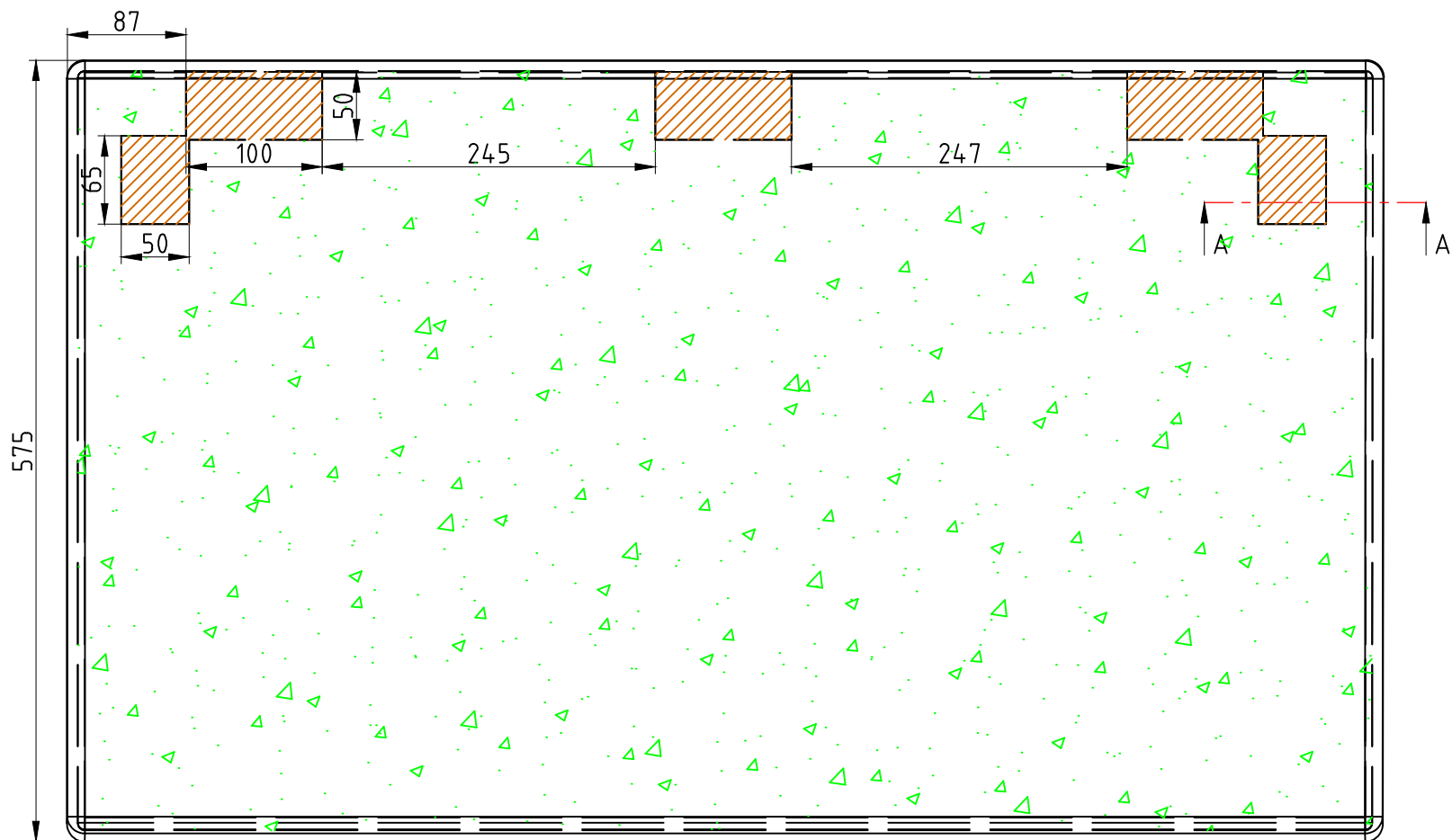
