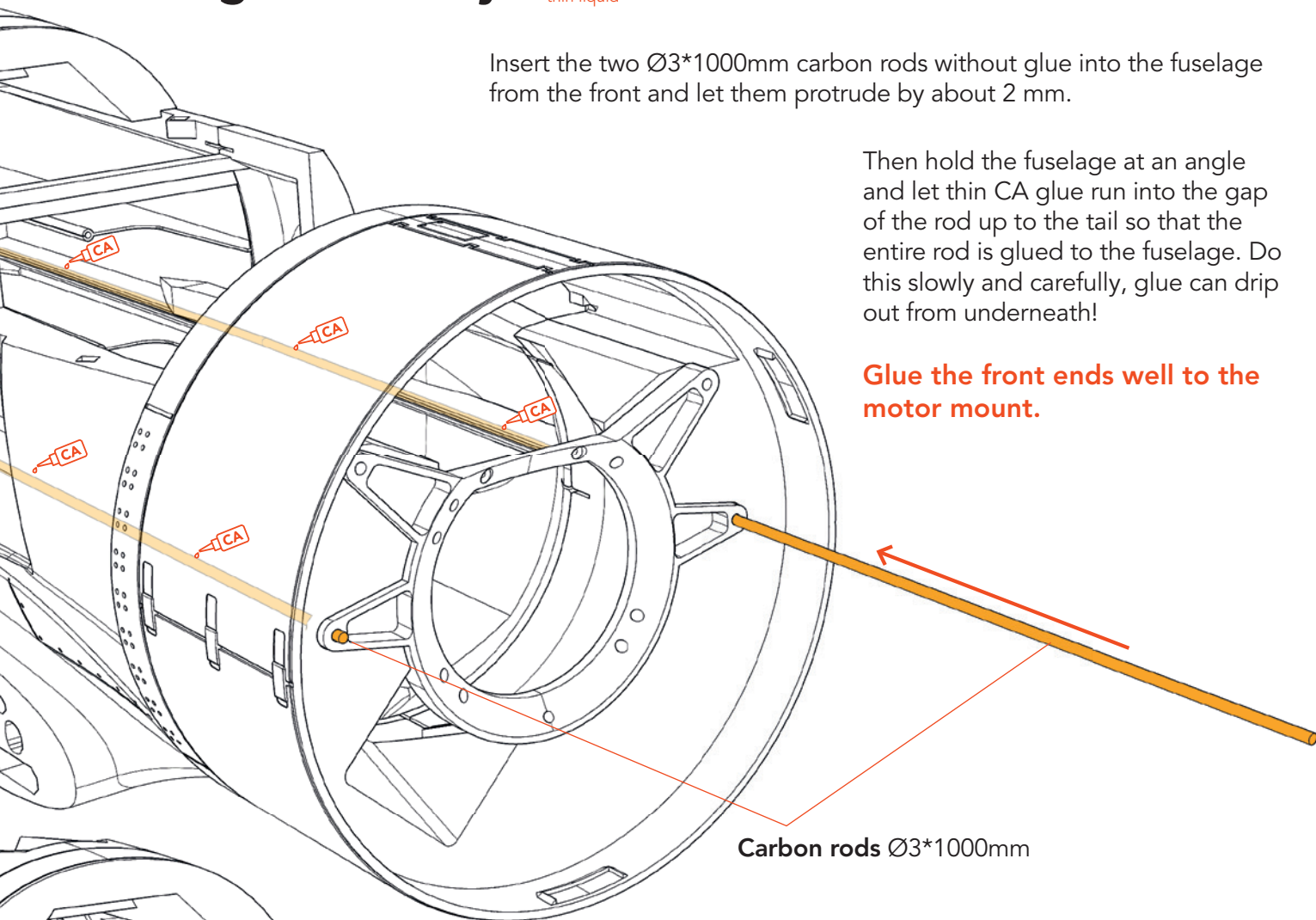
# Fuselage assembly



Insert the two  $\text{Ø}3 \times 1000\text{mm}$  carbon rods without glue into the fuselage from the front and let them protrude by about 2 mm.

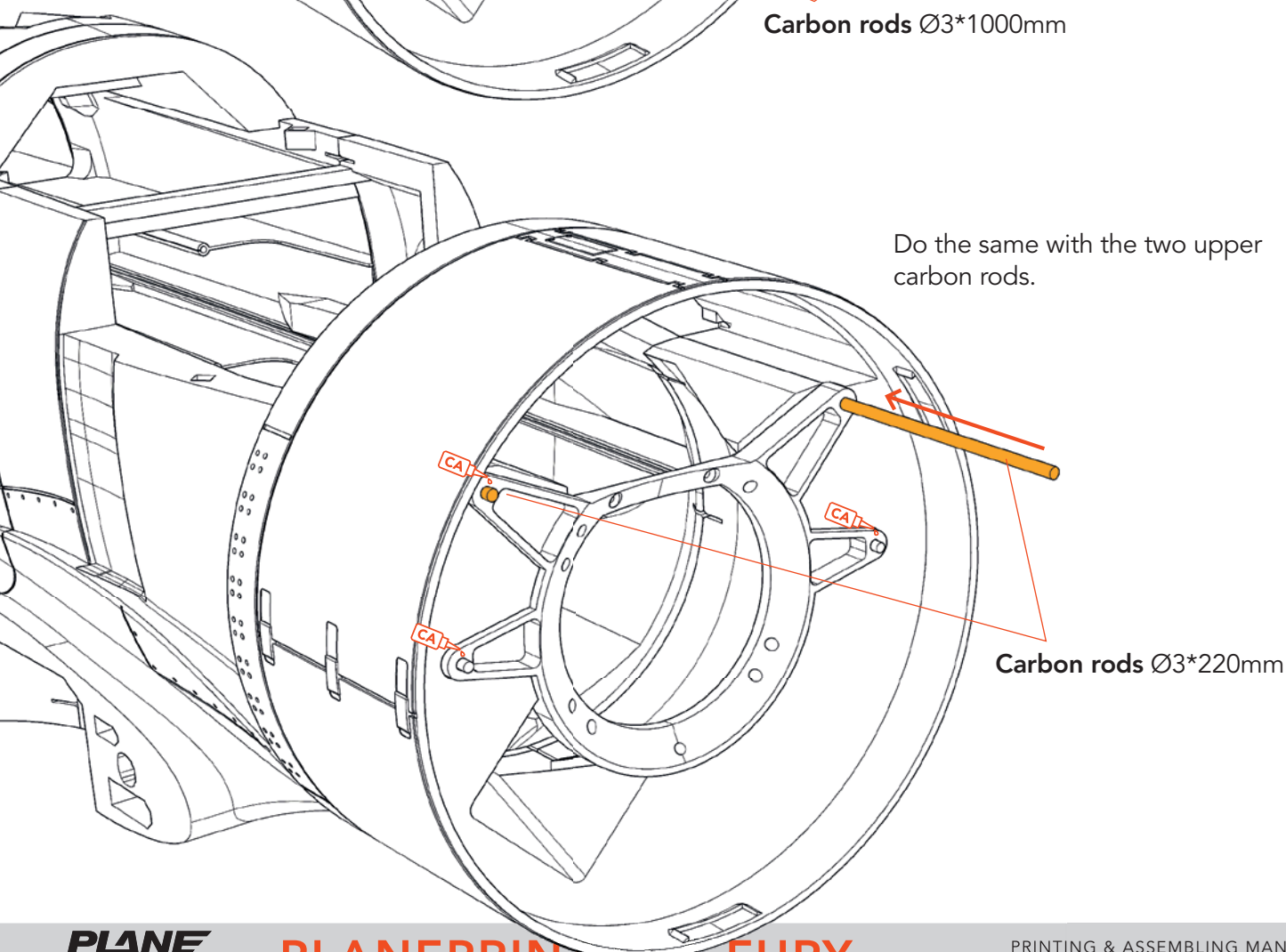
Then hold the fuselage at an angle and let thin CA glue run into the gap of the rod up to the tail so that the entire rod is glued to the fuselage. Do this slowly and carefully, glue can drip out from underneath!

**Glue the front ends well to the motor mount.**



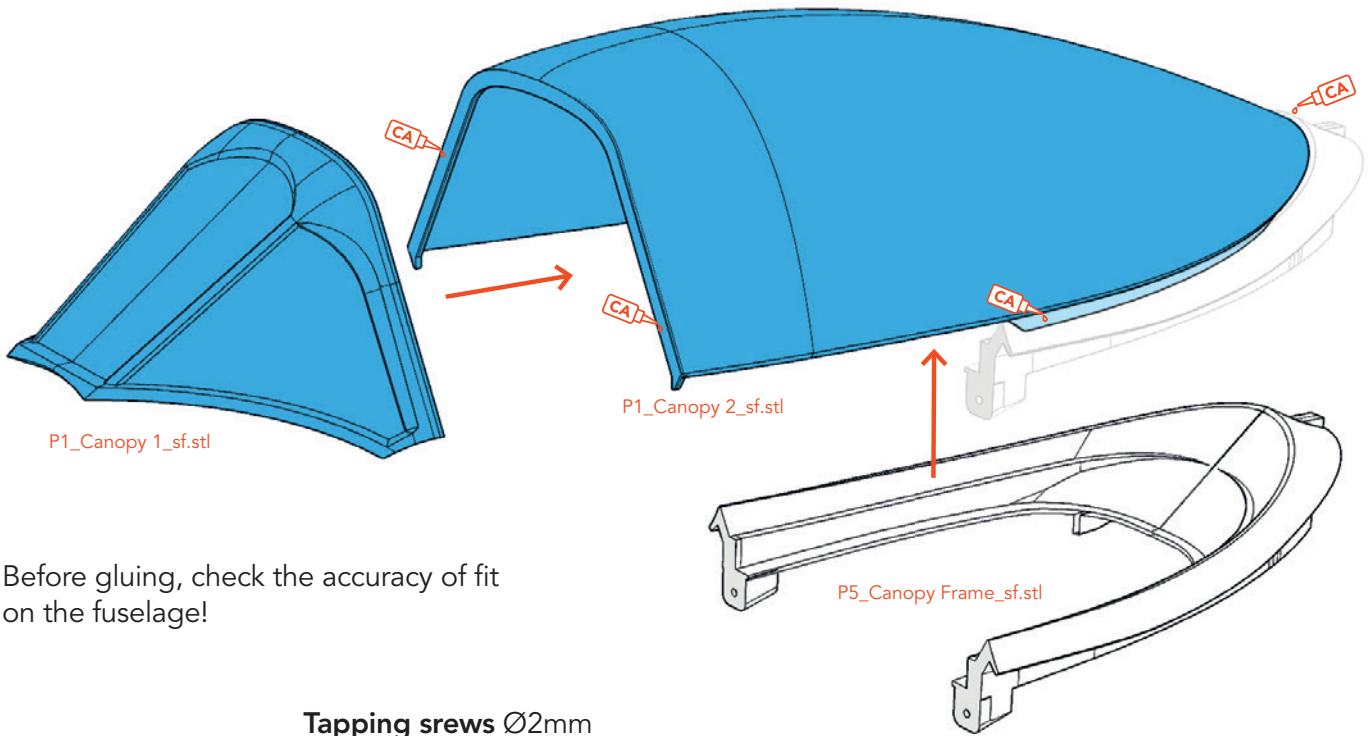
Carbon rods  $\text{Ø}3 \times 1000\text{mm}$

Do the same with the two upper carbon rods.



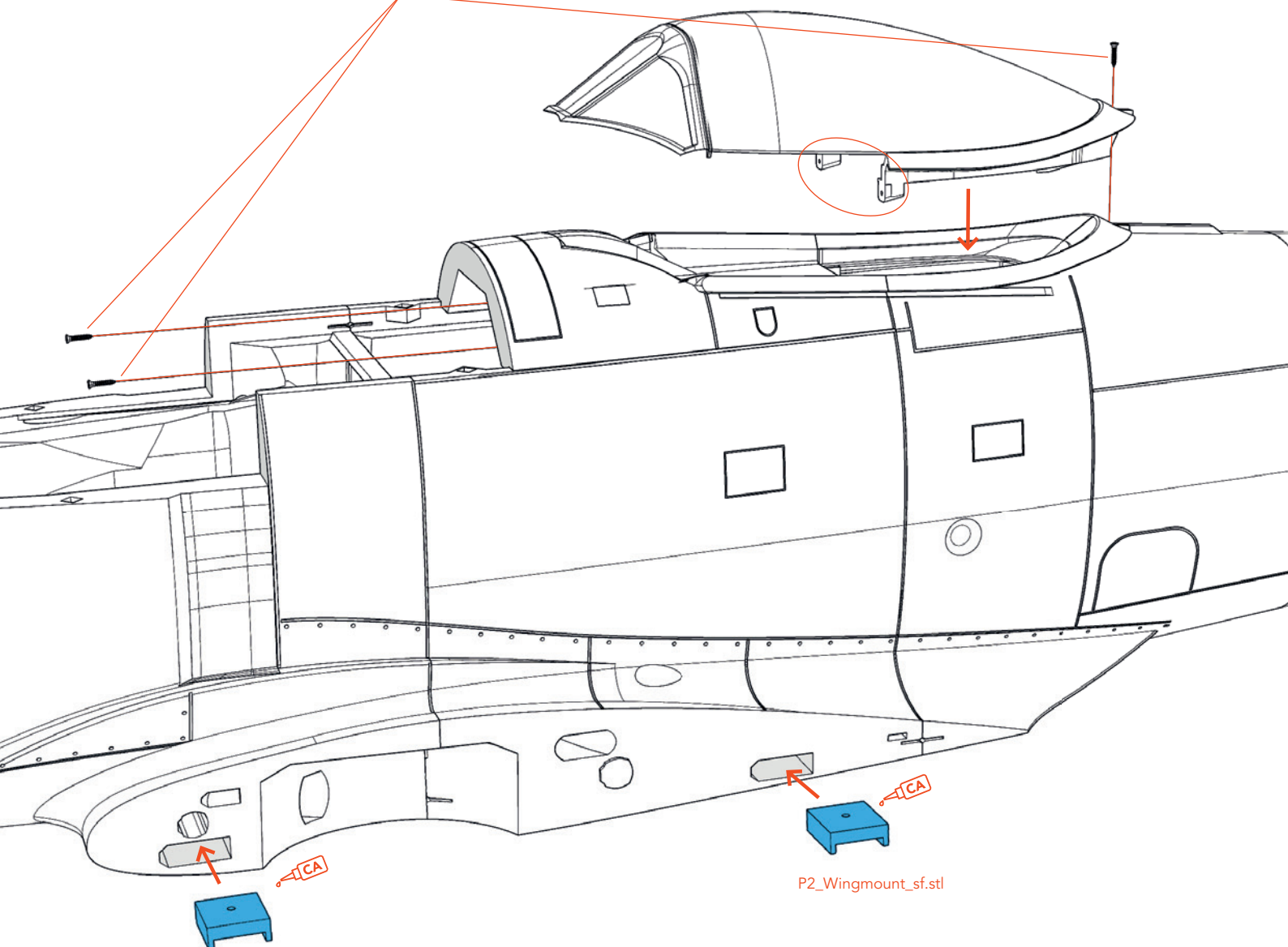
Carbon rods  $\text{Ø}3 \times 220\text{mm}$

# Canopy assembly



Before gluing, check the accuracy of fit on the fuselage!

