

# PLANE PRINT



## PLANE PRINT *LEARJET 35*

Twin-engine RC business jet



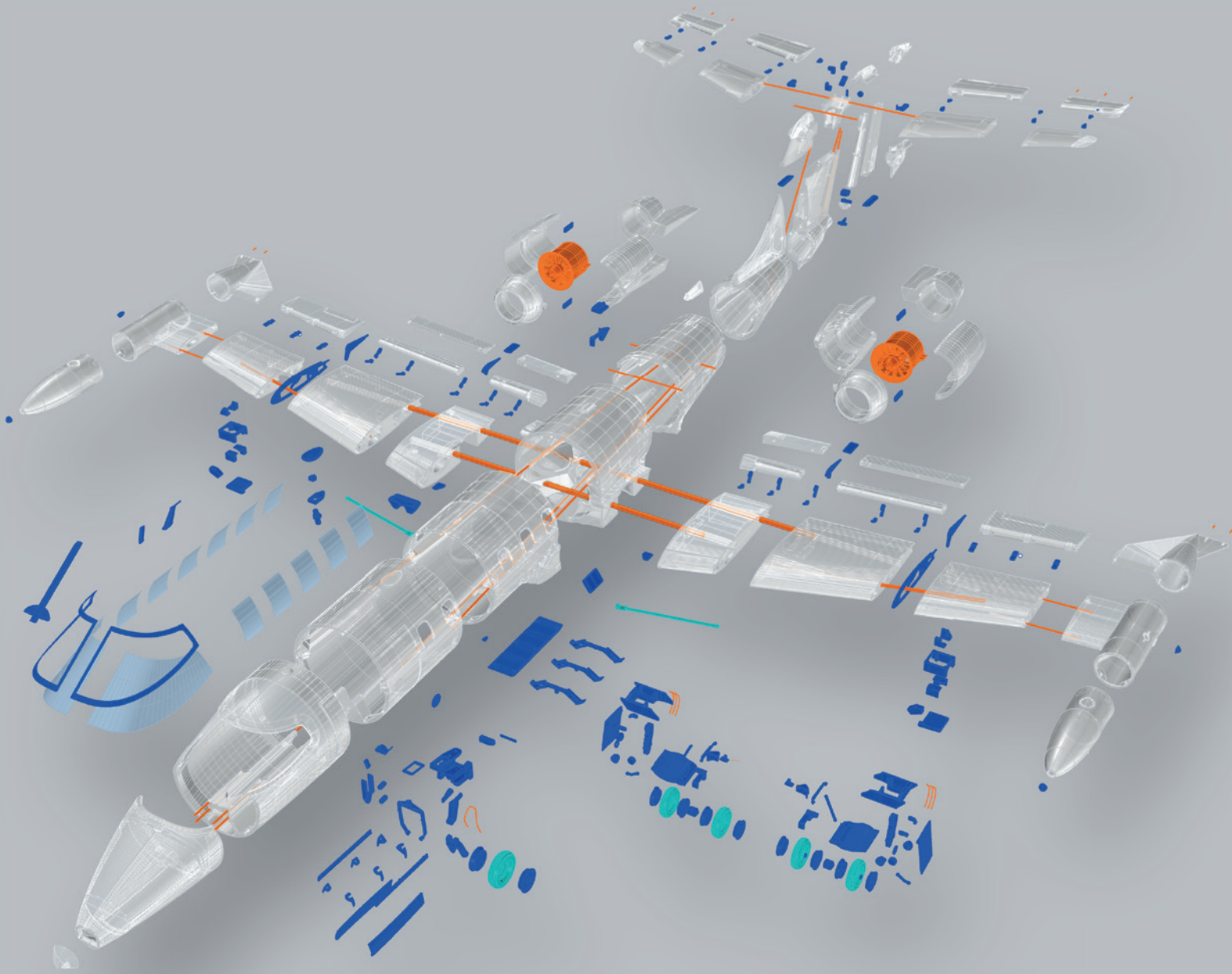
**NOTE:**  
Slicing works best  
with CURA!



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

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

# PLANE PRINT *LEARJET 35*



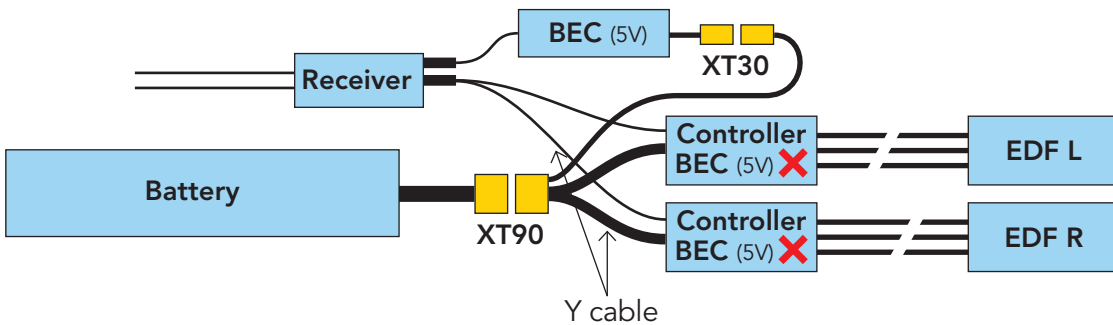
 LW-PLA  PLA  TPU  OTHER

# RC Components

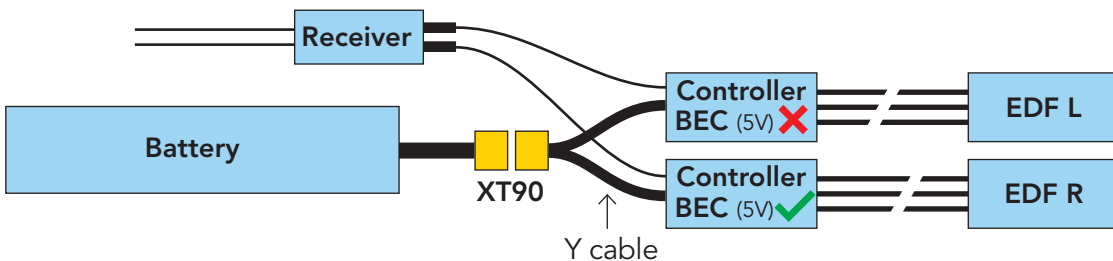
**ENGINE** 2 pieces EDF 70 MM 3060-KV1900 (FMS) or equivalent

**CONTROLLERS** 80A ESC X 2 with 8A BEC EC5 For 70mm A-10 V2 (FMS) or equivalent

**OPTION 1:** you can either use two controllers **without BEC** and an **external supply for the servos**.



**OPTION 2:** **two BEC controllers** and **deactivate** the BEC on **one** of them (Pull the red + cable out of the plug)

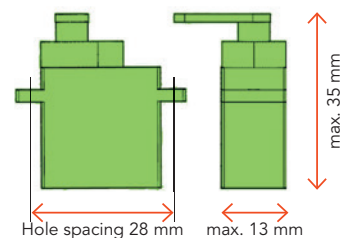


**RECEIVER** 12 Channel (or at least 10 channels if you do without the gear doors)

**BATTERY** 6S LiPo-Battery, 5000 - 6000 mAh (Ideal weight 690g)

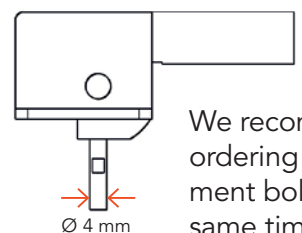
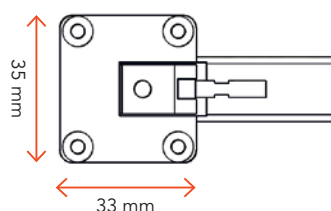
**SERVOS** 5 pieces Quality servos (plus one if you want to control the elevator with two servos) like KST A12-610 V8.0 SG digital or equivalent (for important functions such as ALL, Flaps, ELE) **Metal gears should be preferred for the important functions such as elevator, ailerons, flaps!** We advise against very cheap servos, safety first!

3 pieces like Corona 929MG, Hitec HS55, Savöx SH-0254 or equivalent



**SERVO CABLE EXTENSIONS**  
 800 mm 1 piece – Elevator  
 500 mm 2 pieces – Nose gear steering/door  
 300 mm 4 pieces – Aileron and Flaps Fuselage  
 200 mm 2 pieces – Aileron Wings  
 Distribution cable one to three 1 piece – Retract

**SERVOLESS RETRACTS** Two normal and one steerable Nose Wheel  
 (we used: 40g Landing Gear, AliExpress – for 3.500g Models)



We recommend ordering replacement bolts at the same time.

# Required accessoires – basic equipment

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

- LW-PLA foaming! (**cannot be replaced by PLA!**), ~1600 grams
- Tough PLA, ~300 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 with countersunk head Ø4\*50mm, 2 pieces
- Metal screw with countersunk head Ø4\*30mm, 1 piece
- Carbon tube Ø10mm\*1000mm (inside 8mm), 2 pieces  
Cut the tubes to the following lengths (mm):  
1 tube = 900  
1 tube = 560
- Carbon tube Ø6mm\*1000mm (inside 4mm), 2 pieces  
Cut the tubes to the following lengths (mm):  
1 tube = 2x377  
1 tube = 2x500
- Carbon rod Ø3\*1000mm, 7 pieces  
Cut 4 of the rods to the following lengths (mm):  
2x100, 2x260, 185, 326, 126, 197, 158, 142, 372, 2x150, 2x250
- Steel wire Ø1\*1000mm, 4 pieces (do not use thinner ones!)
- Rod connection (hole for Ø1mm steel wire), 2 pieces
- Rod connection (hole for Ø2mm steel wire), 1 piece
- Ball bearings 4x9x4mm, 10 pieces
- Self-adhesive Velcro tape
- Threaded inserts M3 (optional, see description gear)
- Overhead foils or binding covers of scripts (~0,2mm, office trade) in DIN A4 format. (optional)
- Tinted film for rear car lights (optional)

## Tools

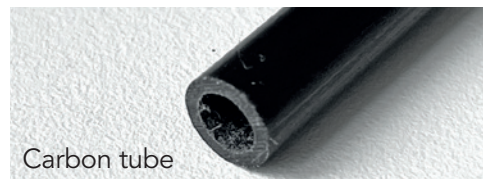
Cutter knife, small Philips screwdriver, Sandpaper grain ~150, Metal saw, Needle nose pliers



Tapping screws Ø2mm



Metal screws Ø3mm



Carbon tube

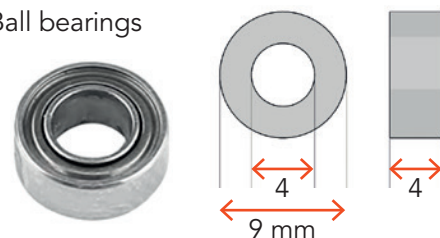


Carbon rod



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:

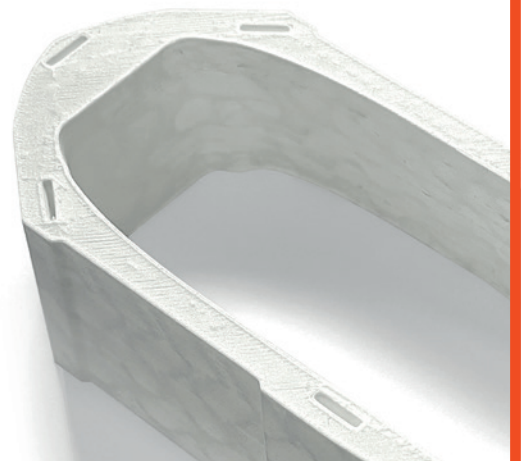


**NOTE** When printing the PLANEPRINT LEARJET you should pay particular attention to a light weight of **each** individual part.

### 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



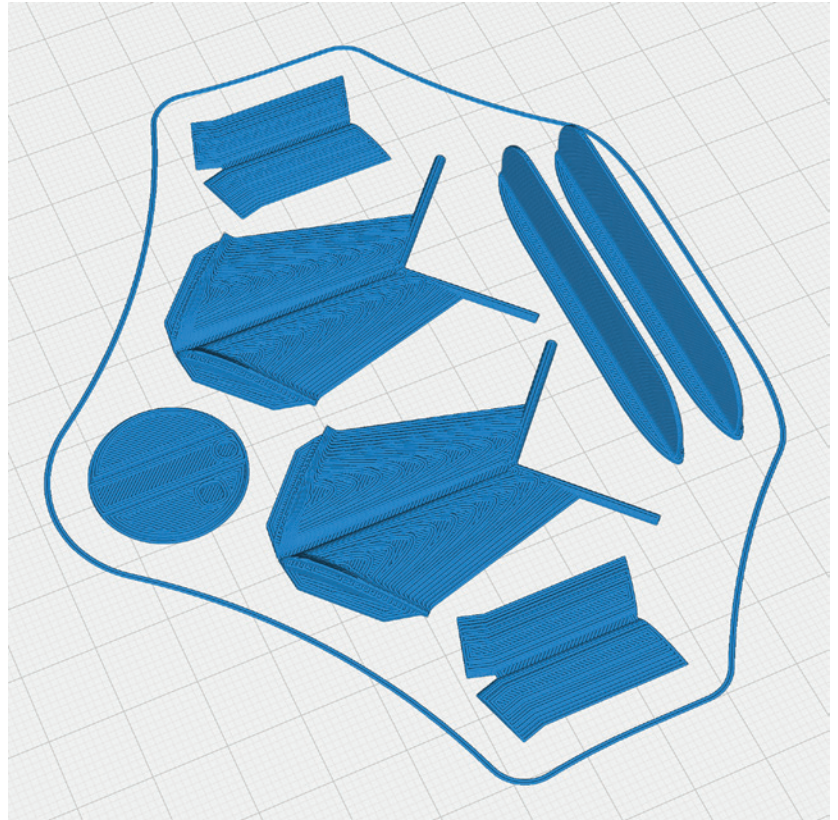
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Antennas\_lj.stl

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

### ADDITIONAL SETTINGS

None required

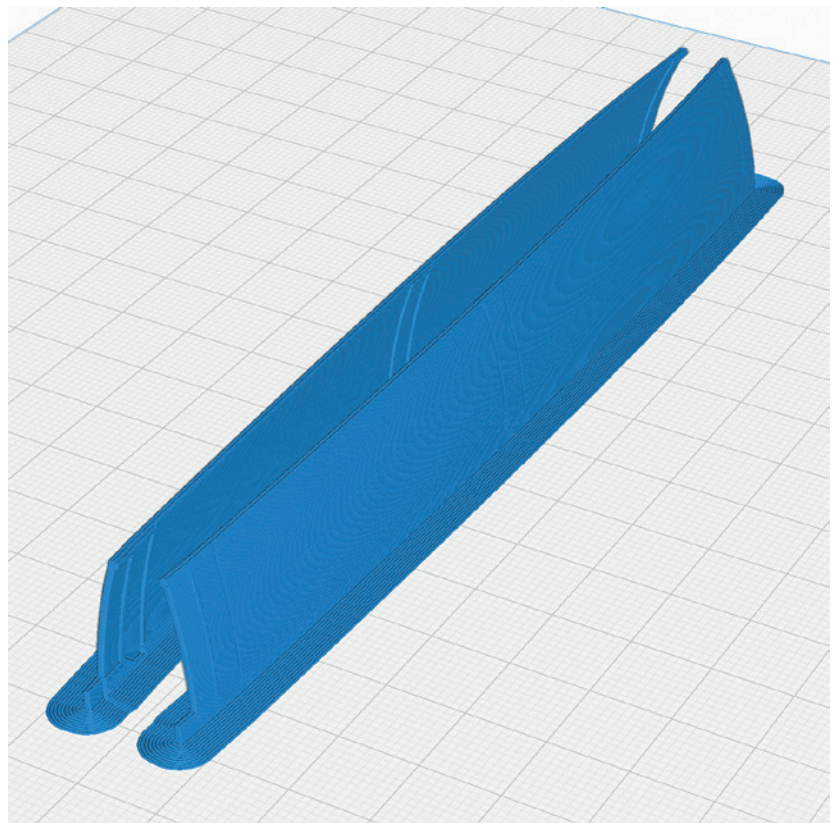


## P1\_Doors front gear\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



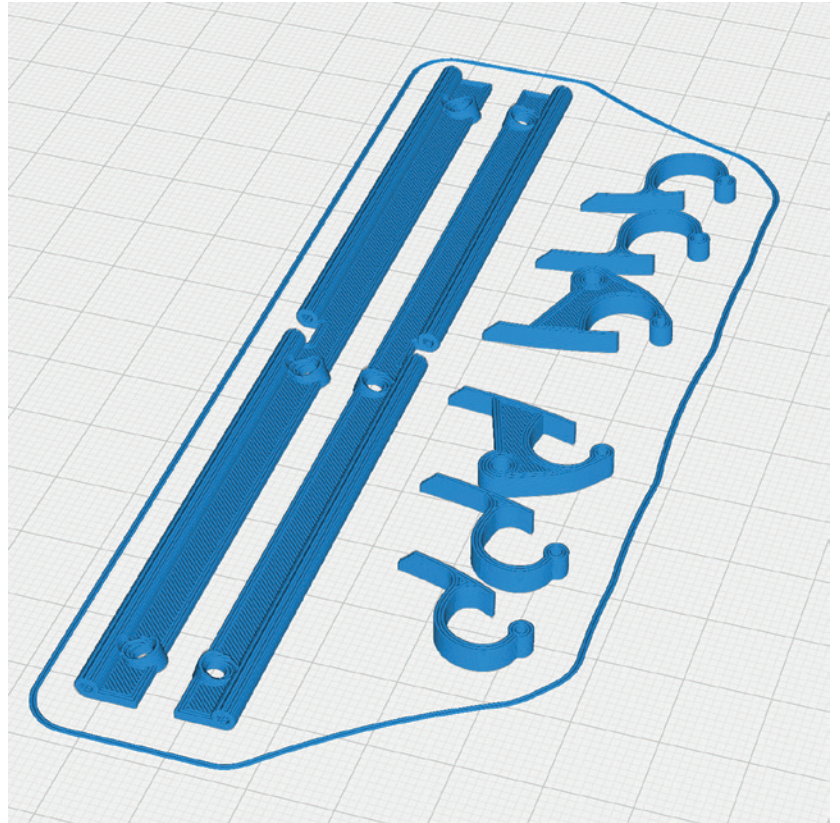
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Doors front mount\_lj.stl

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

### ADDITIONAL SETTINGS

None required

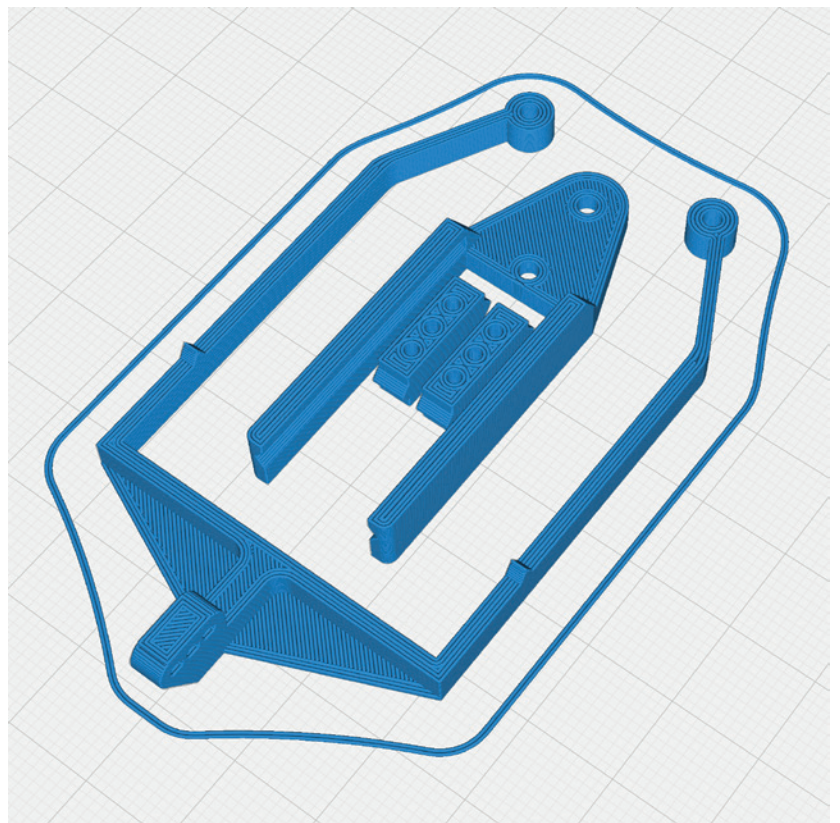


## P1\_Doors front Servo mount\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



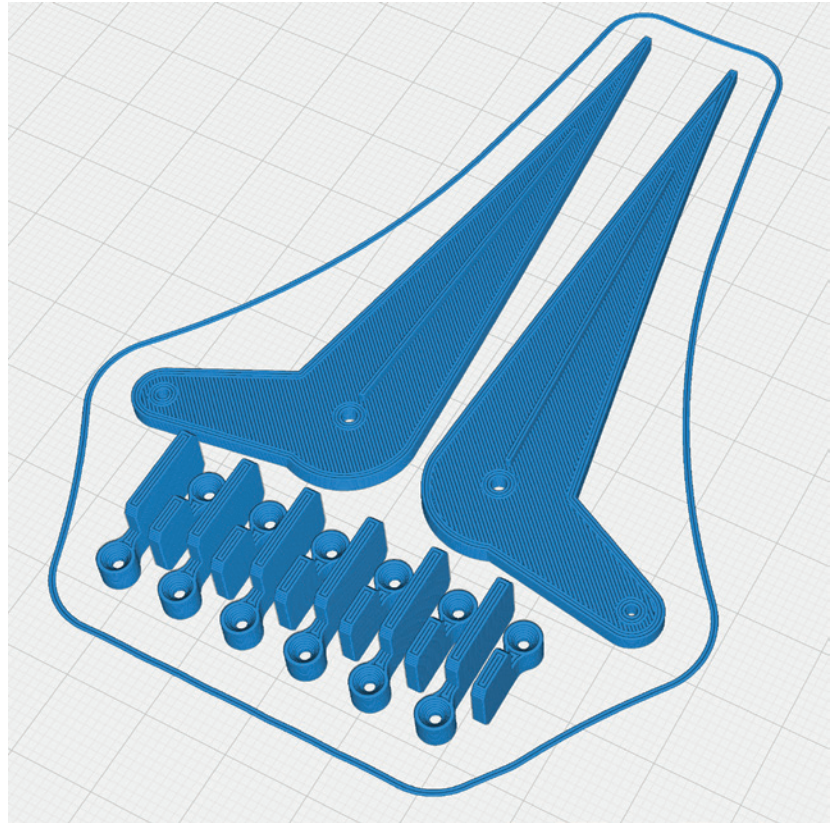
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Hinges AIL\_lj.stl

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

### ADDITIONAL SETTINGS

None required

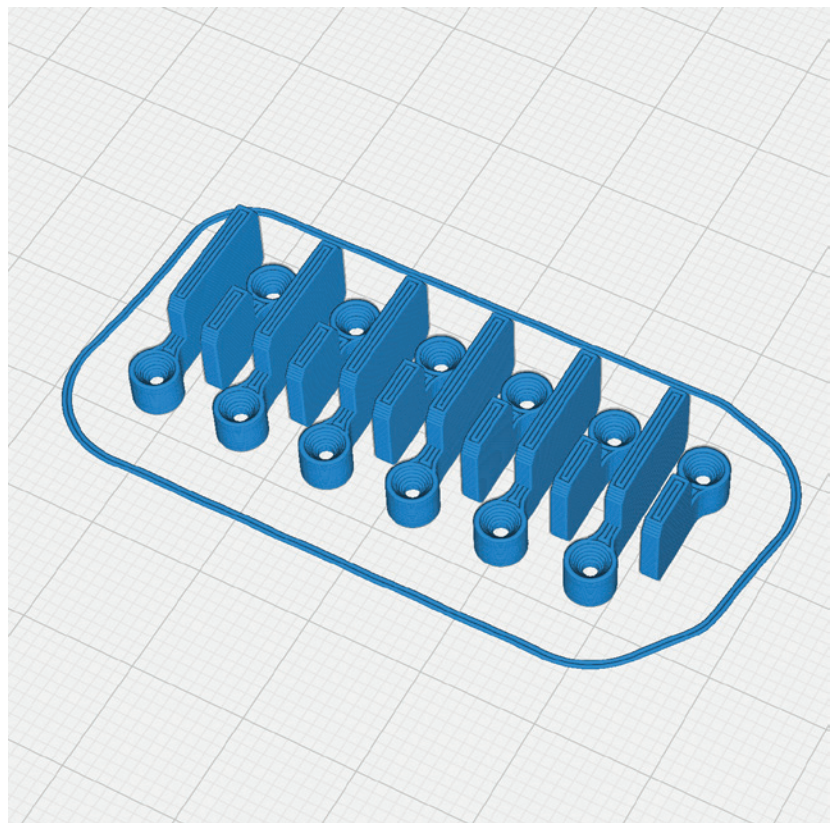


## P1\_Hinges ELE\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



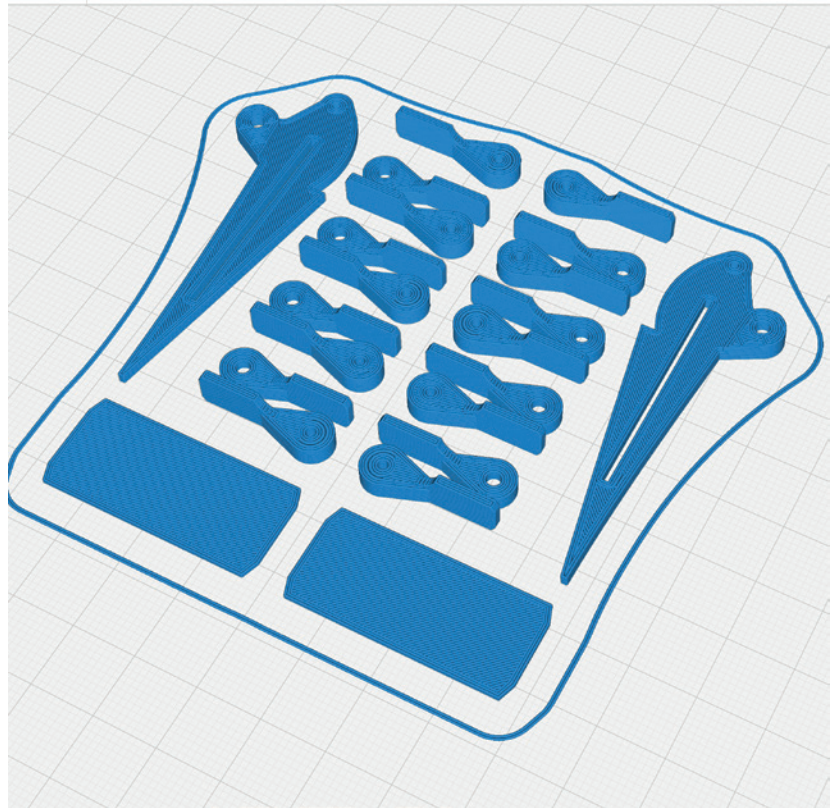
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Hinges Flap\_lj.stl

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

### ADDITIONAL SETTINGS

None required



## P1\_Landing Light glass\_lj.stl

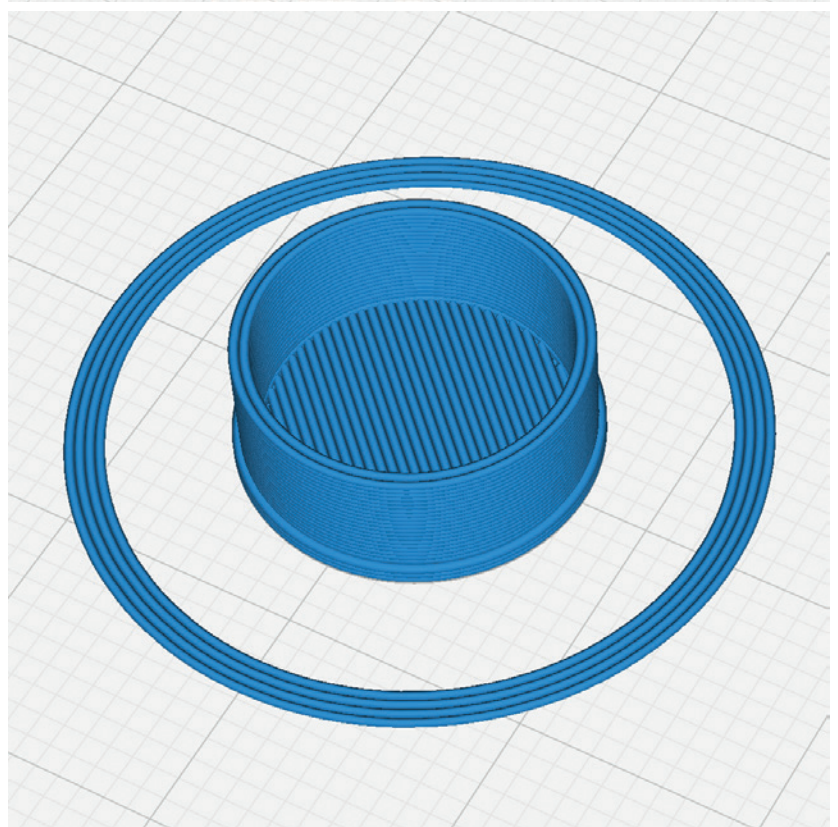
**MATERIAL** PLA, Weight: ~ 1 g

### ADDITIONAL SETTINGS

None required

**TIP** Use transparent filament

For optimum printing, transparent filaments should always be dried.



# PROFILE P1\_Fullbody Tough PLA or PLA



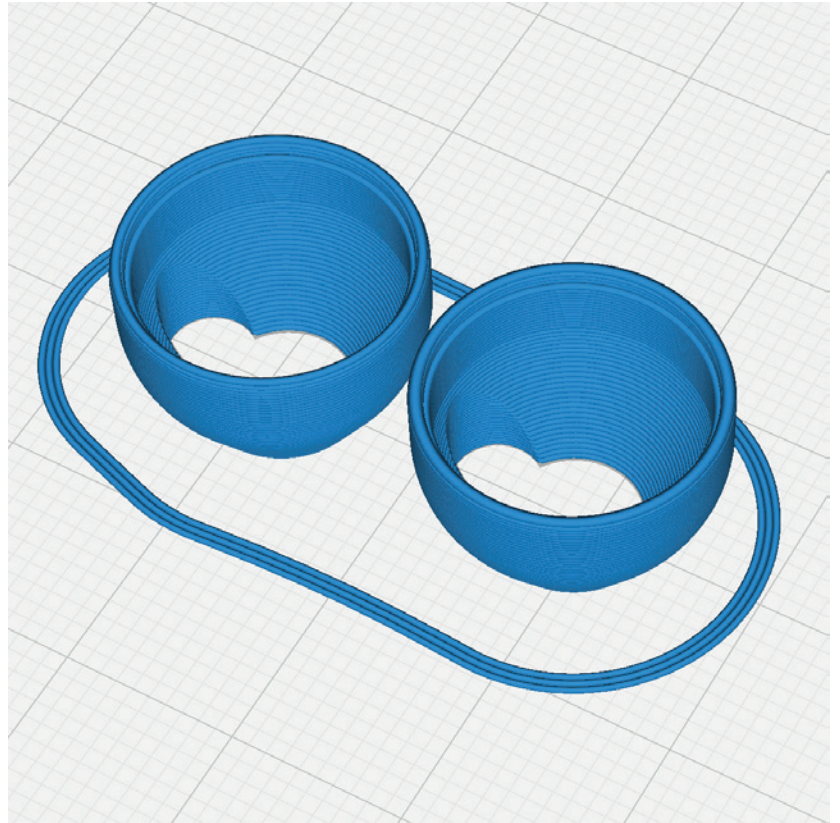
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Landing light\_lj.stl

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

### ADDITIONAL SETTINGS

None required



## P1\_Light\_lj.stl

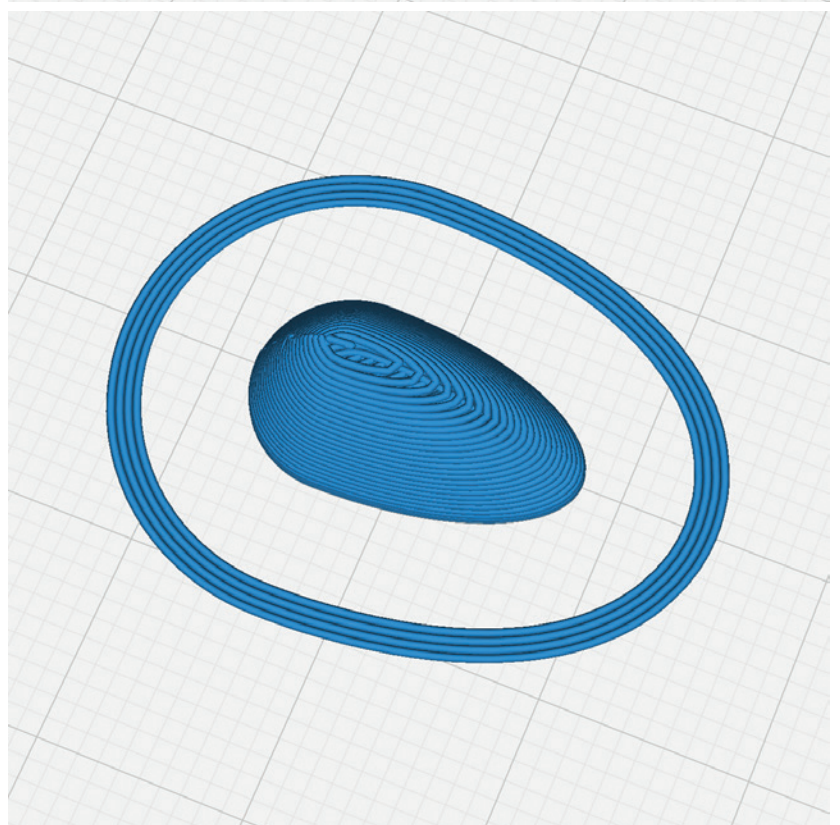
**MATERIAL** PLA, Weight: ~ 1 g

### ADDITIONAL SETTINGS

- print it four times

**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\_Rear Light\_lj.stl

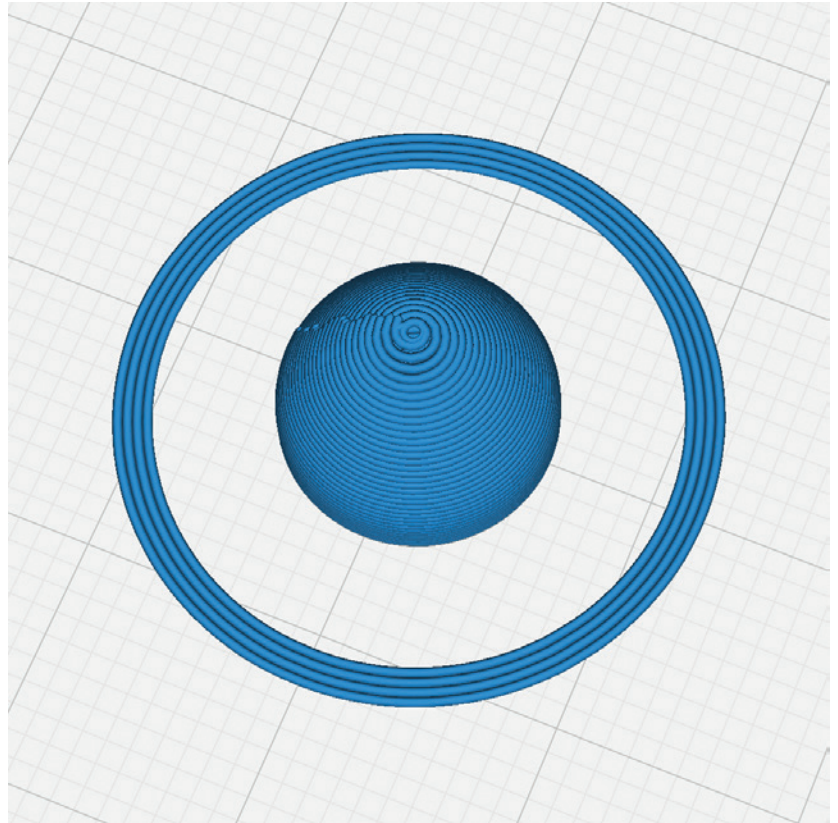
**MATERIAL** PLA, Weight: ~ 1 g

### ADDITIONAL SETTINGS

- Print 3 times

**TIP** Use transparent filament

For optimum printing, transparent filaments should always be dried.

