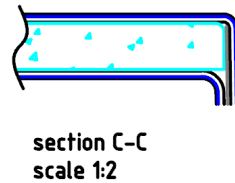
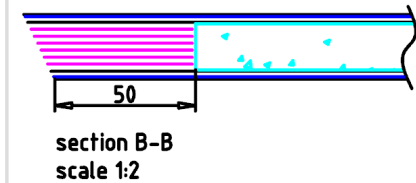
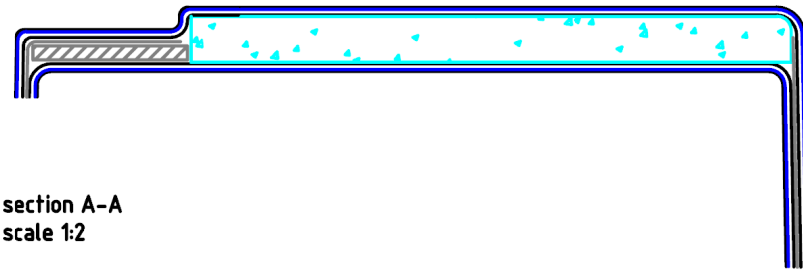
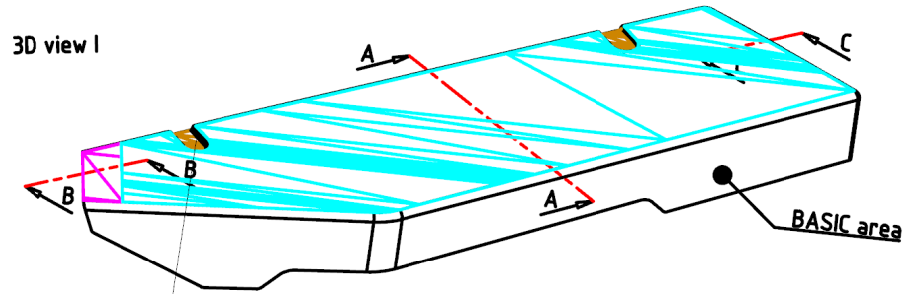


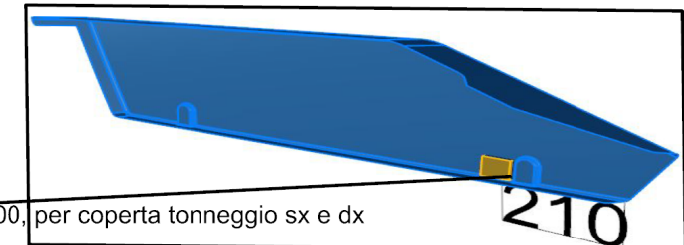
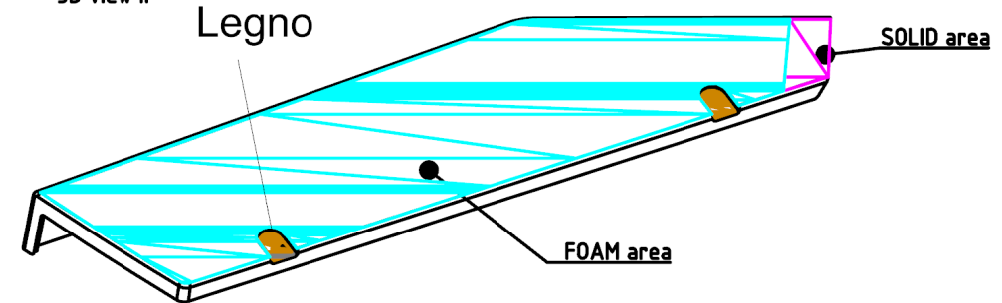
REV. NO.	REVISION NOTE	DATE	NAME	CHECK
B	Modificare piastre da alluminio a legno. aggiunto ottone	03/11/2017	CH.MAO	



3D view I



3D view II



Dimen ottone 50x50mm, sp10mm, laminato con 2 mat 300, per coperta tonneggio sx e dx

Project name:	Stern mooring COVER
Lamination:	Vacuum bag
Part weight:	5,3 kg
Part area:	0,46 m²
Average:	11,5 kg/m²
Nominal fibre content by mass according to EN ISO 12215	

Area	0,19 m2	0,27 m2	0,003 m2	0,006 m2
Ply	BASIC area	FOAM area	ALU area	SOLID area
1	GC (type II)	GC (type III)	GC (type II)	
2	M450/PP180/M450	M450/PP180/M450	M450/PP180/M450	
3		PVC 60 15mm IS)	ALU plate 1/4"	
4				M450/PP180/M450
5				M450/PP180/M450
6				M450/PP180/M450
7				M450/PP180/M450
8				M450/PP180/M450
9				M450/PP180/M450
10	M450/PP180/M450	M450/PP180/M450	M450/PP180/M450	
11	GC (type II)	GC (type III)	GC (type II)	
Total dry fibre:	4.240 g/m2	5.140 g/m2	21.385 g/m2	6.480 g/m2
Total with resin:	9.080 g/m2	12.290 g/m2	26.225 g/m2	21.000 g/m2
Thickness:	6,6 mm	21,6 mm	13,0 mm	15,0 mm
Total w/dry:	125,1 oz/yd2	151,6 oz/yd2	630,7 oz/yd2	191,1 oz/yd2
Total w/resin:	267,8 oz/yd2	362,5 oz/yd2	773,5 oz/yd2	619,4 oz/yd2
Thickness:	0,26 in	0,85 in	0,51 in	0,59 in

INSTALLED material:	Weight:		Area:		Marq. [%]
	[kg]	[lb]	[m²]	[yd²]	
GC (type II)	1,0	2,1	0,9	1,1	0
M450/PP180/M450	1,1	2,4	1,0	1,2	5
PVC 60 15mm (SI)	0,2	0,5	0,3	0,3	0
ALU plate 1/4"	0,1	0,1	0,0	0,0	0
POLYESTER (resin)	2,9	6,3			0
POLYESTER (hardener)	0,06	0,13			0
Total:	5,3 kg	11,6 lb	2,2 m2	2,6 yd2	

Note:

- STBD side cover shown on drawing.
- PORT side symmetrical.
- lamination done in RTM
- trim done according to cutting lines marked in the mould

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

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 medial)
PVC 60 15mm IS)	Solid	2310	5,09	PVC foam
ALU plate 1/4"	Solid	0	0,00	Aluminium plate
POLYESTER (resin)	0			Resin
POLYESTER (hardener)	0			Hardener

Drawing name:	Scale:	Date:	Drawn by:	Page:
Stern mooring COVER	1:4	11.5.2016	M. Prus	1 / 1
Subject:				Page format:
Ferretti F450				A3
File name:				Approved:
F450-00-00-ST-39-T00-ST-STD-3EU-B-Laminazione vasca cime tonneggio-Stern mooring lines cover lamination.dwg				J&J

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