Tapping screws  $\varnothing 2\text{mm}$



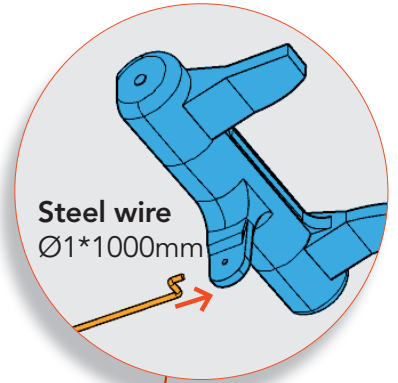


# Elevator assembly

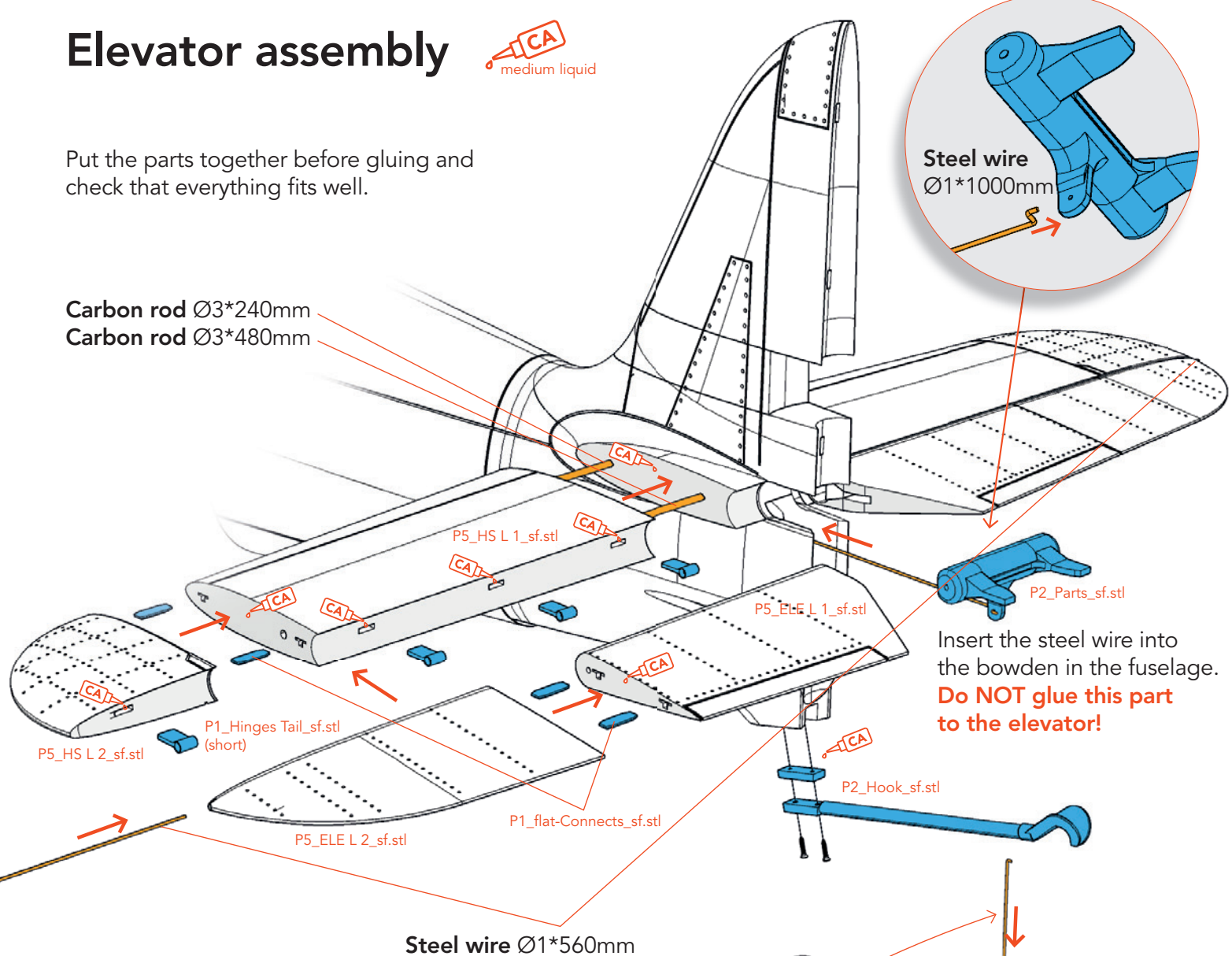


Put the parts together before gluing and check that everything fits well.

Carbon rod  $\varnothing 3 \times 240 \text{mm}$   
Carbon rod  $\varnothing 3 \times 480 \text{mm}$



Steel wire  $\varnothing 1 \times 1000 \text{mm}$

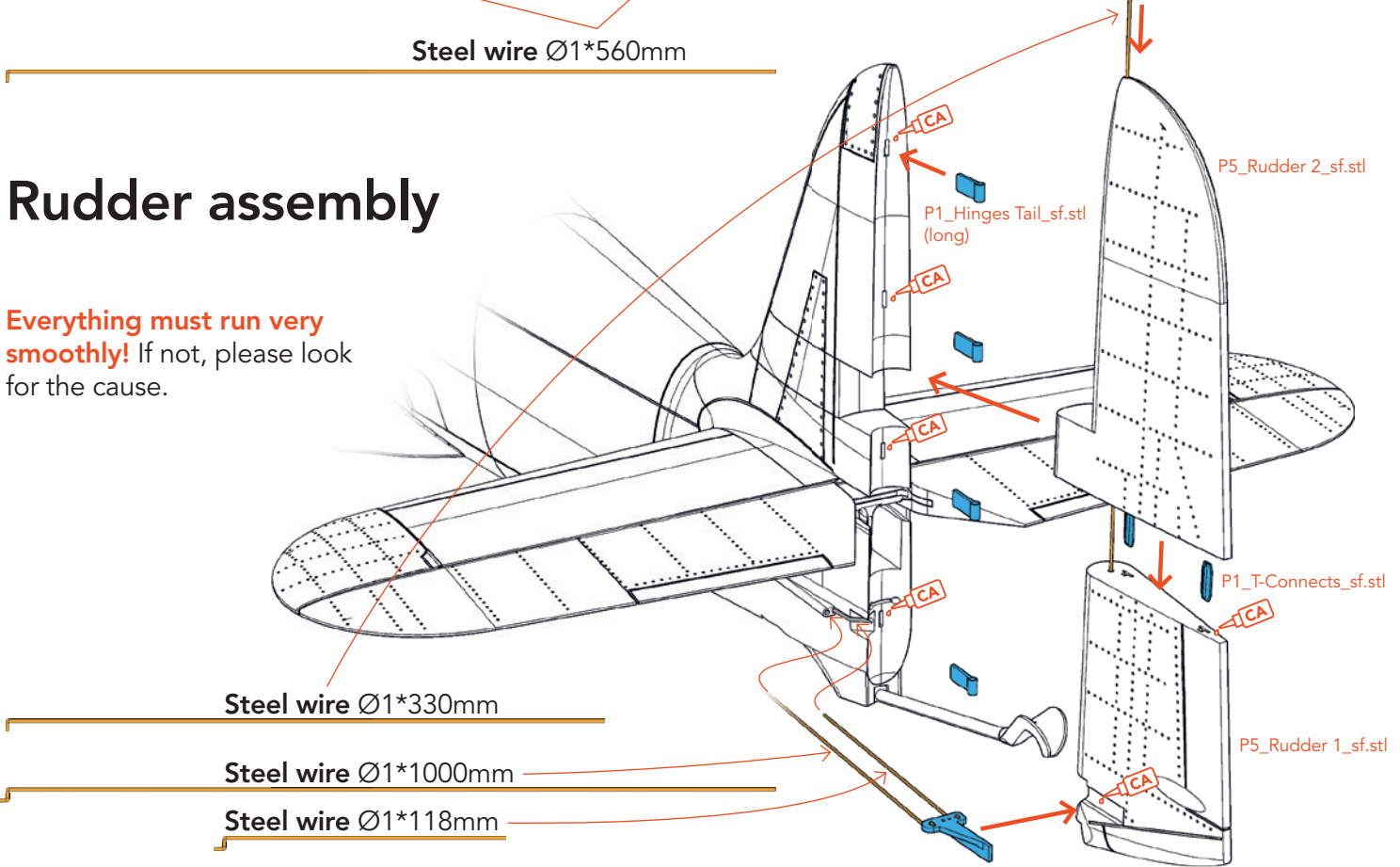


Insert the steel wire into the bowden in the fuselage.  
**Do NOT glue this part to the elevator!**

Steel wire  $\varnothing 1 \times 560 \text{mm}$

# Rudder assembly

Everything must run very smoothly! If not, please look for the cause.



Steel wire  $\varnothing 1 \times 330 \text{mm}$

Steel wire  $\varnothing 1 \times 1000 \text{mm}$

Steel wire  $\varnothing 1 \times 118 \text{mm}$

# Suspended rear landing gear

This lever must be at exactly 90° to the running direction of the wheel!

P1\_Gear Tail\_sf.stl

Carbon rod  
Ø3\*77mm

Rod connection

Steel wire  
Ø1mm

21mm

9mm

47mm

Do NOT glue this part! It must be able to move smoothly.

**LAST STEP**

P5\_Gear Doors\_sf.stl

P2\_Gear Tail\_sf.stl

Assemble the parts as shown in the picture and glue the joint holder in the fuselage. The short wire that comes from the rudder is inserted through the rod connection and thus the wheel is articulated parallel to the rudder.