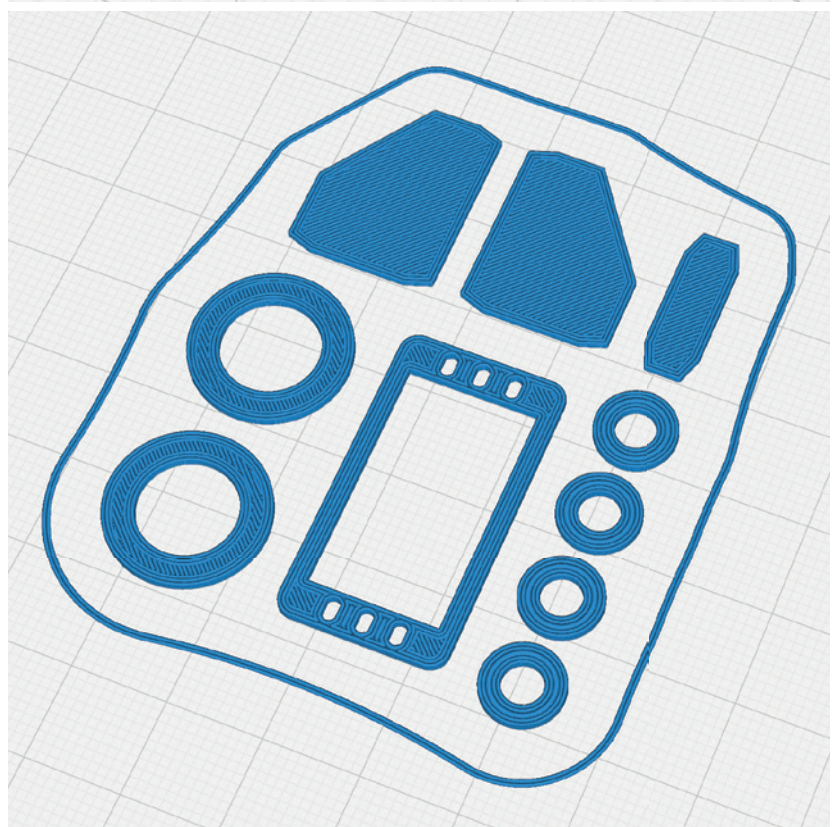


## P1\_Parts\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



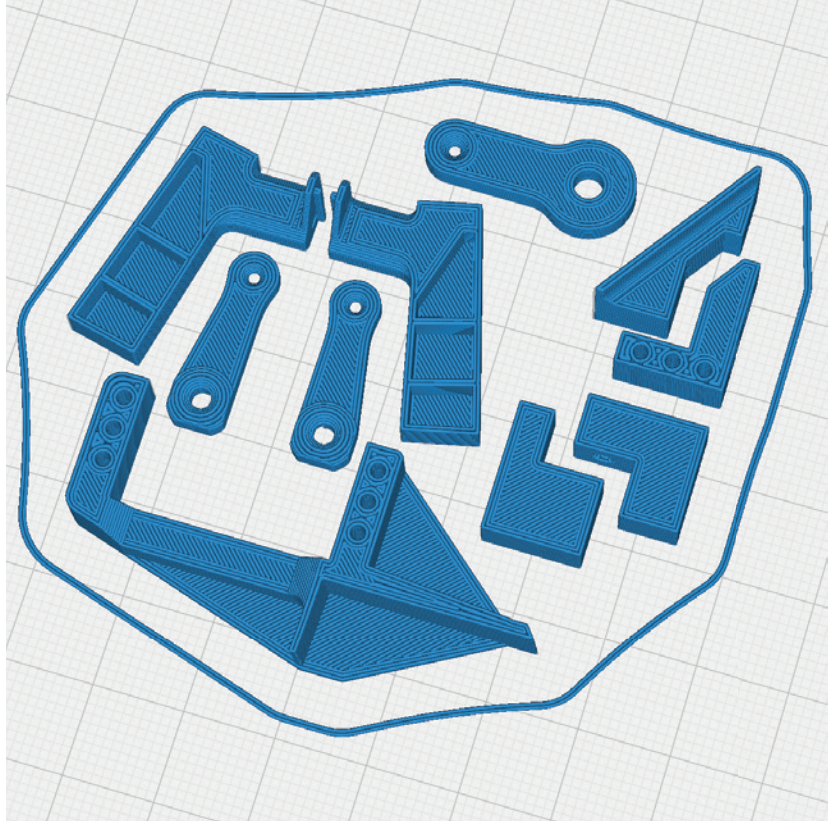
The information about the basic settings you can find on our website at PRINT.  
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## P1\_Servo mount RUD ELE\_lj.stl

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

### ADDITIONAL SETTINGS

None required

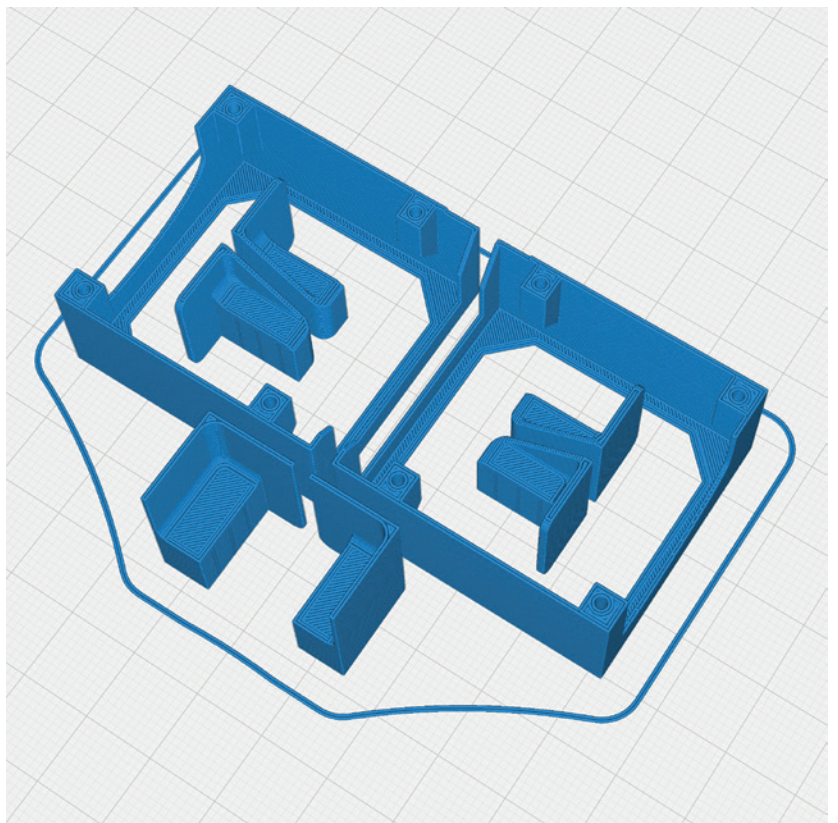


## P1\_Servo mount wing\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



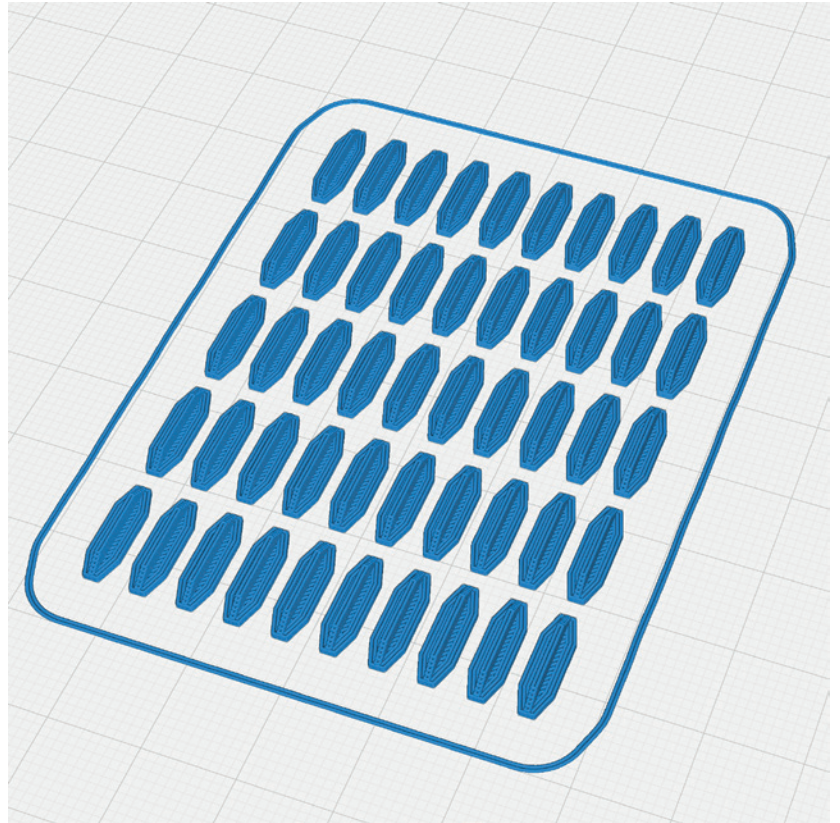
The information about the basic settings you can find on our website at PRINT.  
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## P1\_T-Connects small\_lj.stl

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

### **ADDITIONAL SETTINGS**

None required

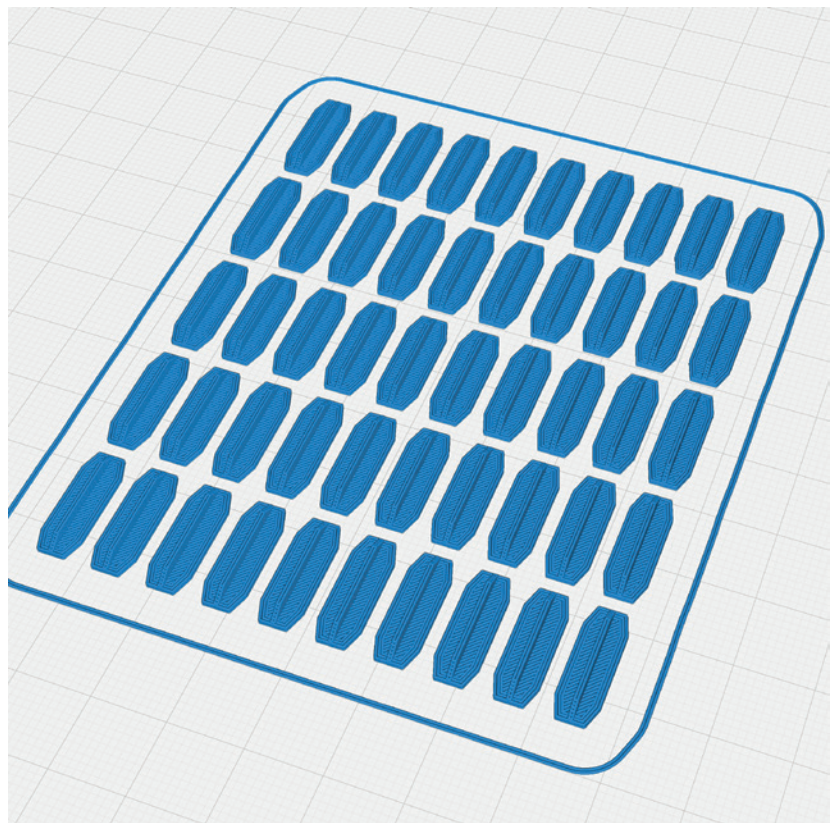


## P1\_T-Connects\_lj.stl

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

### **ADDITIONAL SETTINGS**

None required



# PROFILE P1\_Fullbody Tough PLA or PLA



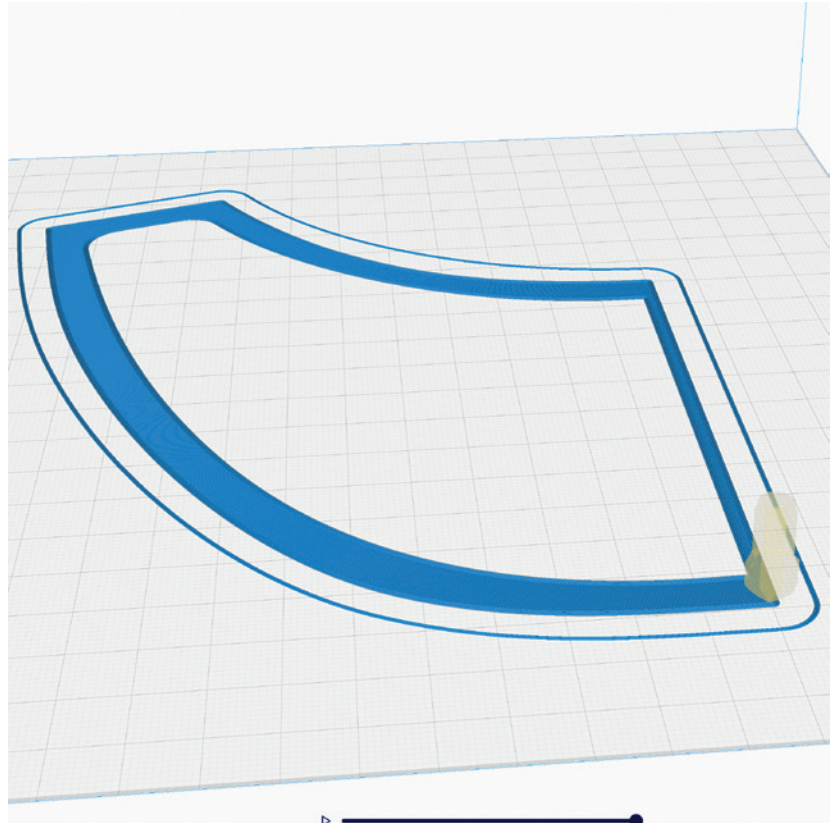
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P1\_Windshield L\_lj.stl and P1\_Windshield R\_lj

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

### ADDITIONAL SETTINGS

None required

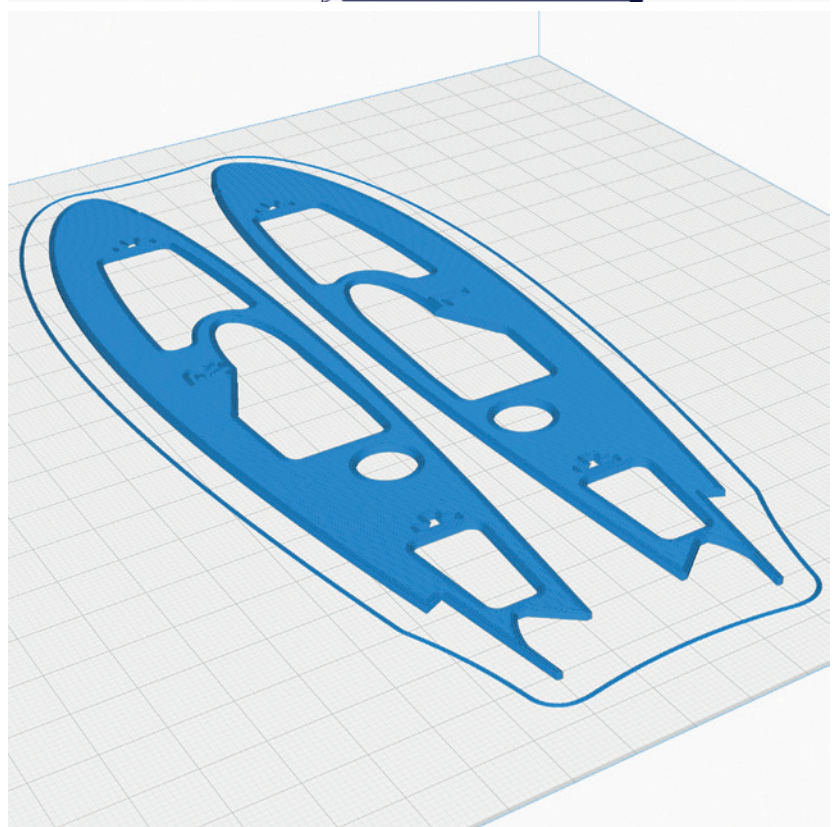


## P1\_Wing Fence\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



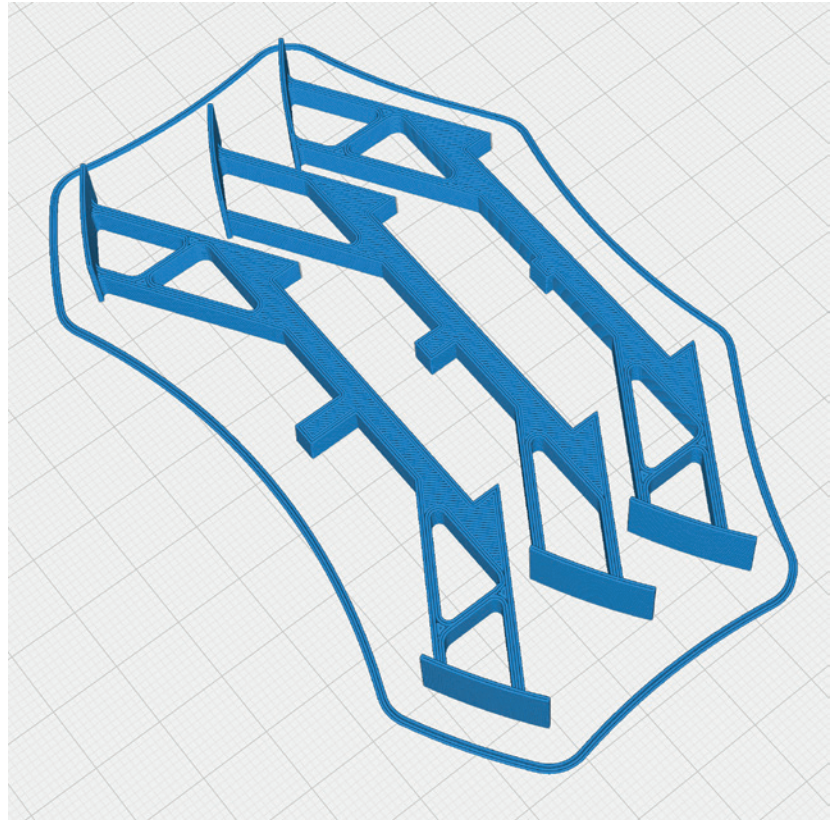
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Battery mount\_lj.stl

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

### **ADDITIONAL SETTINGS**

None required

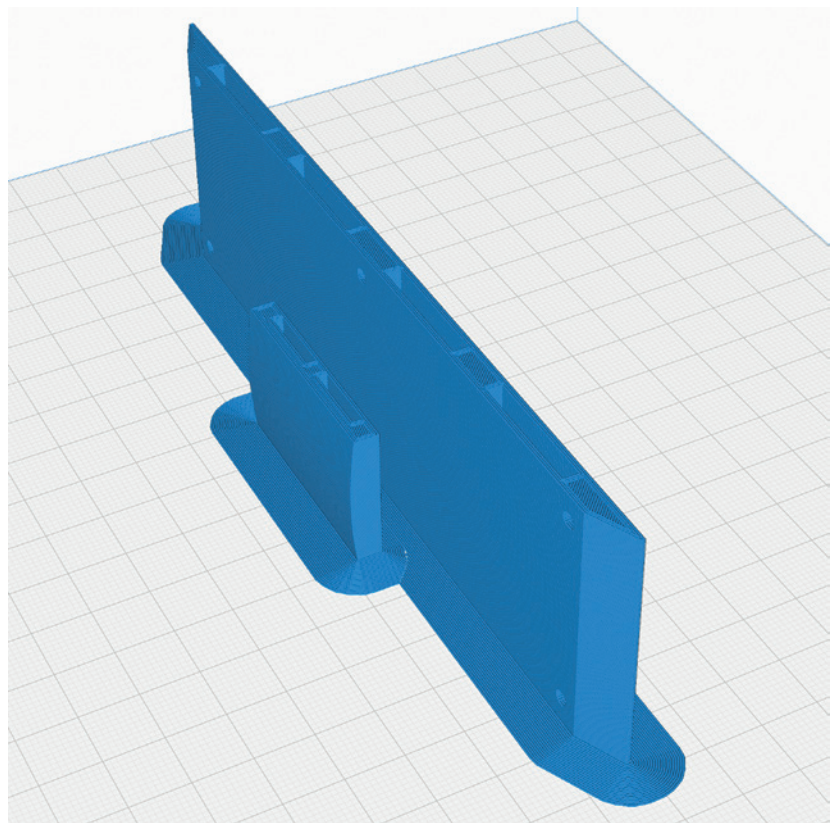


## P2\_Battery plate\_lj.stl

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

### **ADDITIONAL SETTINGS**

- use brim



# PROFILE P2\_Hollowbody Tough PLA or PLA



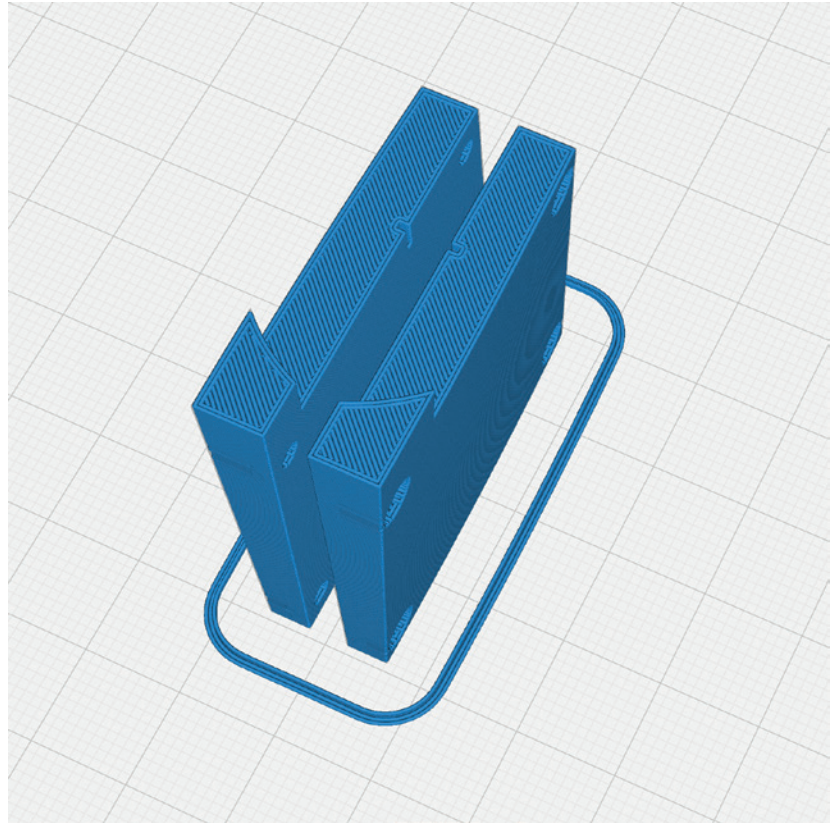
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_AIL covers\_lj.stl

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

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 1
- Infill: 8 %



## P2\_Cover lock\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



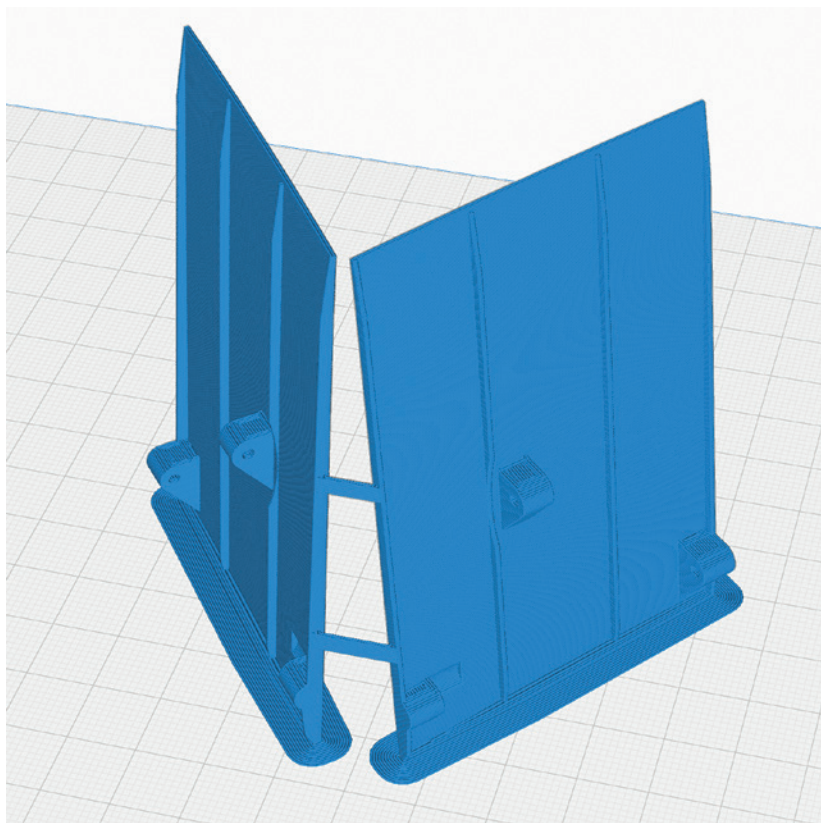
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Doors1 main gear\_lj.stl

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

### ADDITIONAL SETTINGS

- use brim



## P2\_Gear leg nose\_lj.stl\* or P2\_Gear leg nose M3\_lj.stl\*\*

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

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 4
- Top Layers: 4
- Bottom Layers: 4

\* With holes for threaded inserts (**better solution**)

\*\* With holes for Screws  $\varnothing 3\text{mm}$



# 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 legs main\_lj.stl\* or P2\_Gear legs main M3\_lj.stl\*\*

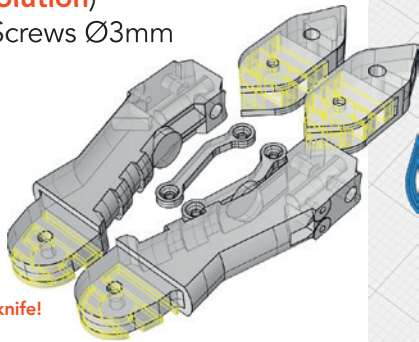
**MATERIAL** Tough PLA, Weight: ~ 21 g

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 4
- Top Layers: 4
- Bottom Layers: 4

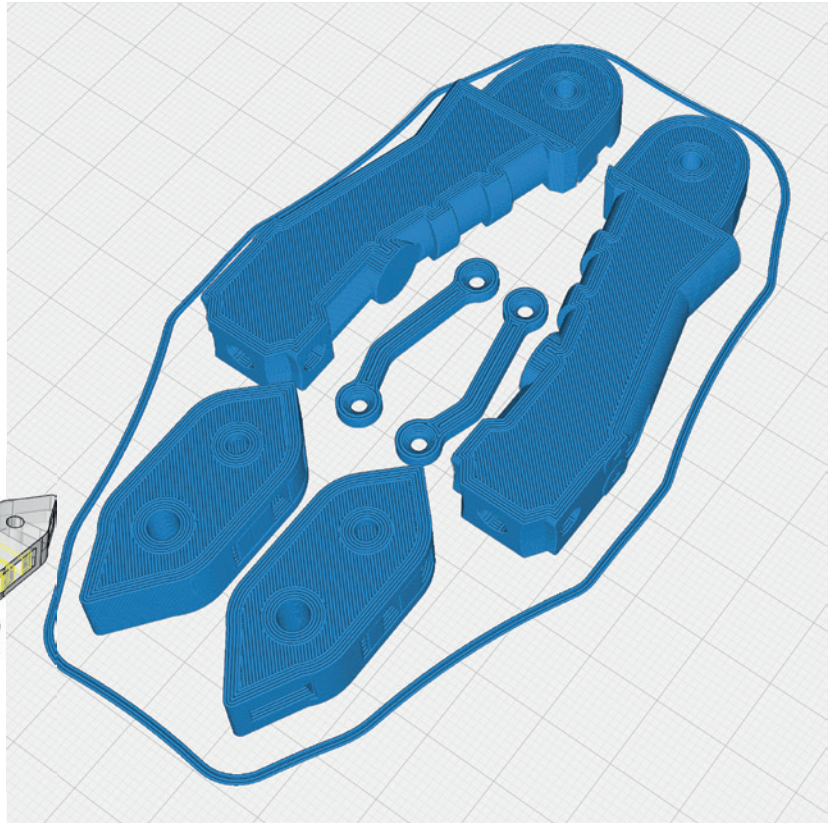
\* With holes for threaded inserts (**better solution**)

\*\* With holes for Screws  $\varnothing 3\text{mm}$



Remove support.

Please be careful with the knife!

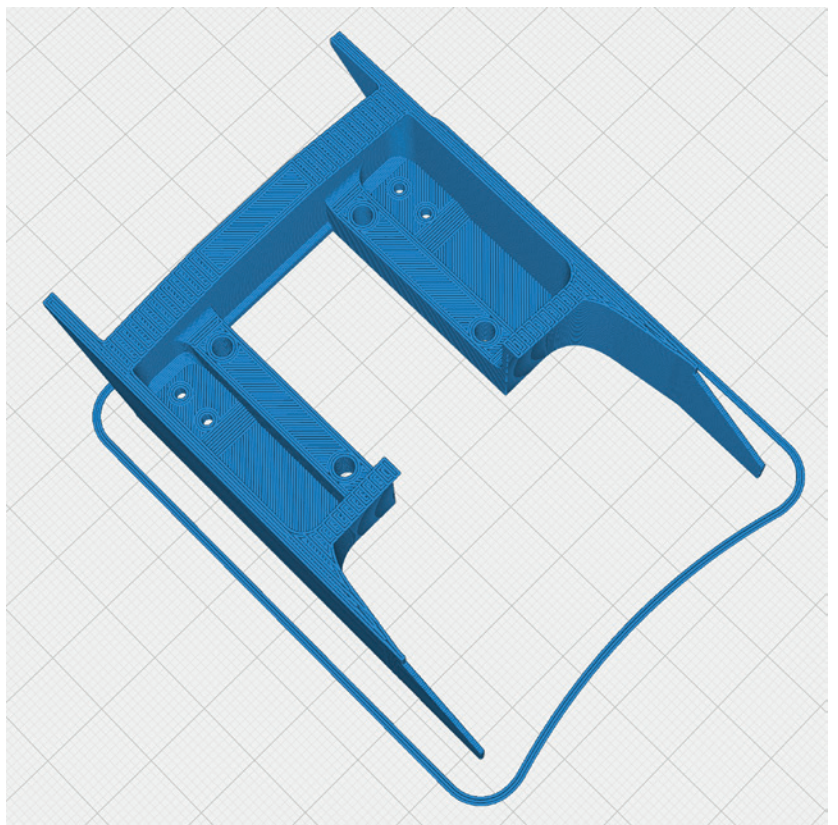


## P2\_Gear mount main\_lj.stl

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

### ADDITIONAL SETTINGS

- print twice



# PROFILE P2\_Hollowbody Tough PLA or PLA



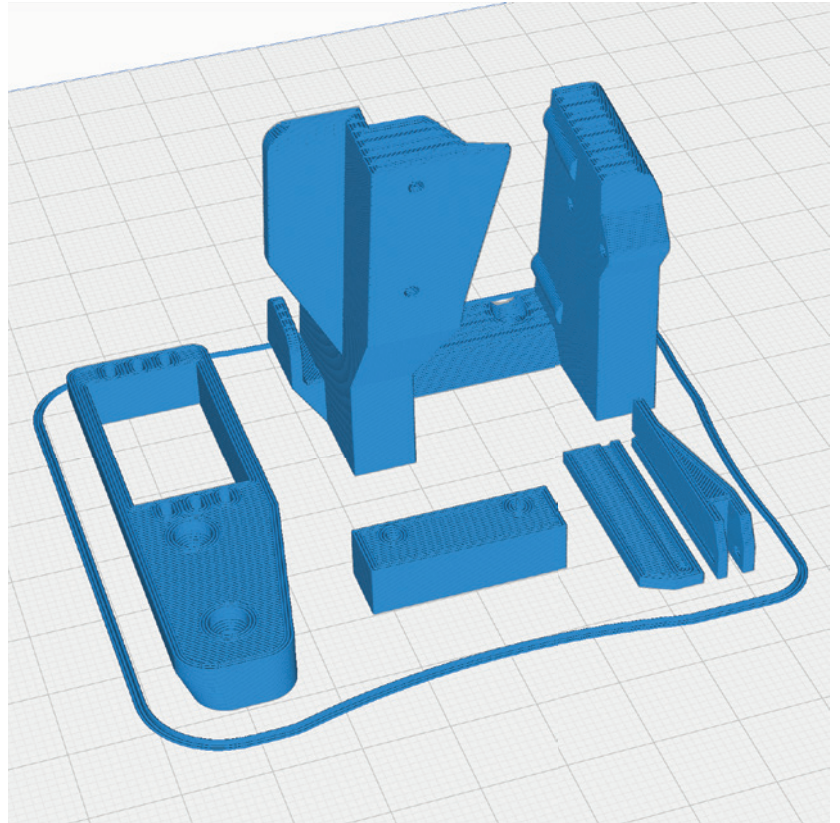
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Gear mount nose\_lj.stl

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

### ADDITIONAL SETTINGS

None required

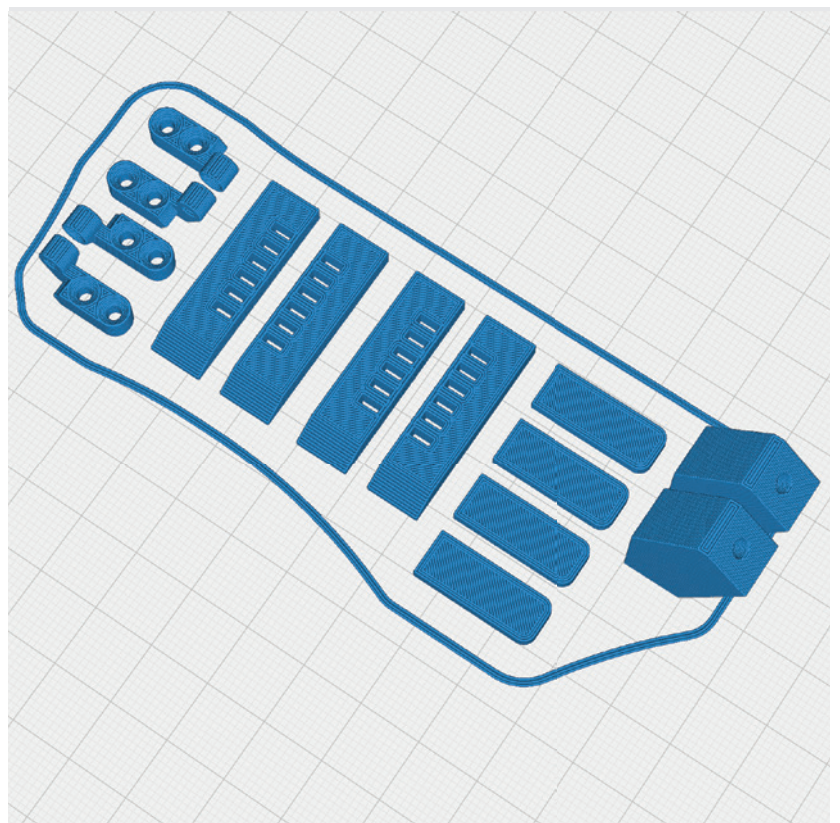


## P2\_Parts\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



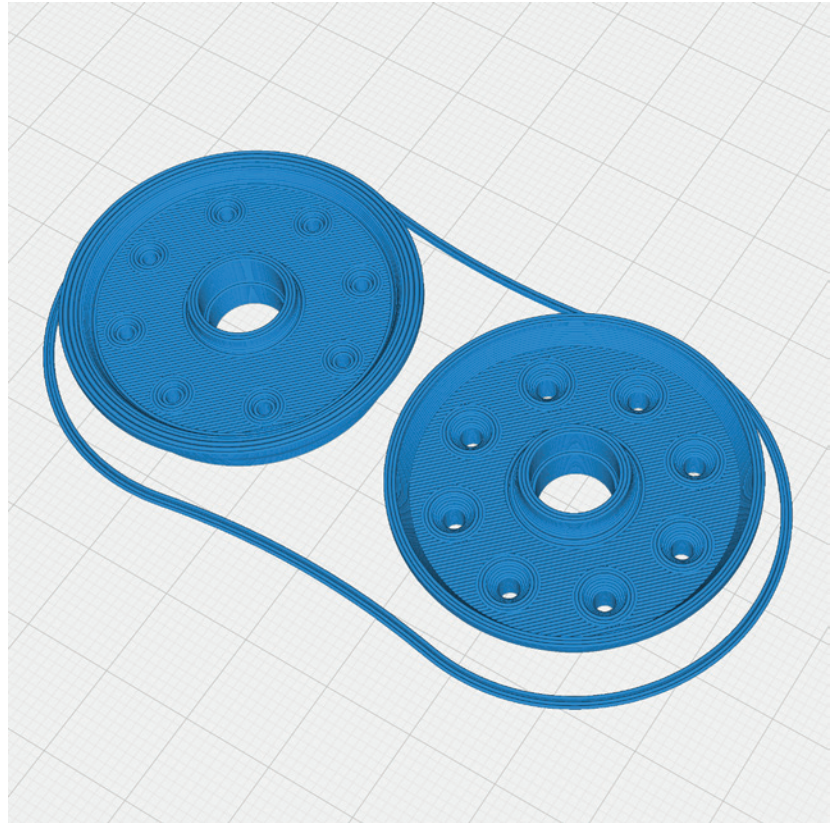
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Rim main\_lj.stl

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

### ADDITIONAL SETTINGS

- Print it four times

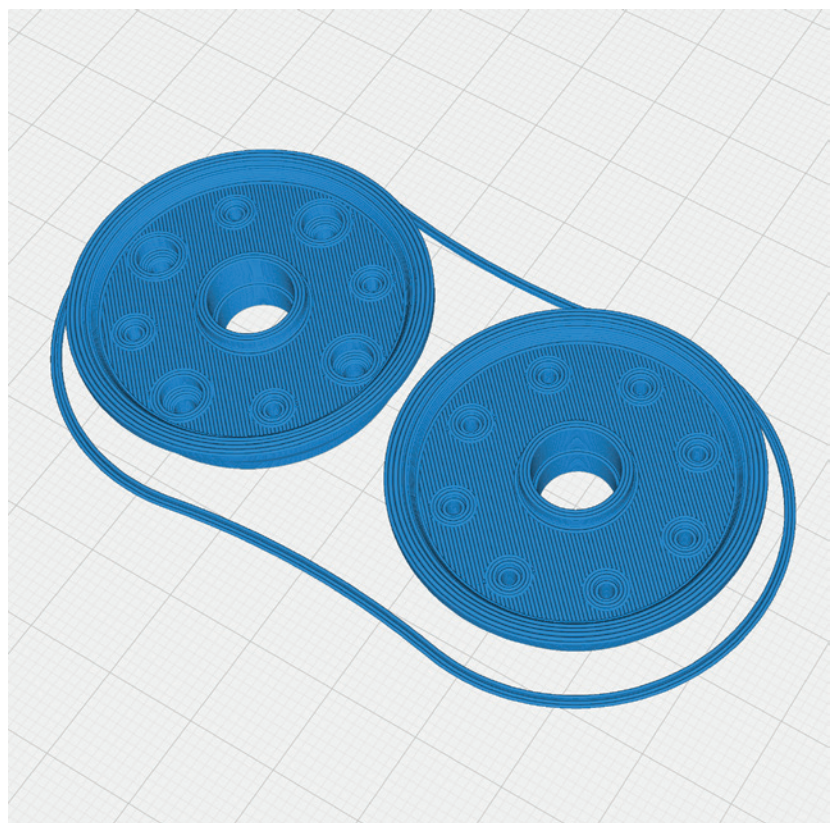


## P2\_Rim nose\_lj.stl

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

### ADDITIONAL SETTINGS

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



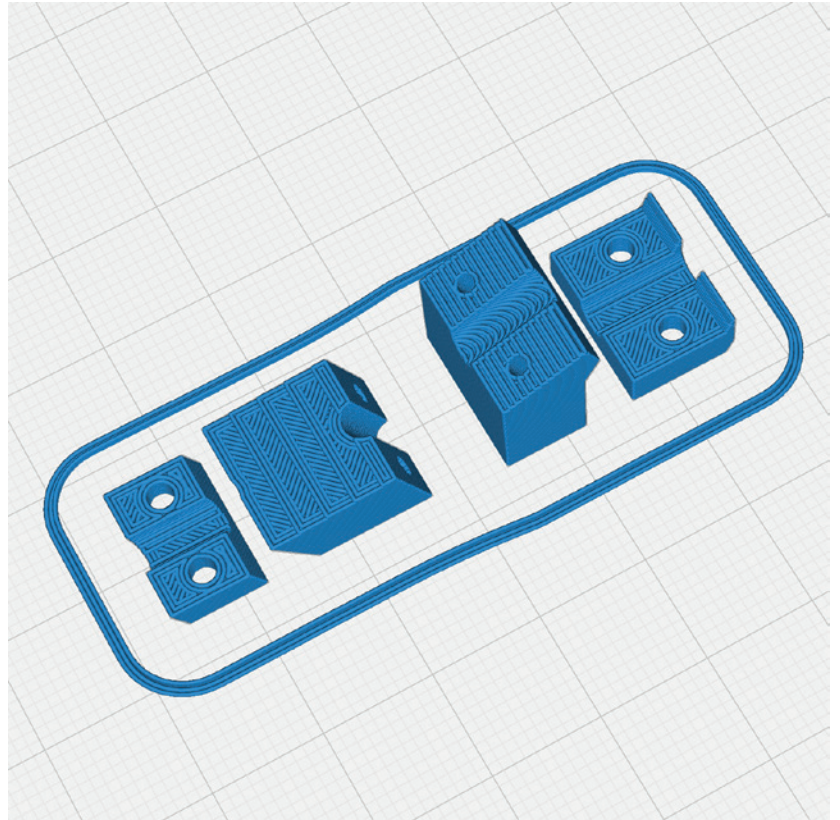
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Rudder mount\_lj.stl

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

### **ADDITIONAL SETTINGS**

None required

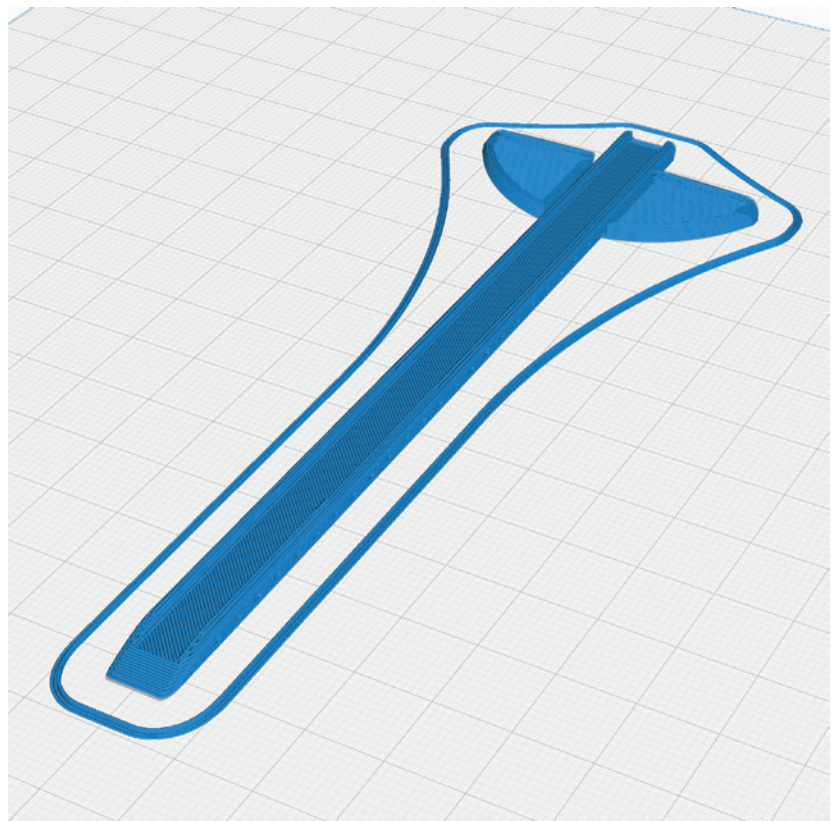


## P2\_Window strut\_lj.stl

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

### **ADDITIONAL SETTINGS**

None required



# PROFILE P2\_Hollowbody Tough PLA or PLA



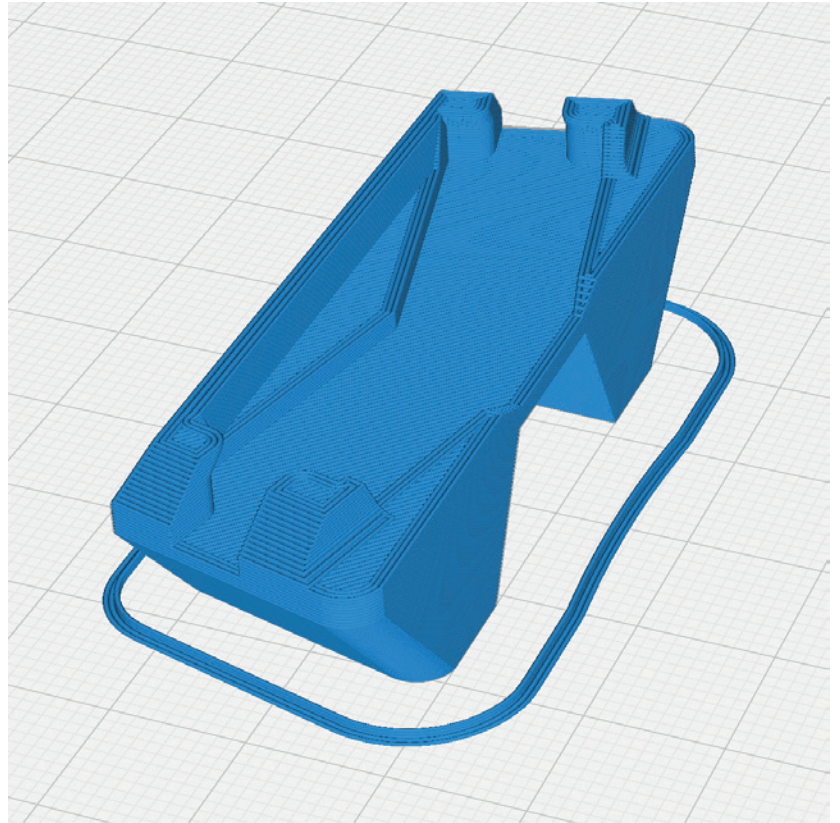
The information about the basic settings you can find on our website at PRINT.  
Please note the additional settings for the individual parts!