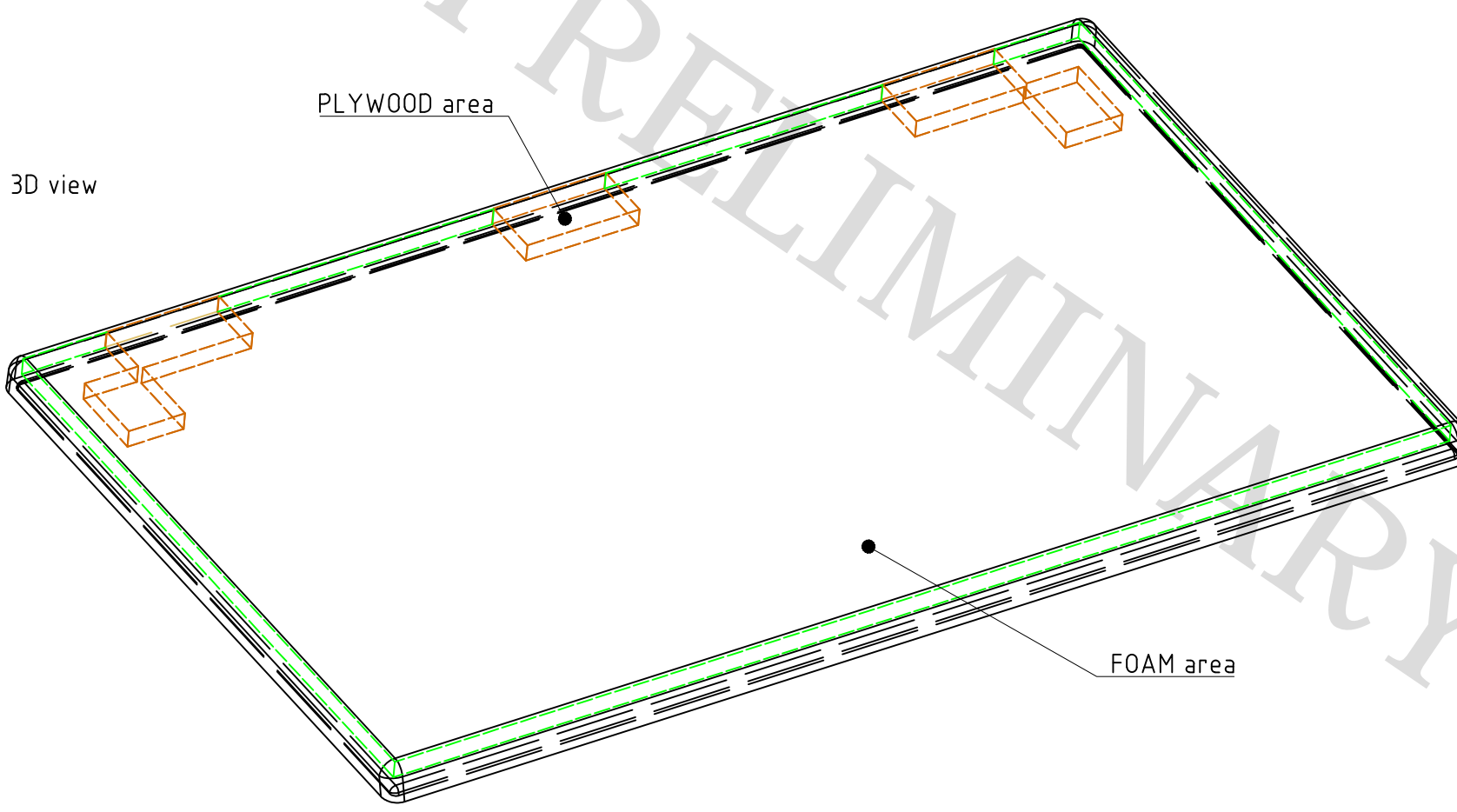