Metal screw Ø3mm

Carbon rod Ø3mm

P2\_Rim back\_sf.stl

P4\_Tire back\_sf.stl

Tapping screws Ø2mm

P2\_Gear Tail\_sf.stl

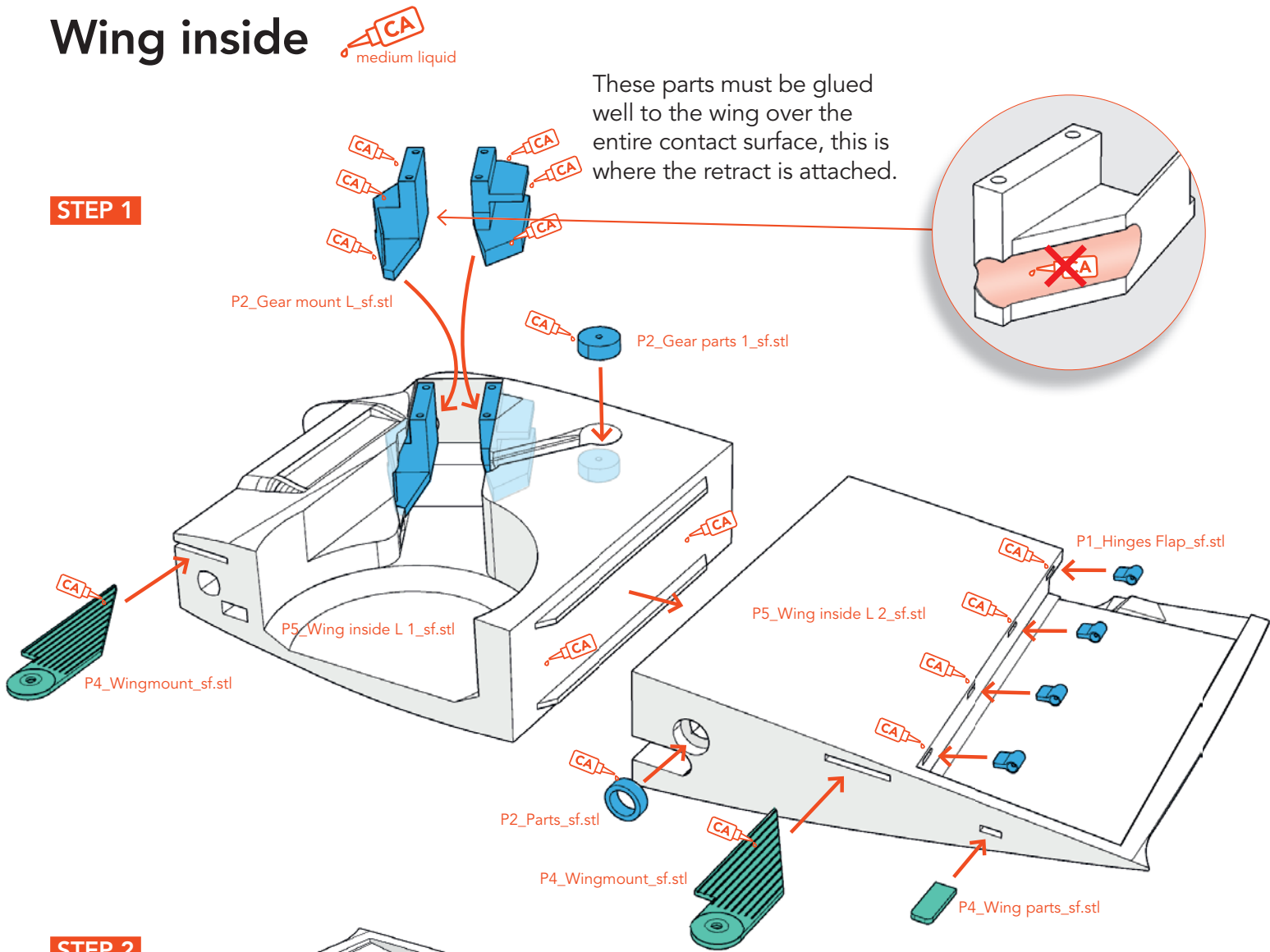
P5\_FUS 6\_sf.stl

# Wing inside

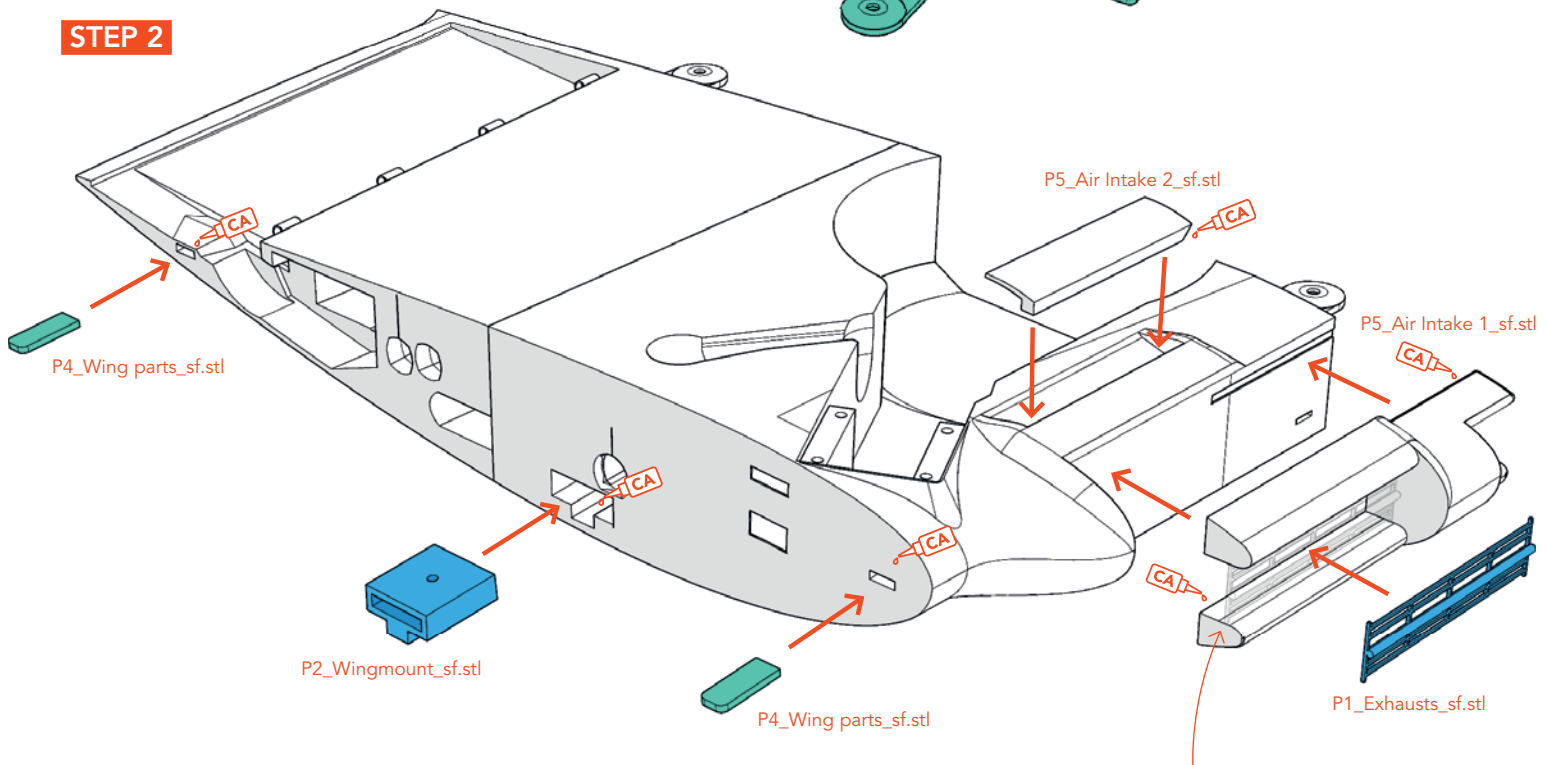


These parts must be glued well to the wing over the entire contact surface, this is where the retract is attached.

## STEP 1



## STEP 2

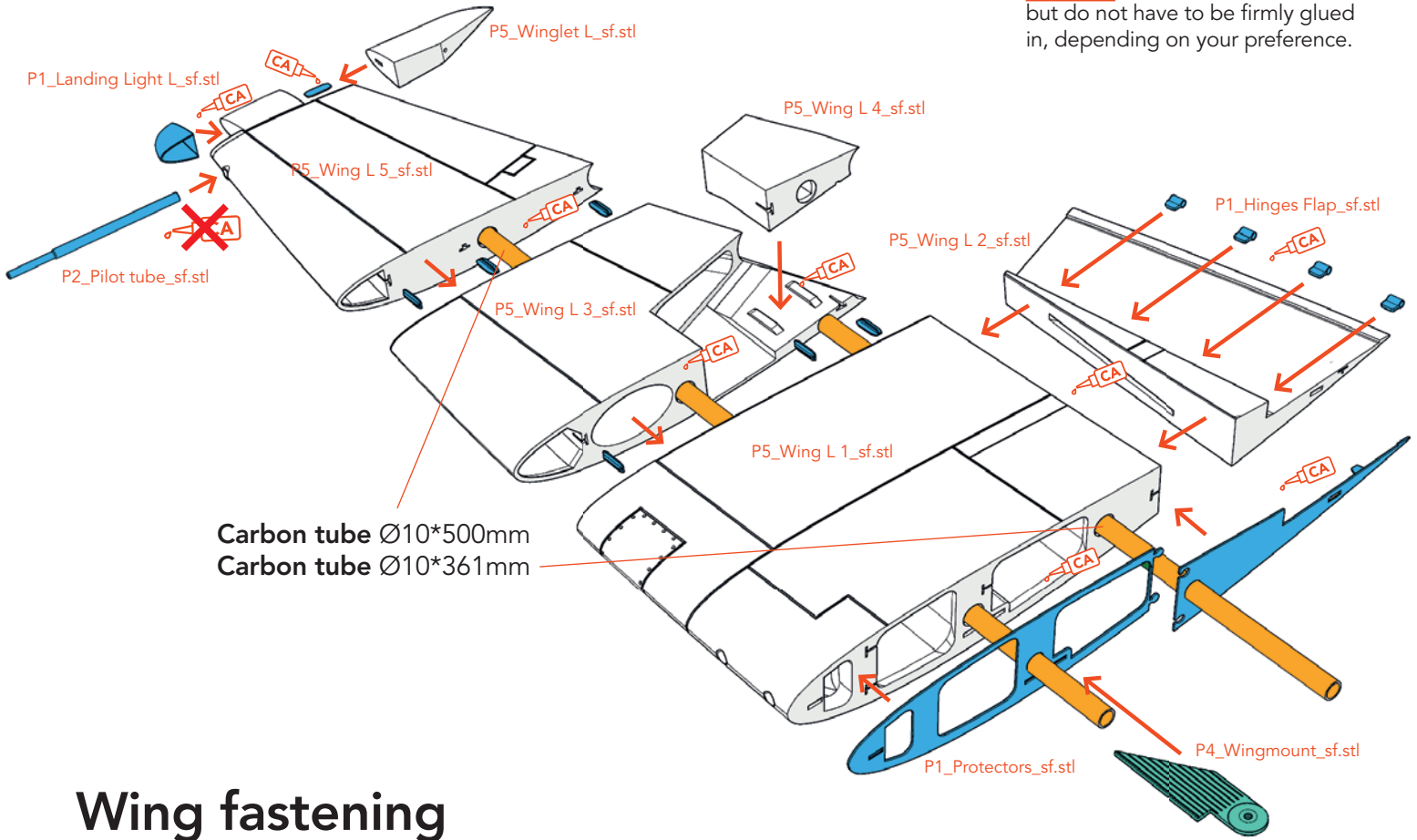


This grid should be positioned approximately here. Paint the area behind it black.