## P2\_Wing mount\_lj.stl

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

### ADDITIONAL SETTINGS

None required

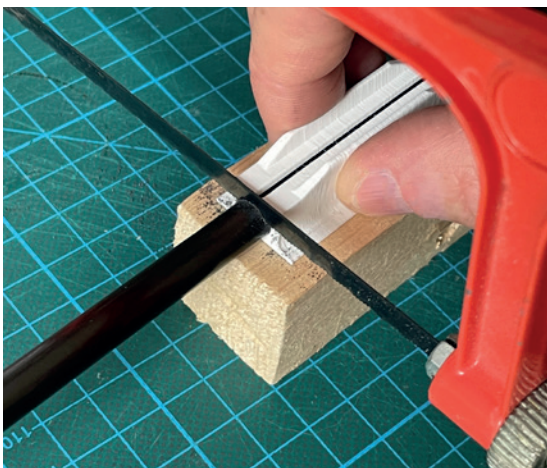
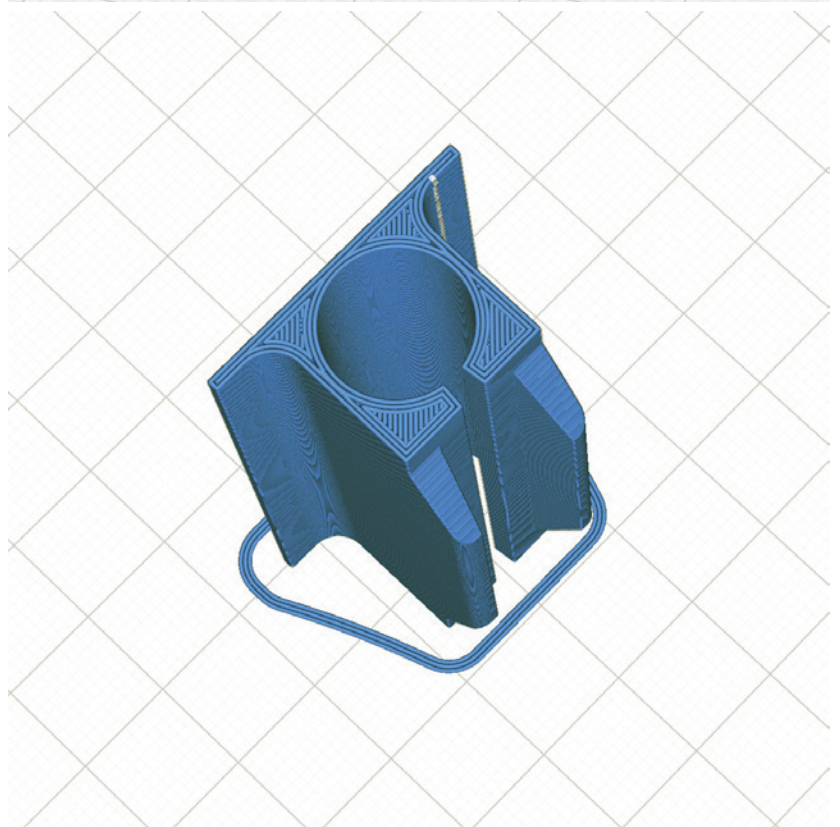


## P2\_Carbon tool 10mm.stl and P2\_Carbon tool 6mm.stl

**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\_Wheel main\_lj.stl

**MATERIAL** VarioShore or TPU A95

### ADDITIONAL SETTINGS

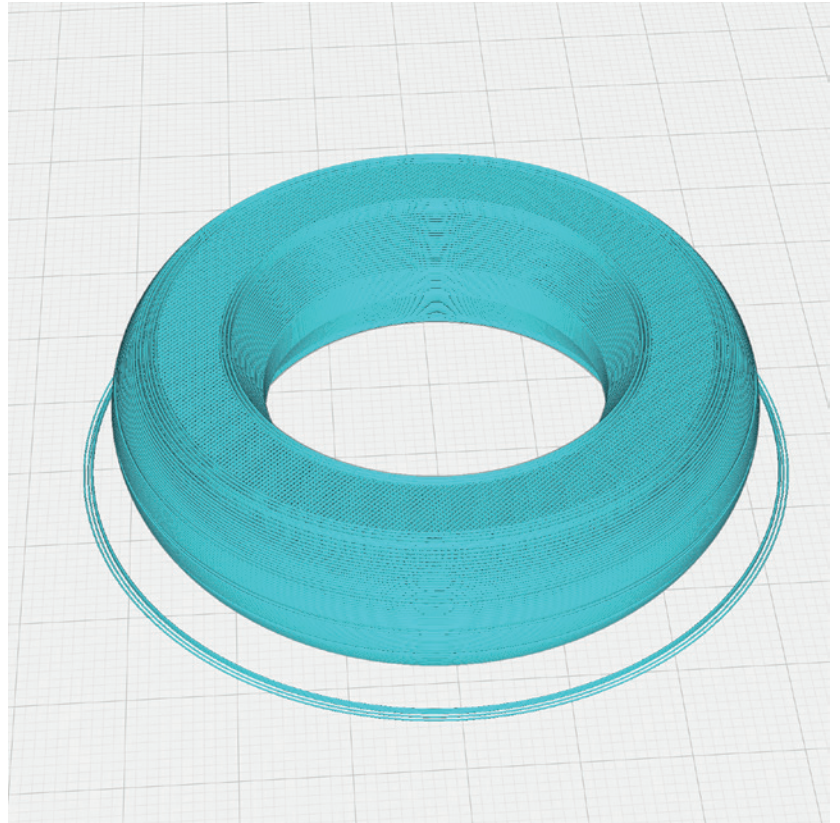
#### VarioShore with Flow 70 %:

- 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

- Print it four times



## P4\_Wheel nose\_lj.stl

**MATERIAL** VarioShore or TPU A95

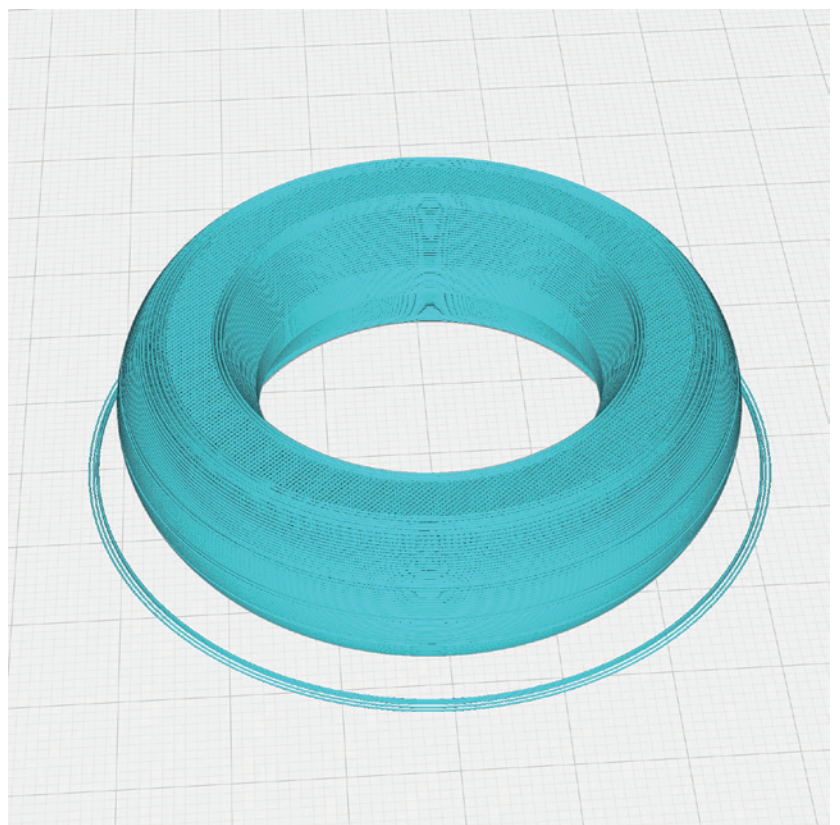
### ADDITIONAL SETTINGS

#### 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



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



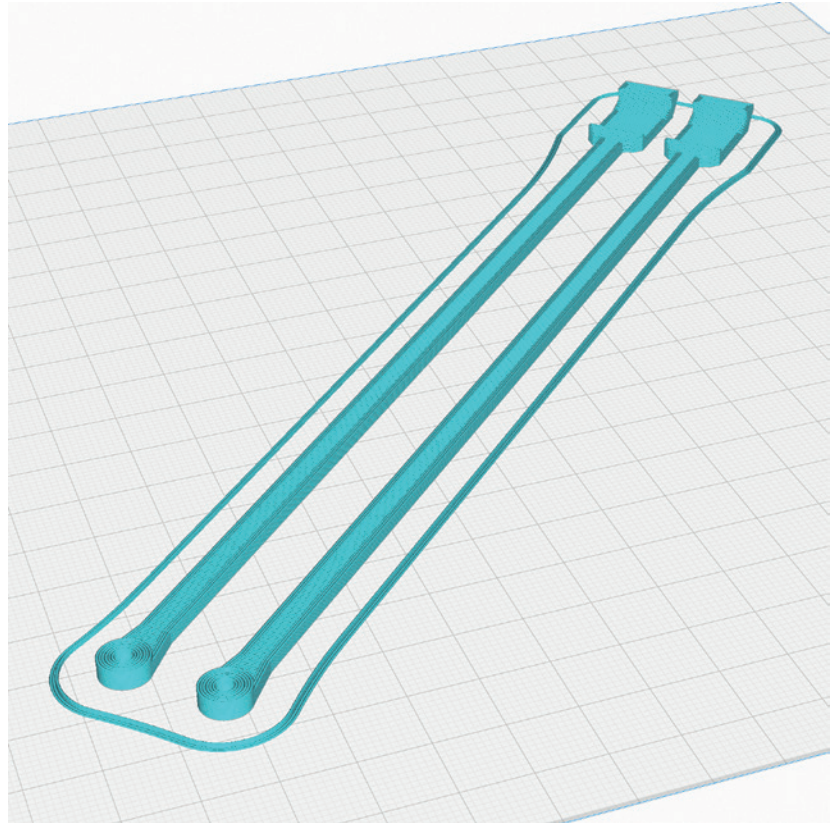
The information about the basic settings you can find on our website at [PRINT](#).  
Please note the additional settings for the individual parts!

## P4\_Tension belt\_lj.stl

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

### **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!

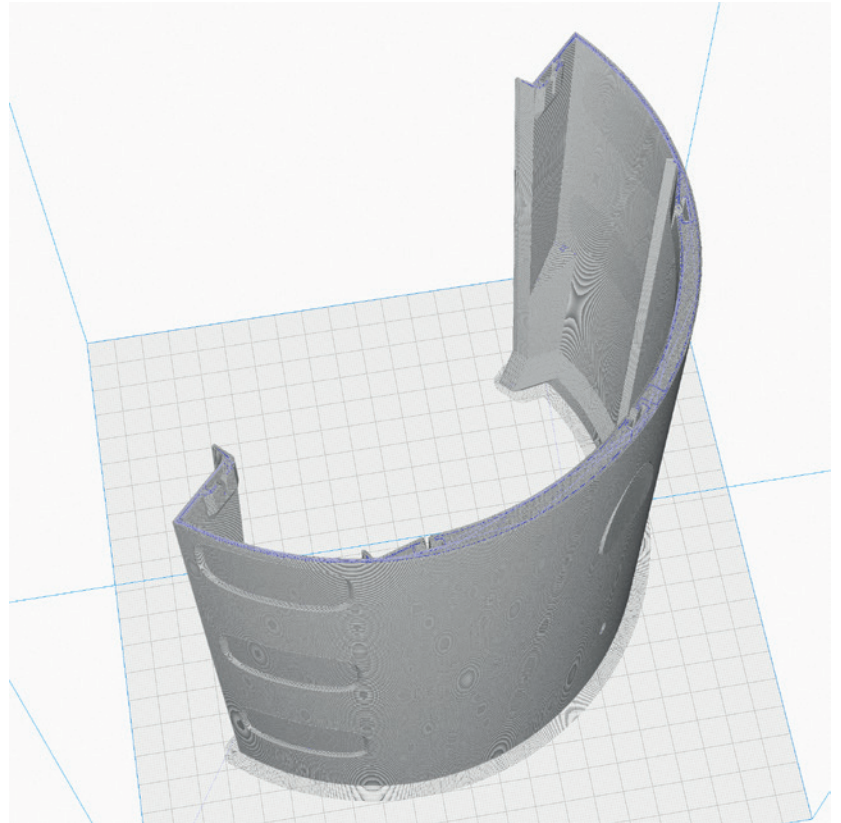
## P5\_Cover 1\_lj.stl

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

**TIME** ~ 9 hours

### ADDITIONAL SETTINGS

- Set a very wide brim (15 mm)
- The build plate must be free of grease!



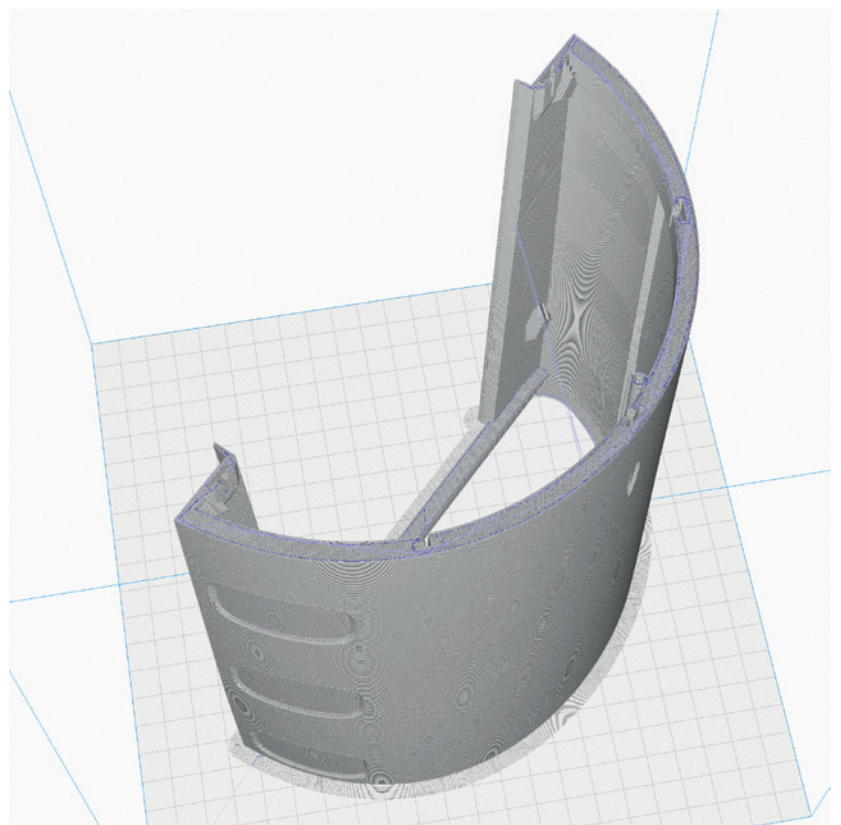
## P5\_Cover 2\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 49 g

**TIME** ~ 10 hours

### ADDITIONAL SETTINGS

- Set a very wide brim (15 mm)
- The build plate must be free of grease!



# 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!

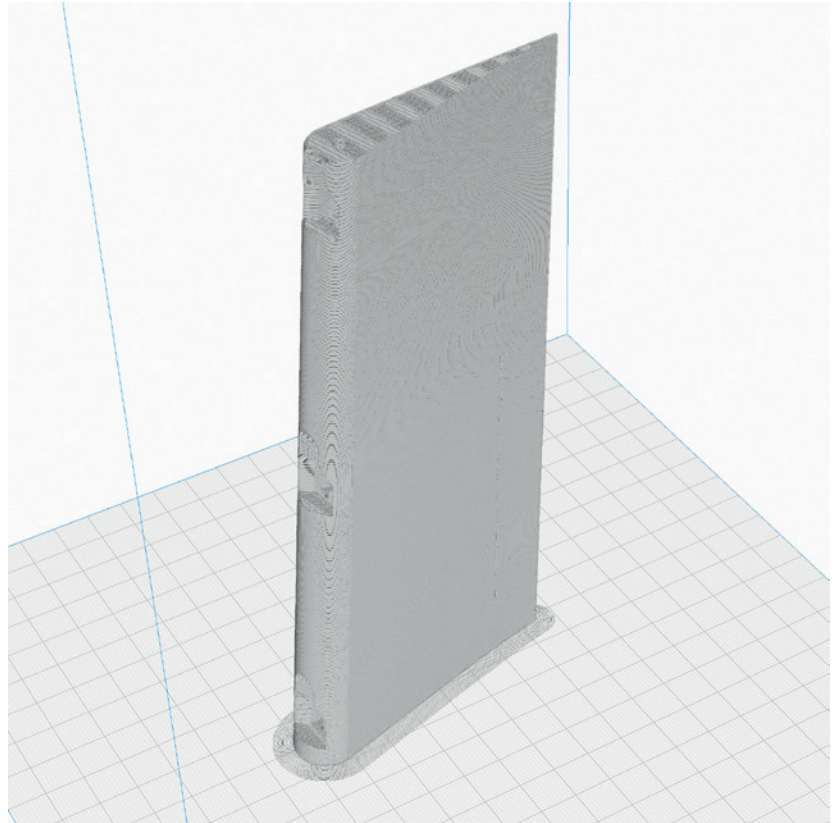
## P5\_AIL L\_lj.stl and P5\_AIL R\_lj.stl

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

**TIME** ~ 2 hours 10 minutes

### ADDITIONAL SETTINGS

- use brim



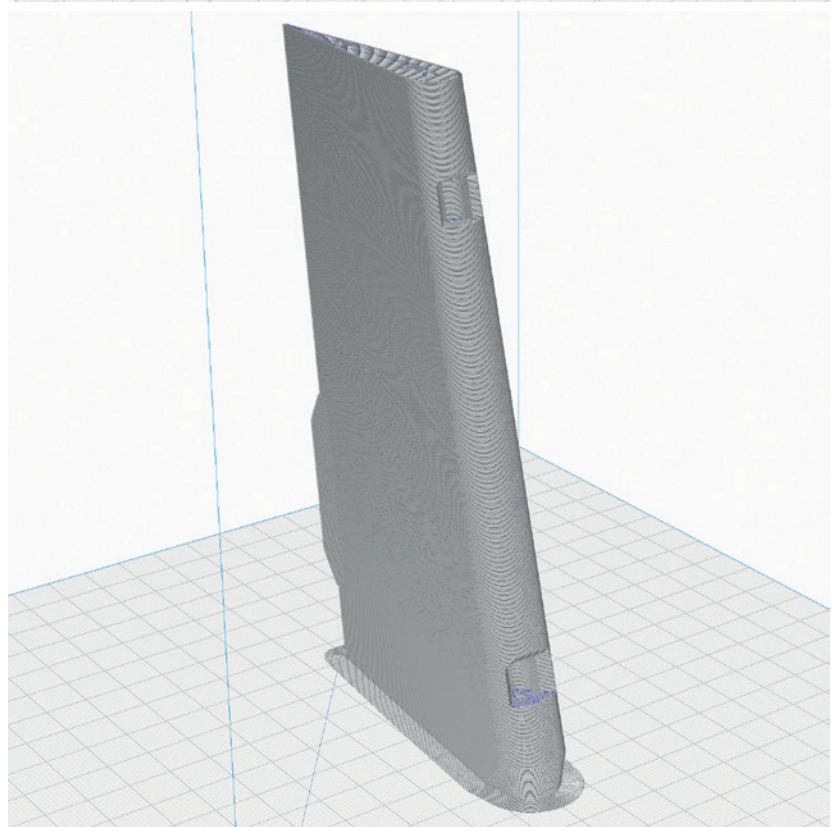
## P5\_Elevator L1\_lj.stl and P5\_Elevator R1\_lj.stl

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

**TIME** ~ 2 hours

### 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!

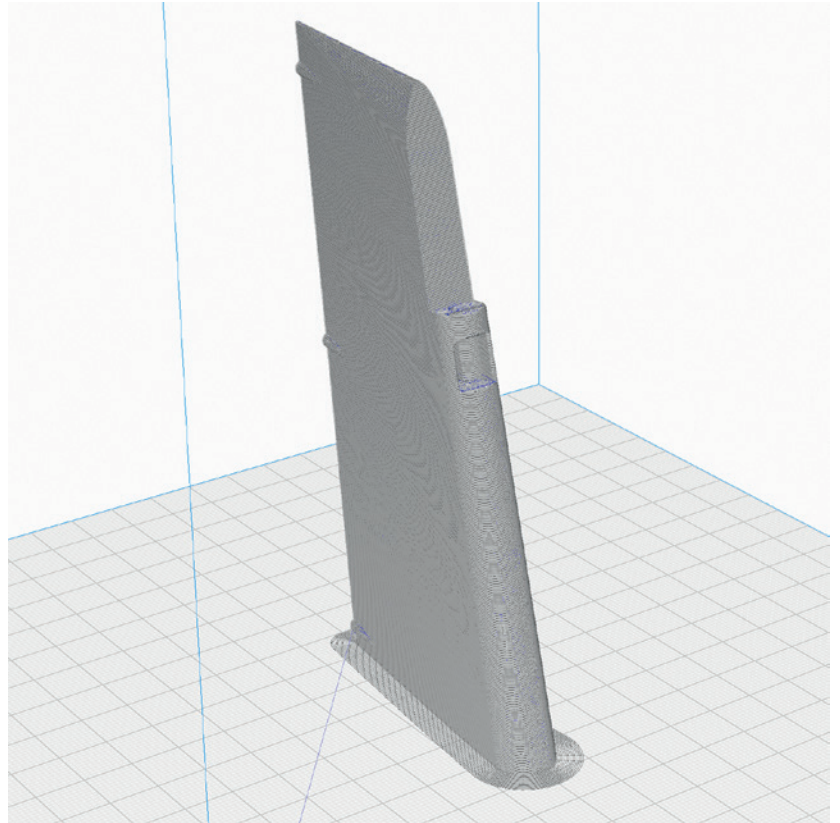
## P5\_Elevator L2\_lj.stl and P5\_Elevator R2\_lj.stl

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

**TIME** ~ 1 hour

### **ADDITIONAL SETTINGS**

None required



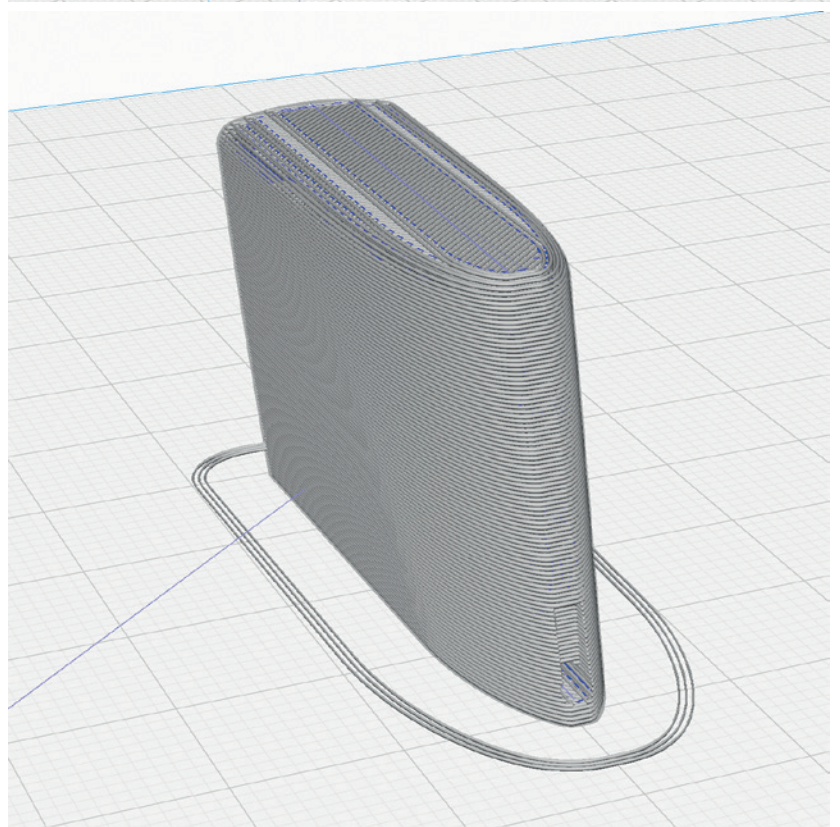
## P5\_Elevator L+R3\_lj.stl

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

**TIME** ~ 15 minutes

### **ADDITIONAL SETTINGS**

- Print twice



# 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!

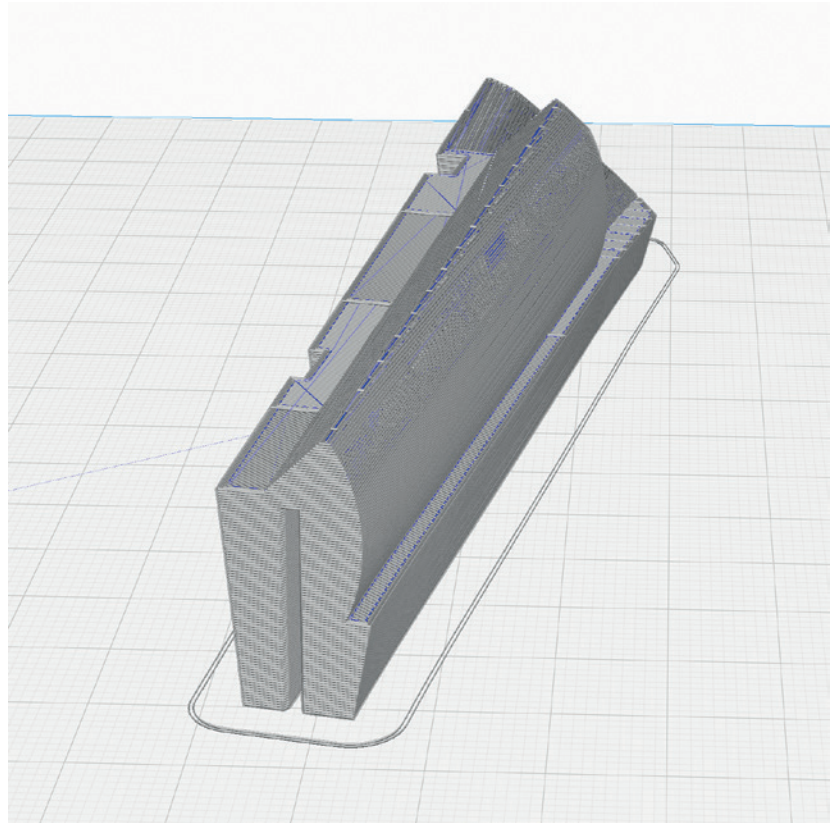
## P5\_Flap L1\_lj.stl and P5\_Flap R1\_lj.stl

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

**TIME** ~ 50 minutes

### ADDITIONAL SETTINGS

None required



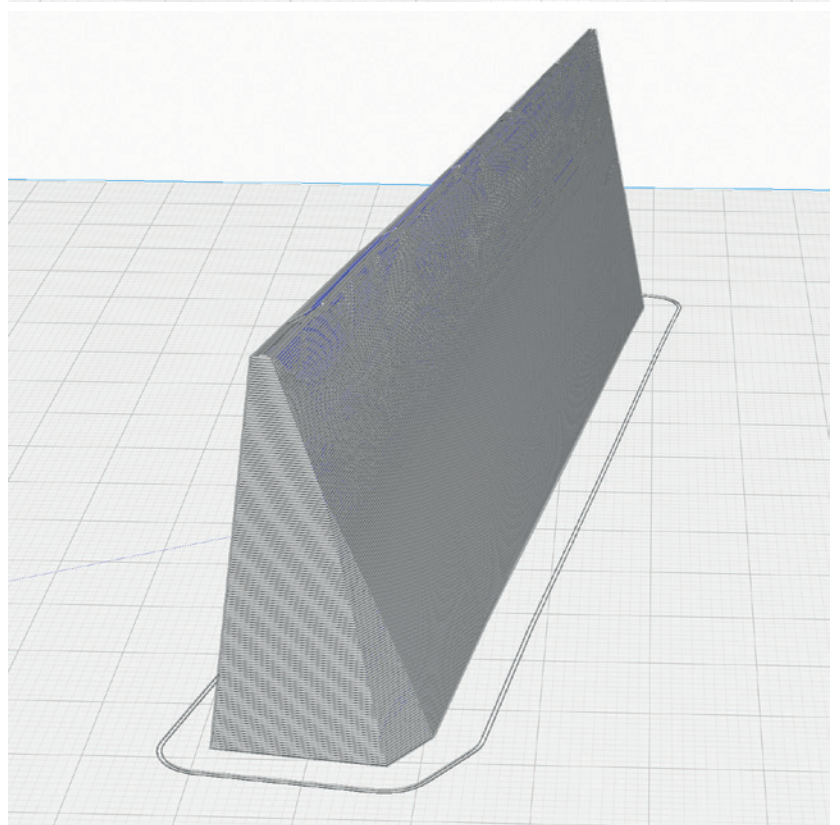
## P5\_Flap L2\_lj.stl and P5\_Flap R2\_lj.stl

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

**TIME** ~ 40 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!

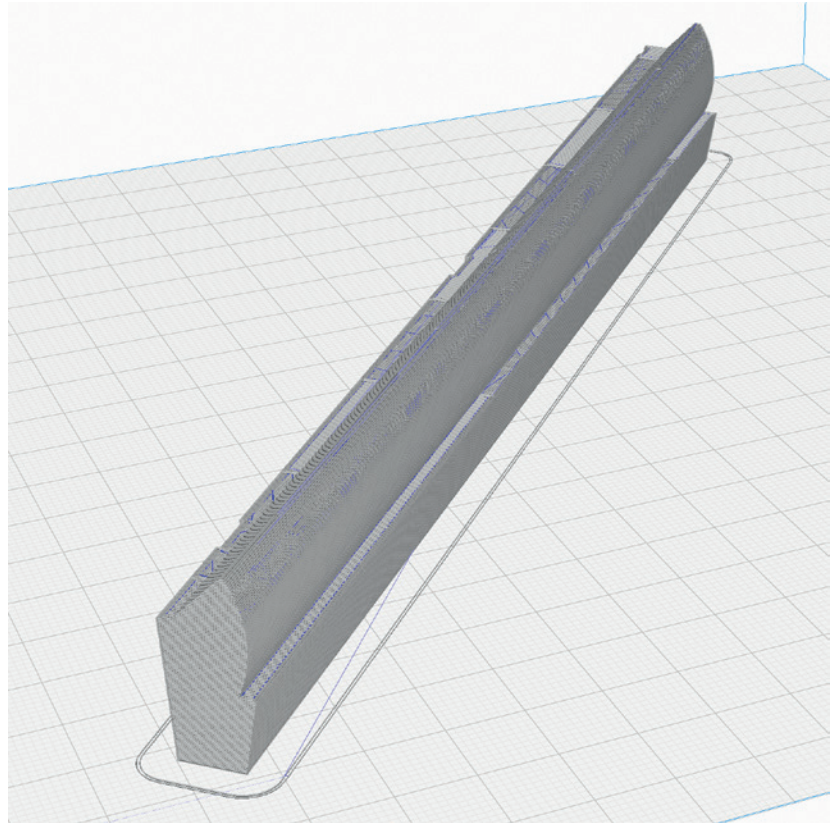
## P5\_Flap L3\_lj.stl and P5\_Flap R3\_lj.stl

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

**TIME** ~ 1 hour

### **ADDITIONAL SETTINGS**

None required



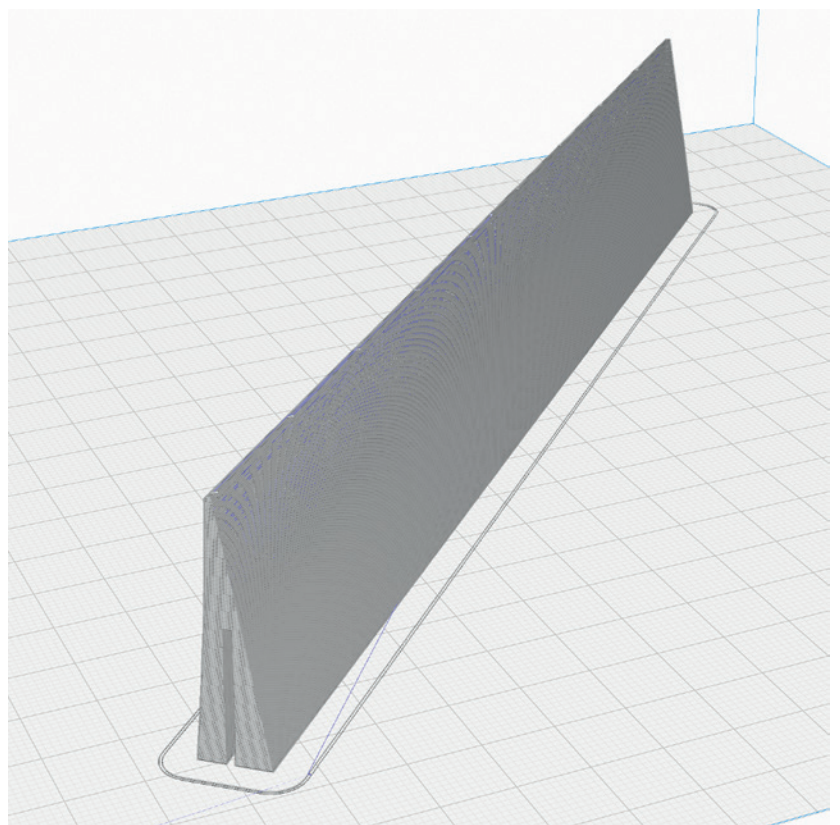
## P5\_Flap L4\_lj.stl and P5\_Flap R4\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 6 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!