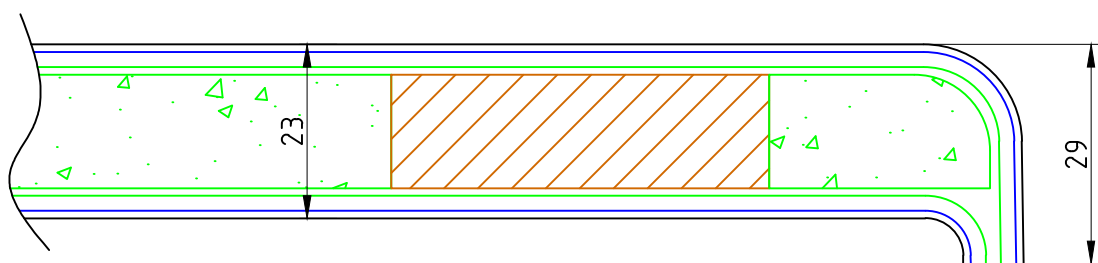
top view



3D view



section A-A
scale 1:1



JAI COMPOSITE CALCULATOR V7

Project name:	F450-Fly wet bar cover		 We Create Winners.
Lamination:	Vacuum bag		
	Vacuum bag		
Part weight:	6,7 kg	14,8 lb	
Part area:	0,6 m ²	0,7 yd ²	
Average:	10,8 kg/m ²	20,0 lb/yd ²	
Nominal fibre content by mass according to EN ISO 12215			

Area	Ply	0,1 m2	0,49 m2	0,02 m2
		BASIC area	FOAM area	PLYWOOD area
EU	1	GC (type II)	GC (type II)	GC (type II)
	2	M450/PP180/M450	M450/PP180/M450	M450/PP180/M450
	3		PVC 60 15mm (S)	Plywood 15mm
	4	M450/PP180/M450	M450/PP180/M450	M450/PP180/M450
	5	GC (type II)	GC (type II)	GC (type II)
EU	Total dry fibre:	4.240 g/m2	5.140 g/m2	12.040 g/m2
	Total with resin:	9.080 g/m2	10.805 g/m2	17.380 g/m2
	Thickness:	6,6 mm	21,6 mm	21,6 mm
USA	Total w/dry:	125,1 oz/yd2	151,6 oz/yd2	355,1 oz/yd2
	Total w/resin:	267,8 oz/yd2	318,7 oz/yd2	512,6 oz/yd2
	Thickness:	0,26 in	0,85 in	0,85 in

INSTALLED material:	Weight:		Area:		Marg. [%]:
	[kg]	[lb]	[m ²]	[yd ²]	
GC (type II)	1,3	2,8	1,2	1,5	0
M450/PP180/M450	1,4	3,1	1,3	1,6	5
PVC 60 15mm (S)	0,4	1,0	0,5	0,6	0
Plywood 15mm	0,2	0,4	0,0	0,0	0
POLYESTER (resin)	3,3	7,4			0
POLYESTER (hardener)	0,07	0,15			0
Total:	6,7 kg	14,8 lb	3,1 m2	3,7 yd2	

Material:	Fibre orientation:	Resin uptake [g]:	Resin uptake [lb]:	Material description:
GC (type II)	SPRY application	0	0,00	GelCoat
M450/PP180/M450	Random/Foam/Random	2420	5,34	Rovicore_RTM (two layers CSM with PP flow media)
PVC 60 15mm (S)	Solid	825	1,82	PVC foam
Plywood 15mm	Solid [5 layers]	500	1,10	Marine Plywood
POLYESTER (resin)	0			Resin
POLYESTER (hardener)	0			Hardener

- Important:**
- during the lamination process environment temperature and humidity needs to be checked and recorded with temperature and humidity logger and comply with technical data sheets from suppliers
 - resin/hardener ratio needs to be correct for ambient temperature
 - all built in materials MUST have CE or similar certification
 - before secondary bonding or lamination surface must be sanded with GRIT 60 paper
 - Core must be sealed when hole is cut in to sandwich laminate or hole must be drilled to single skin area

	Drawing name: <i>Flybridge wet bar cover lam</i>	Scale: <i>1:5</i>	Date: <i>13.5.2016</i>	Drawn by: <i>M. Prus</i>	Page: <i>1 / 1</i>
	Subject: <i>Ferretti F450</i>				Page format: <i>A2</i>
File name:					Approved:
<i>F450-00-00-ST-24-T00-ST-STD-3EU-A-Laminazione coperchio mobile bar 1a sovrastruttura-Flybridge wet bar cover lamination.dwg</i>					
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