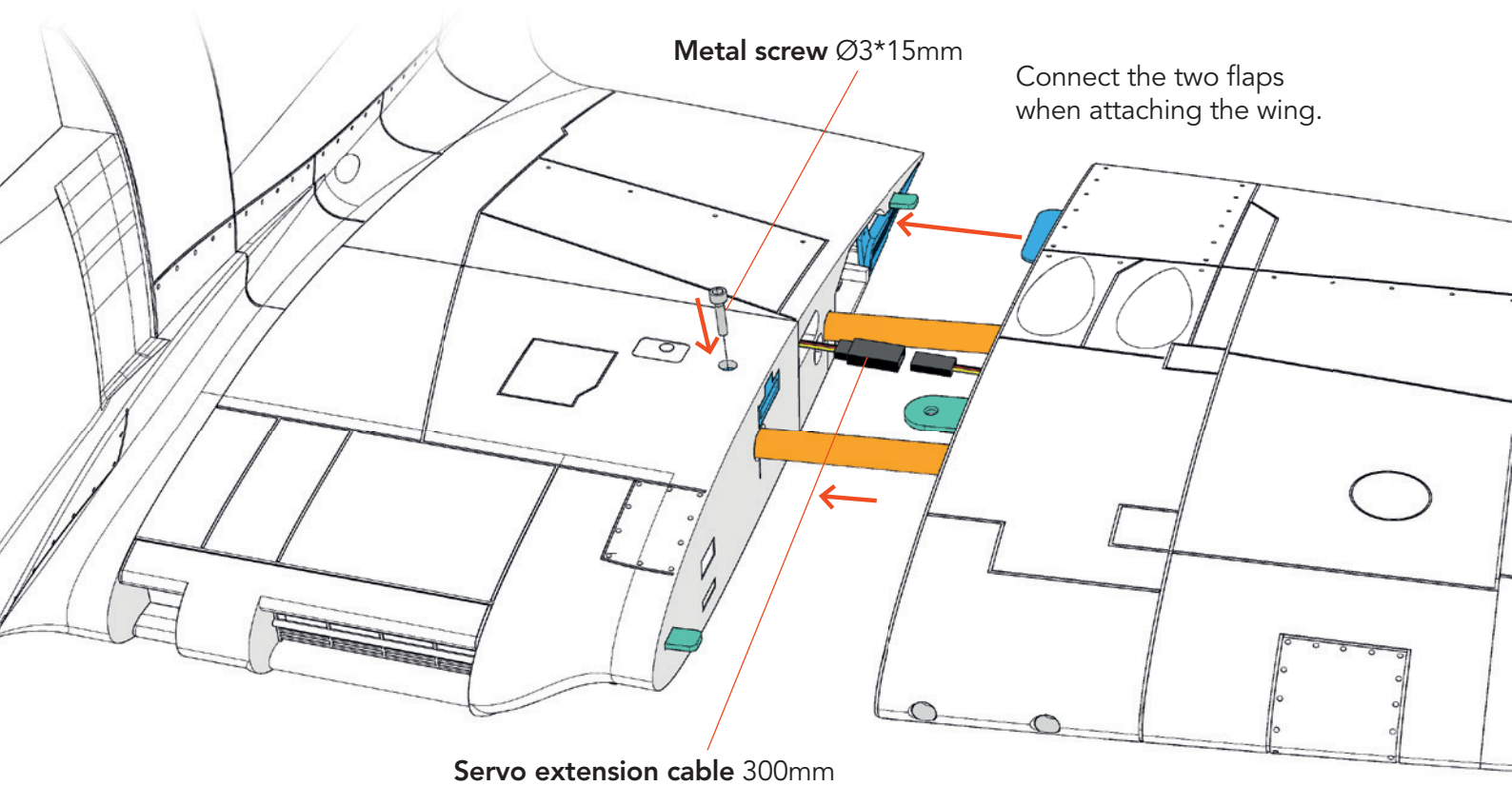
# Wing assembly



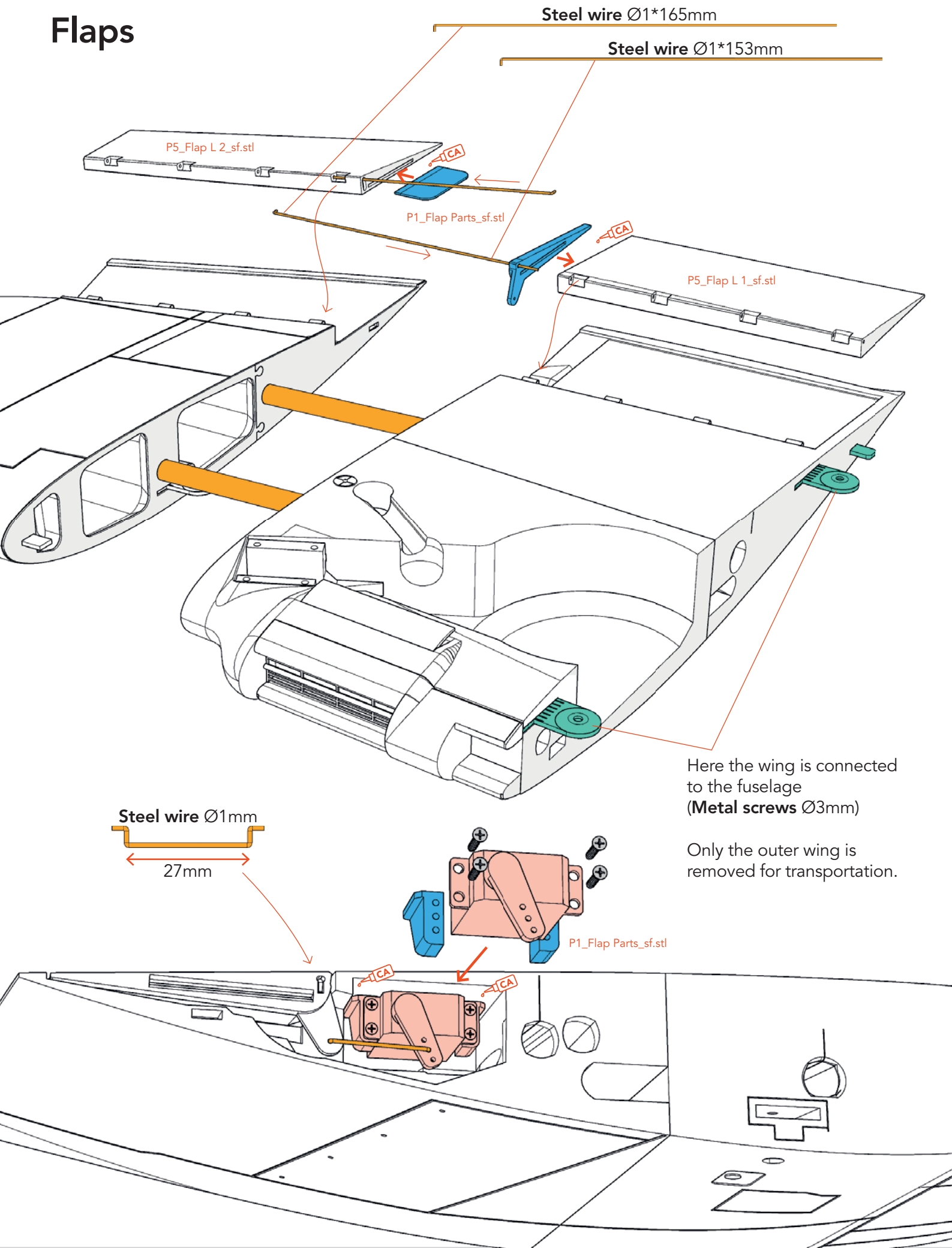
**NOTE** The carbon tubes can, but do not have to be firmly glued in, depending on your preference.



# Wing fastening



# Flaps



Steel wire Ø1\*165mm

Steel wire Ø1\*153mm

P5\_Flap L 2\_sf.stl

P1\_Flap Parts\_sf.stl

P5\_Flap L 1\_sf.stl

Steel wire Ø1mm

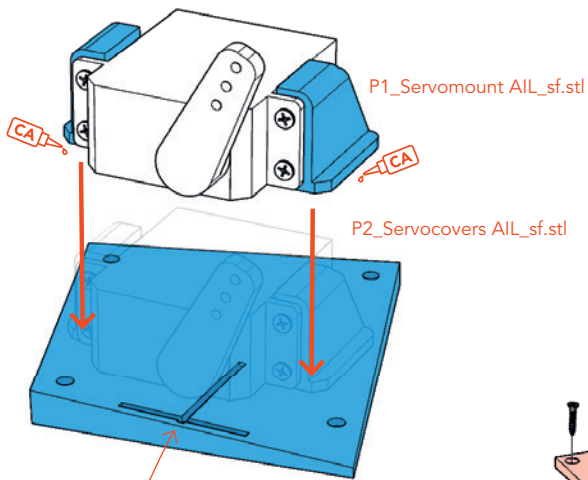
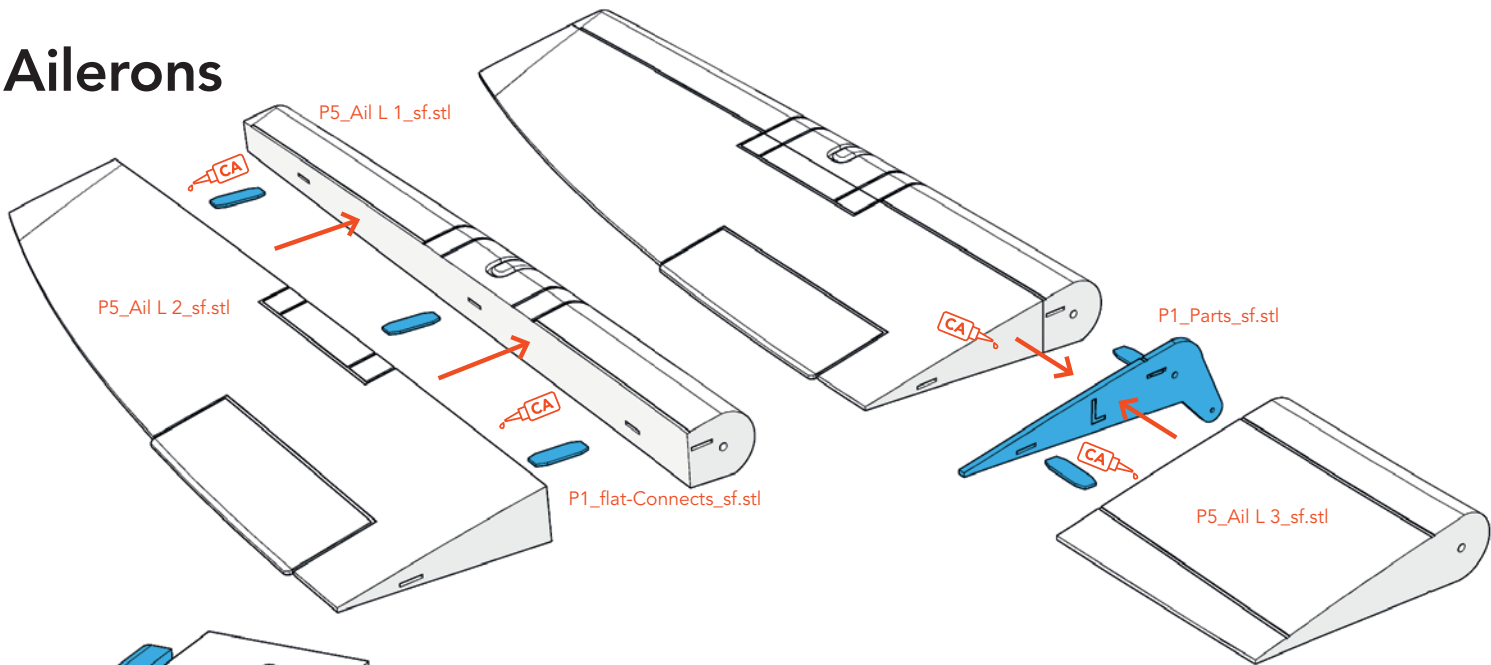
27mm

Here the wing is connected to the fuselage  
**(Metal screws Ø3mm)**

Only the outer wing is removed for transportation.

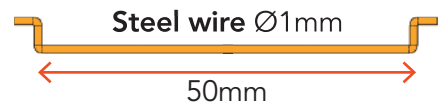
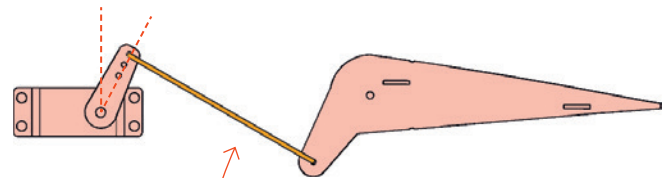
P1\_Flap Parts\_sf.stl

# Ailerons

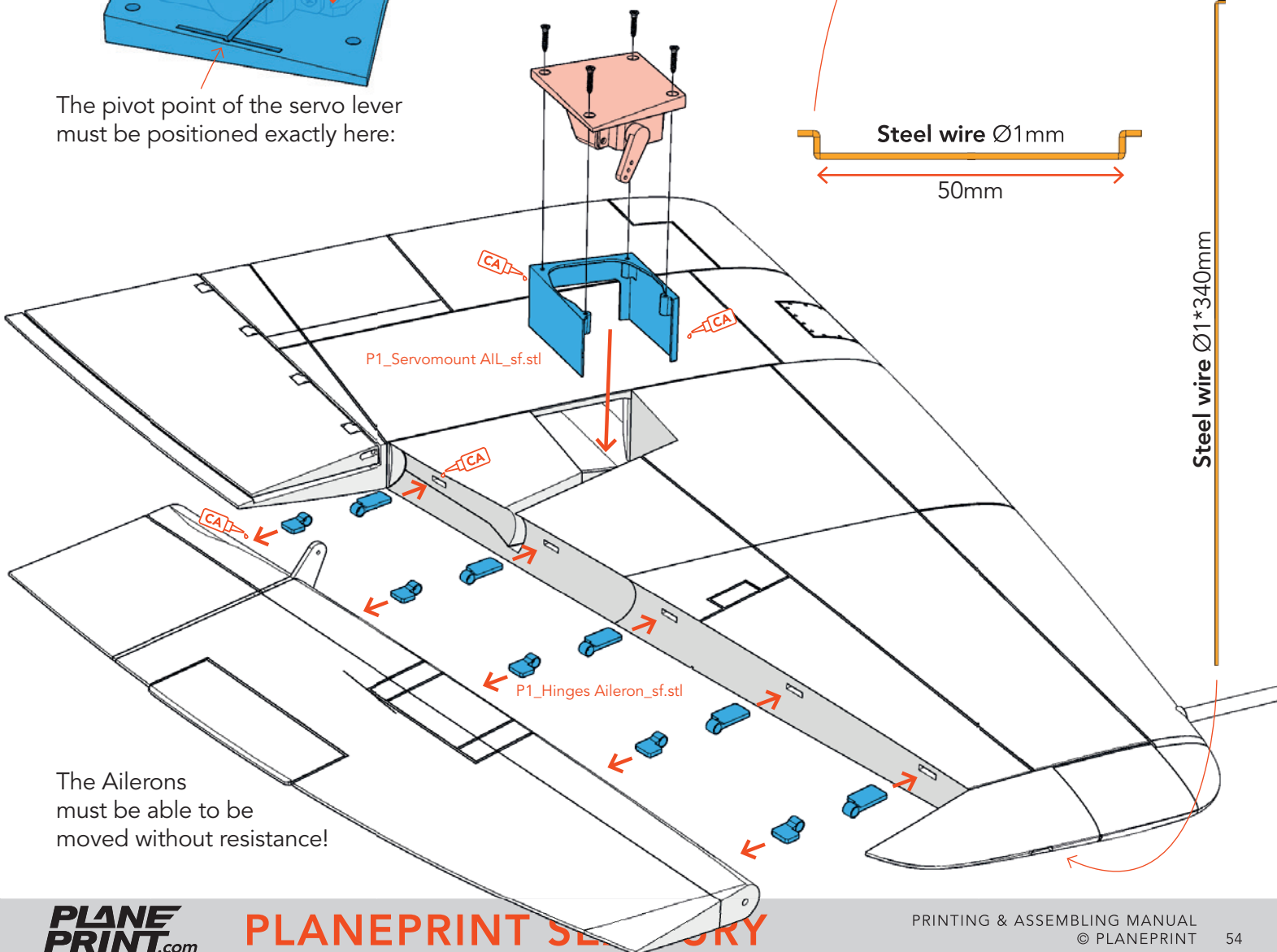


The pivot point of the servo lever must be positioned exactly here:

Adjust the servo electronically to center, then mount the lever at 90° to the linkage wire.