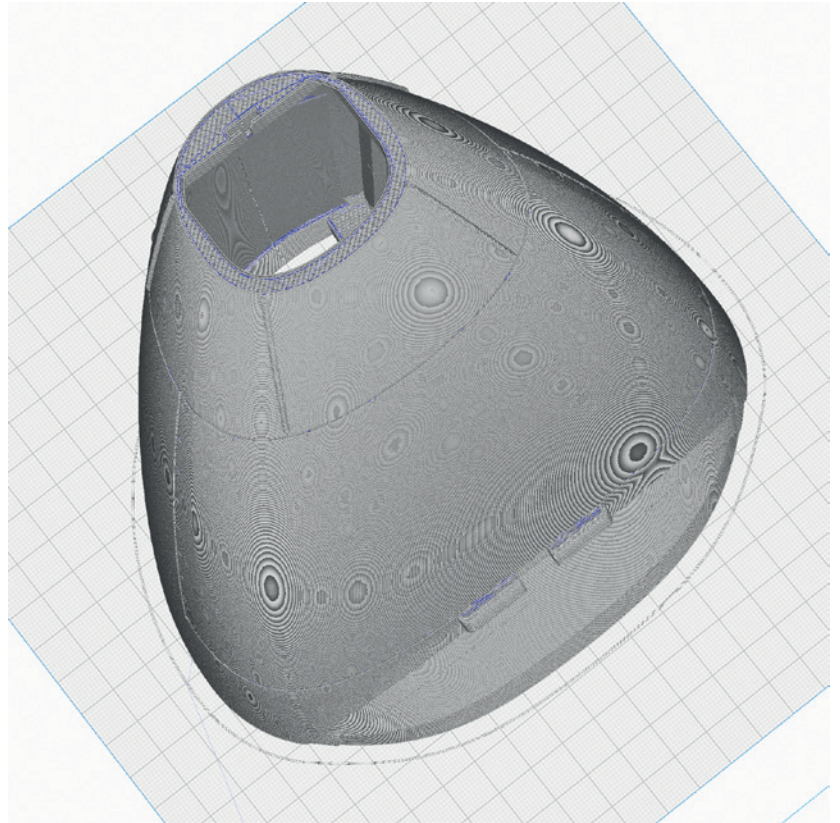
## P5\_FUS 1\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 41 g

**TIME** ~ 8 hours

### ADDITIONAL SETTINGS

None required



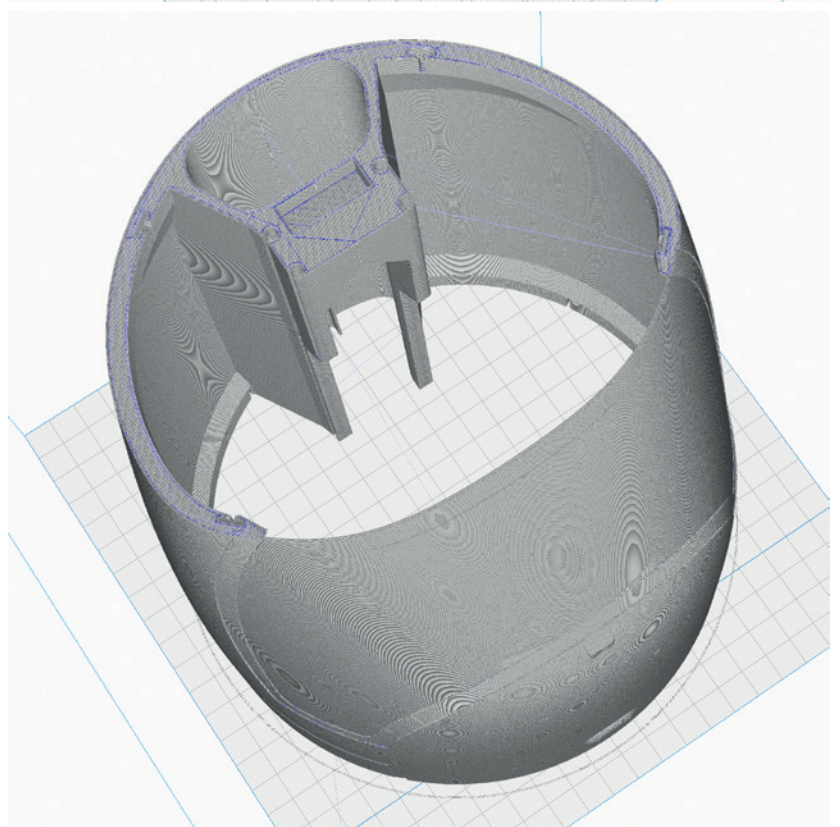
## P5\_FUS 2\_lj.stl

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

**TIME** ~ 17 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!

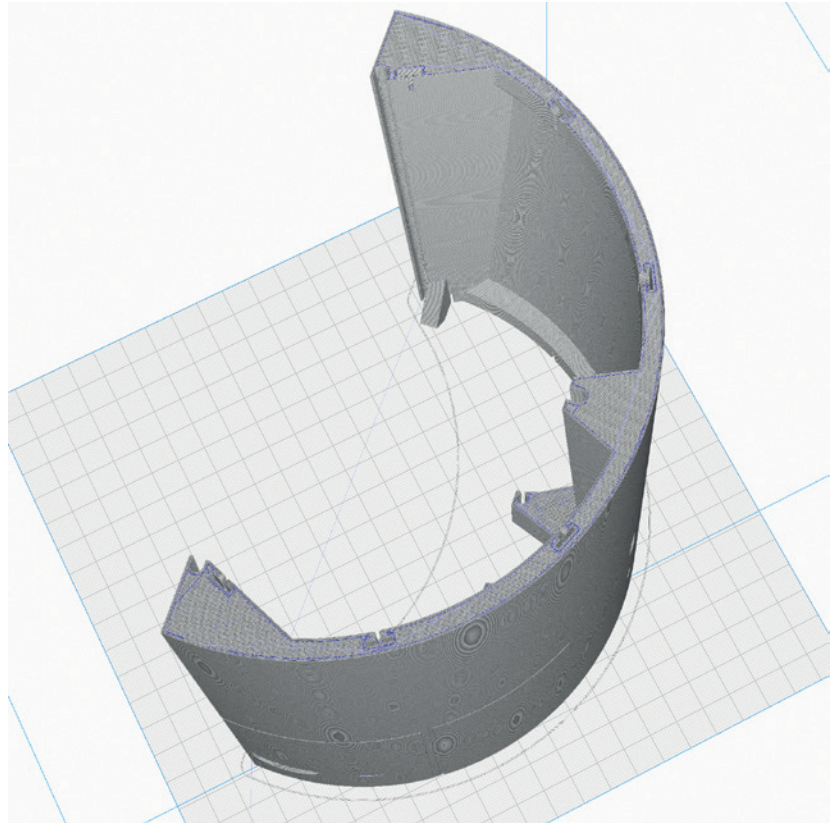
## P5\_FUS 3\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 50 g

**TIME** ~ 10 hours

### ADDITIONAL SETTINGS

None required



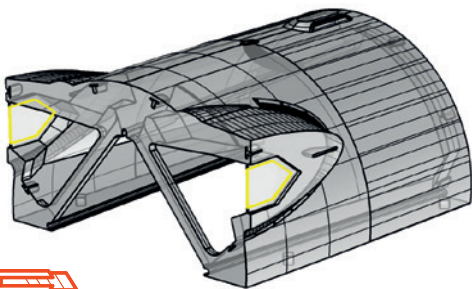
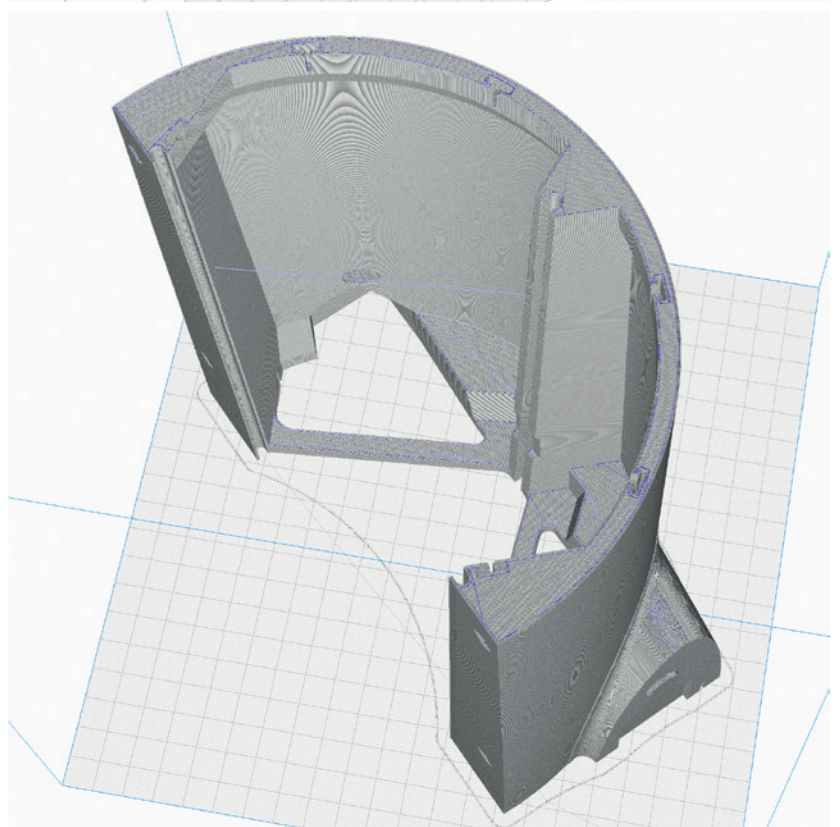
## P5\_FUS 4\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 66 g

**TIME** ~ 13 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!

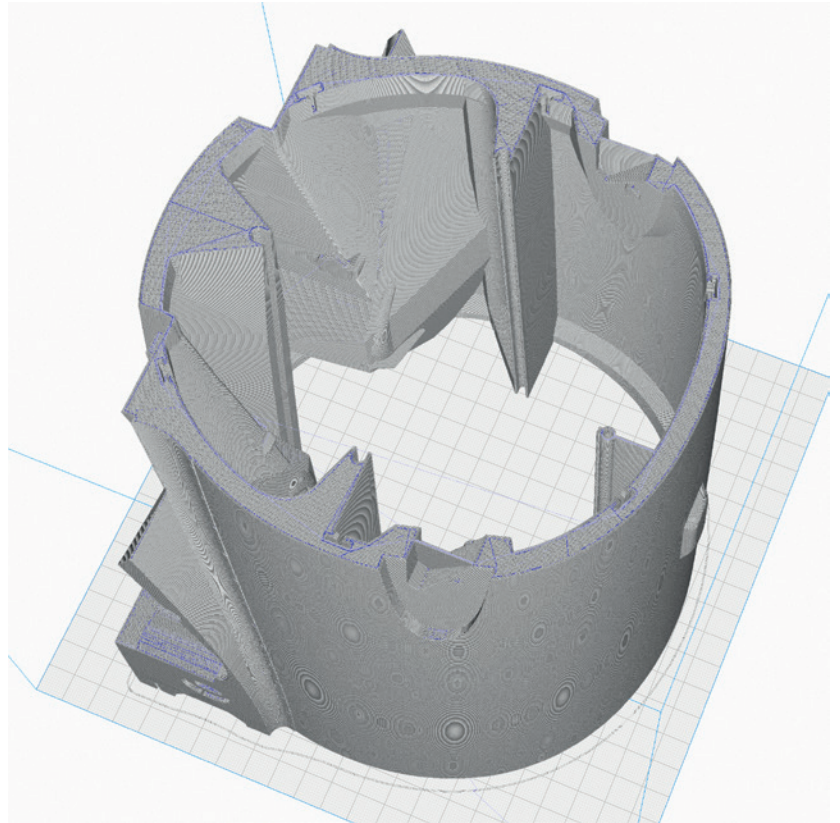
## P5\_FUS 5a\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 115 g

**TIME** ~ 19 hours

### ADDITIONAL SETTINGS

None required



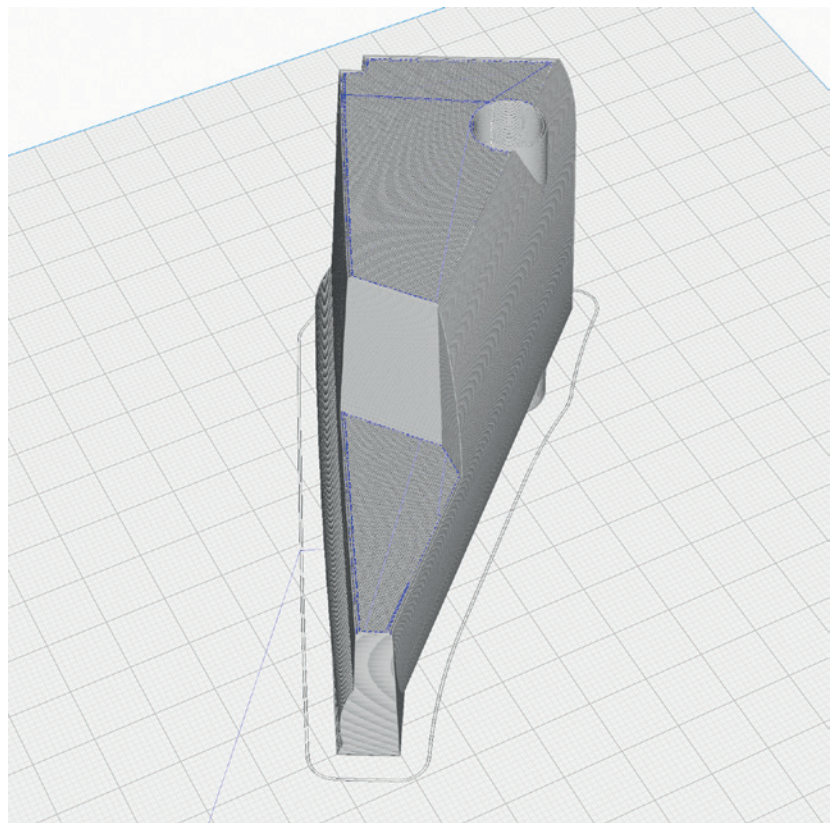
## P5\_FUS 5b L\_lj.stl and P5\_FUS 5b R\_lj.stl

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

**TIME** ~ 1 hour 10 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!

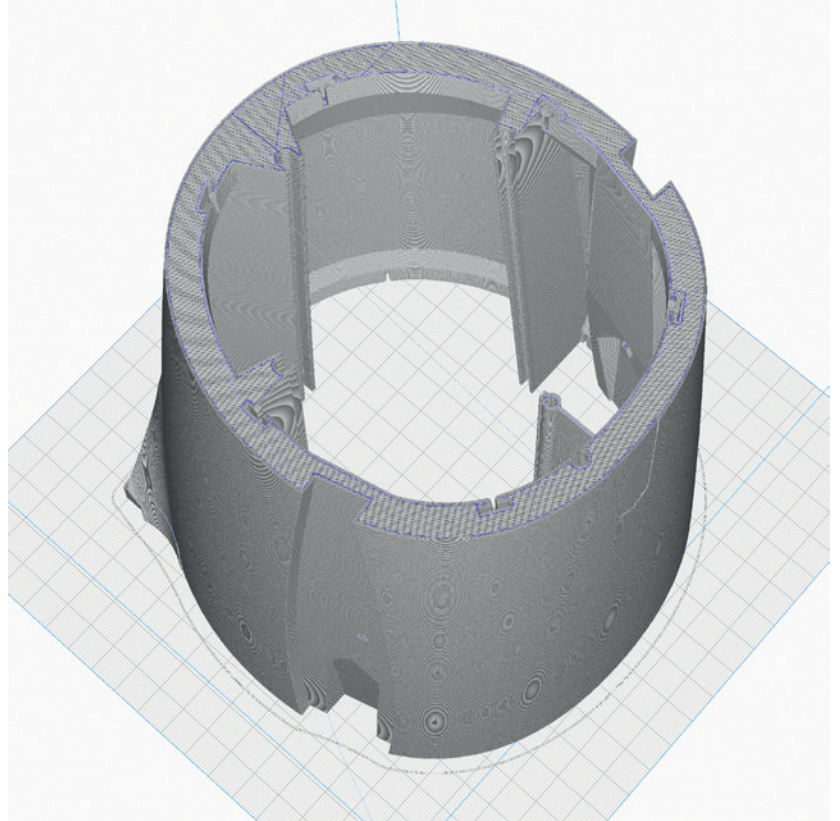
## P5\_FUS 6a\_lj.stl

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

**TIME** ~ 18 hours

### ADDITIONAL SETTINGS

None required



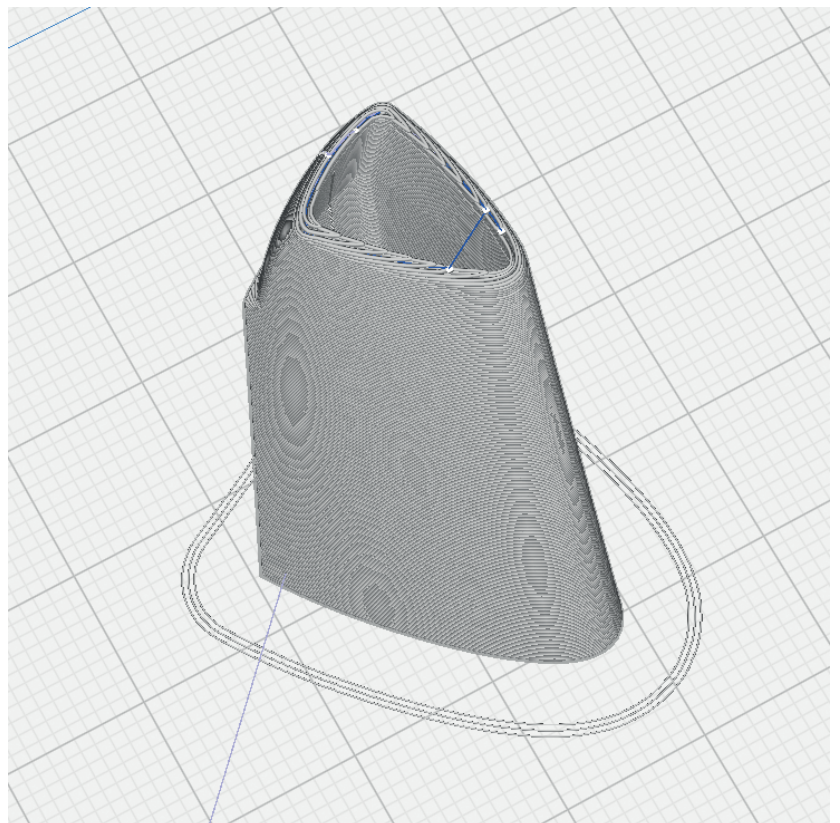
## P5\_FUS 6b\_lj.stl

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

**TIME** ~ 15 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!

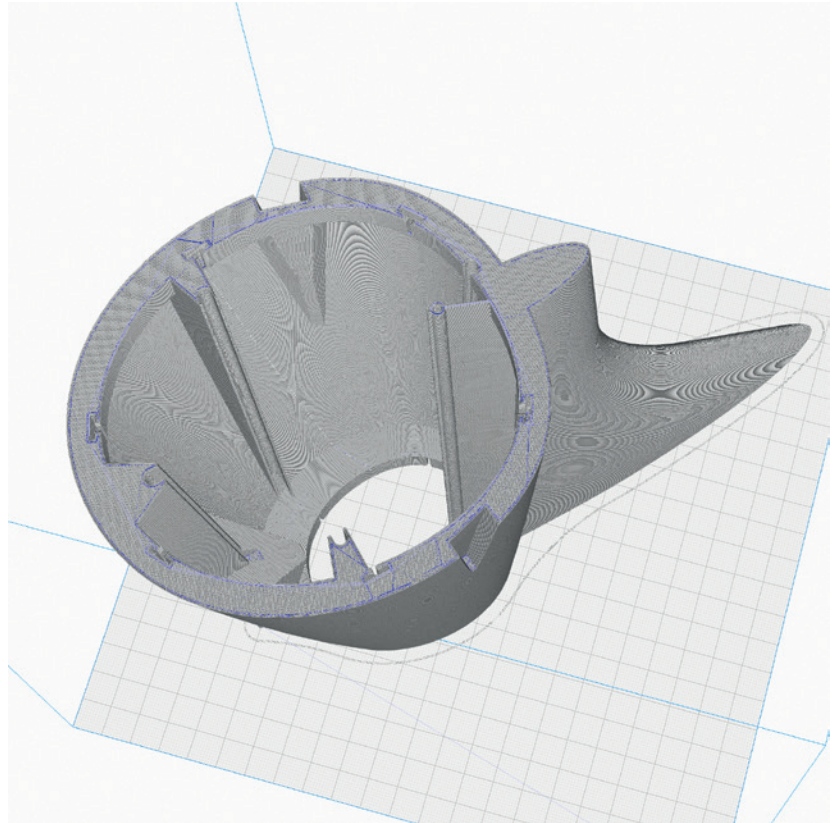
## P5\_FUS 7\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 63 g

**TIME** ~ 13 hours

### ADDITIONAL SETTINGS

- set Z-Seam back left



## P5\_FUS 8a\_lj.stl

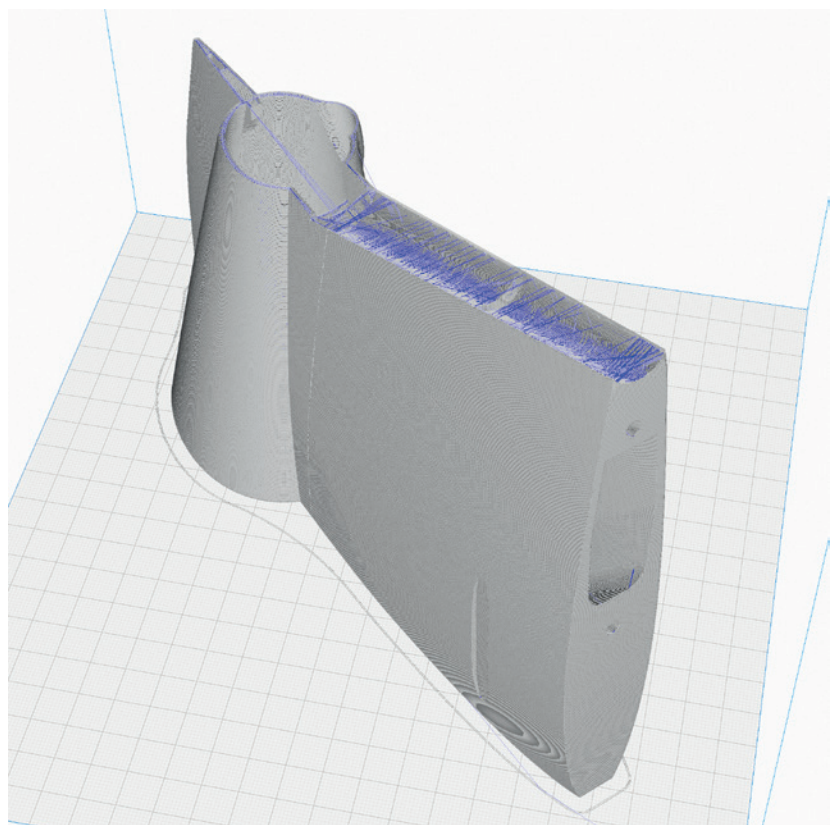
**MATERIAL** LW PLA, Weight: ~ 47 g

**TIME** ~ 9 hours

### ADDITIONAL SETTINGS

None required

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



# 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!

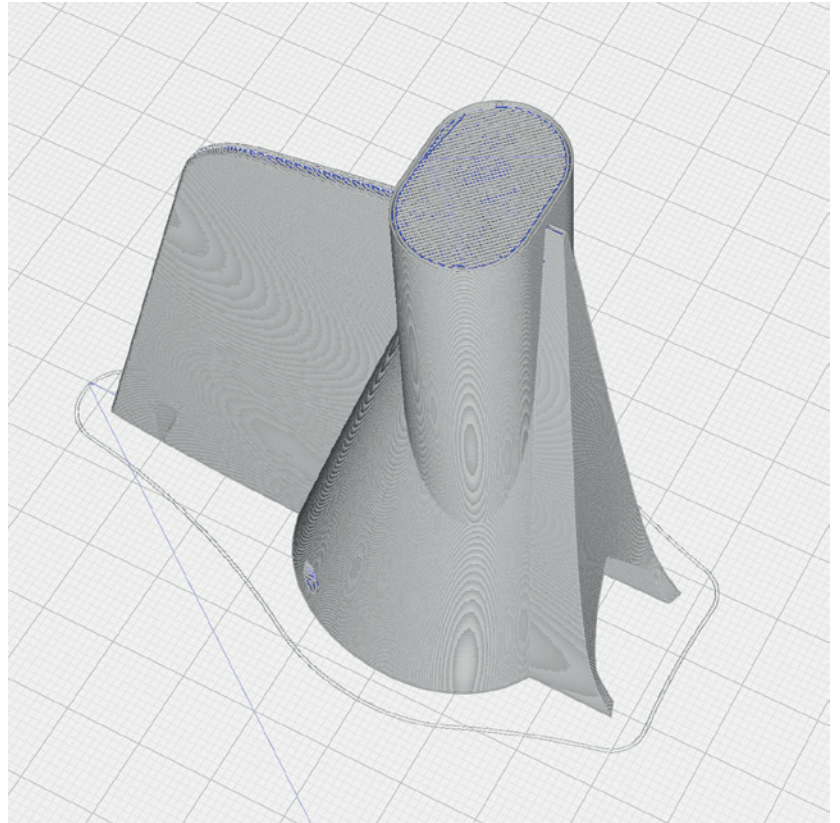
## P5\_FUS 8b\_lj.stl

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

**TIME** ~ 1 hour

### ADDITIONAL SETTINGS

None required



## P5\_FUS 8c\_lj.stl

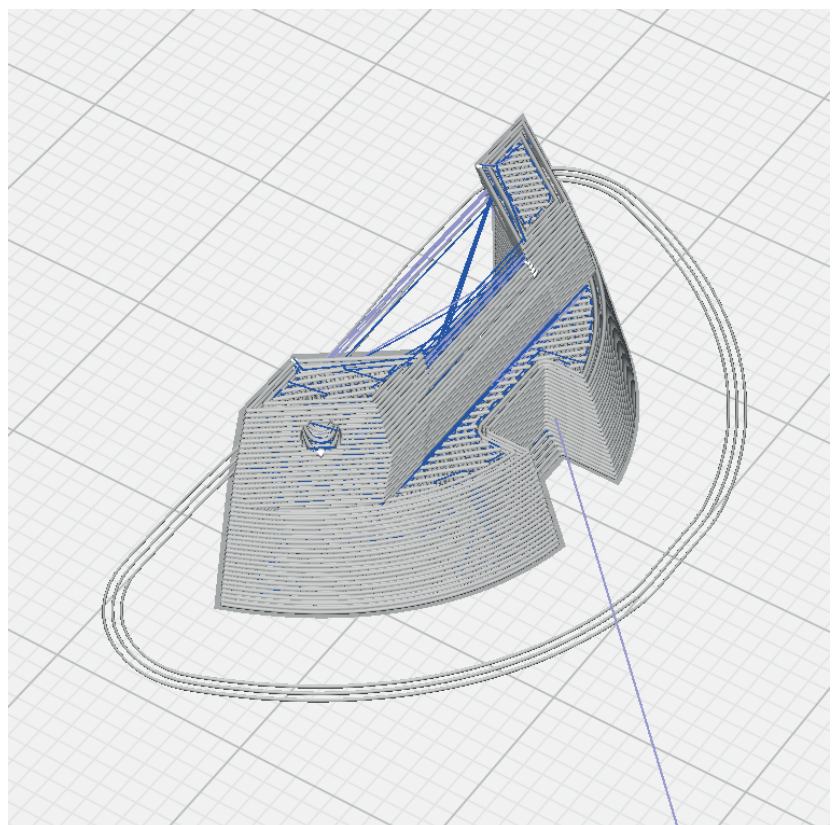
**MATERIAL** LW PLA, Weight: ~ 1 g

**TIME** ~ 4 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.



# 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!

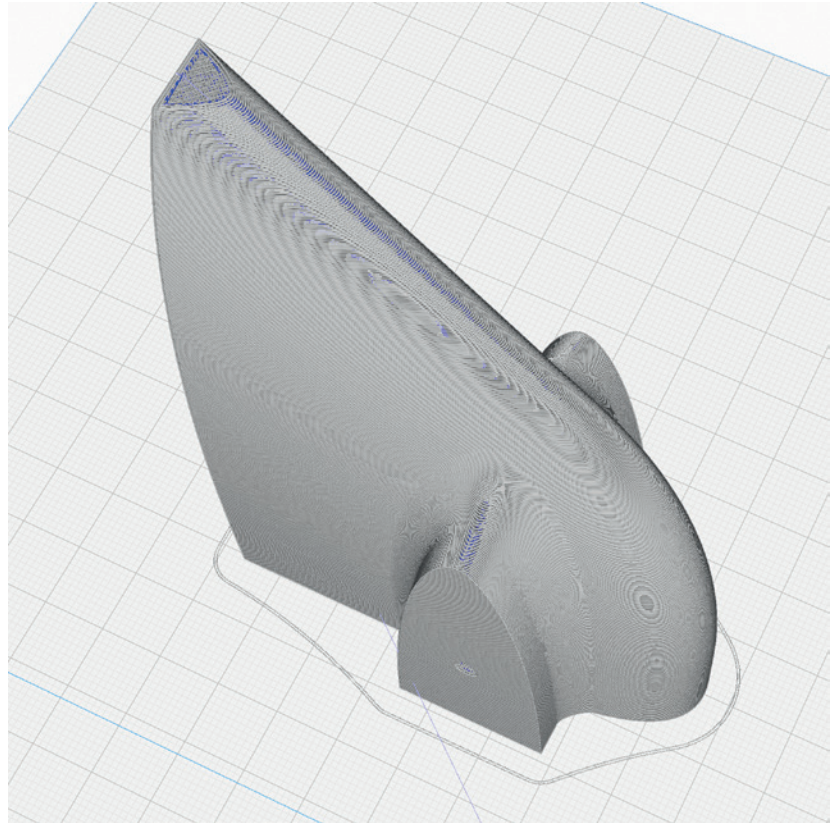
## P5\_FUS 9a\_lj.stl

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

**TIME** ~ 2 hours

### ADDITIONAL SETTINGS

None required



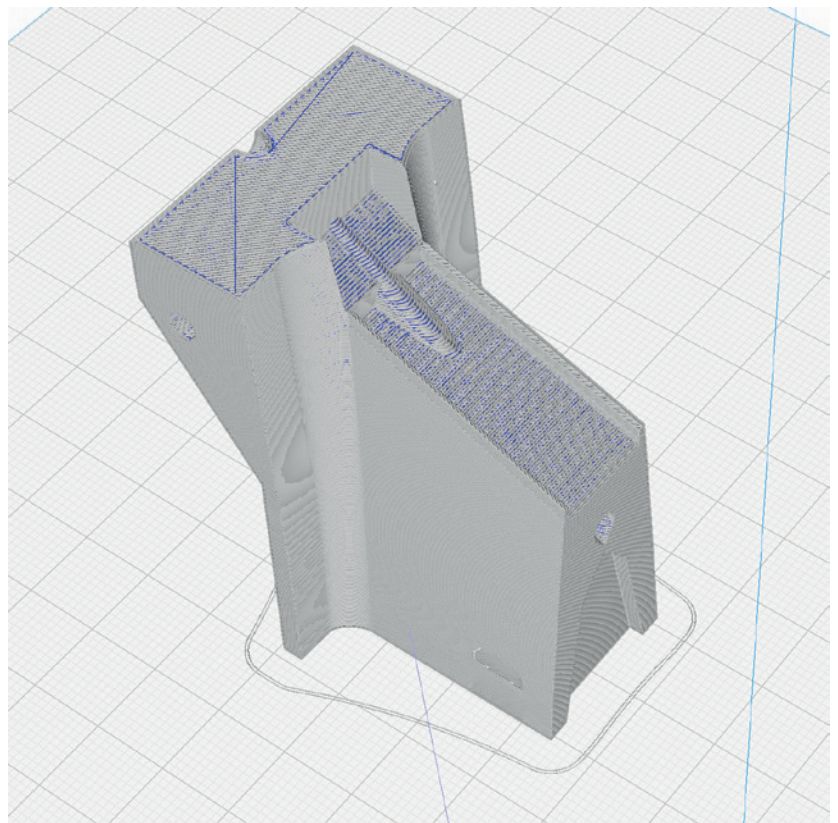
## P5\_FUS 9b\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 6 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!