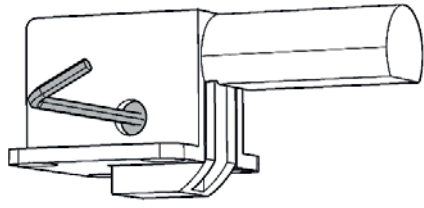


Steel wire Ø1\*340mm

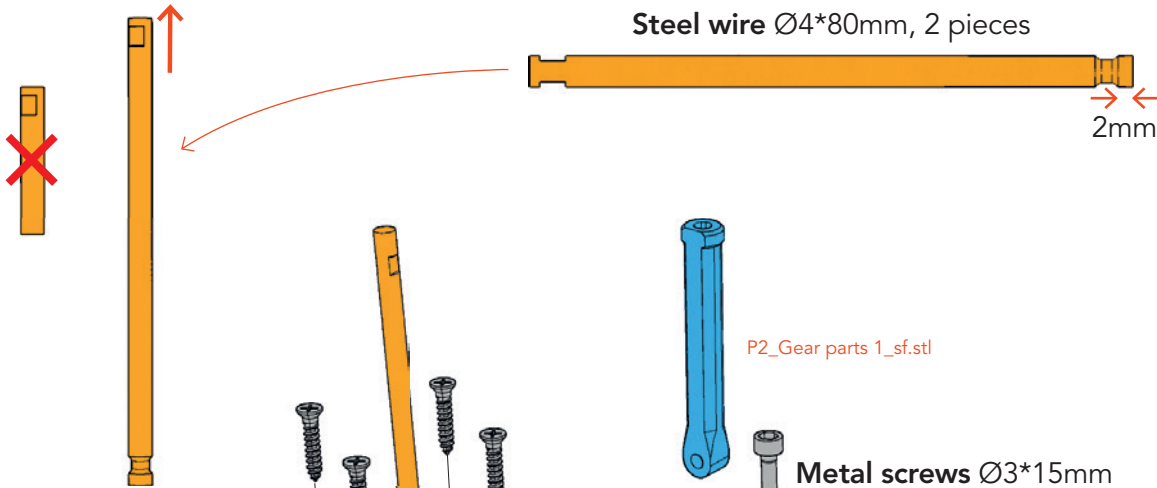


The Ailerons must be able to be moved without resistance!

# Sprung retractable landing gear



Remove the short steel pins from the retracts and prepare an 80 mm long one. File the same notches at the top as in the original and a circumferential notch at the bottom so that a 2 mm wide bar remains.



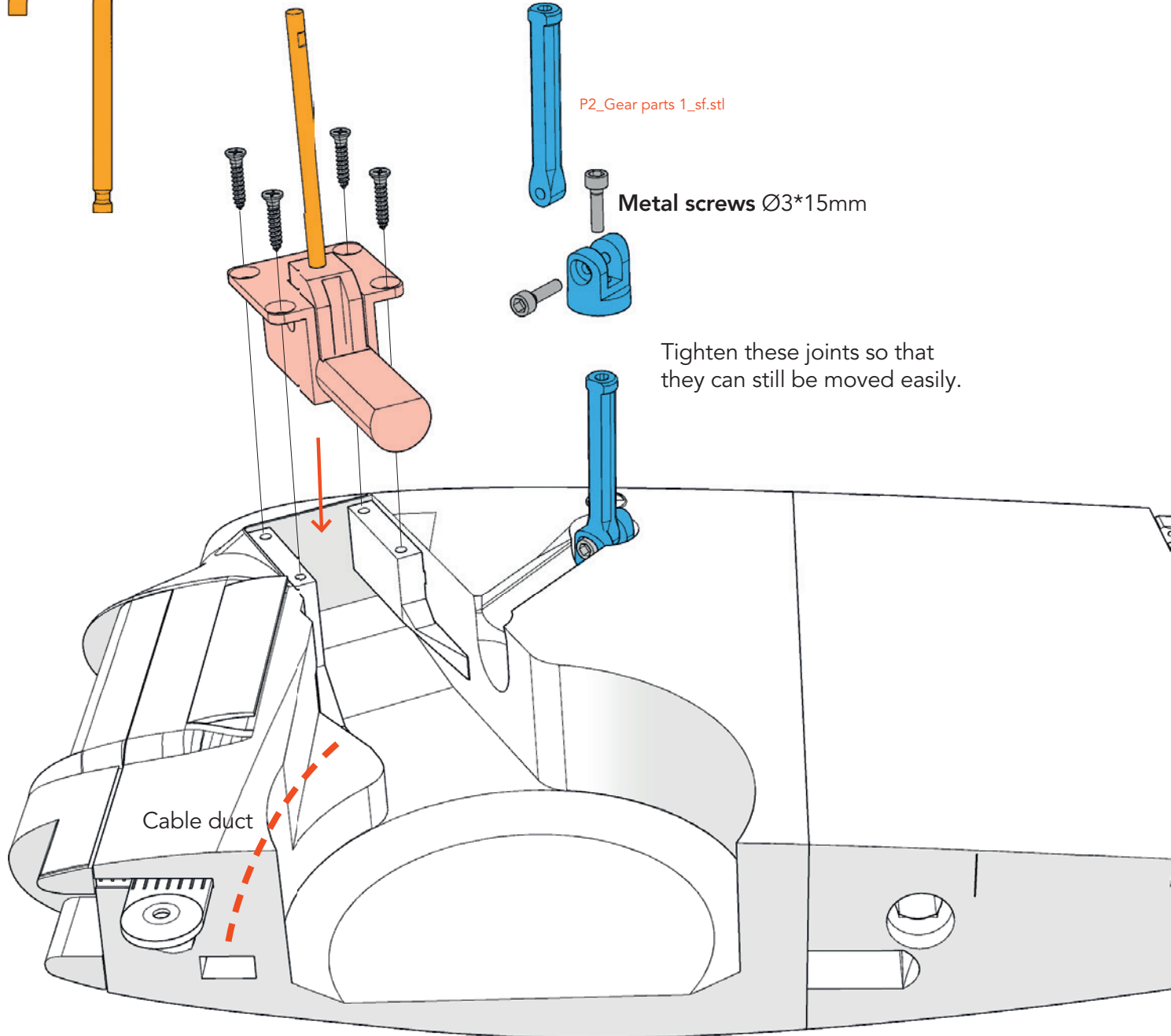
Steel wire Ø4\*80mm, 2 pieces

2mm

P2\_Gear parts 1\_sf.stl

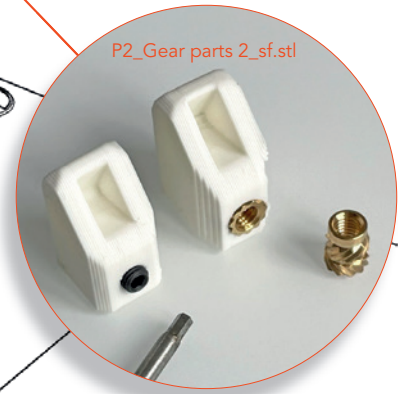
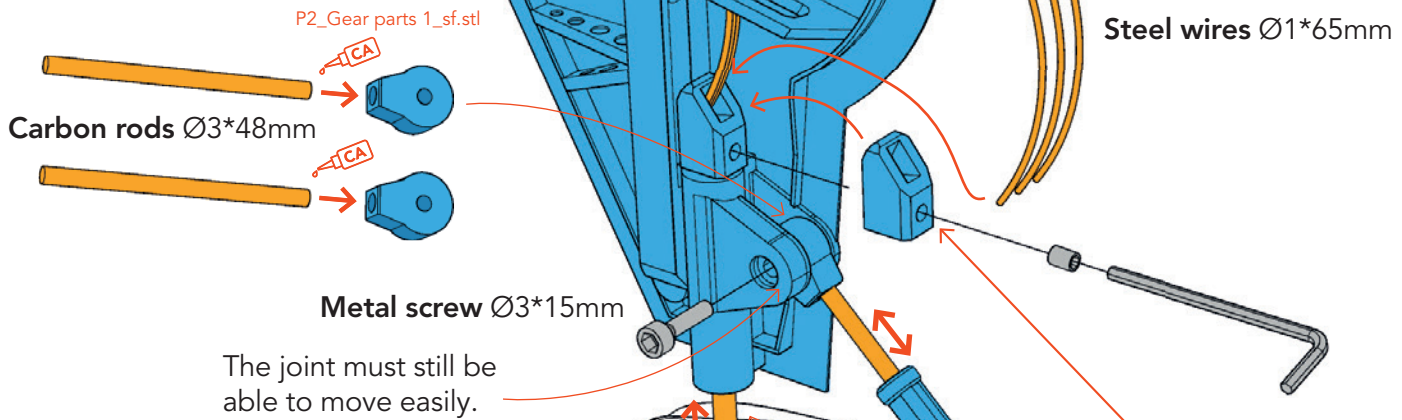
Metal screws Ø3\*15mm

Tighten these joints so that they can still be moved easily.



Cable duct

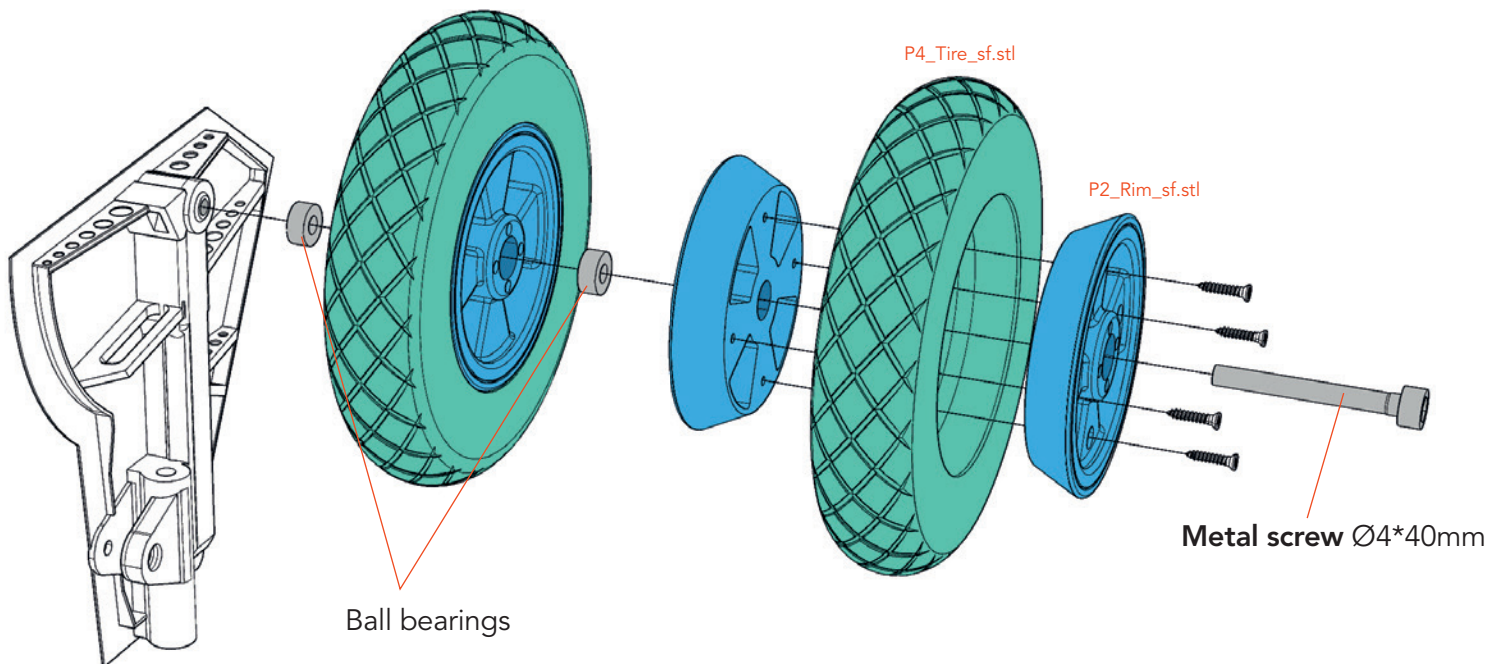
Check that the gear extends and retracts correctly.



The carbon rod must run smoothly!

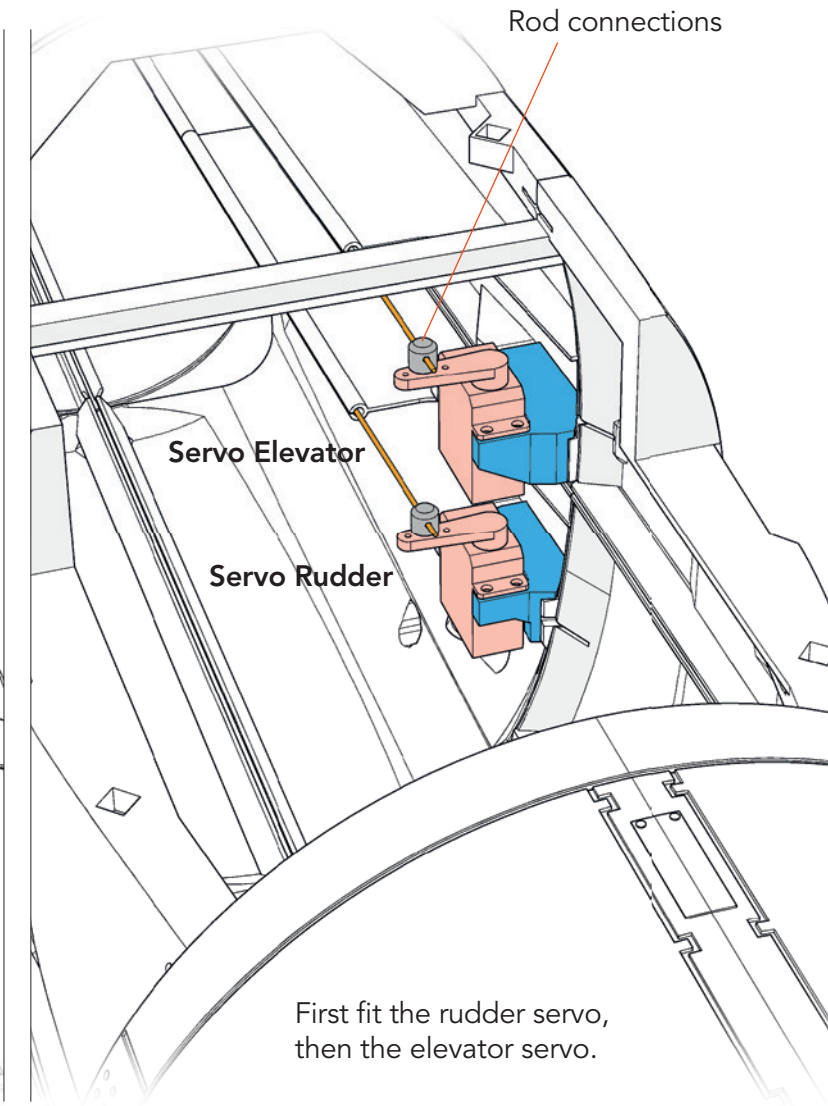
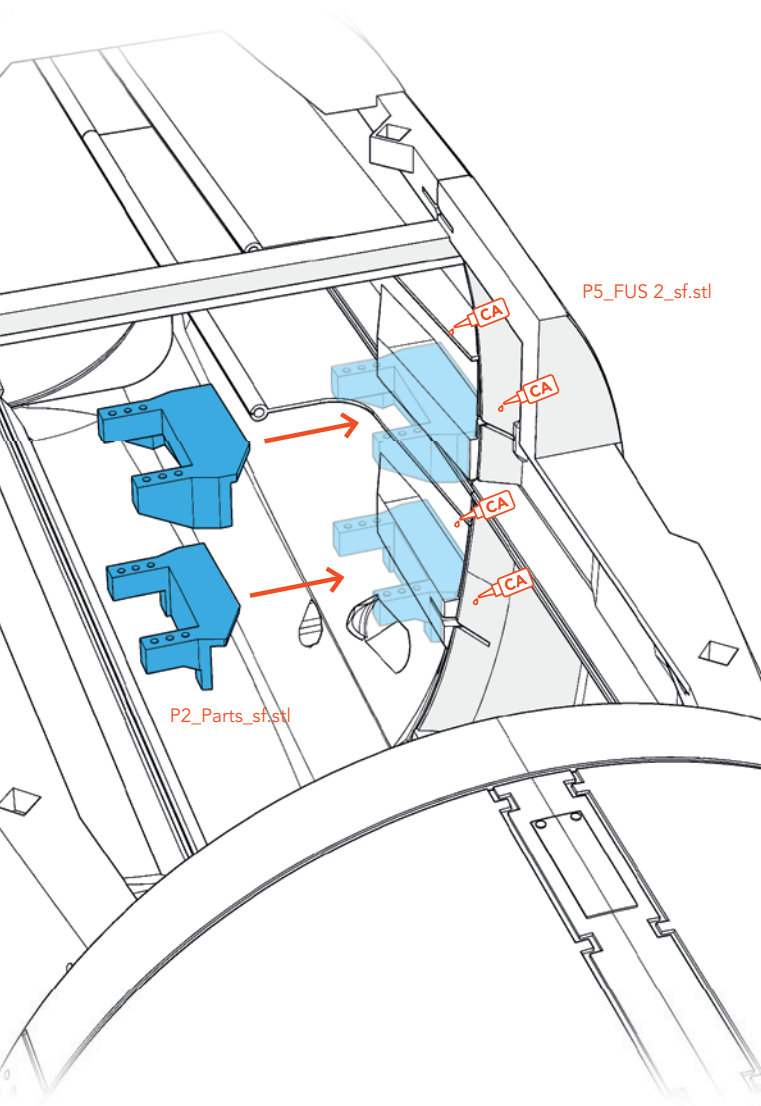
There are two versions with different drillings. The better version is if you use a threaded insert M3.

Apply some grease/oil to the axle so that the suspension works better.



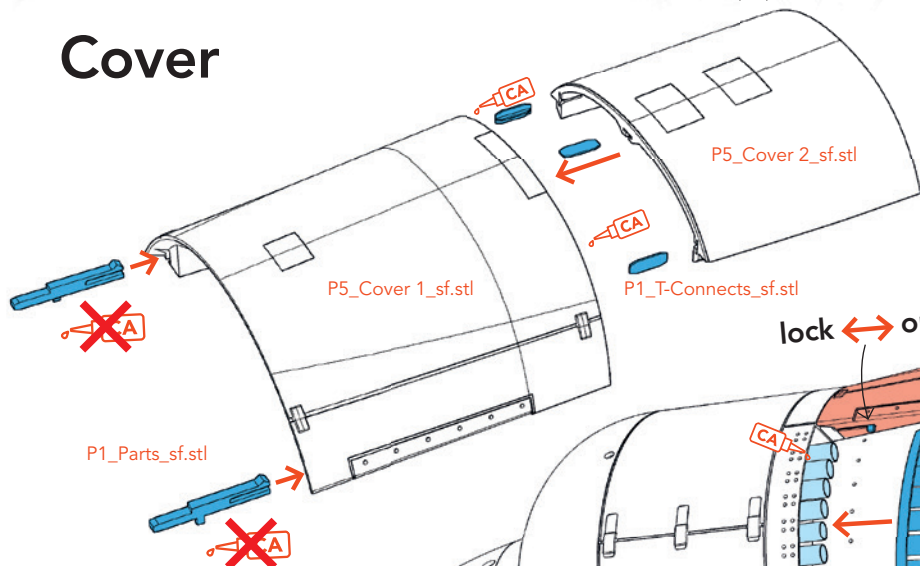


# Servo Elevator and Rudder

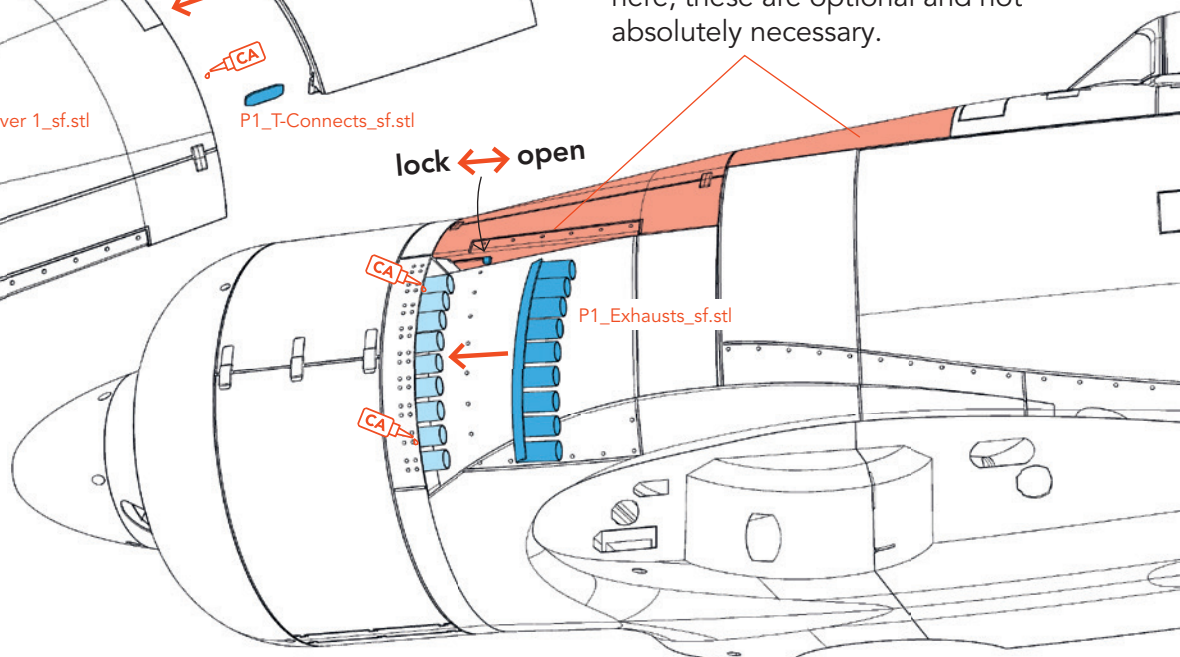


First fit the rudder servo, then the elevator servo.

## Cover



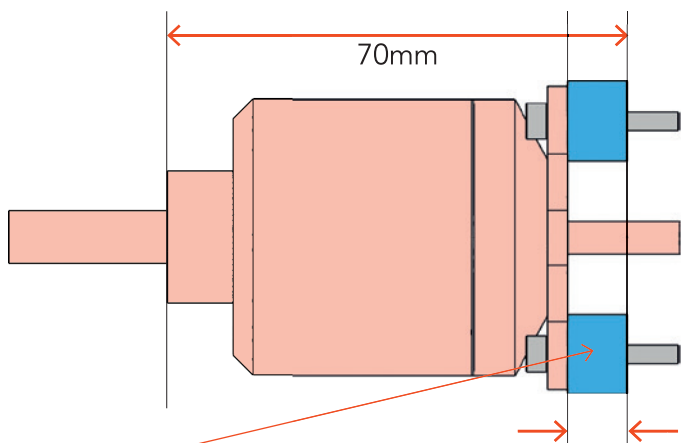
**INFO** Recesses for four magnets (5x5x5mm) are also provided here; these are optional and not absolutely necessary.



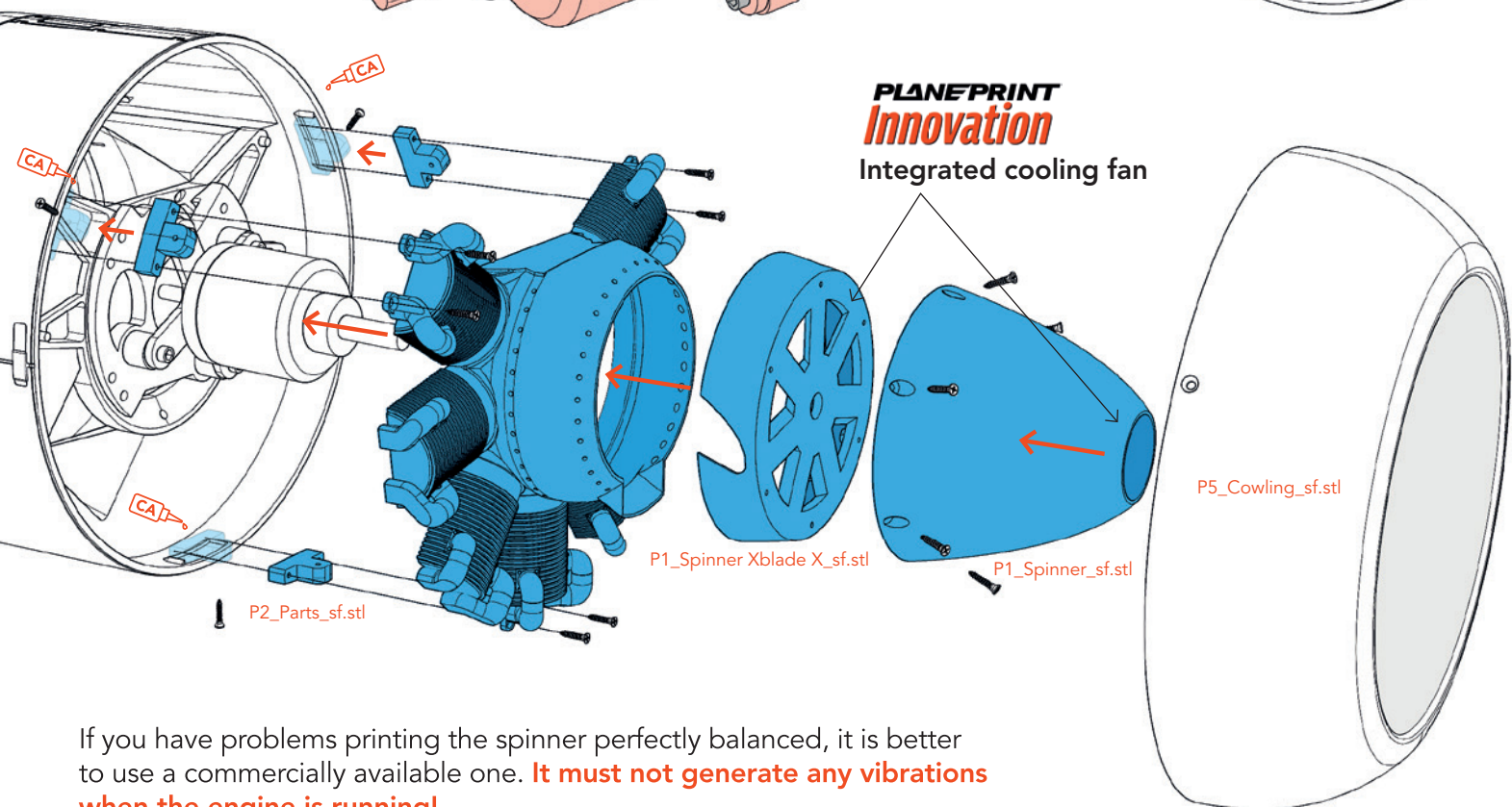
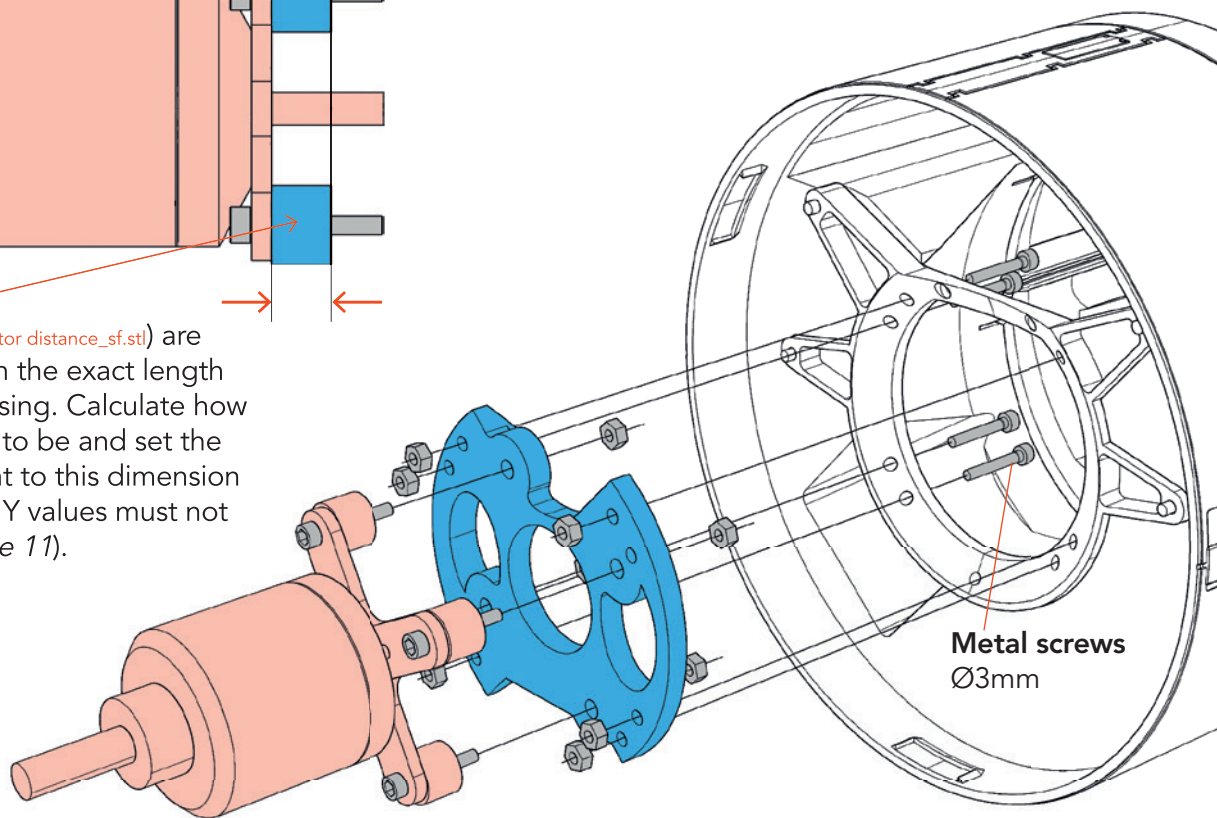
# Motor mount