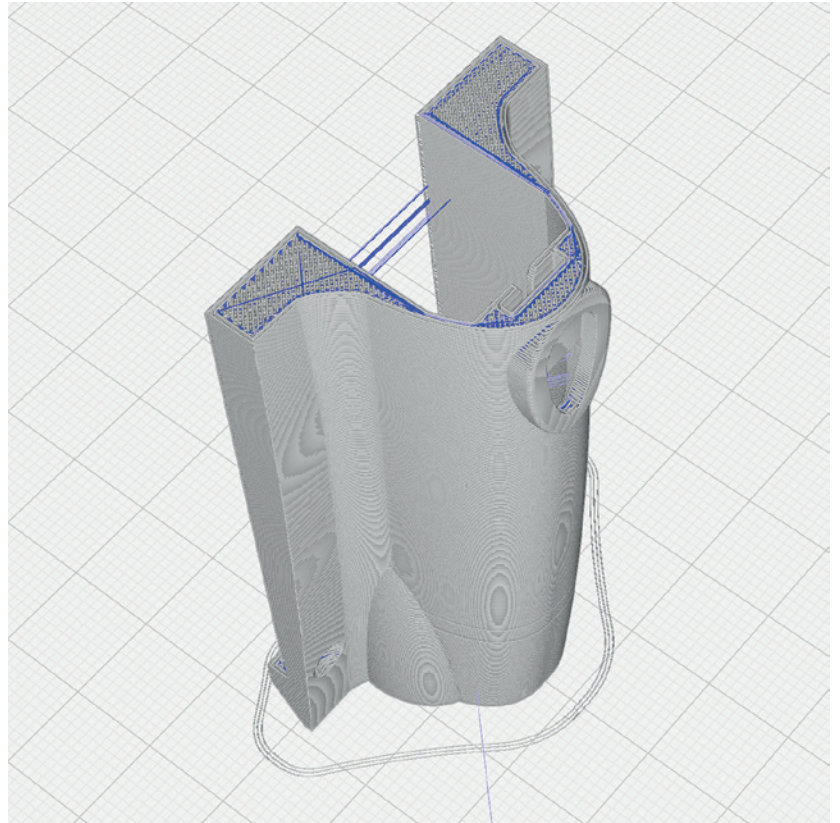
## P5\_FUS 9c\_lj.stl

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

**TIME** ~ 40 minutes

### ADDITIONAL SETTINGS

None required



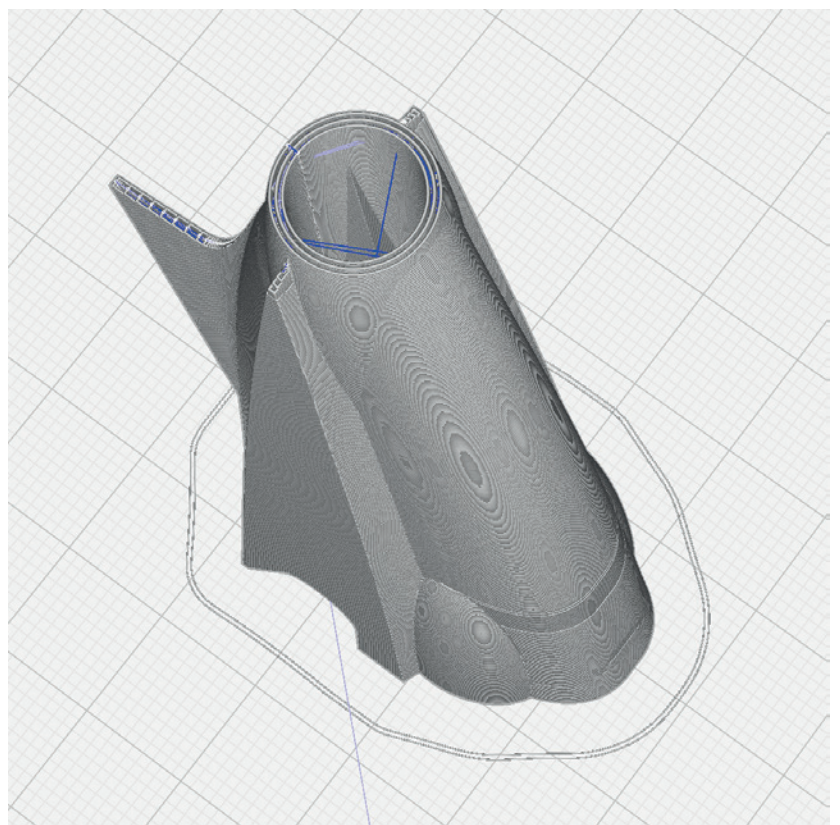
## P5\_FUS 9d\_lj.stl

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

**TIME** ~ 48 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!

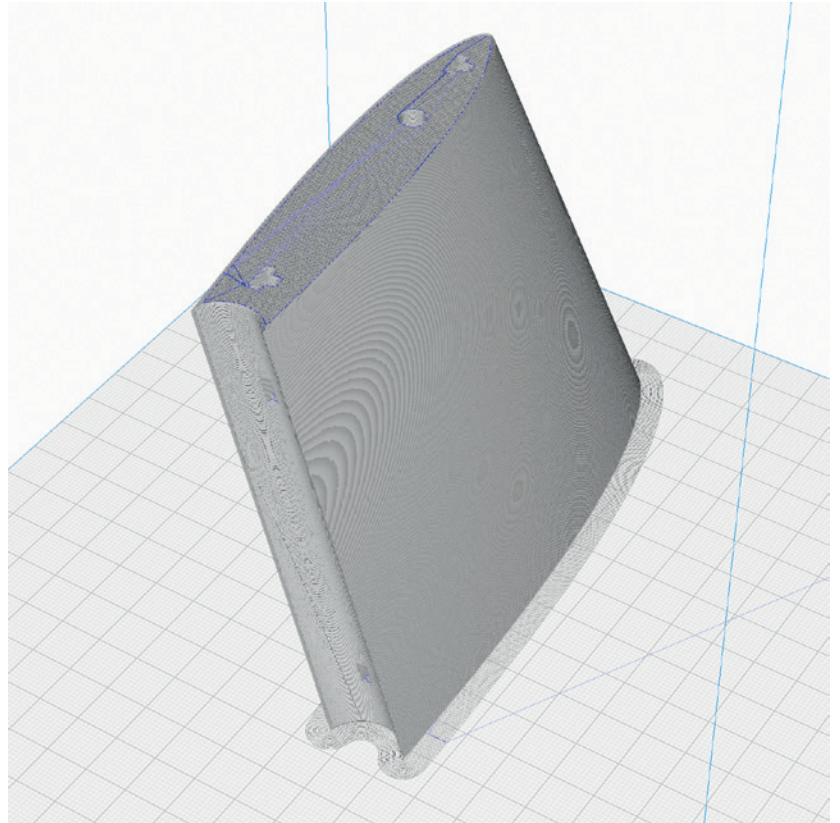
**P5\_HS L1\_lj.stl and  
P5\_HS R1\_lj.stl**

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

**TIME** ~ 4 hours

**ADDITIONAL SETTINGS**

None required



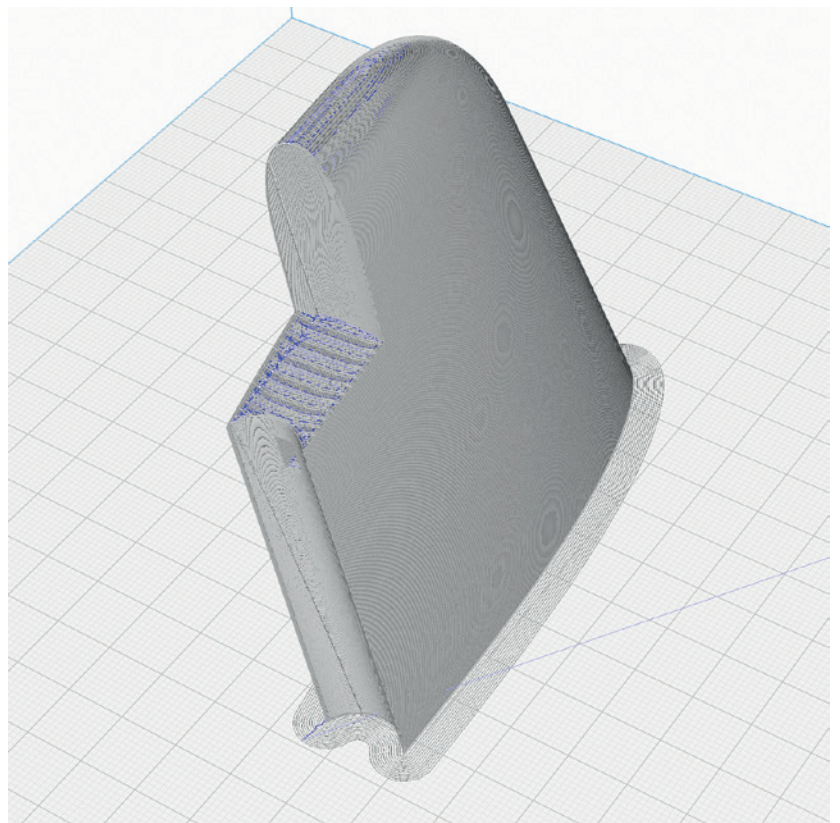
**P5\_HS L2\_lj.stl and  
P5\_HS R2\_lj.stl**

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

**TIME** ~ 1 hour 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!

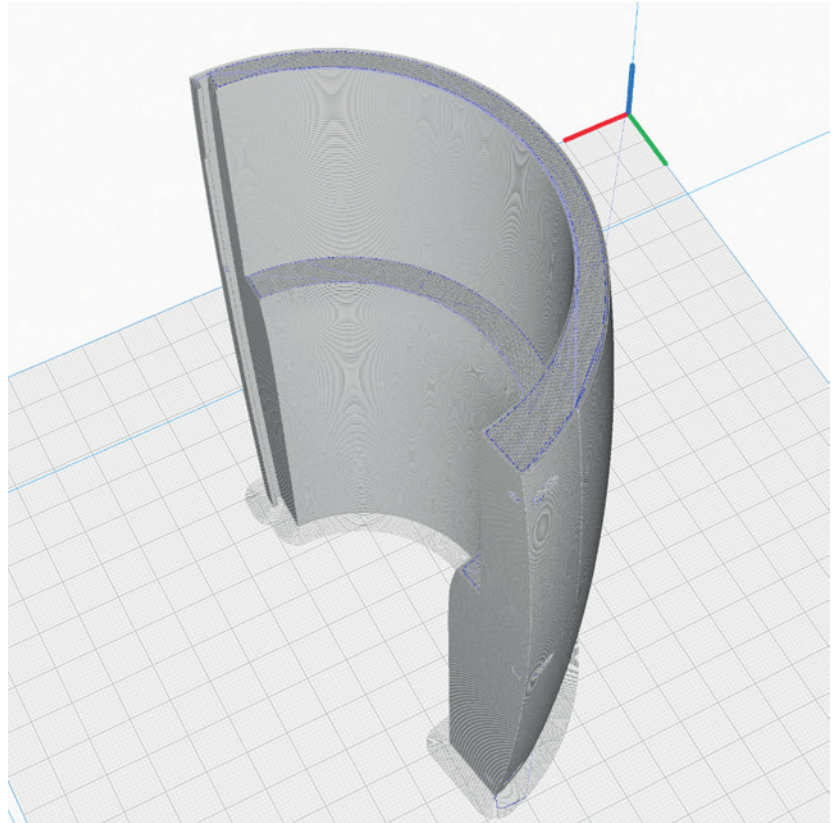
## P5\_Nacelle Cover L\_lj.stl and P5\_Nacelle Cover R\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 23 g

**TIME** ~ 4 hours

### ADDITIONAL SETTINGS

None required



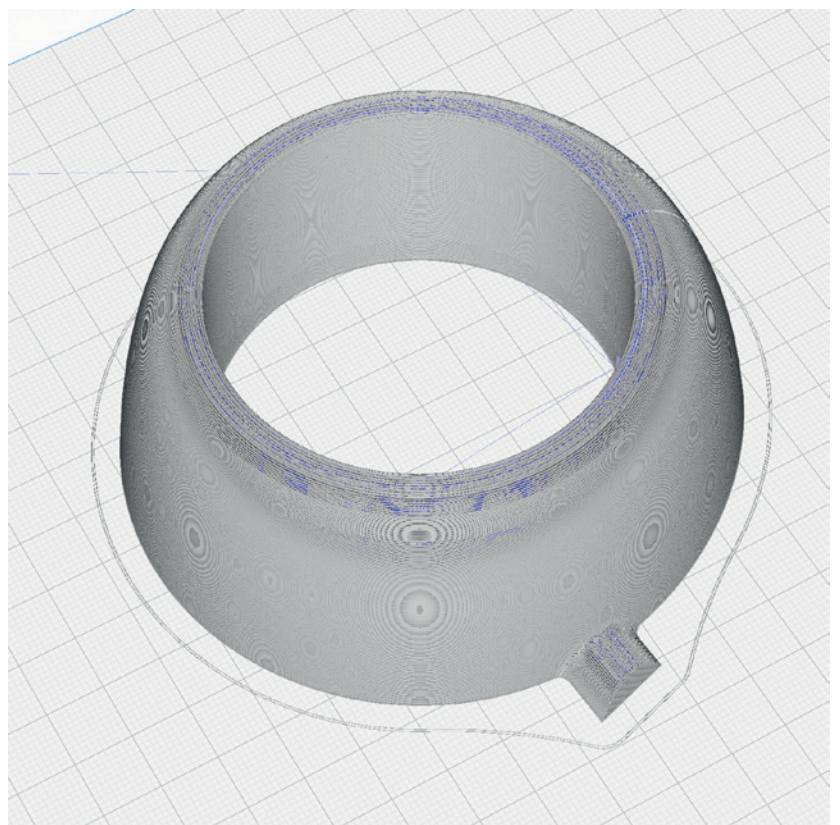
## P5\_Nacelle L1\_lj.stl and P5\_Nacelle R1\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 14 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!

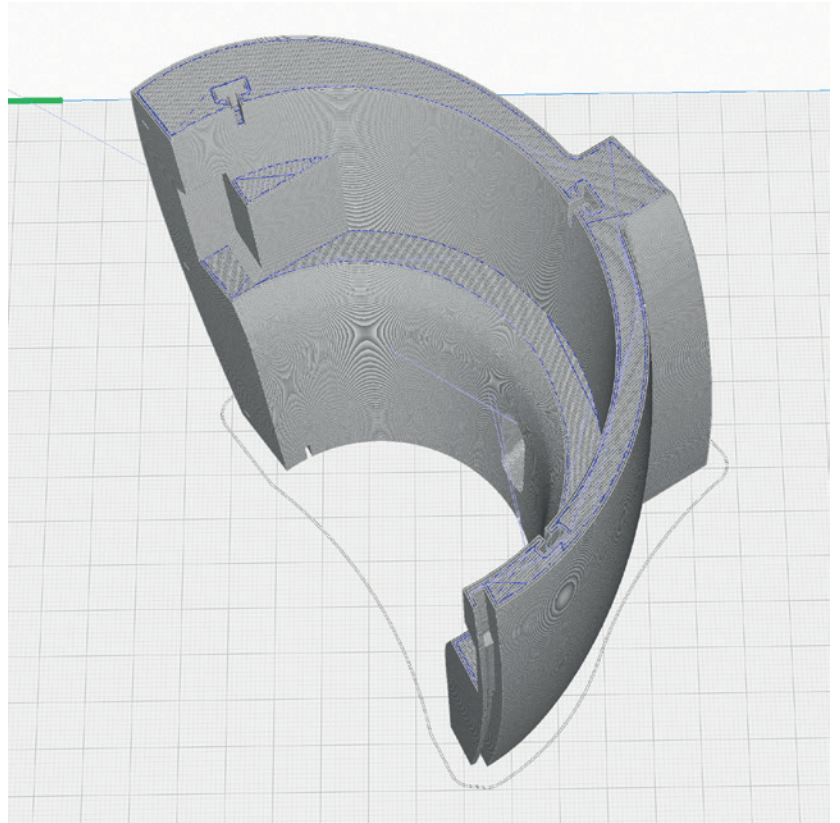
## P5\_Nacelle L2\_lj.stl and P5\_Nacelle R2\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 30 g

**TIME** ~ 5 hours

### ADDITIONAL SETTINGS

None required



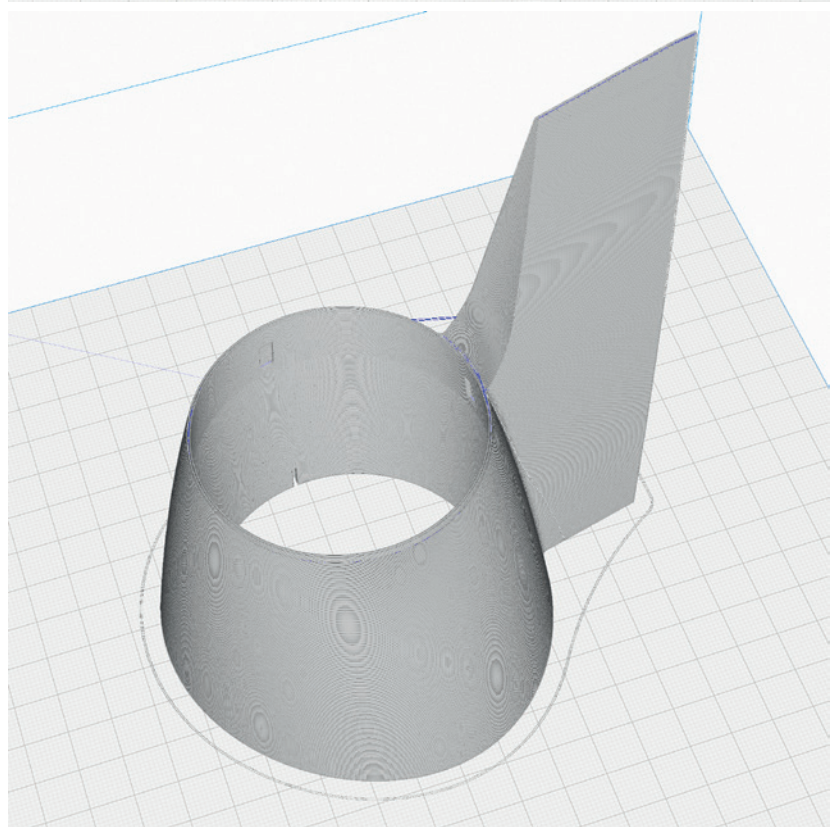
## P5\_Nacelle L3\_lj.stl and P5\_Nacelle R3\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 20 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\_Rudder1\_lj.stl

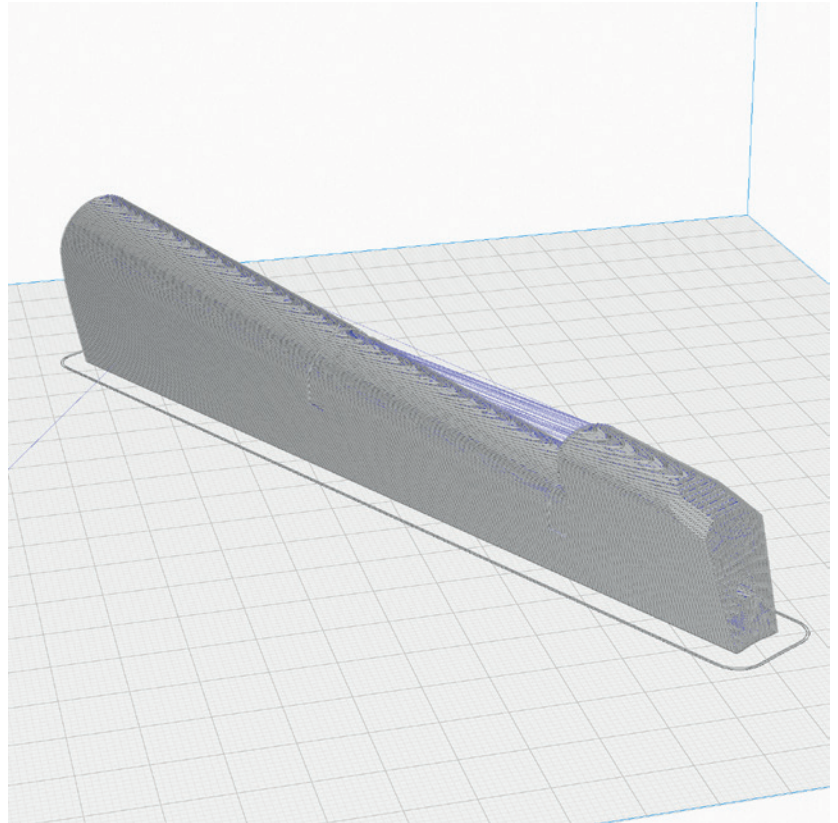
**MATERIAL** LW PLA, Weight: ~ 7 g

**TIME** ~ 1 hour 10 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.



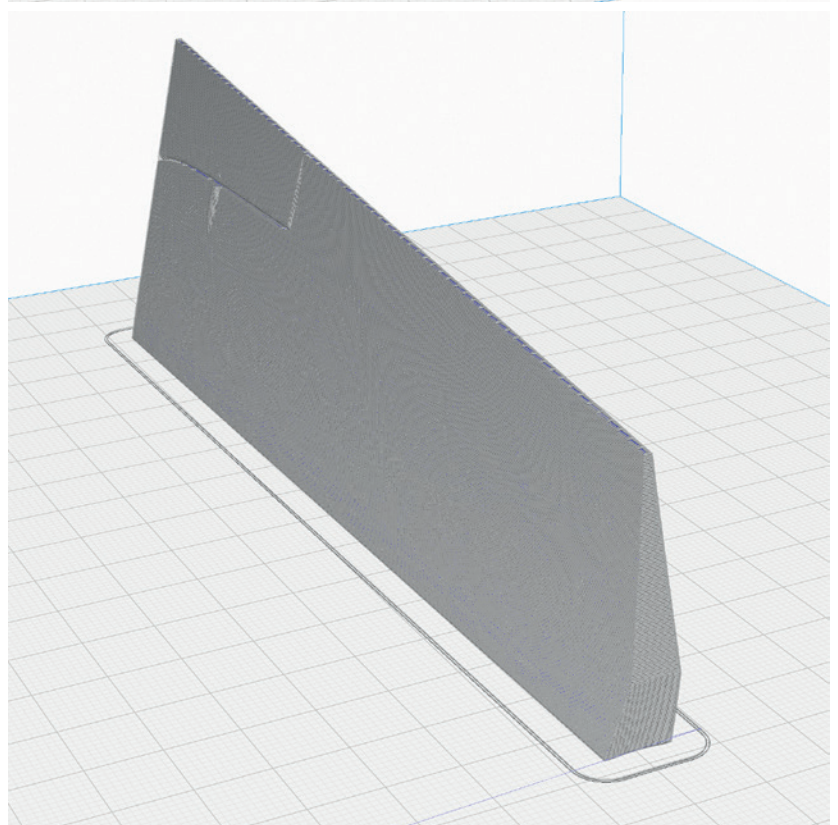
## P5\_Rudder2\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 6 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!

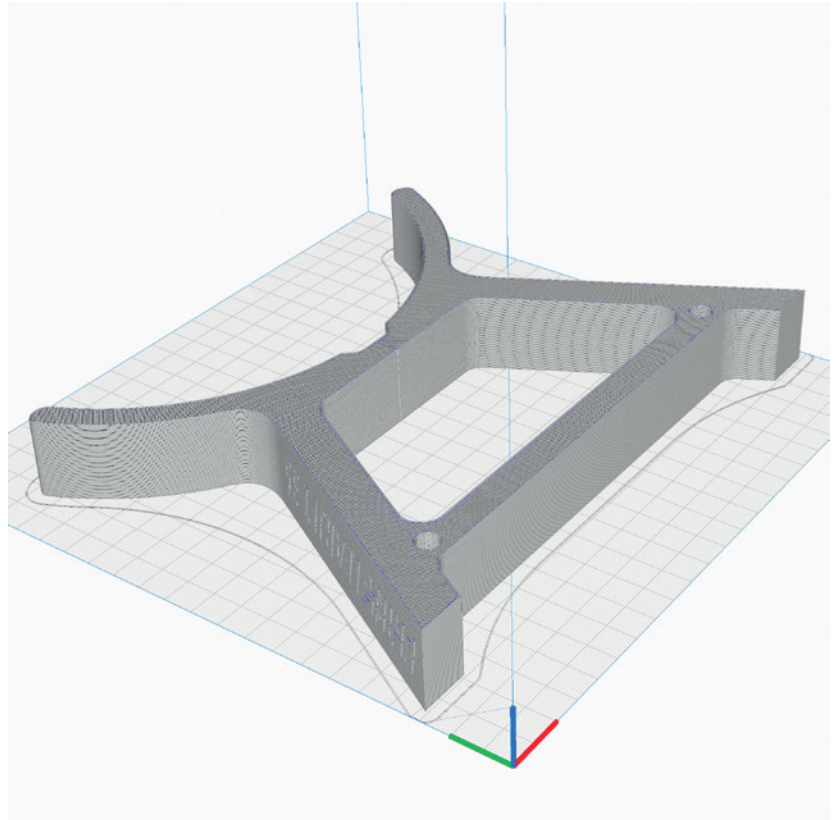
## P5\_Stand1\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 22 g

**TIME** ~ 3 hours 20 minutes

### ADDITIONAL SETTINGS

None required



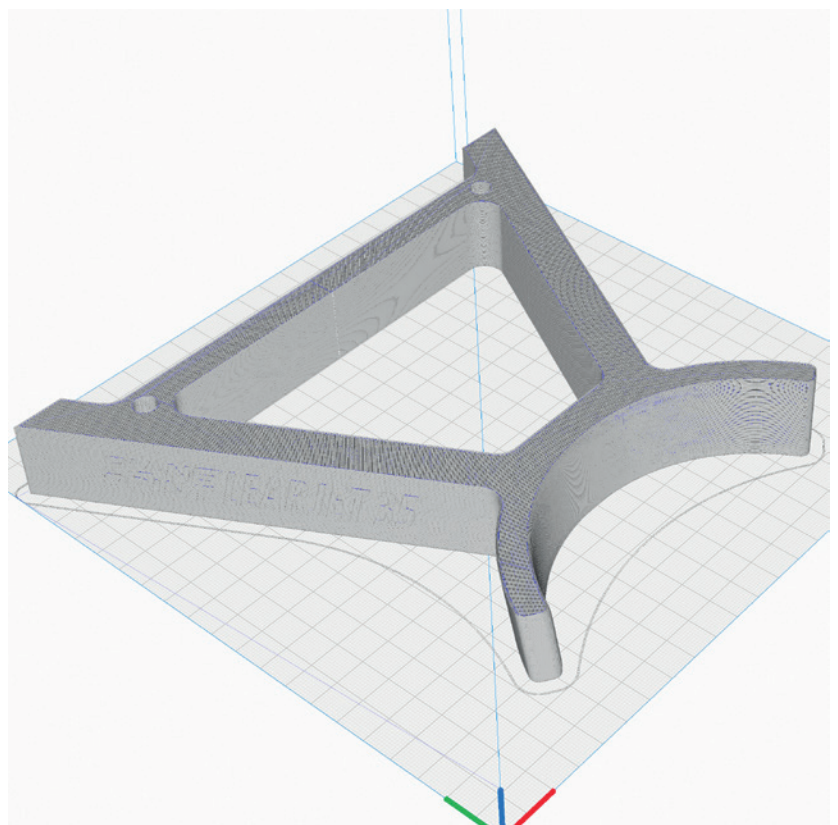
## P5\_Stand2\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 22 g

**TIME** ~ 3 hours 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!

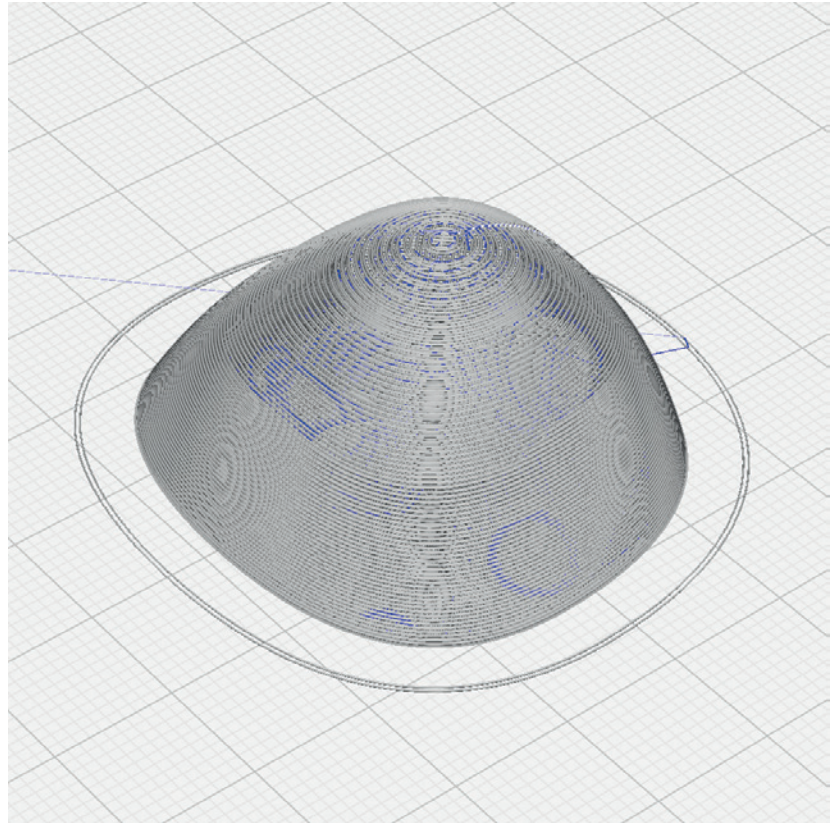
## P5\_Nose\_lj.stl

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

**TIME** ~ 15 minutes

### ADDITIONAL SETTINGS

- Wall Line Count/Perimeters: 2



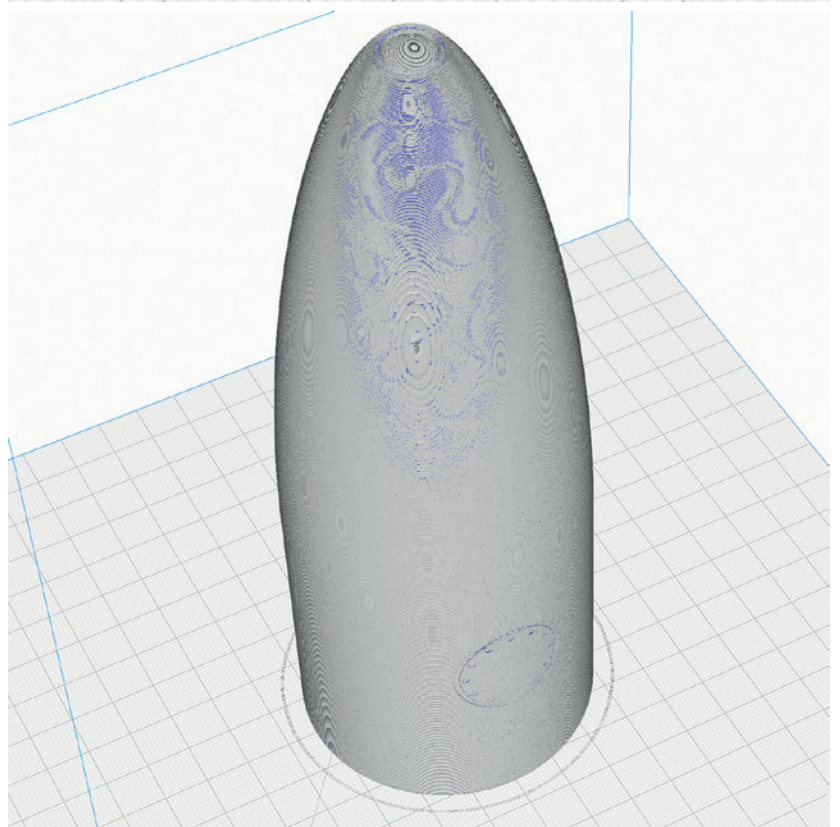
## P5\_Tank L1\_lj.stl and P5\_Tank R1\_lj.stl

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

**TIME** ~ 4 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!

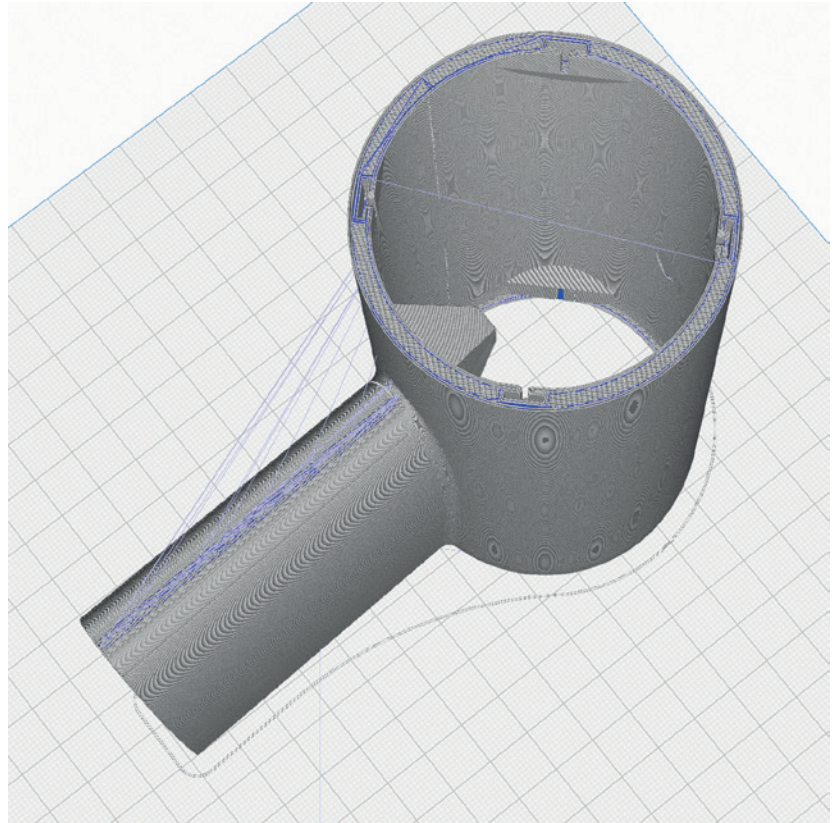
## P5\_Tank L2\_lj.stl and P5\_Tank R2\_lj.stl

**MATERIAL** LW PLA, Weight: ~ 35 g

**TIME** ~ 7 hours

### **ADDITIONAL SETTINGS**

None required



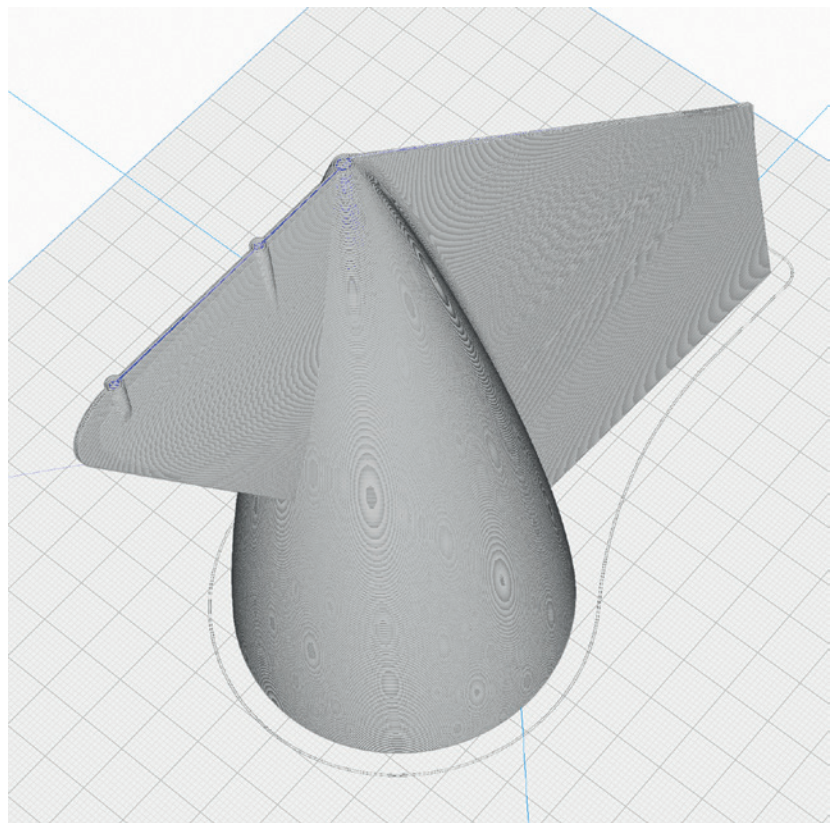
## P5\_Tank L3\_lj.stl and P5\_Tank R3\_lj.stl

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

**TIME** ~ 3 hours 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!

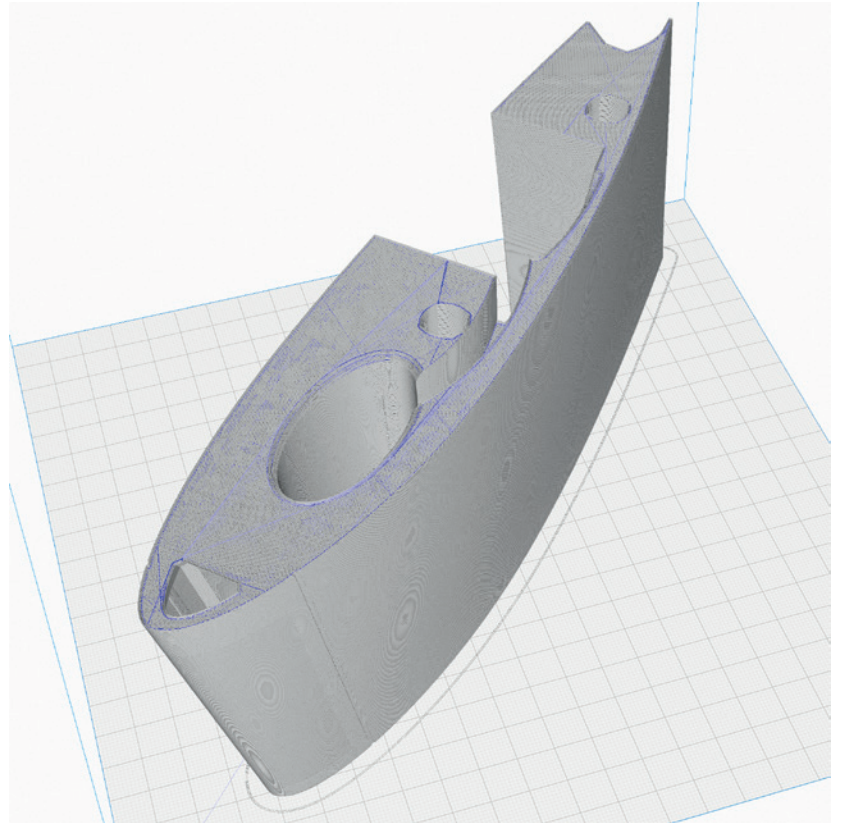
## P5\_Wing L1\_lj.stl and P5\_Wing R1\_lj

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

**TIME** ~ 7 hours 30 minutes

### **ADDITIONAL SETTINGS**

None required



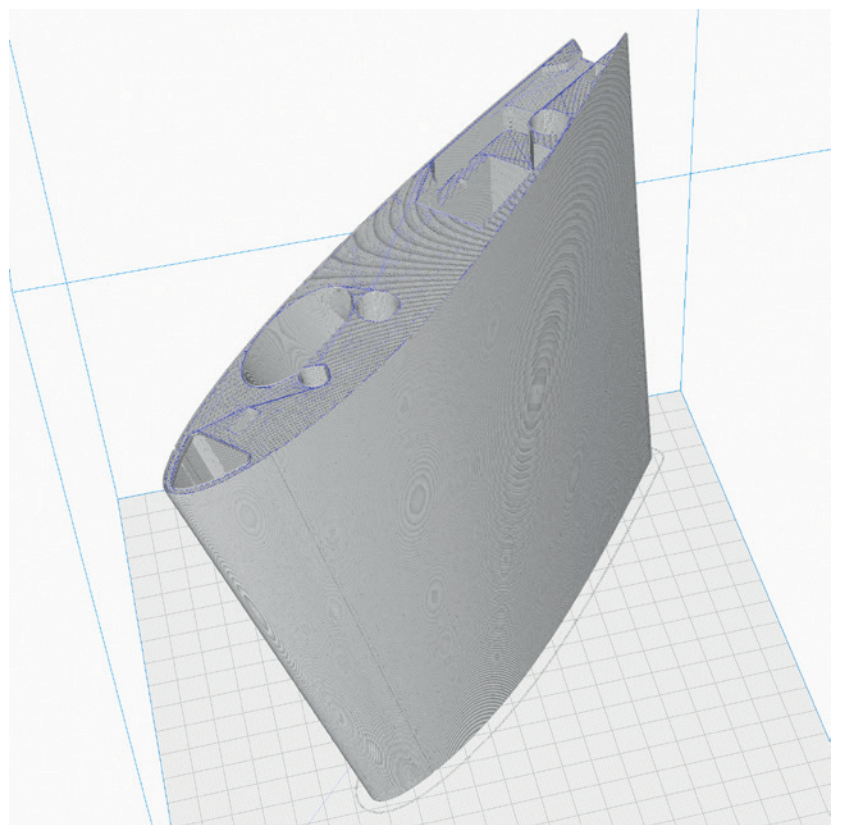
## P5\_Wing L2\_lj.stl and P5\_Wing R2\_lj

**MATERIAL** LW PLA, Weight: ~ 75 g

**TIME** ~ 12 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!

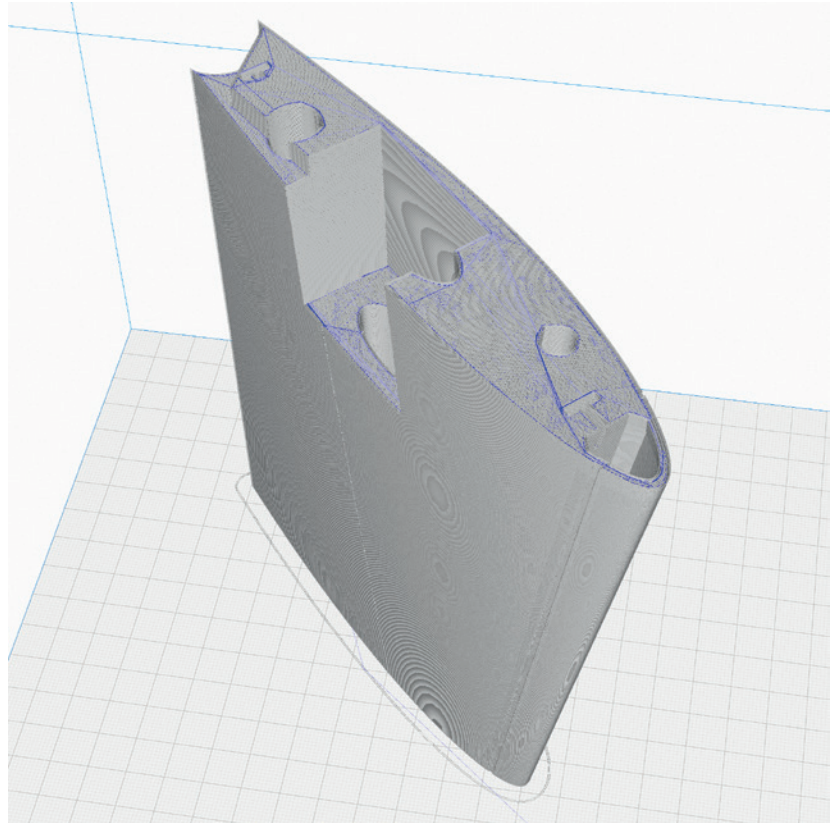
P5\_Wing L3\_lj.stl and  
P5\_Wing R3\_lj

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

**TIME** ~ 7 hours

**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.

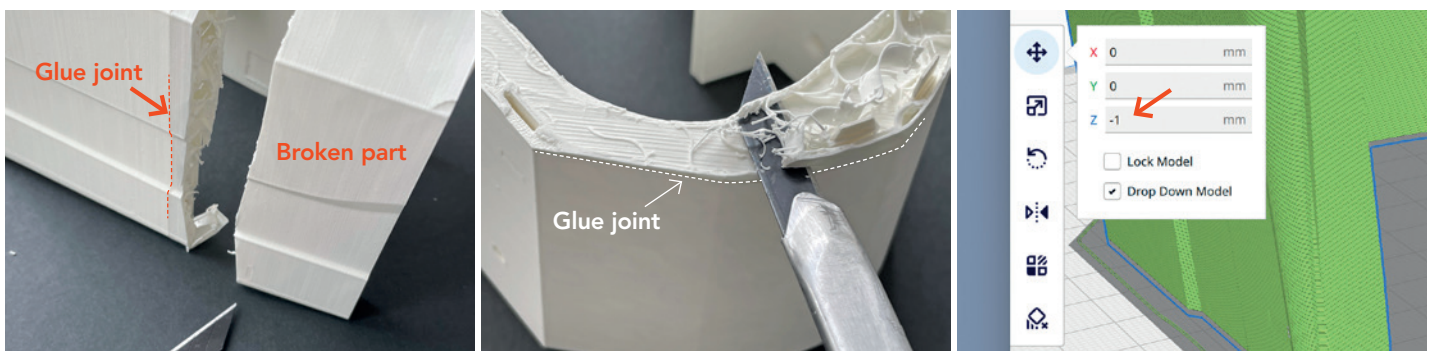
After assembly, **align the two parts exactly** and wipe off the excess CA glue from the surface with a cloth. Now spray with activator spray along the gluing surface and carefully press the parts together.

- 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.



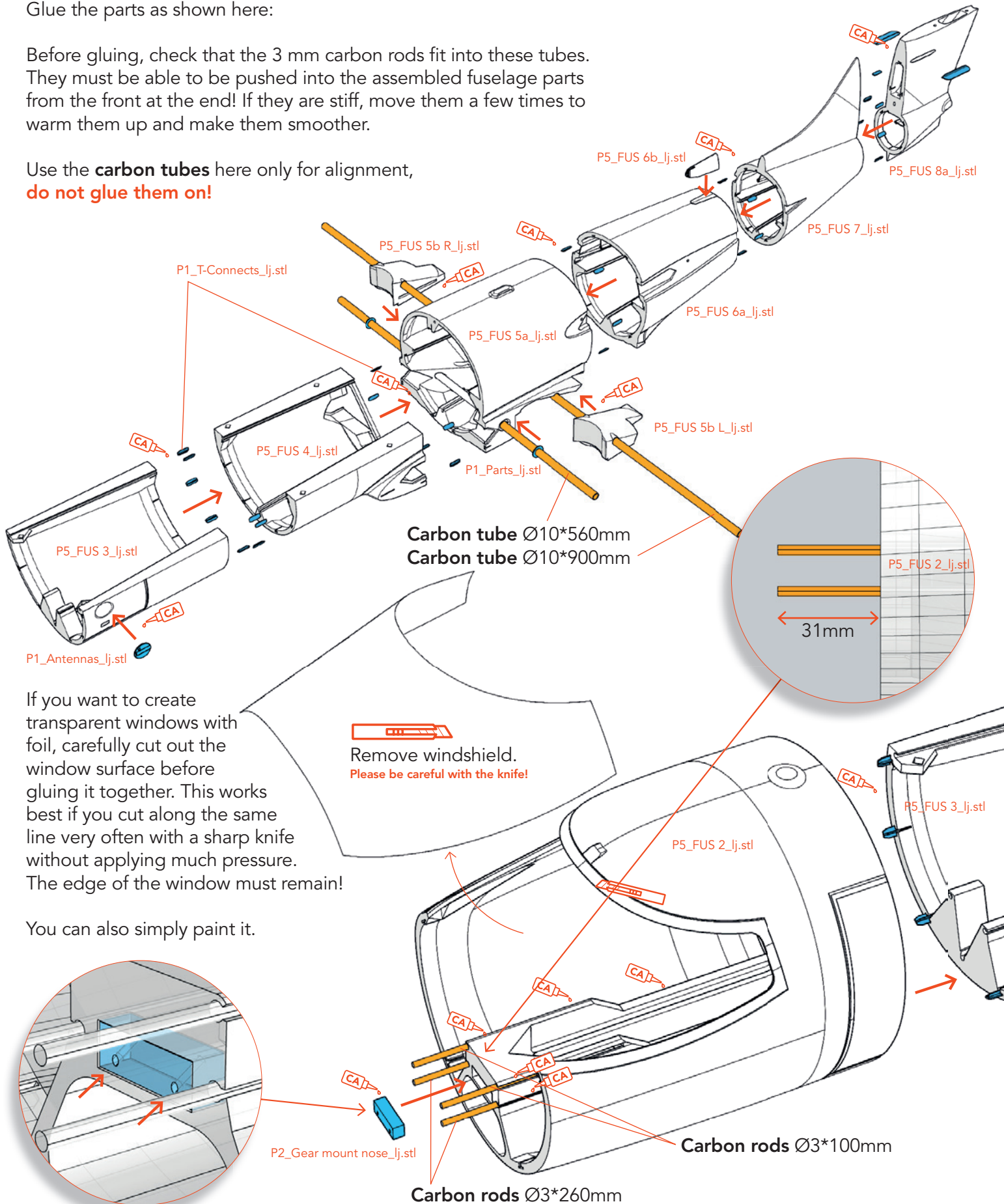
# Fuselage assembly

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

Glue the parts as shown here:

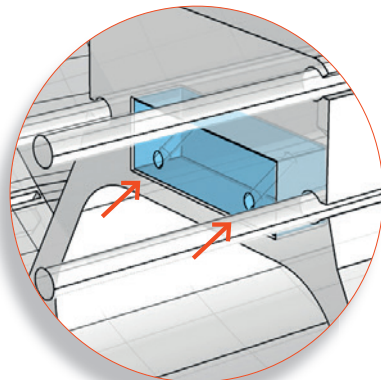
Before gluing, check that the 3 mm carbon rods fit into these tubes. They must be able to be pushed into the assembled fuselage parts from the front at the end! If they are stiff, move them a few times to warm them up and make them smoother.

Use the **carbon tubes** here only for alignment, **do not glue them on!**



If you want to create transparent windows with foil, carefully cut out the window surface before gluing it together. This works best if you cut along the same line very often with a sharp knife without applying much pressure. The edge of the window must remain!

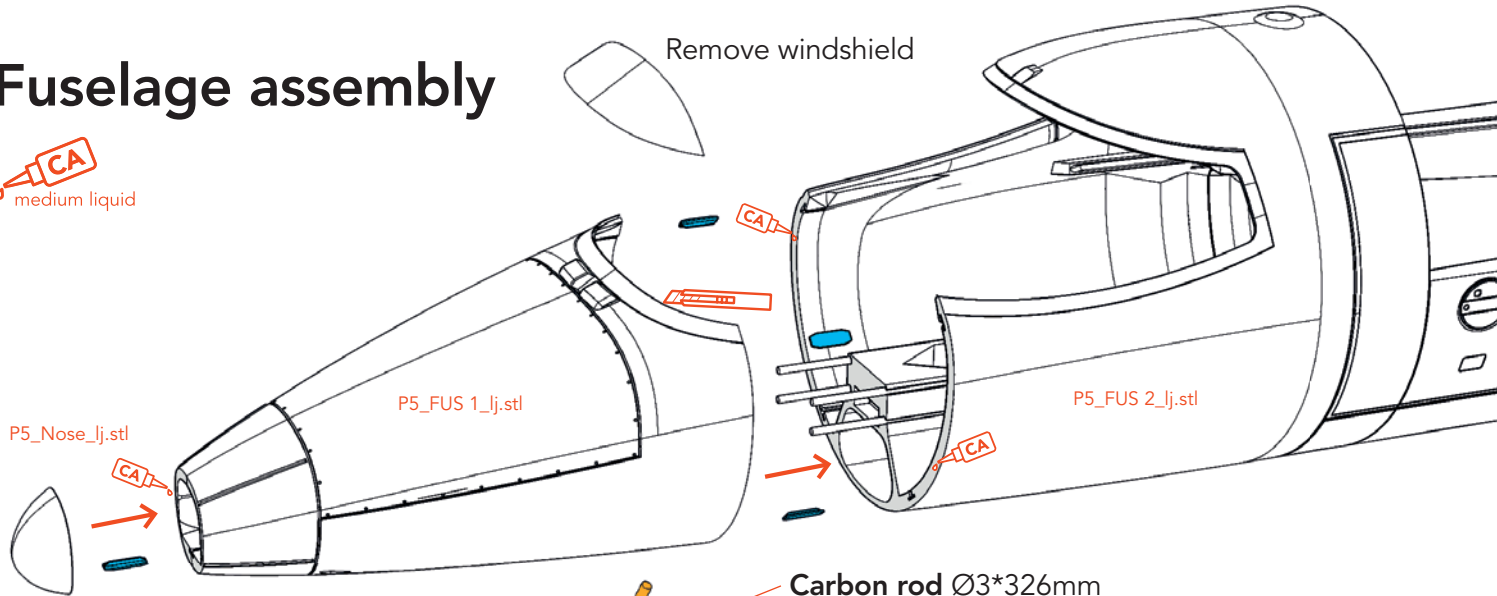
You can also simply paint it.



# Fuselage assembly

**CA**  
medium liquid

Remove windshield



P5\_Nose\_lj.stl

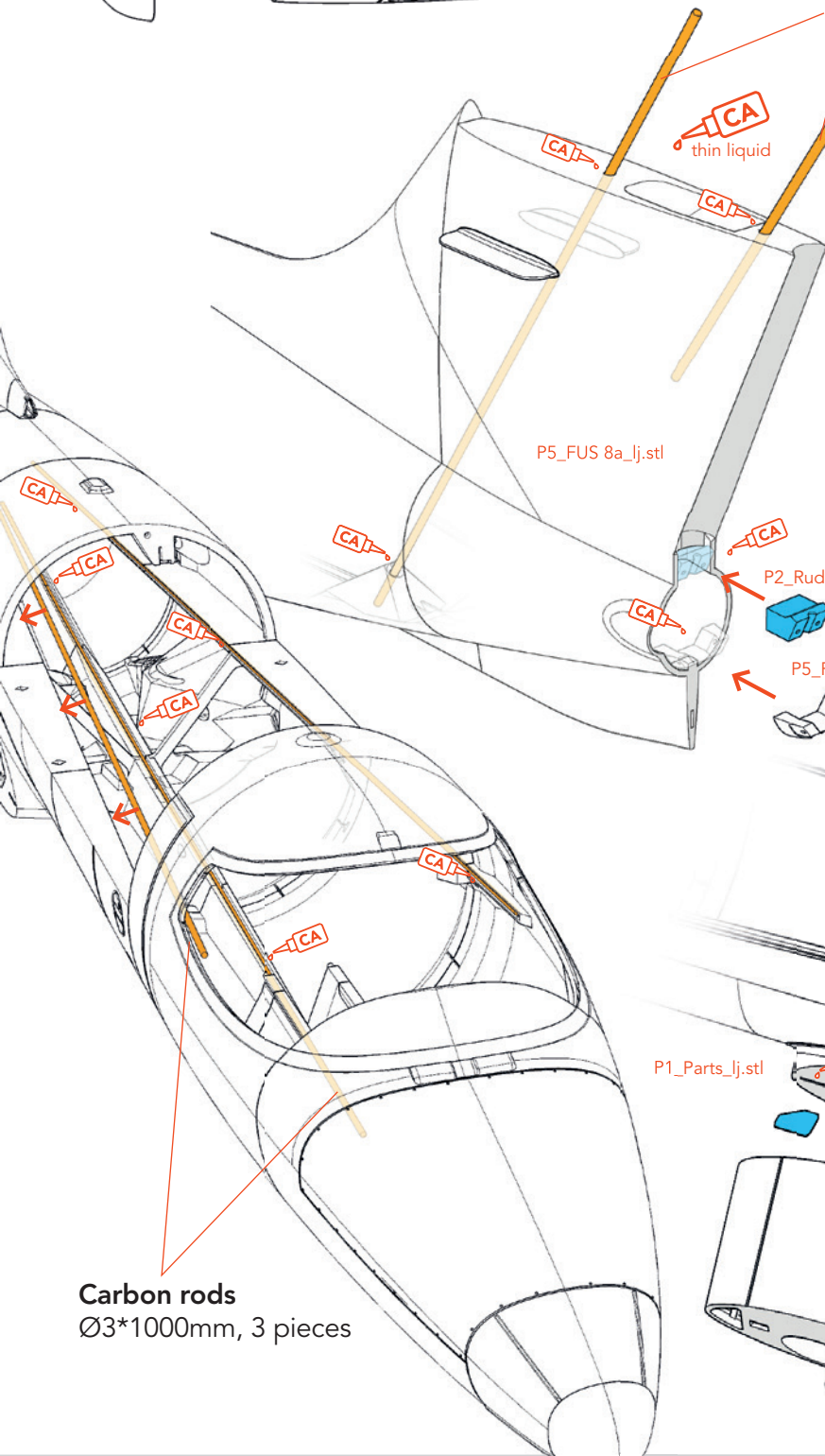
P5\_FUS 1\_lj.stl

P5\_FUS 2\_lj.stl

Carbon rod  $\varnothing 3 \times 326 \text{mm}$   
Carbon rod  $\varnothing 3 \times 126 \text{mm}$

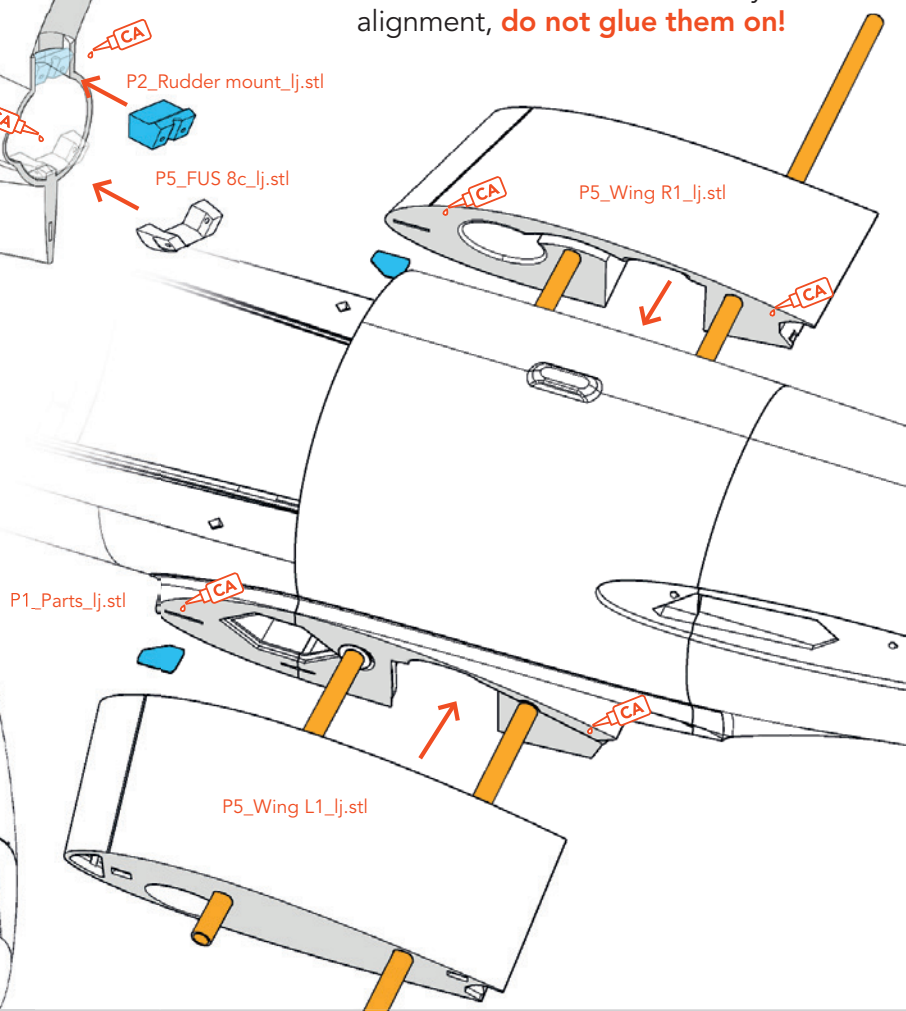
**CA**  
thin liquid

First insert the rods into the fuselage and then let thin CA glue run into them from above. There are channels for the glue. Be sure to also glue the front rod to the bottom of the fuselage 7.



P5\_FUS 8a\_lj.stl

Use the **carbon tubes** here only for alignment, **do not glue them on!**



P2\_Rudder mount\_lj.stl

P5\_FUS 8c\_lj.stl

P5\_Wing R1\_lj.stl

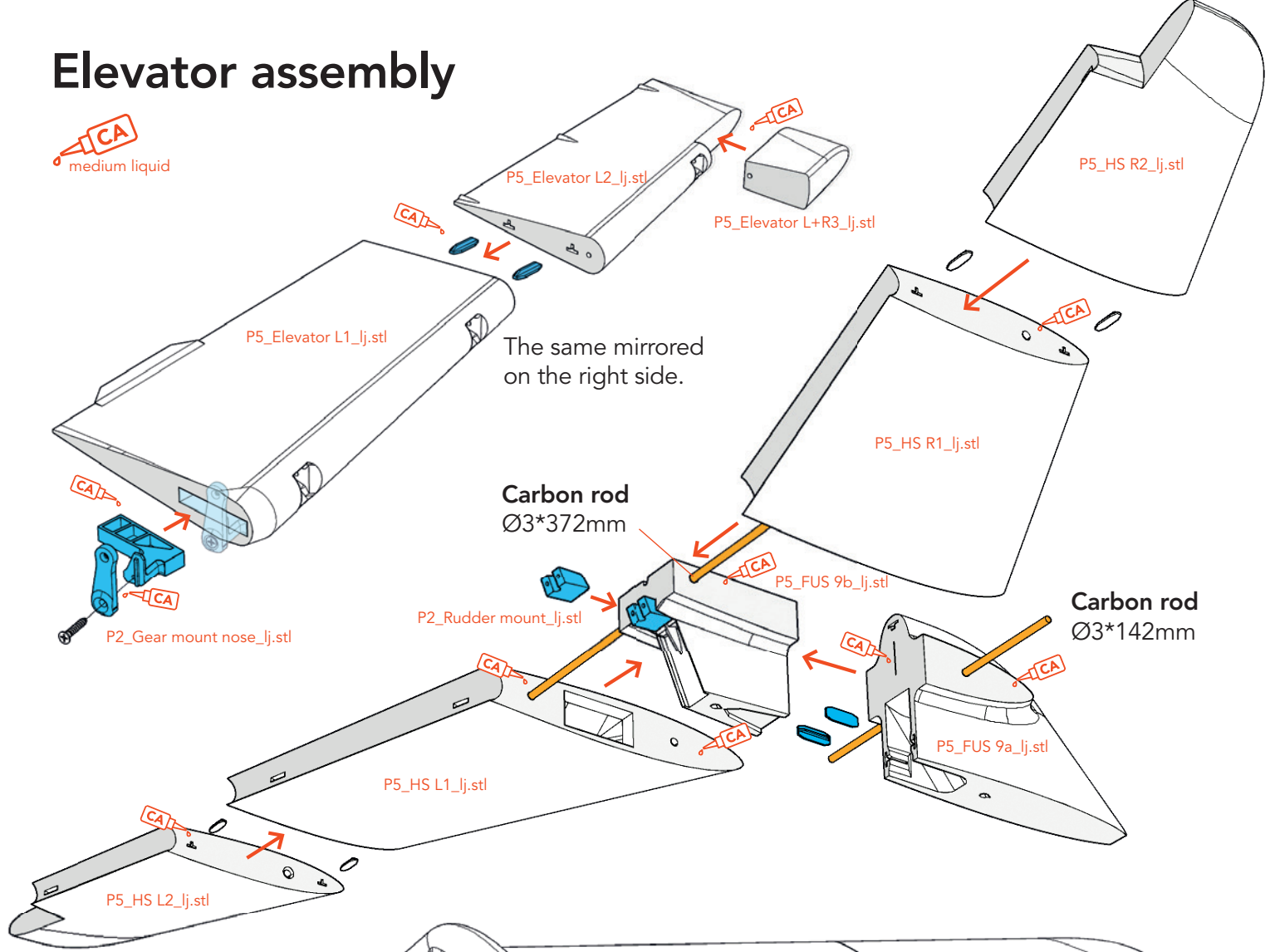
P1\_Parts\_lj.stl

P5\_Wing L1\_lj.stl

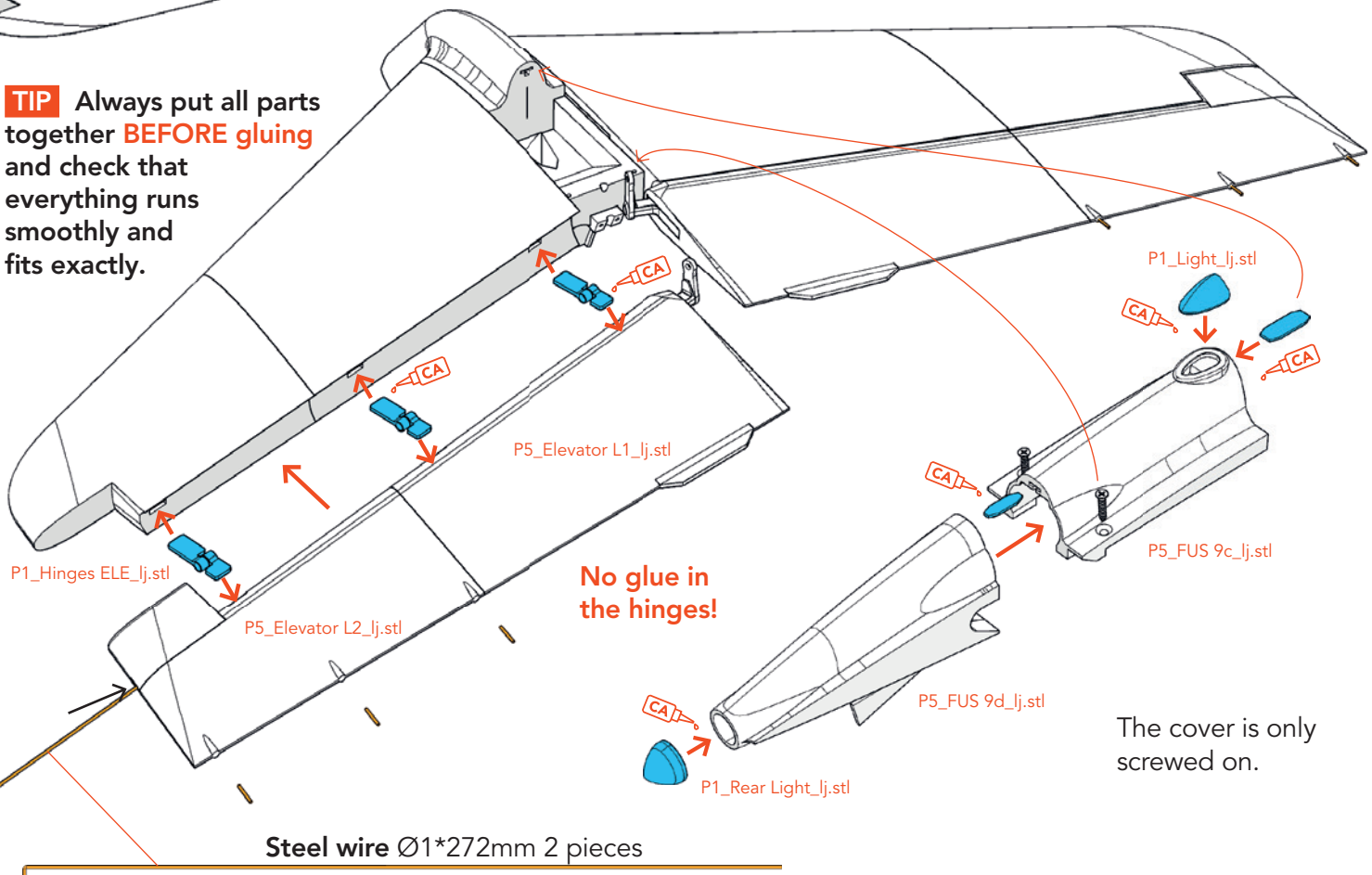
Carbon rods  
 $\varnothing 3 \times 1000 \text{mm}$ , 3 pieces

# Elevator assembly

 medium liquid



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



Steel wire Ø1\*272mm 2 pieces

# Elevator Servo

**NOTE** It is very important that the elevator linkage has **NO play**, otherwise rudder flutter can occur, which can **destroy the entire tail!** Too much play can be caused by too thin wire in the hinge or too large holes in the horns or cheap servos.

If you prefer to operate the elevator with two separate servos (safer against flutter and redundant in the event of servo failure), you will find the STL for this in the **FREE TUNING PARTS** on our website.

Mount the servo mount parts on the servo exactly as shown in the picture and glue it firmly in place with the lower brackets.

Make sure that the hole of the rod connection is exactly in the center!

Rod connection

P1\_Servo mount RUD ELE\_lj.stl

Steel wire  $\varnothing 1 \times 60\text{mm}$  2 pieces

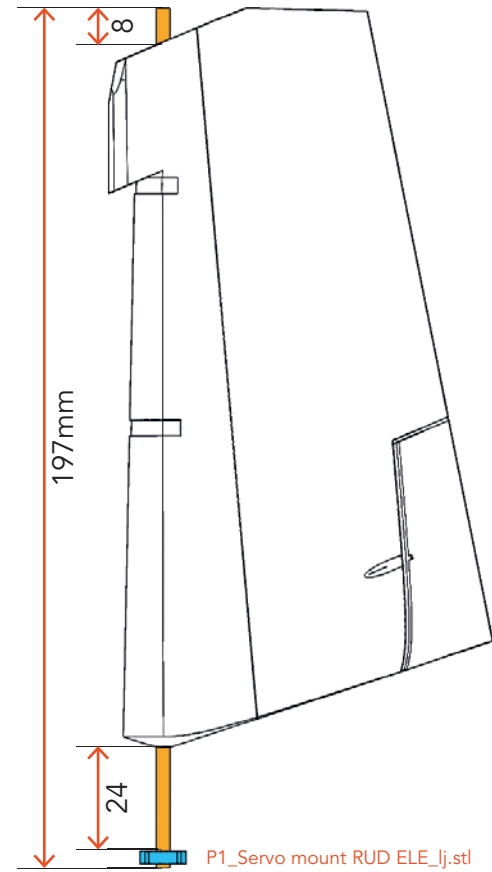
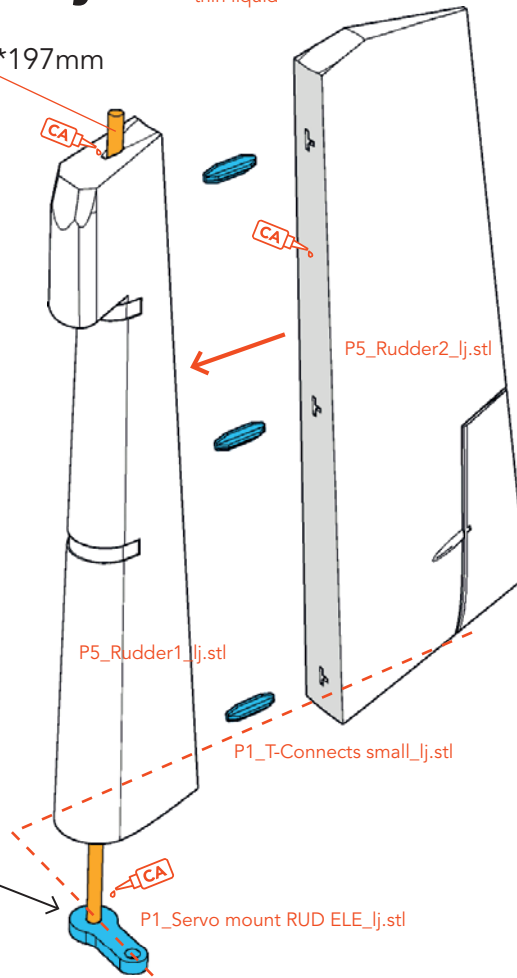
Position the two elevators exactly the same and fix the two linkages with the rod connection.

# Rudder assembly

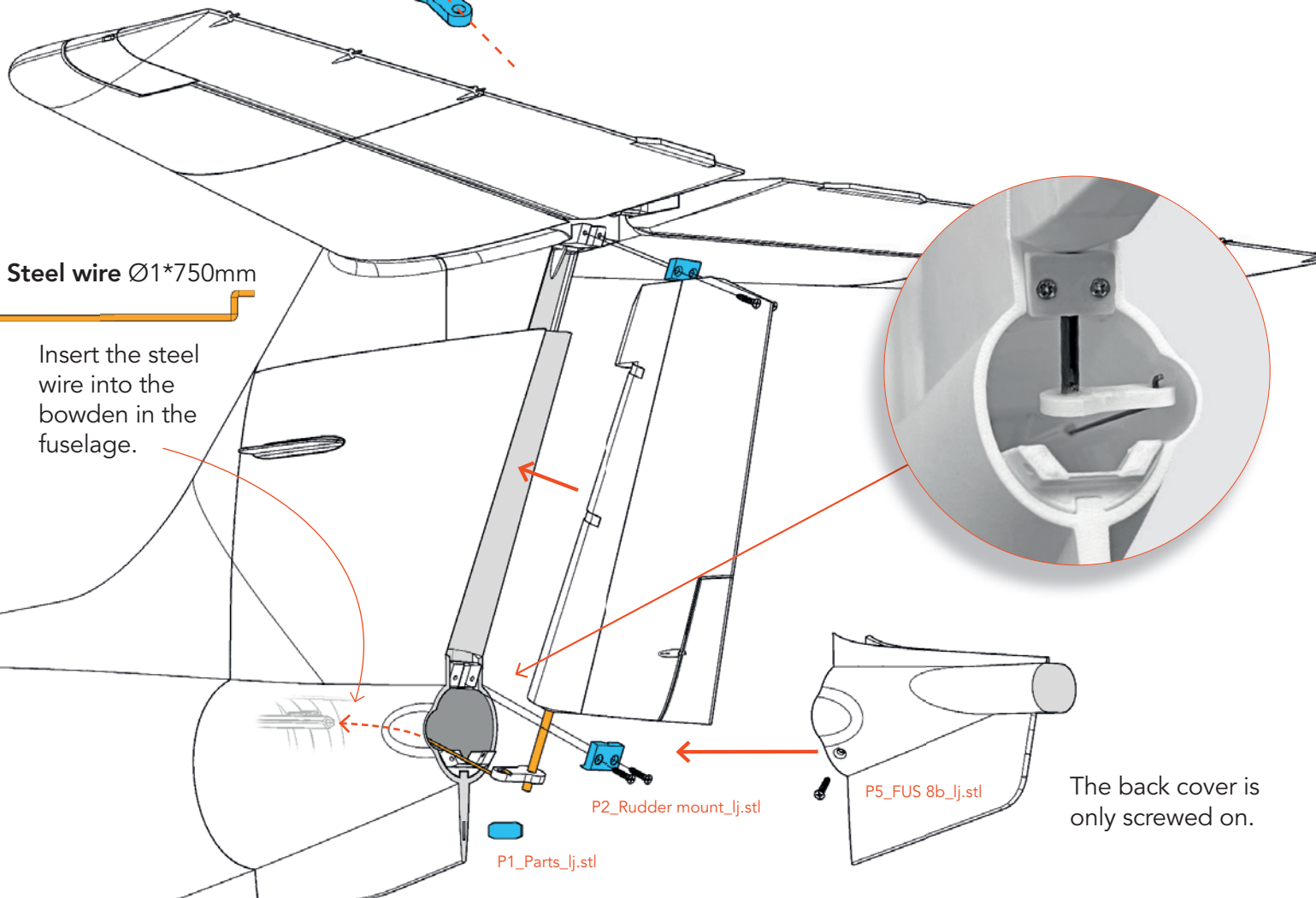


Carbon rod  $\varnothing 3 \times 197 \text{mm}$

Assemble the rudder as shown and pay attention to the exact position of the parts on the carbon rod.



This lever must be at exactly  $90^\circ$  to the rudder.

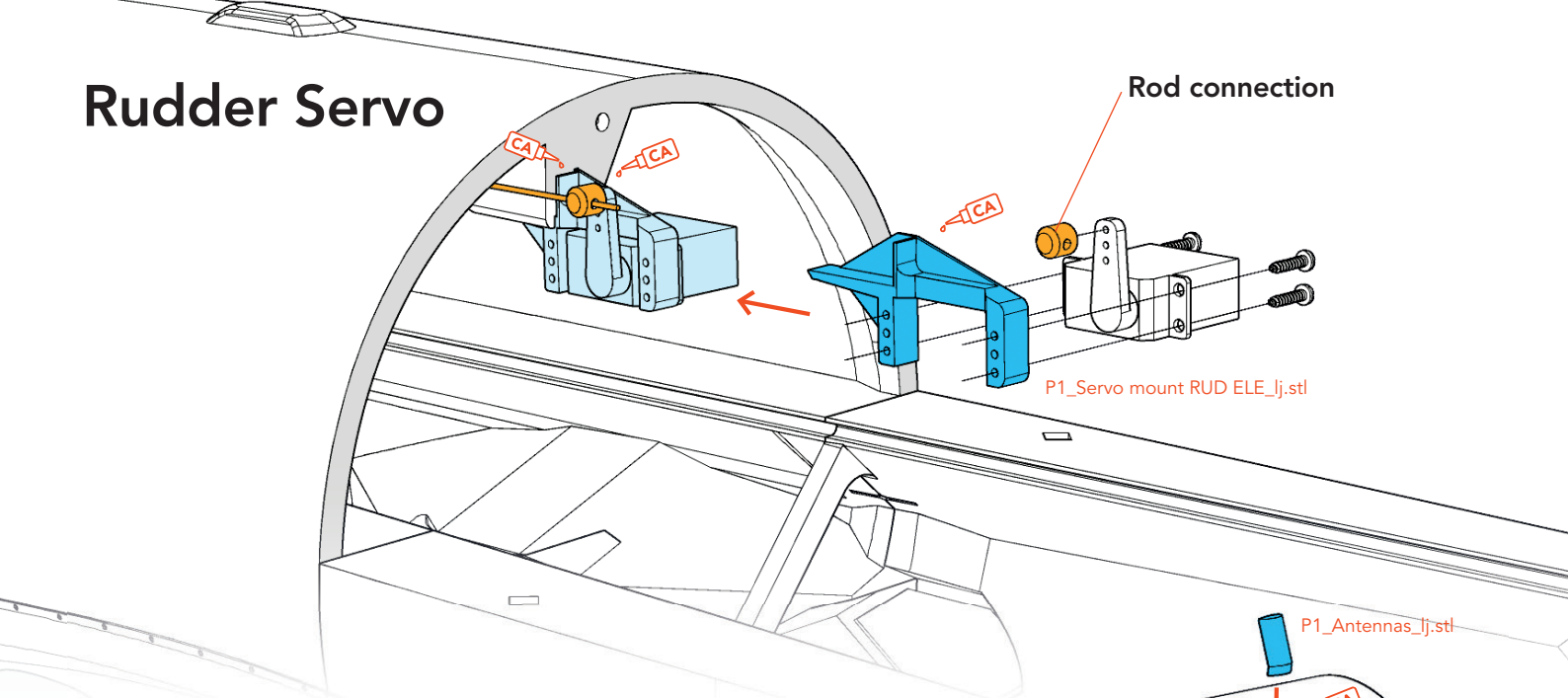


Steel wire  $\varnothing 1 \times 750 \text{mm}$

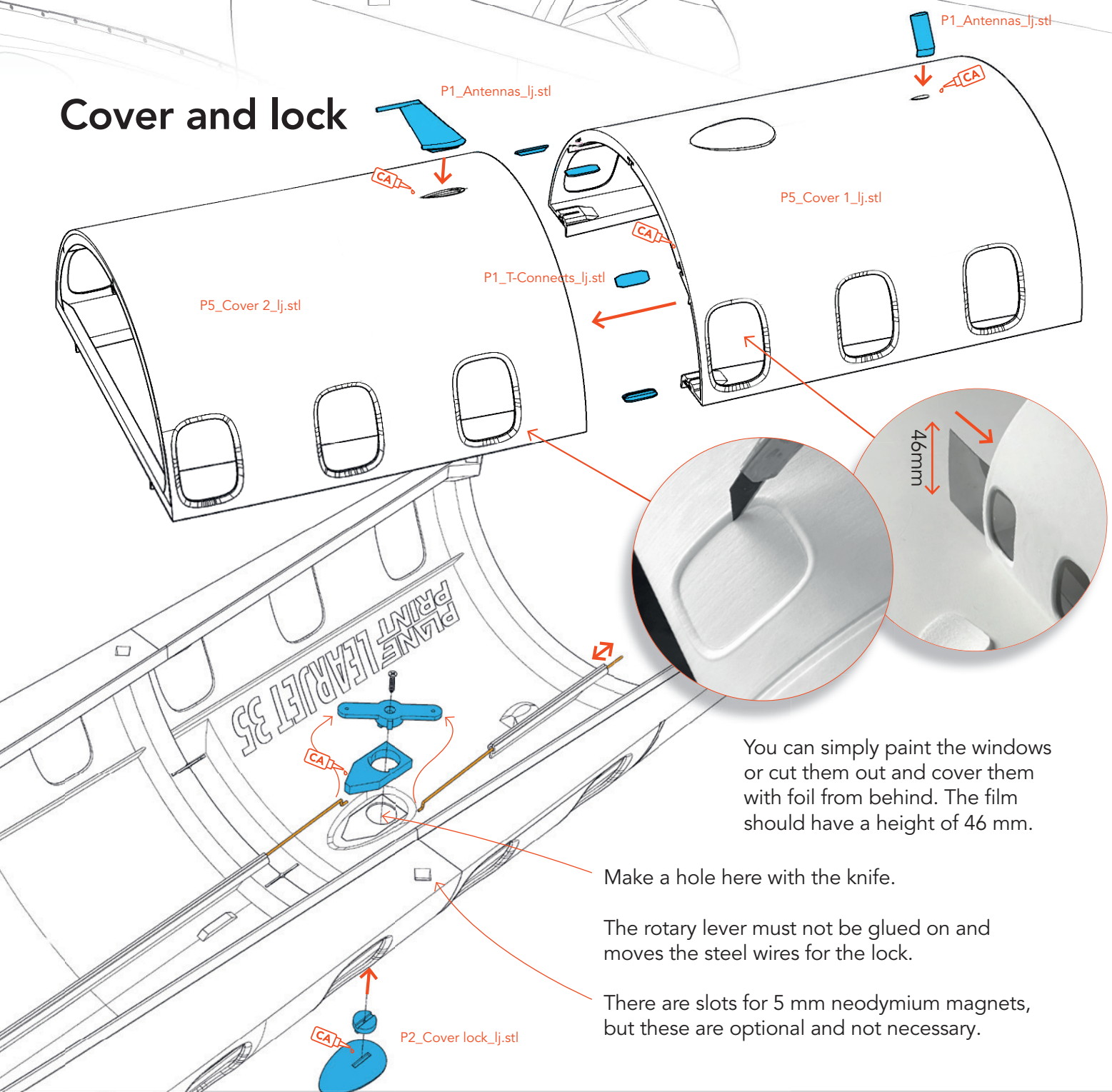
Insert the steel wire into the bowden in the fuselage.