**SAFETY FIRST** Ensure that the prop does not generate any vibrations. Make sure that the motor does not get very hot (smaller prop, flying style). **Check regularly that the motor mountings are tight!**

The motor must have a length of exactly 70 mm from the motor plate to the prop support:



The four spacers (P1\_Motor distance\_sf.stl) are required depending on the exact length of the motor you are using. Calculate how high the spacers need to be and set the corresponding Z-height to this dimension in the slicer (the X and Y values must not be changed – see page 11).

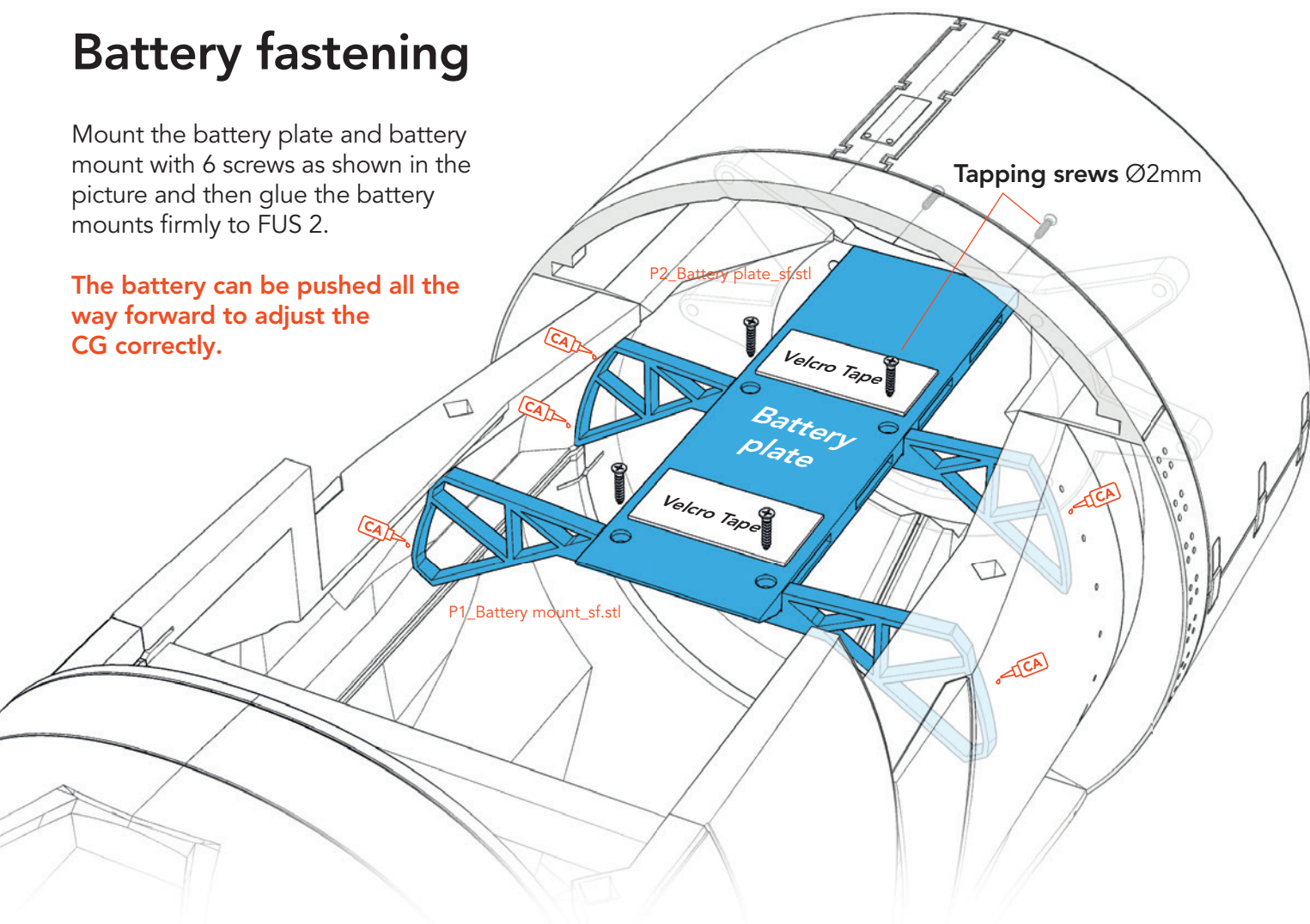


If you have problems printing the spinner perfectly balanced, it is better to use a commercially available one. **It must not generate any vibrations when the engine is running!**

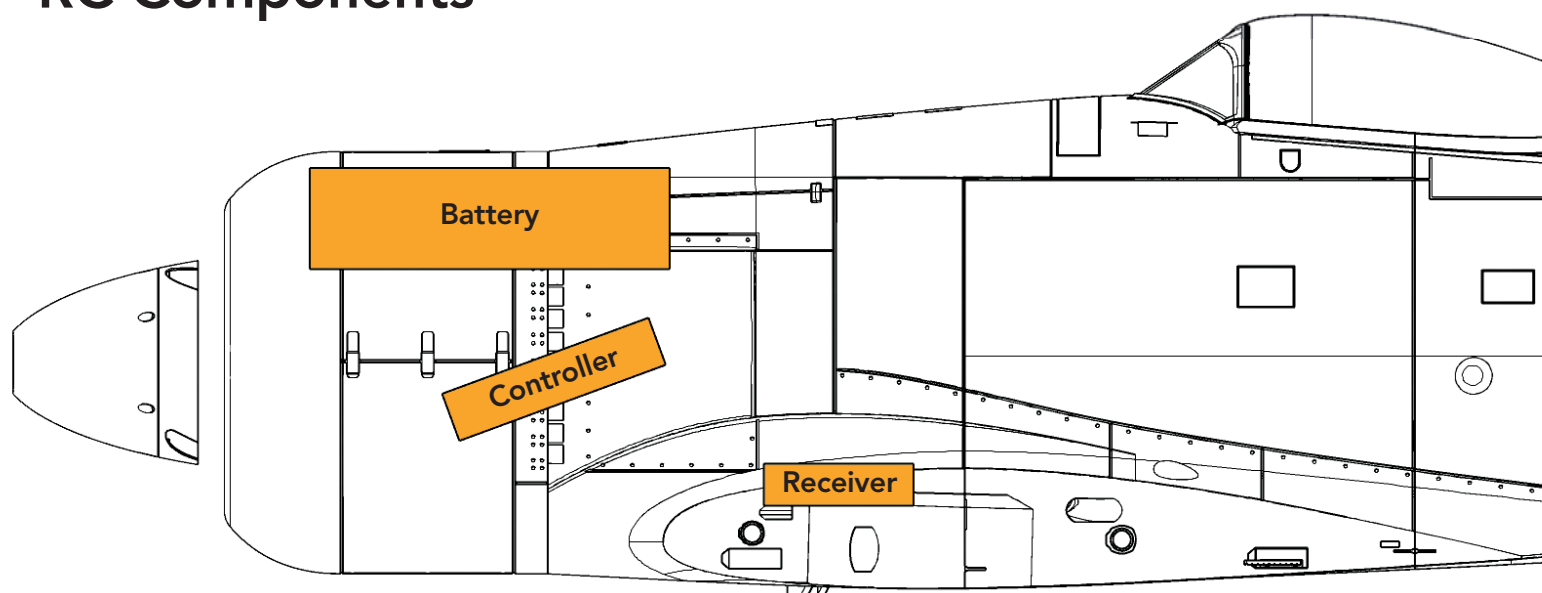
# Battery fastening

Mount the battery plate and battery mount with 6 screws as shown in the picture and then glue the battery mounts firmly to FUS 2.

The battery can be pushed all the way forward to adjust the CG correctly.



# RC Components



Attach the receiver to the floor with self-adhesive Velcro tape. The controller is attached with cable ties to the battery mounts or can sit right at the front under the motor.