The back cover is only screwed on.

# Rudder Servo



# Cover and lock



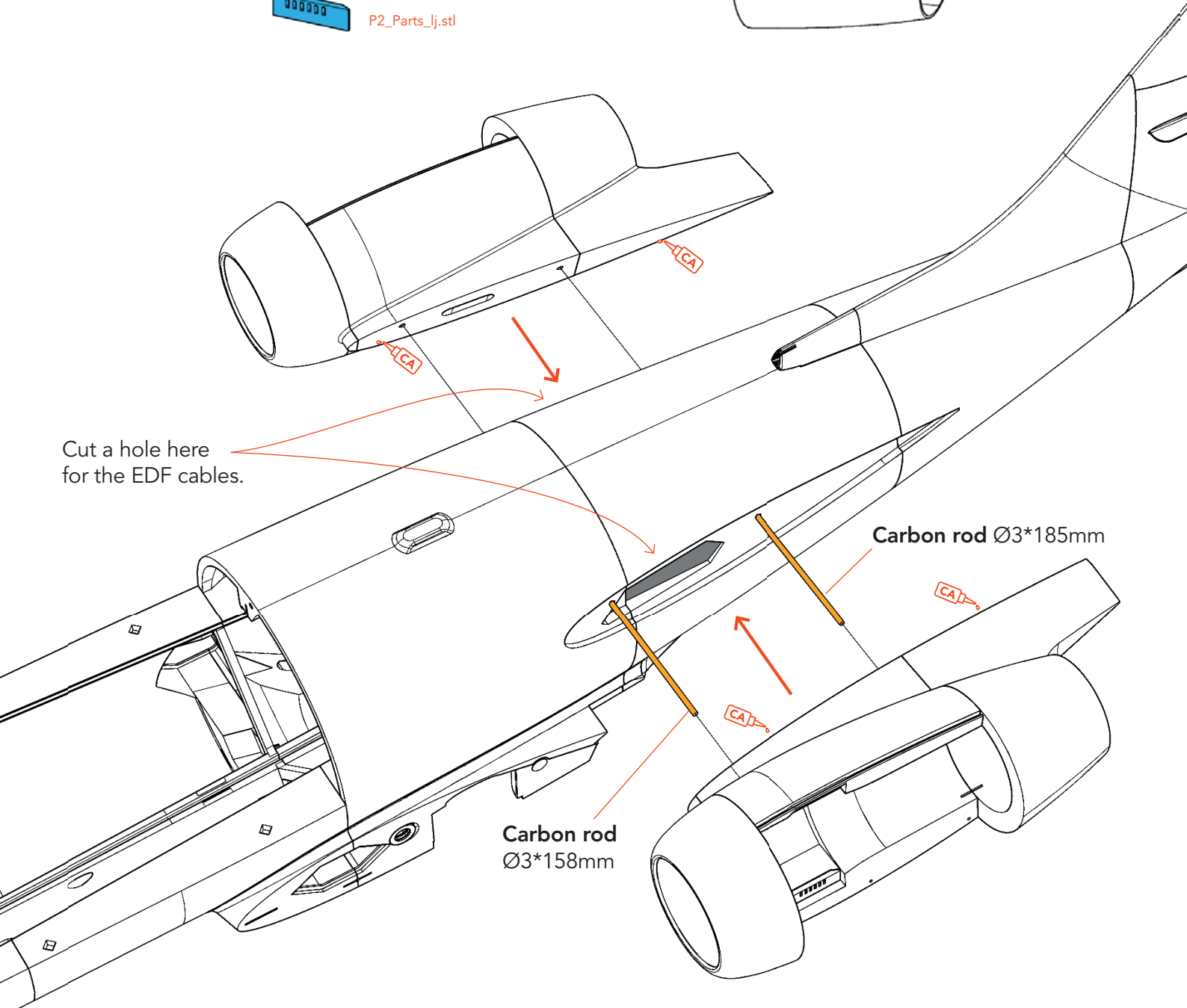
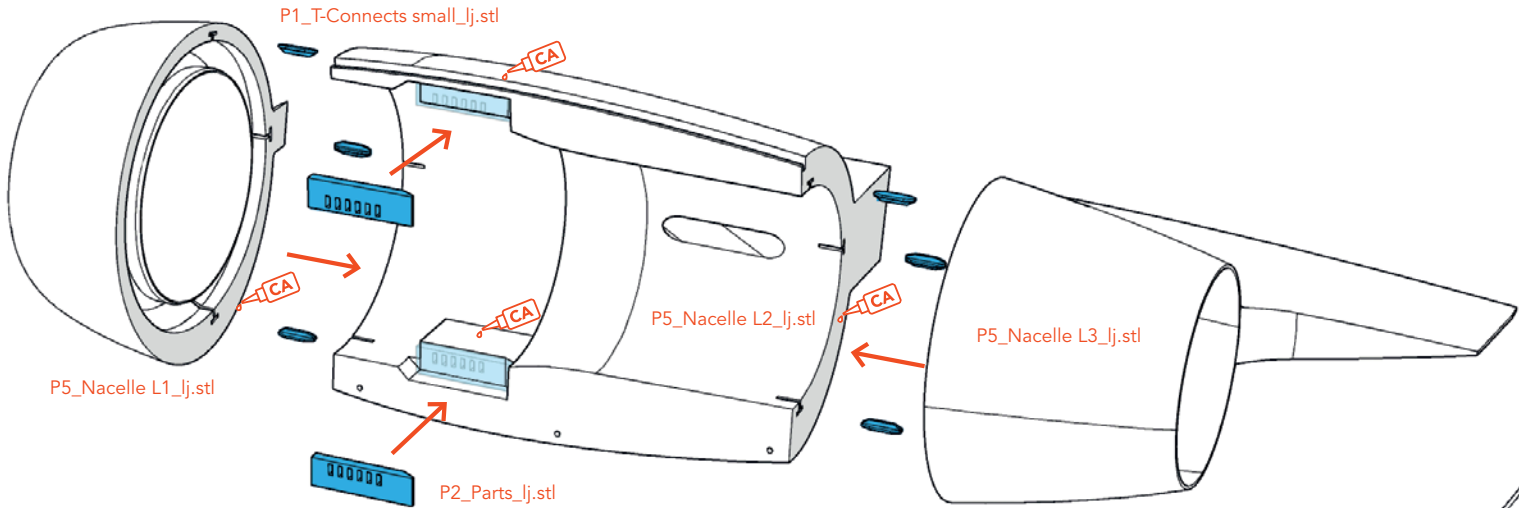
You can simply paint the windows or cut them out and cover them with foil from behind. The film should have a height of 46 mm.

Make a hole here with the knife.

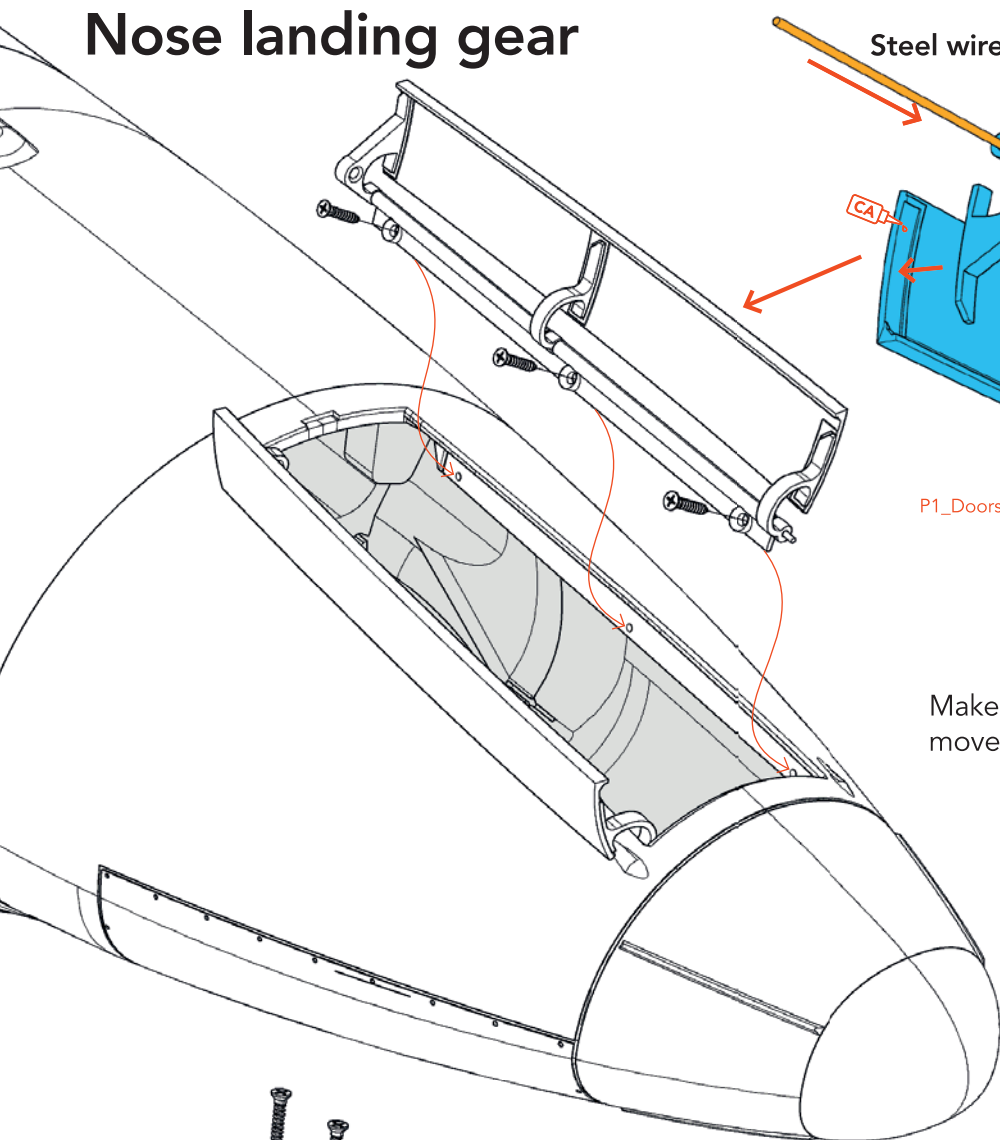
The rotary lever must not be glued on and moves the steel wires for the lock.

There are slots for 5 mm neodymium magnets, but these are optional and not necessary.

# EDF Nacelle

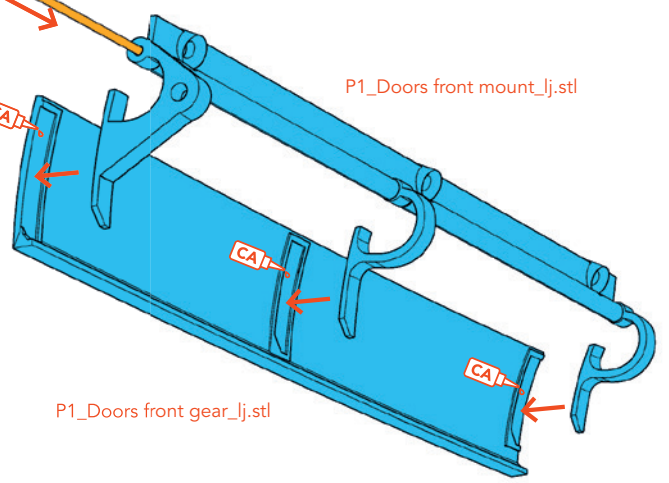


# Nose landing gear



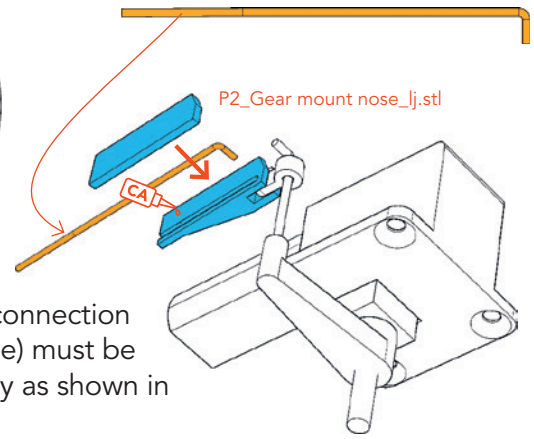
Steel wire Ø1\*140mm

Do the same for the right-hand door.



Make sure that the doors move absolutely smoothly.

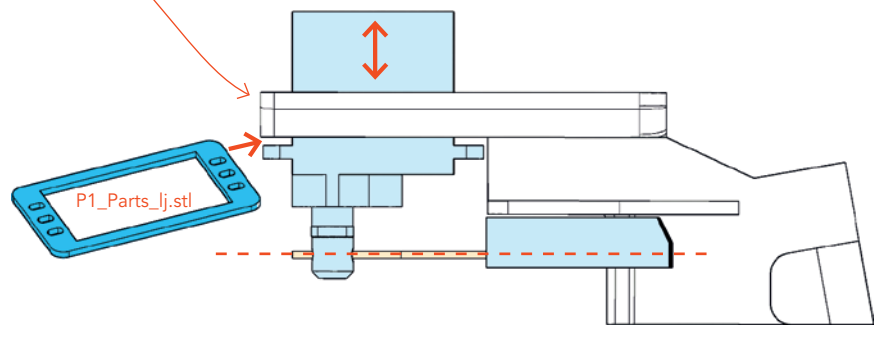
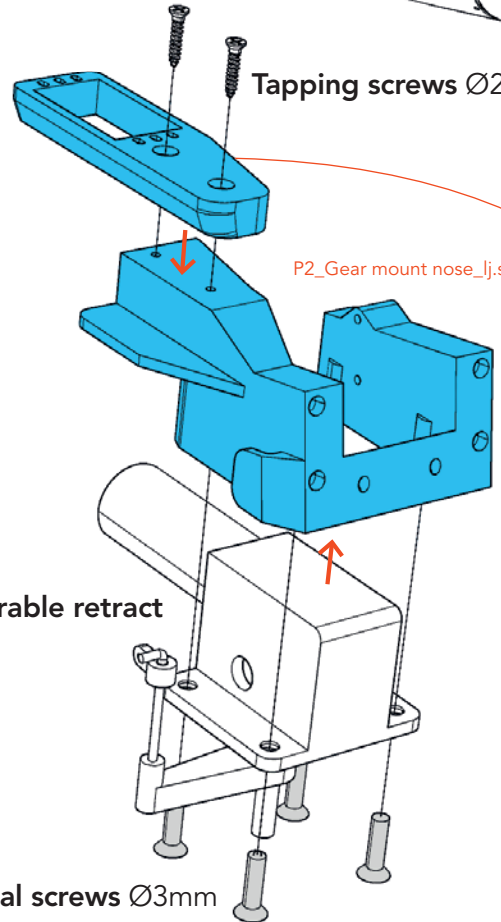
Steel wire Ø1\*54mm



The linkage connection (shown in blue) must be turned exactly as shown in the picture!

Tapping screws Ø2mm

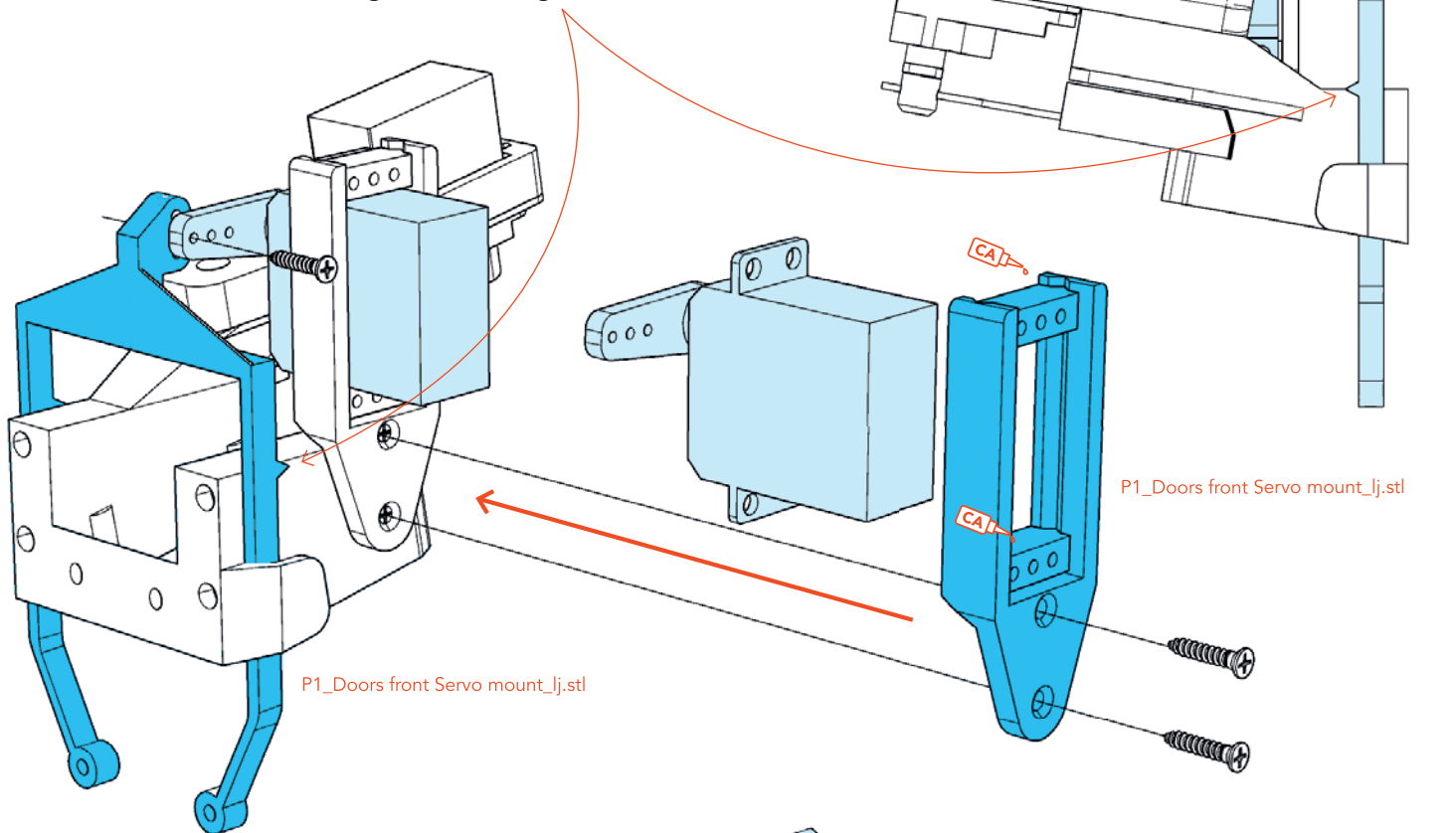
P2\_Gear mount nose\_lj.stl



Position the **servo for steering** exactly at the height that the linkage runs horizontally as shown in the picture. Use this part as a spacer if your servo has different dimensions.

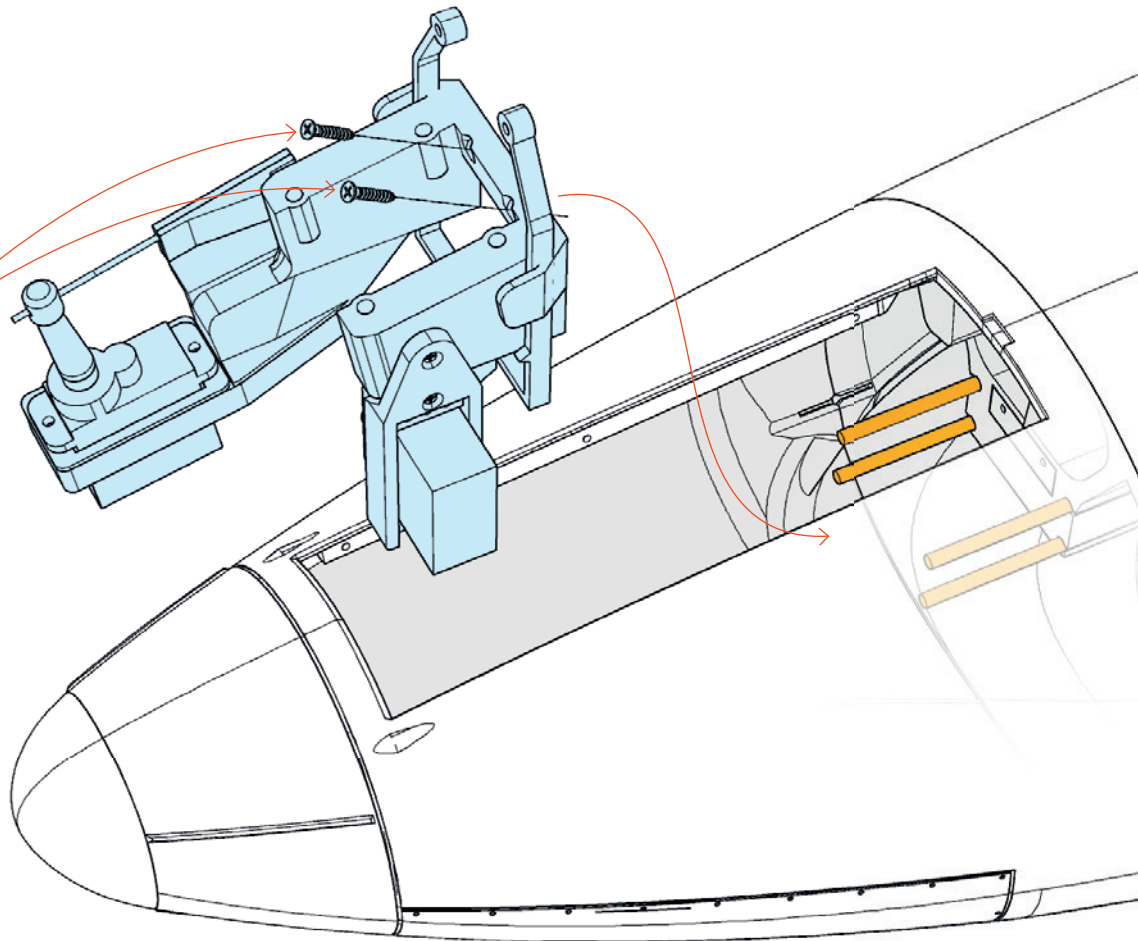
# Nose landing gear

The servo must be positioned in the center position so that this arrow is at the height of this edge.



The entire assembly is then placed on the four carbon rods in fuselage position 2 and secured with the **two tapping screws** only (**NOT glued**).

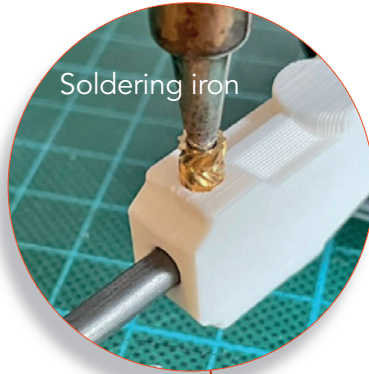
The steering servo must be loosened again slightly and the retract removed.



# Nose landing gear – suspended

**PLANEPRINT**  
**Innovation**

Connect the doors to the linkage bracket with two short tapping screws. Everything must be easy to move.



Soldering iron

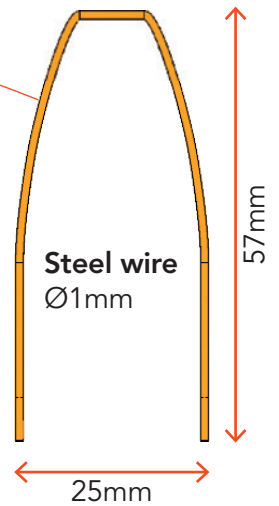
Threaded inserts

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

P2\_Gear leg nose\_lj.stl

Metal screw  $\varnothing 3\text{mm}$

Metal screw  $\varnothing 4 \times 30\text{mm}$



P4\_Wheel nose\_lj.stl

P2\_Rim nose\_lj.stl

Ball bearings

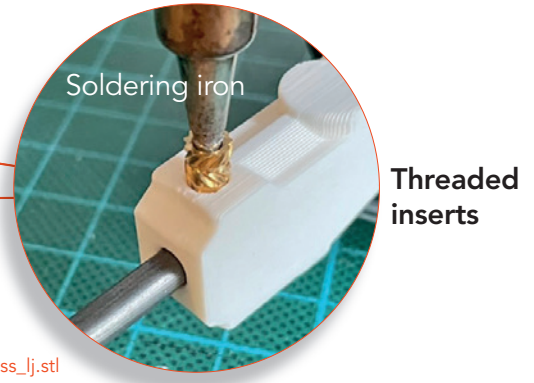
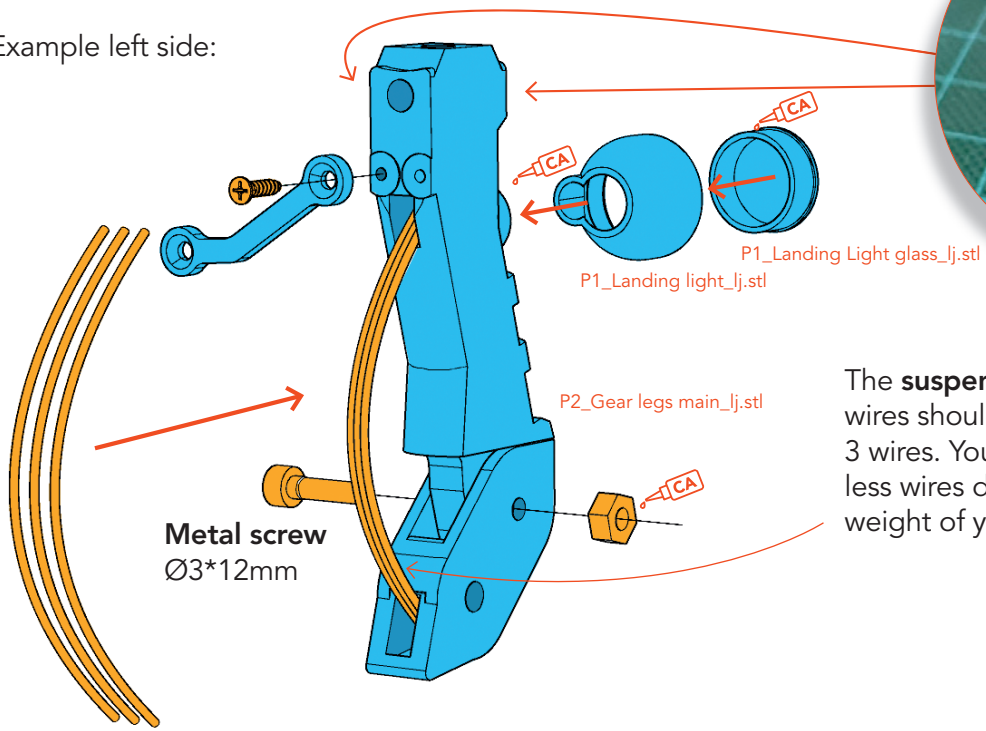
Secure the metal screws with a drop of CA glue

The doors must be programmed so that they open before the retract and only close when the retract is retracted. To do this, you must program a sequence on your remote control.

You can also omit the doors if this is too complicated for you or if you have too few channels available on the receiver.

# Main landing gear – suspended

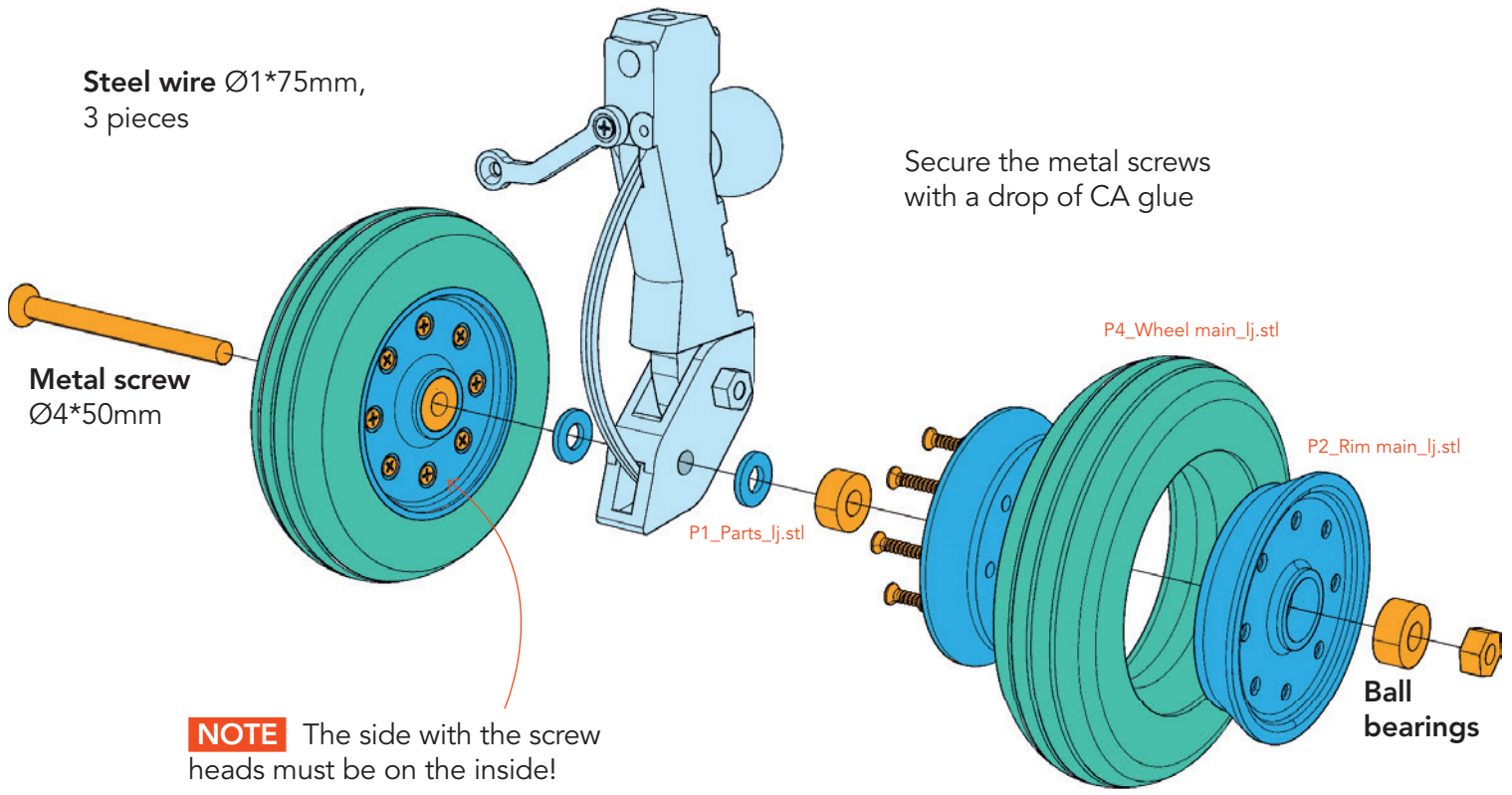
Example left side:



The **suspension** with the steel wires should work correctly with 3 wires. You can also use more or less wires depending on the total weight of your Learjet.

Steel wire Ø1\*75mm,  
3 pieces

Secure the metal screws  
with a drop of CA glue



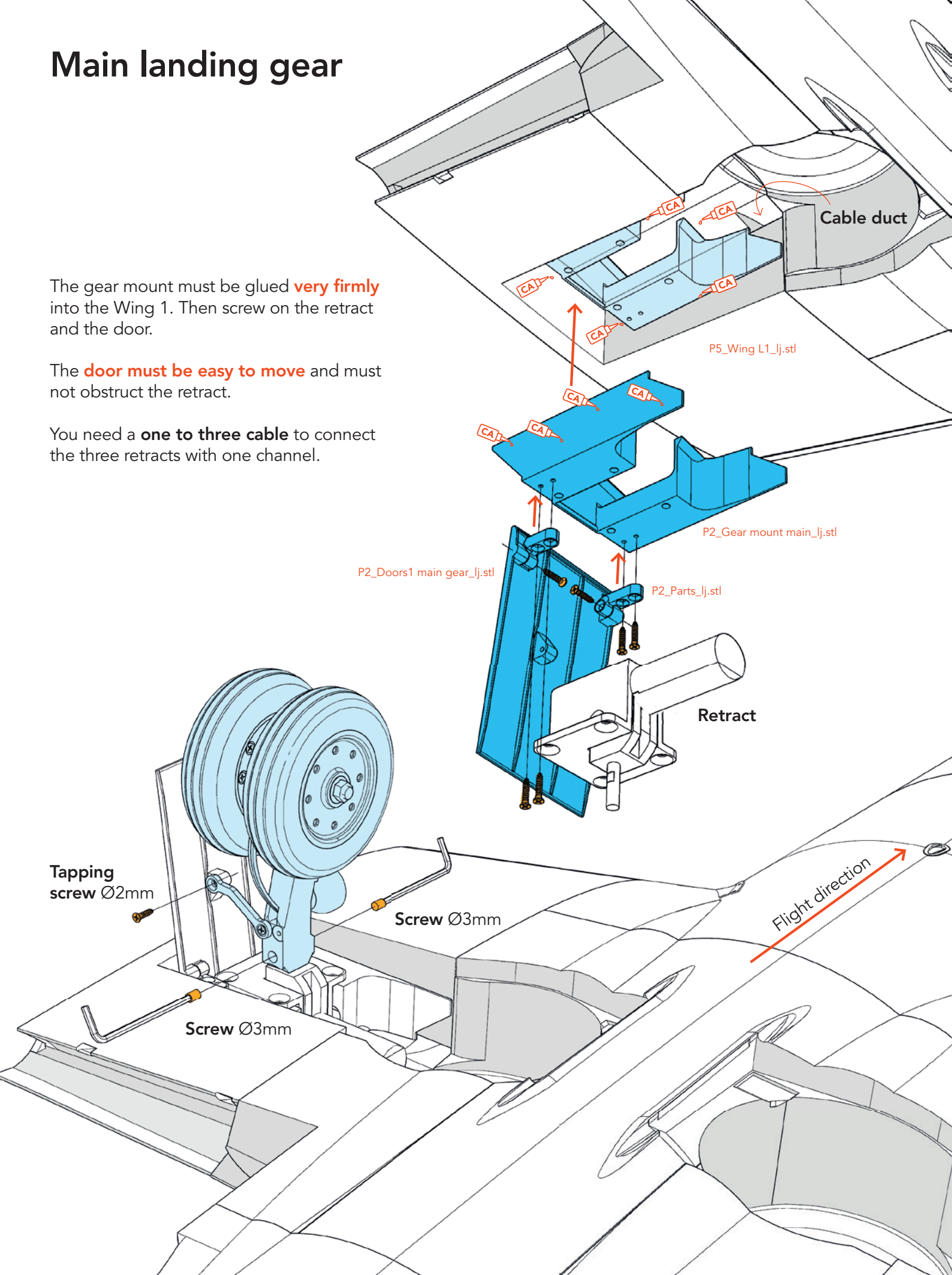
**NOTE** The side with the screw heads must be on the inside!

# Main landing gear

The gear mount must be glued **very firmly** into the Wing 1. Then screw on the retract and the door.

The **door must be easy to move** and must not obstruct the retract.

You need a **one to three cable** to connect the three retracts with one channel.

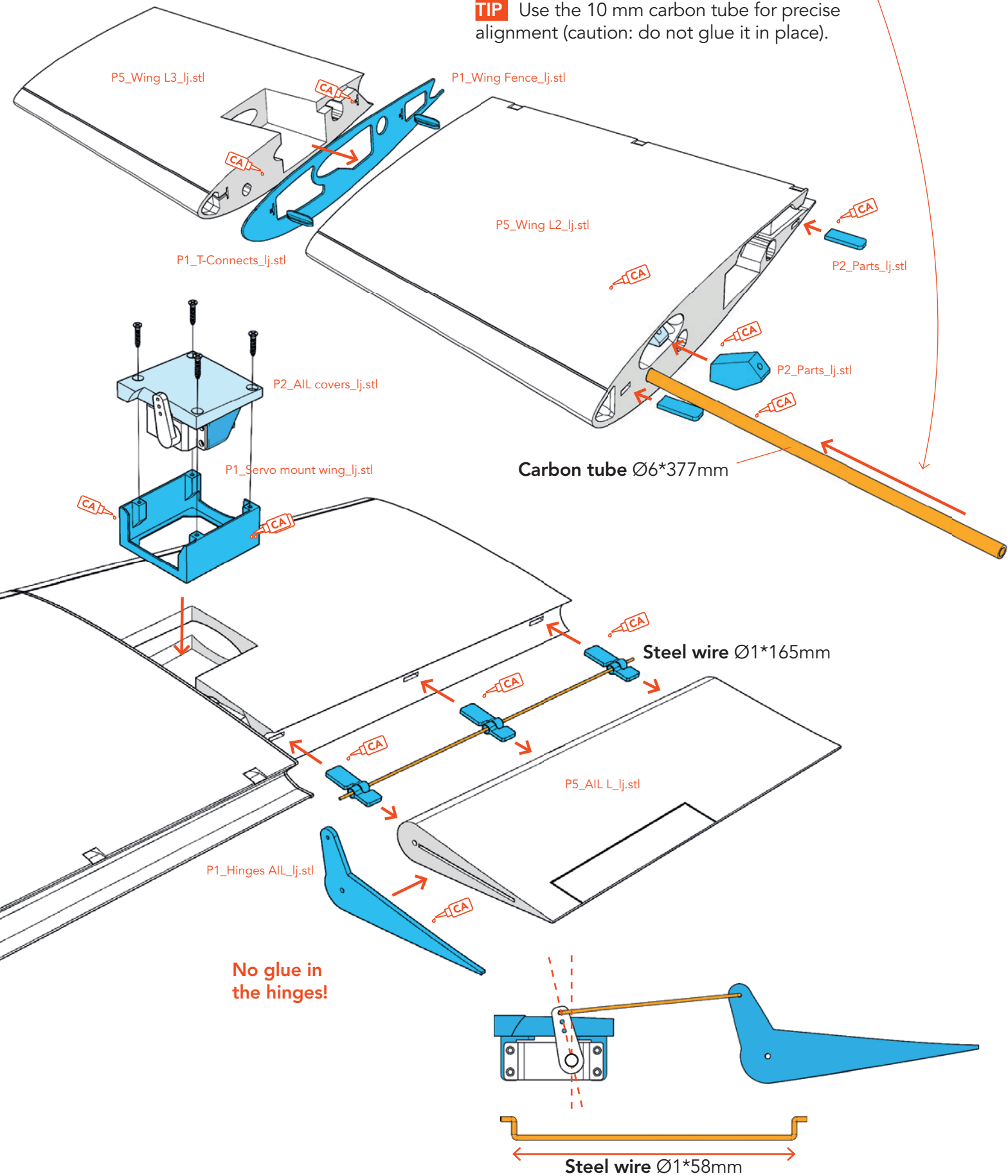


# Wing assembly



Finally, the carbon tube is inserted into the wing **without** glue. Then let **thin CA glue** run into the gap to connect the tube to the wing along its entire length. Place a rag underneath and wait until the CA glue runs out the other side.