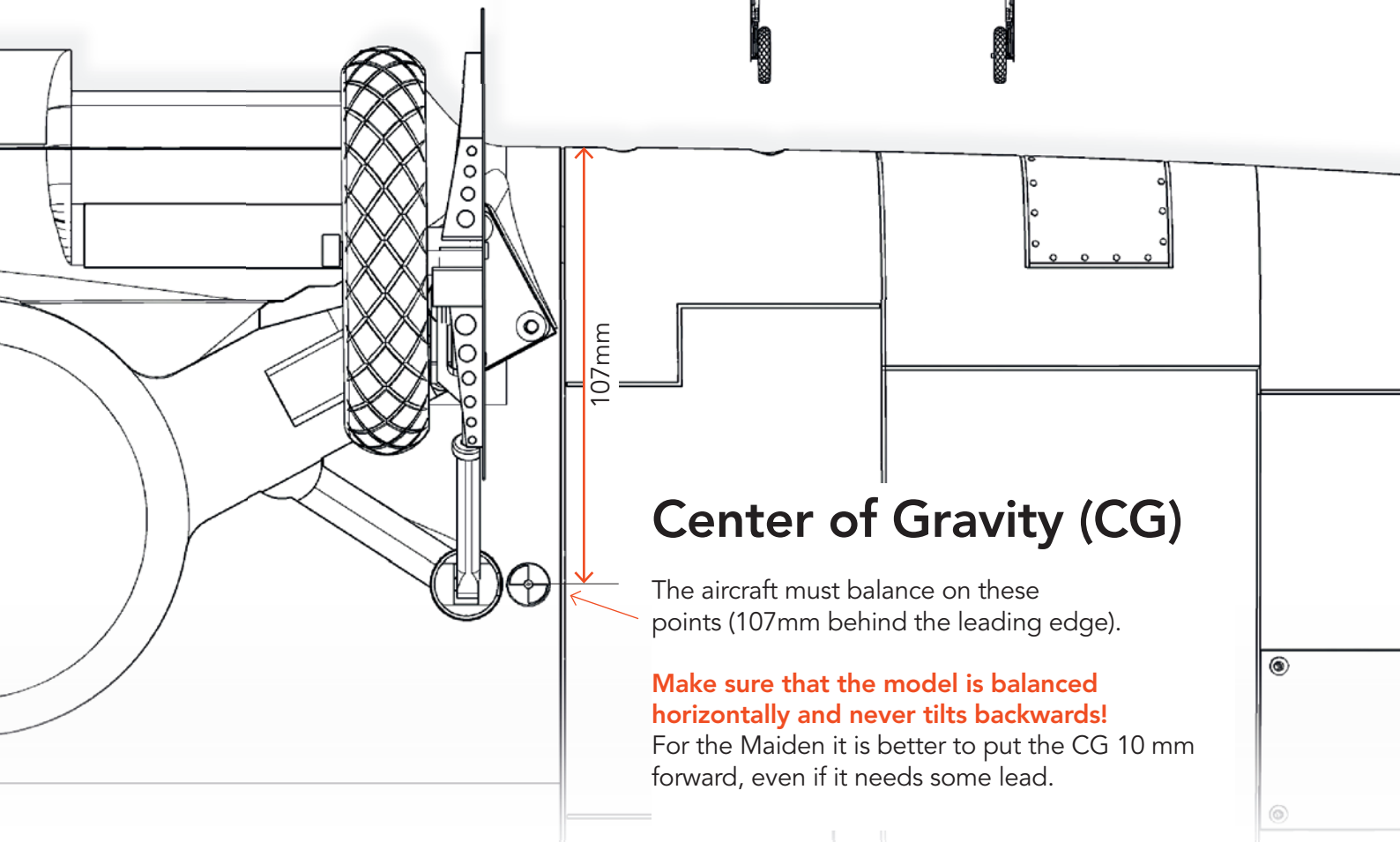
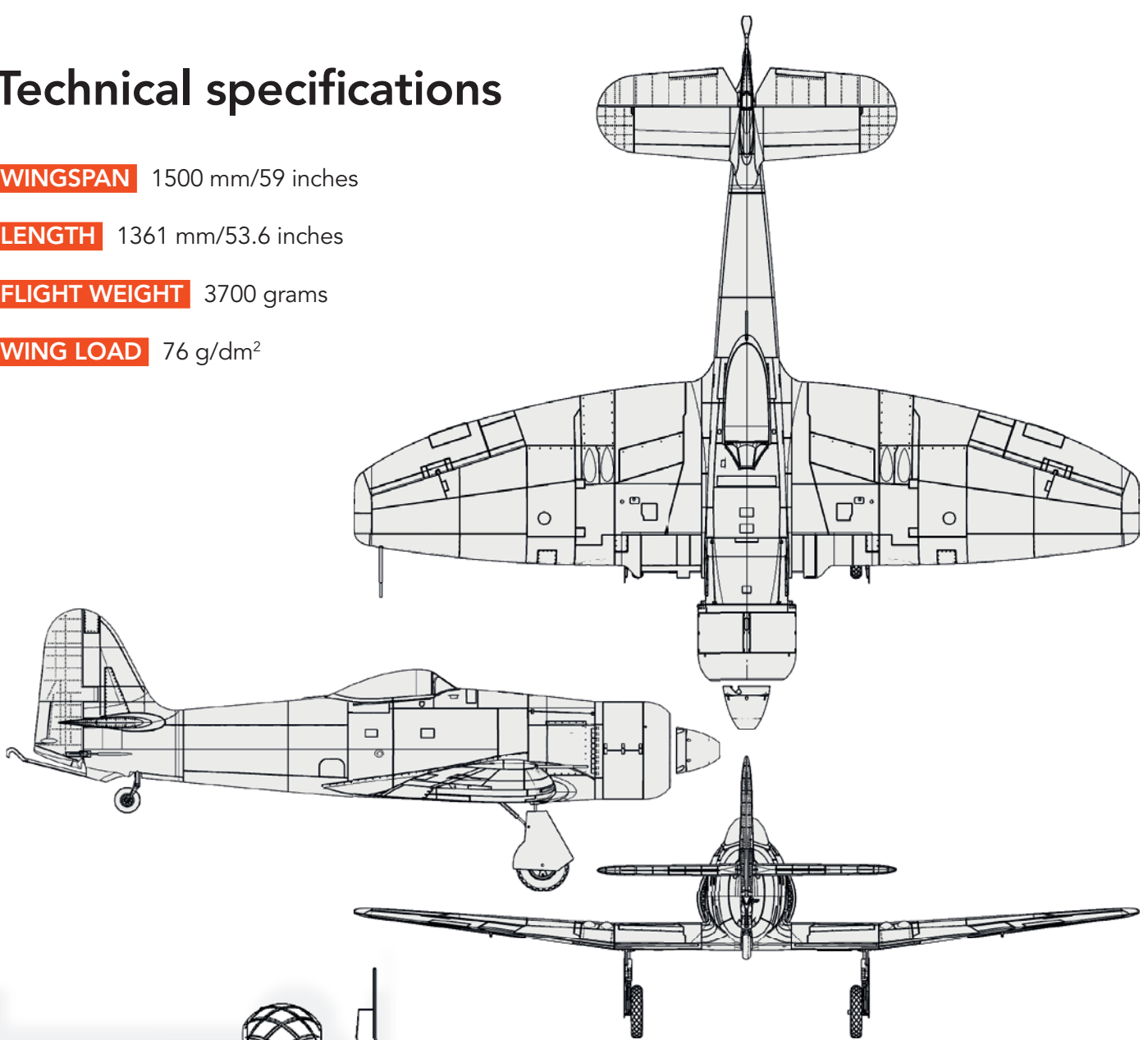
# Technical specifications

**WINGSPAN** 1500 mm/59 inches

**LENGTH** 1361 mm/53.6 inches

**FLIGHT WEIGHT** 3700 grams

**WING LOAD** 76 g/dm<sup>2</sup>



## Center of Gravity (CG)

The aircraft must balance on these points (107mm behind the leading edge).

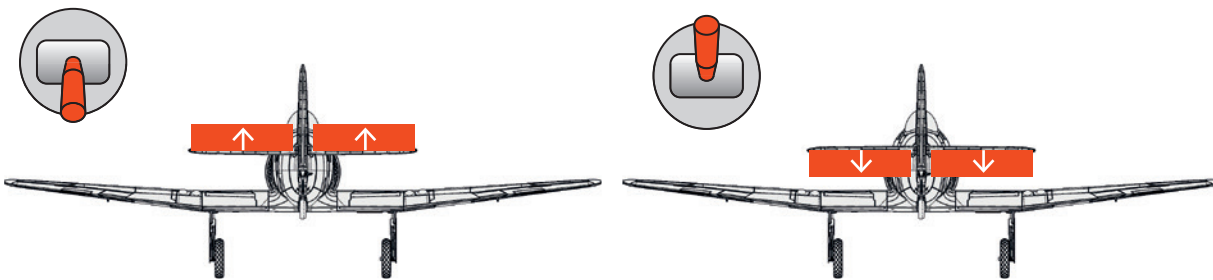
**Make sure that the model is balanced horizontally and never tilts backwards!**

For the Maiden it is better to put the CG 10 mm forward, even if it needs some lead.

# Control Direction Test Look at the aircraft from behind

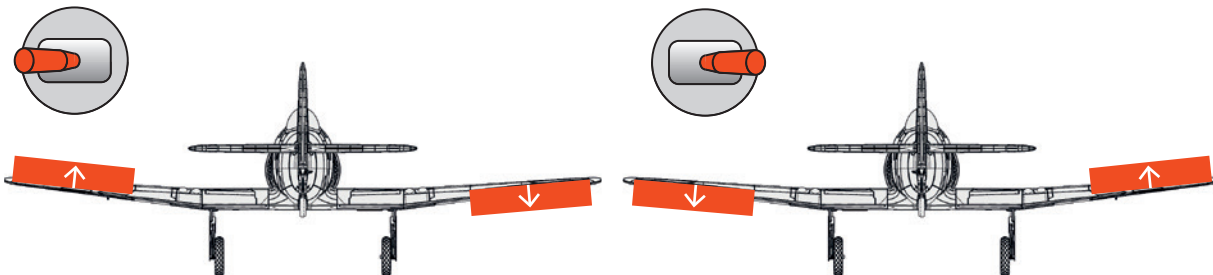
## ELEVATOR

22 mm up  
22 mm down



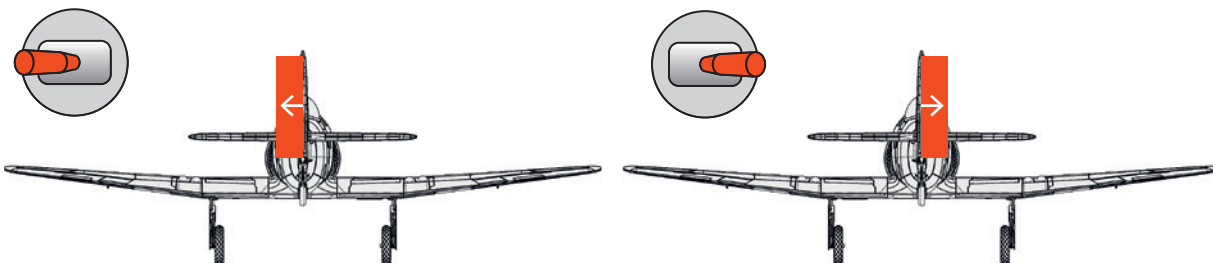
## AILERON

27 mm up  
23 mm down



## RUDDER

38 mm left  
38 mm right



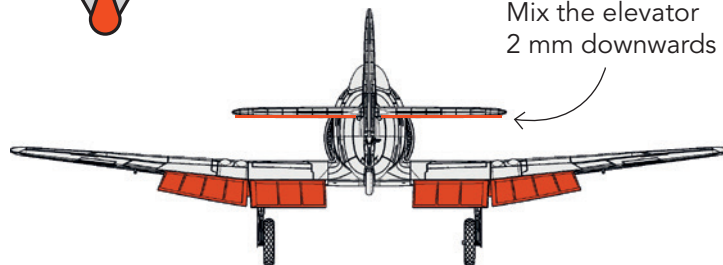
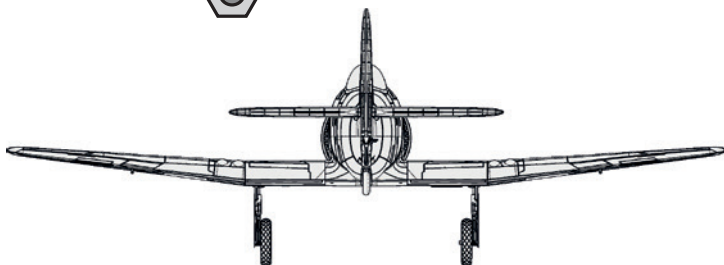
## FLAPS



Zero (Start, normal flight)



Slow flight, Landing



30 mm down

**NOTE** The flaps have a strong braking effect! We recommend using them rather carefully at first (maximum 30 mm down). They are not needed for take-off and you can land the Sea Fury without flaps.

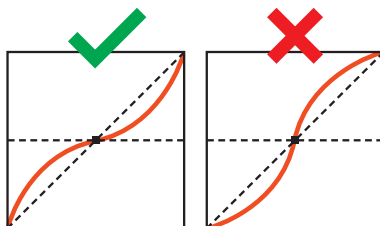
The flaps must be aligned exactly the same in every position, otherwise the aircraft will not fly straight!

## EXPO

**ELEVATOR** 40 %

**AILERON** 40 %

**RUDDER** 40 %



(for some remote controls a minus has to be in front of the number)

# AGE RECOMMENDATION 14+

## NOT FOR CHILDREN UNDER 14 YEARS. THIS IS NOT A TOY!

The STL data (or data processed from it, such as G codes) must never be passed on to third parties!

The purchase of the STL does not authorize the production of models for third parties.

By using the download data, an RC model airplane, called „model“ for short, can be manufactured using a 3D printer. As a user of this model, only you are responsible for safe operation that does not endanger you or others, or that does not damage the model or property of others.

PLANEPRINT.com assumes no responsibility for damage to persons and property caused by pressure, transport or use of the product. Filaments, printing supplies, hardware or consumables that can not be used after faulty 3D printing will not be replaced by PLANEPRINT.com in any way.

When operating, always keep a safe distance from your model in all directions to avoid collisions and injuries.

This model is controlled by a radio signal. Radio signals can be disturbed from outside without being able to influence it. Interference can lead to a temporary loss of control.

Always operate your model on open terrains, far from cars, traffic and people.

Always follow the instructions and warnings for this product and any optional accessories (servos, receivers, motors, propellers, chargers, rechargeable batteries, etc.) carefully.

Keep all chemicals, small parts and electrical components out of the reach of children.

Avoid water contact with all components that are not specially designed and protected. Moisture damages the electronics.

Never take an item of the model or accessory in your mouth as this can lead to severe injuries or even death.

Never operate your model with low batteries in the transmitter or model.

Always keep the model in view and under control.  
Use only fully charged batteries.

Always keep the transmitter switched on when the model is switched on.

Always remove the battery before disassembling the model.

Keep moving parts clean and dry at all times.

Always allow the parts to cool before touching them.

Always remove the battery after use.

Make sure that the Failsafe is properly set before the flight.

Never operate the model with damaged wiring.

Never touch moving parts.

We develop our models to the best of our knowledge and belief.  
We accept no liability for consequential damage and injuries caused by improper use or incorrectly printed parts. **Please be careful when handling motors, batteries and propellers** and only move your model with insurance and in approved places!

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