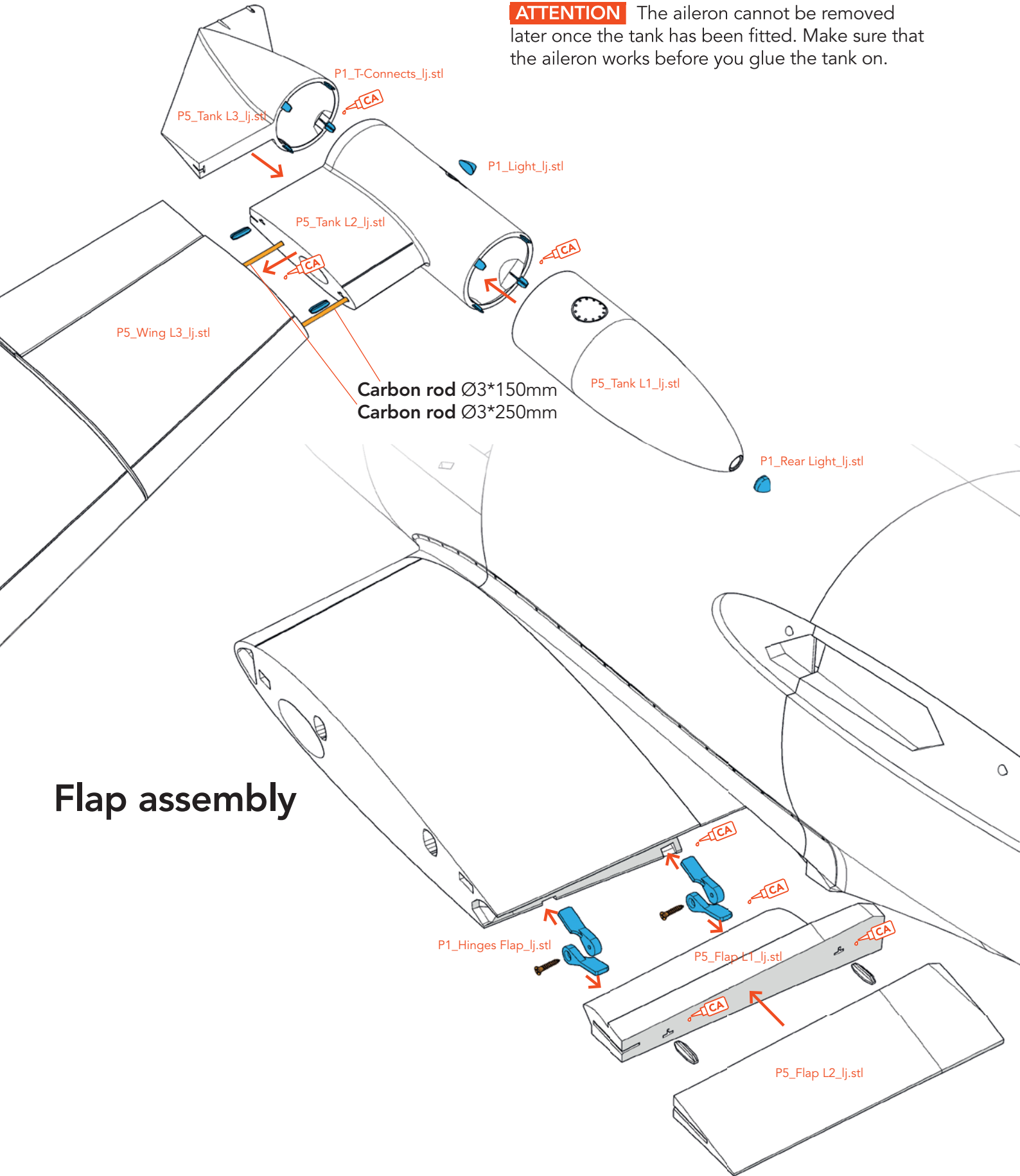
**TIP** Use the 10 mm carbon tube for precise alignment (caution: do not glue it in place).



# Wing assembly



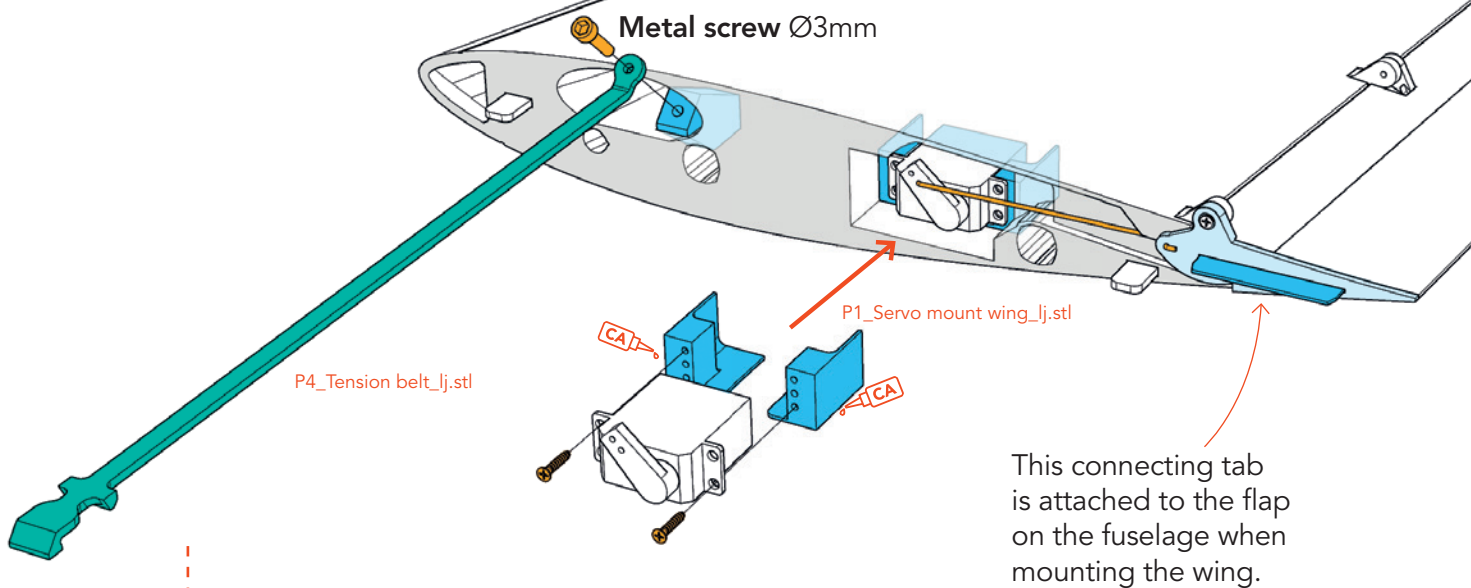
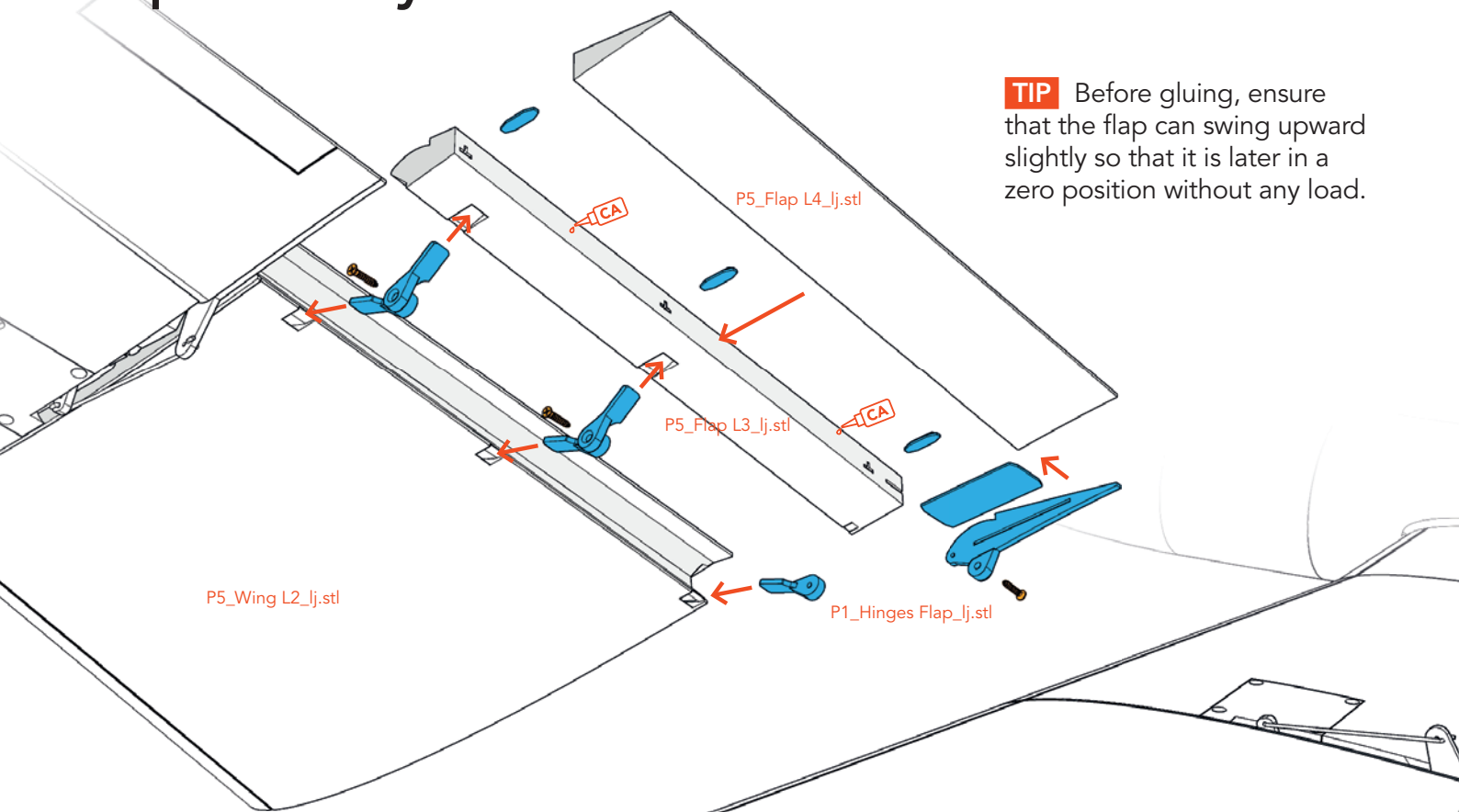
**ATTENTION** The aileron cannot be removed later once the tank has been fitted. Make sure that the aileron works before you glue the tank on.



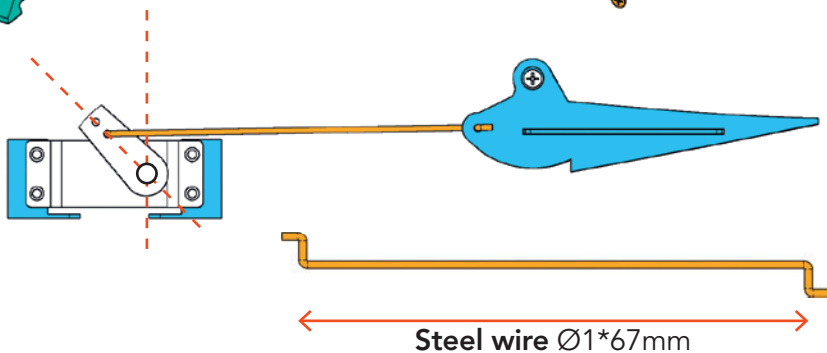
# Flap assembly

# Flap assembly

**TIP** Before gluing, ensure that the flap can swing upward slightly so that it is later in a zero position without any load.

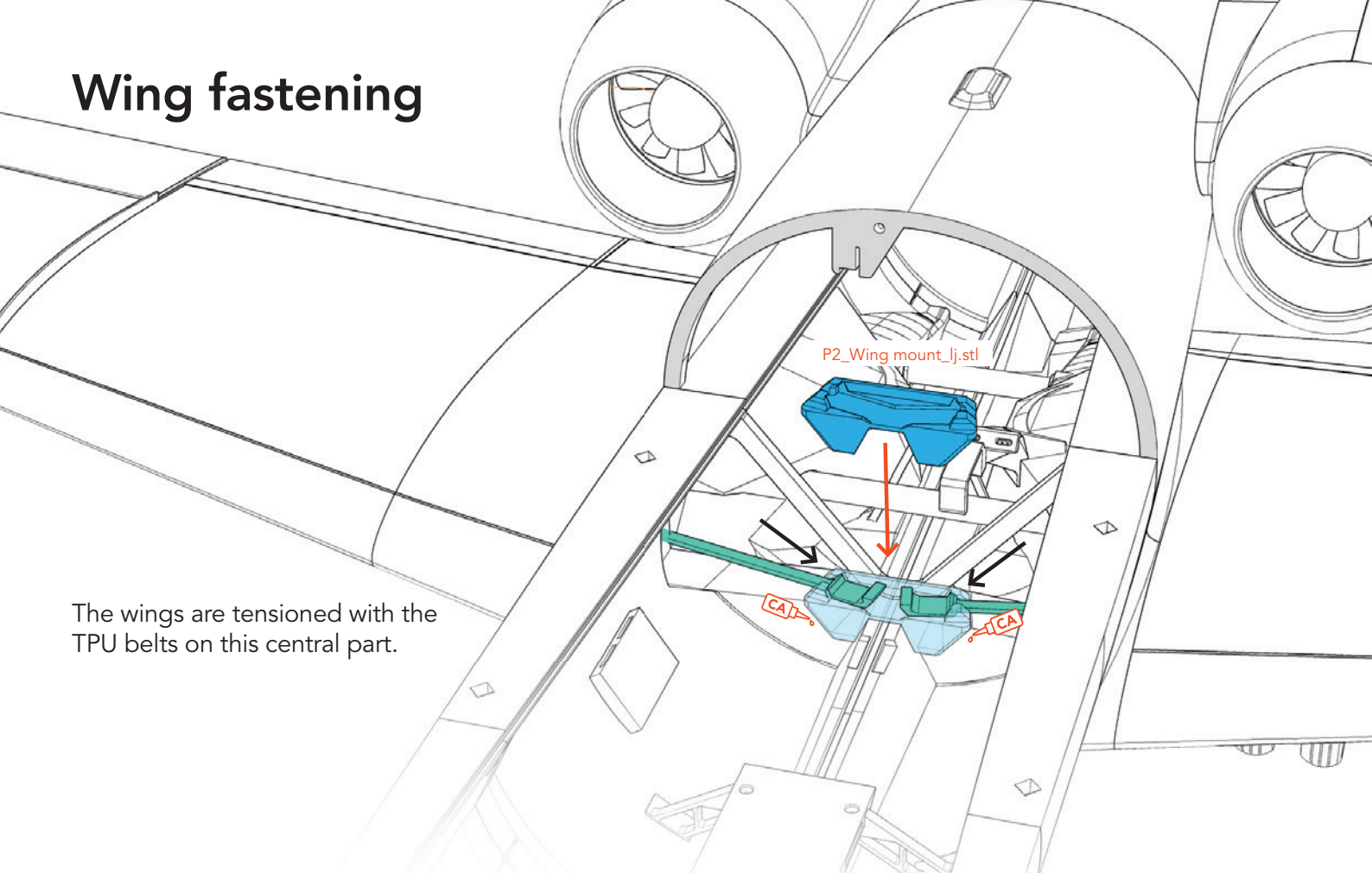


This connecting tab is attached to the flap on the fuselage when mounting the wing.

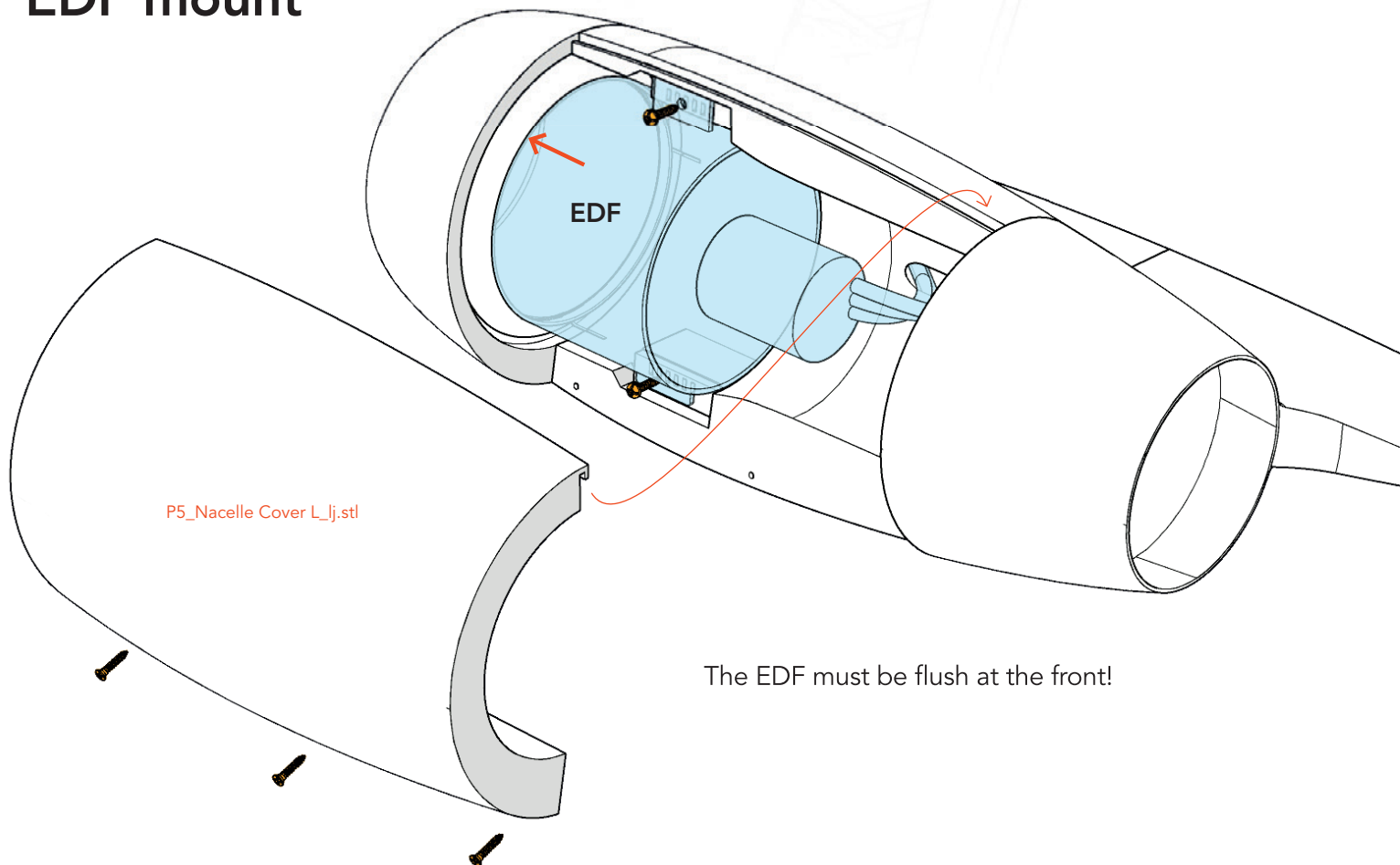


## Wing fastening

The wings are tensioned with the TPU belts on this central part.



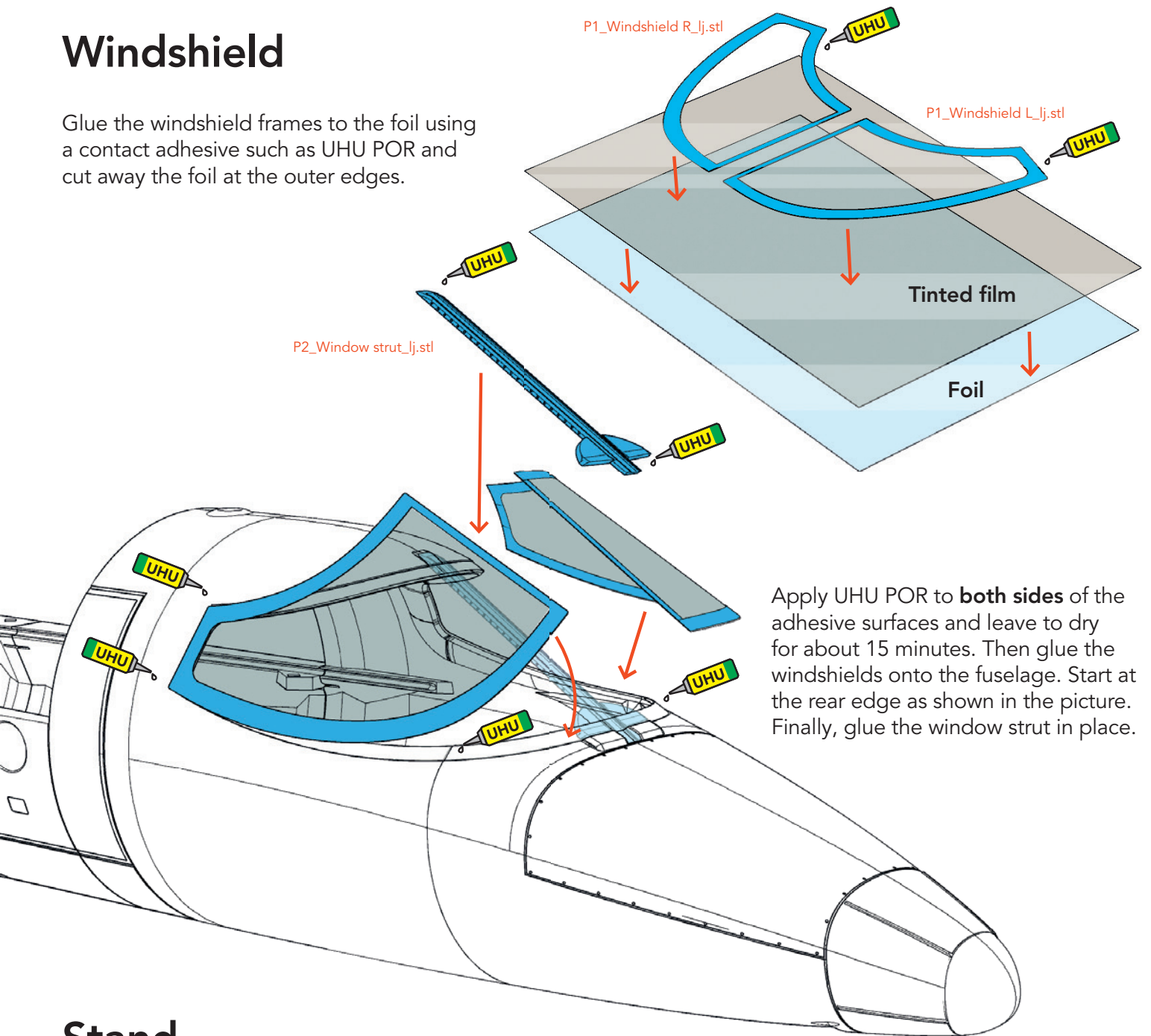
## EDF mount



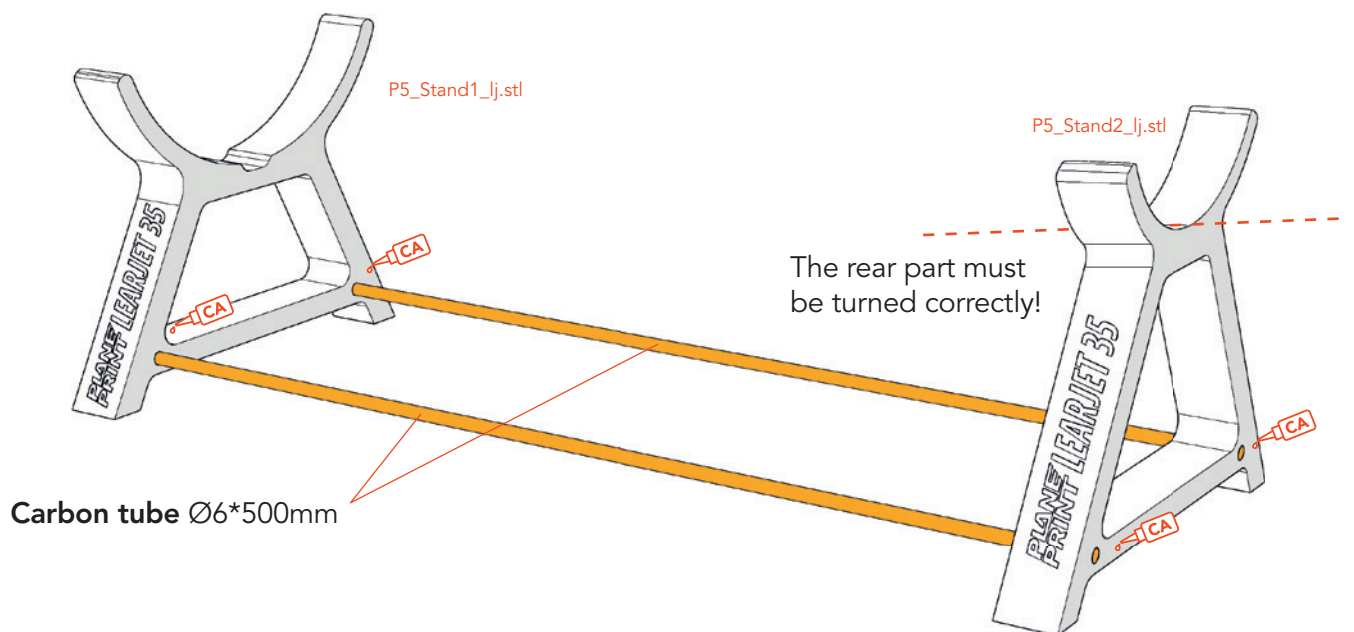
The EDF must be flush at the front!

# Windshield

Glue the windshield frames to the foil using a contact adhesive such as UHU POR and cut away the foil at the outer edges.



# Stand





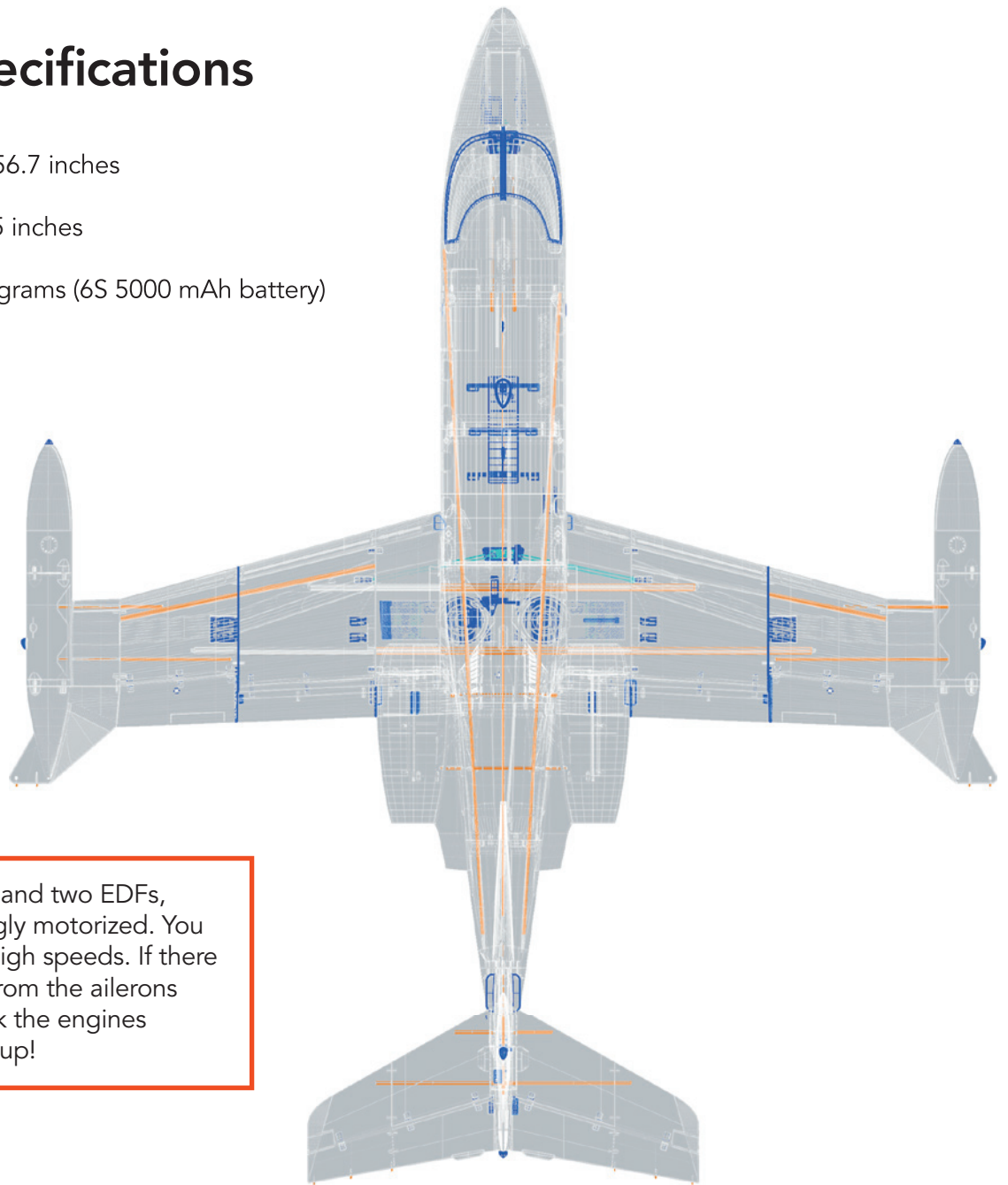
# Technical specifications

**WINGSPAN** 1440 mm/56.7 inches

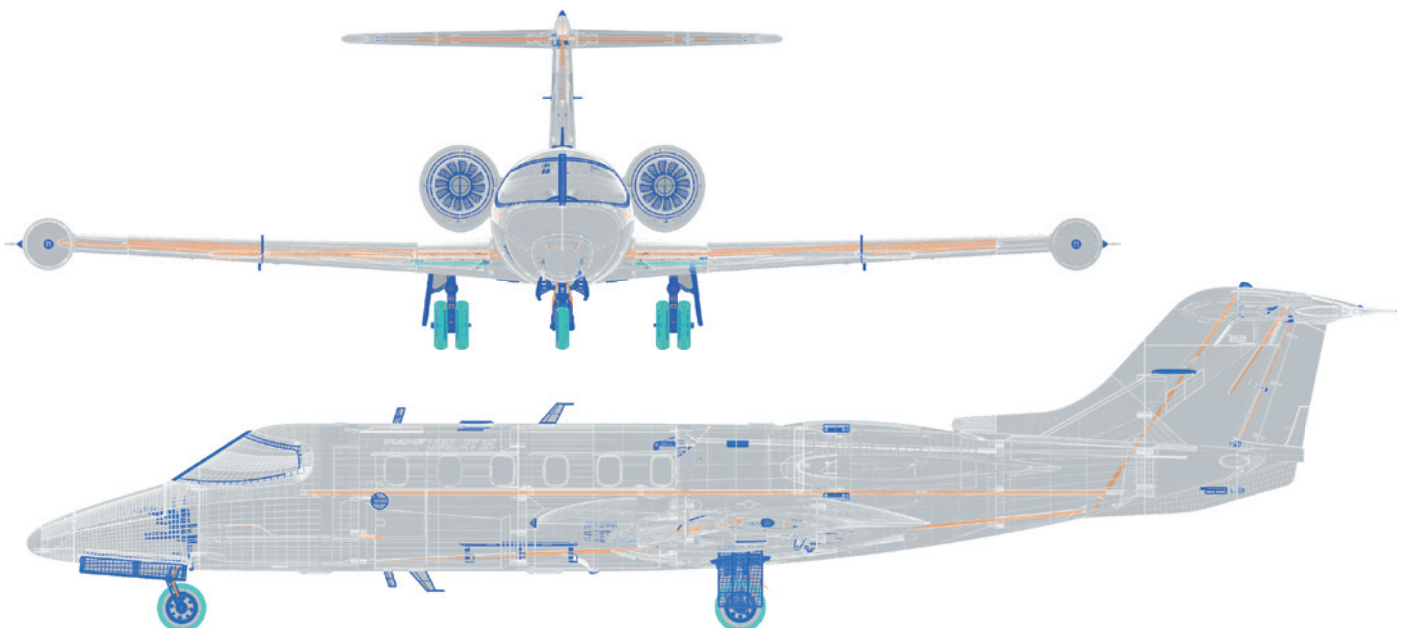
**LENGTH** 1716 mm/67.5 inches

**FLIGHT WEIGHT** 3900 grams (6S 5000 mAh battery)

**WING LOAD** 81 g/dm<sup>2</sup>



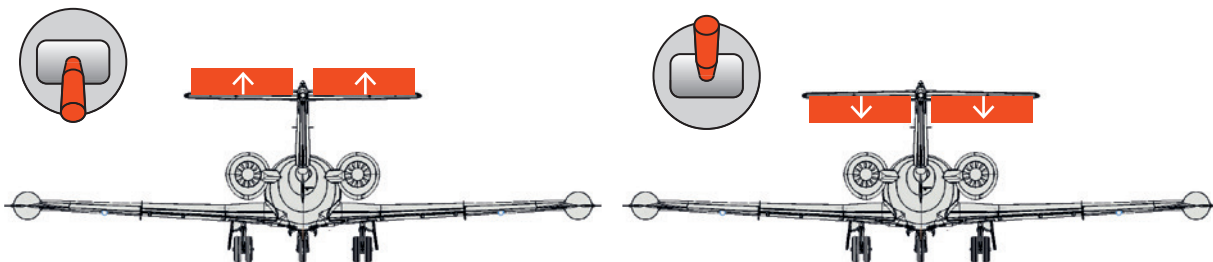
**SAFETY FIRST:** with 6S and two EDFs, the Learjet is very strongly motorized. You should be careful with high speeds. If there are any signs of flutter from the ailerons or elevator, throttle back the engines IMMEDIATELY and pull up!



# Control Direction Test Look at the aircraft from behind

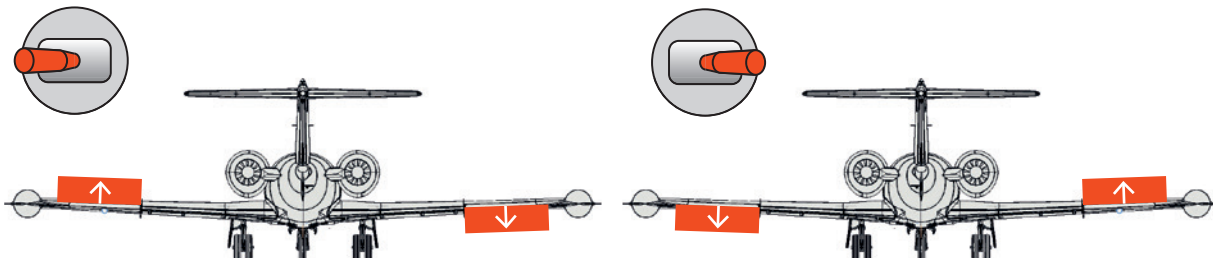
## ELEVATOR

30 mm up  
30 mm down



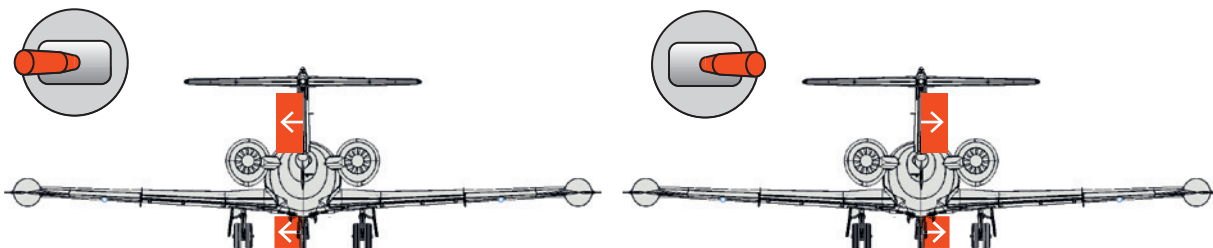
## AILERON

19 mm up  
19 mm down



## RUDDER

30 mm left  
30 mm right



## FLAPS

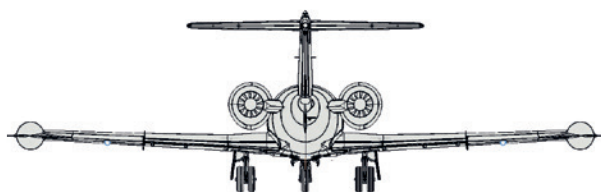
Normal



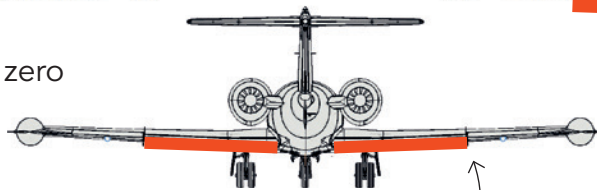
Start, slow flight



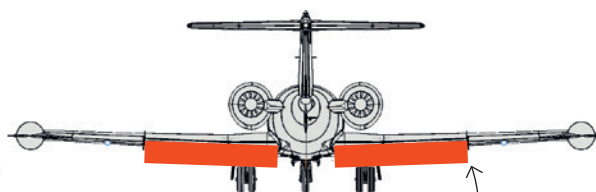
Landing



Aileron and elevator at zero



Flap 15 mm down  
(Measured outside)



Flap 38 mm down  
(Measured outside)

No or only minimal admixture of the elevator down is necessary.

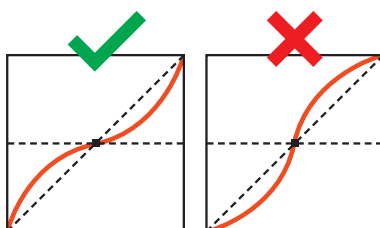
**NOTE** The flaps must be aligned exactly the same in every position, otherwise the aircraft will not fly straight!

## EXPO

**ELEVATOR** 30 %

**AILERON** 30 %

**RUDDER** 30 %



(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!

# PLANE PRINT