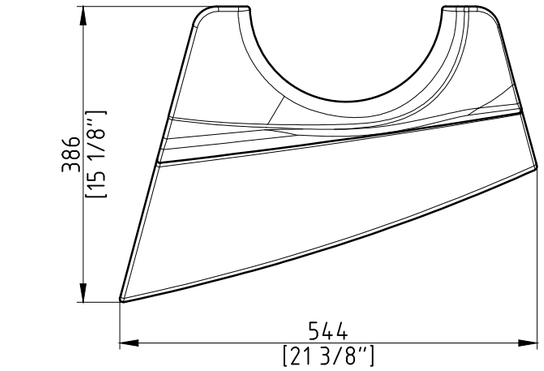
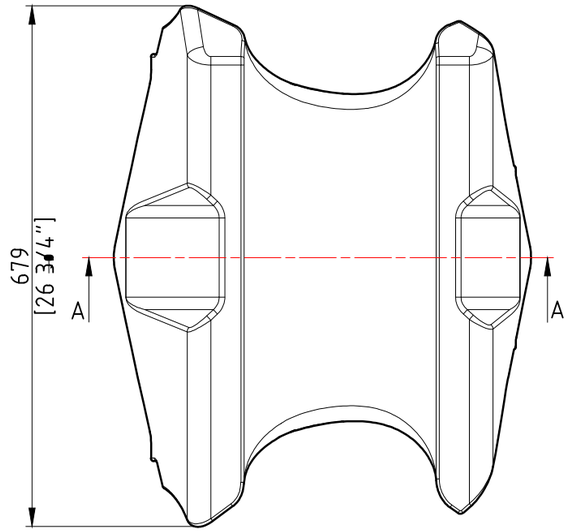
REV. NO.	REVISION NOTE	DATE	NAME	CHECK
REV. B	WET lamination	20.5.2016	M. Prus	

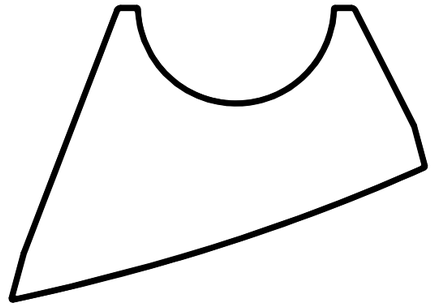
Side view



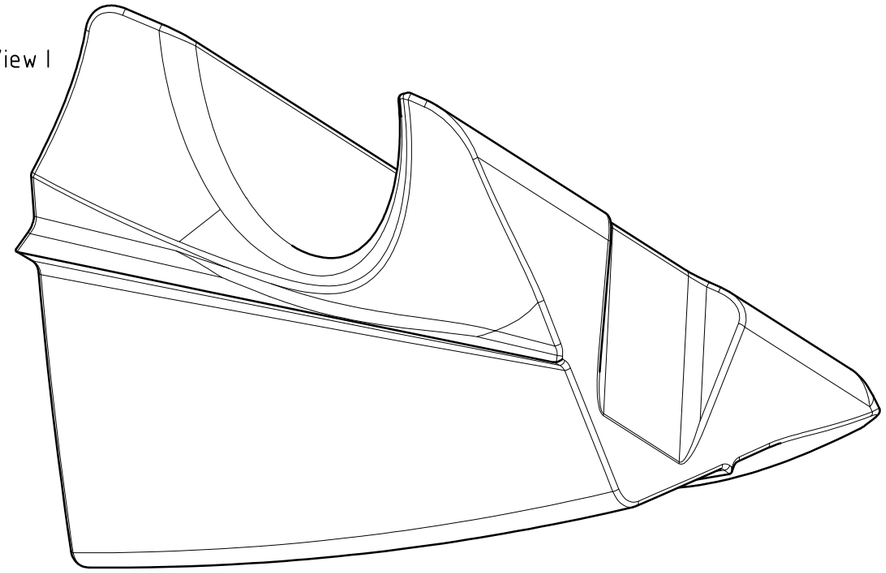
Top view



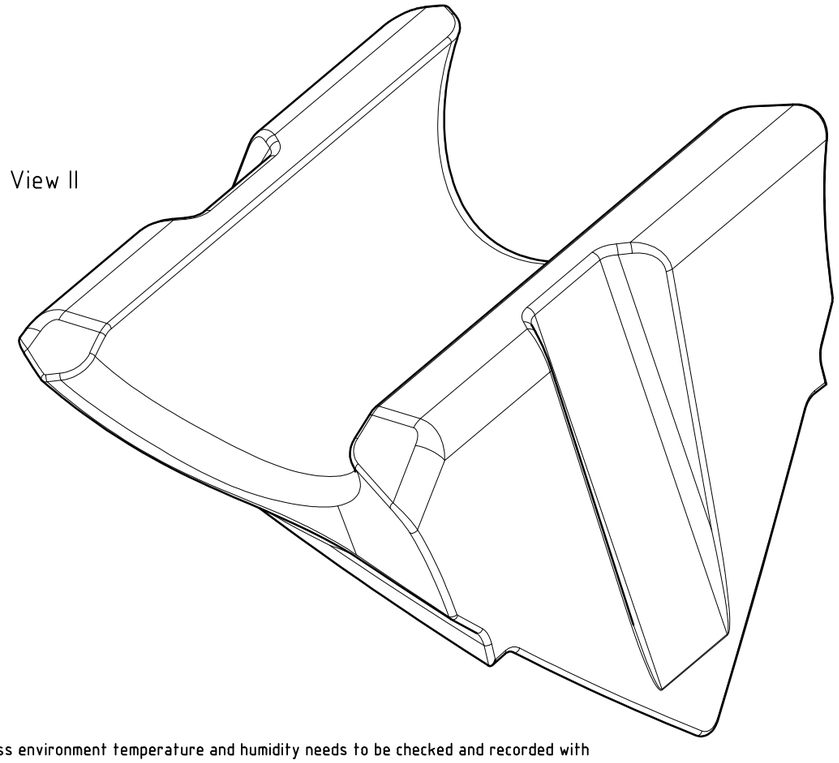
Section A-A



3D View I



3D View II



Area		0,9 m2
	Ply	BASIC area
	1	GC (type II)
	2	CSM 300
	3	CSM 300
	4	CSM 450
	5	EBXS 600 M225
	6	
EU Total dry fibre:		2.921 g/m2
EU Total with resin:		6.000 g/m2
EU Thickness:		4,2 mm
USA Total w/dry:		86,2 oz/yd2
USA Total w/resin:		177,0 oz/yd2
USA Thickness:		0,17 in

Project name:	F450_COCKPIT CABINETS	J&J DESIGN We Create Winners
Lamination:	Open mould [WET]	
	Simple surface	
Part weight:	5,5 kg	12,1 lb
Part area:	0,9 m^2	1,1 yd^2
Average:	6,1 kg/m^2	11,2 lb/yd^2
Nominal fibre content by mass according to EN ISO 12215		

INSTALLED material:	Weight: [kg]	Weight: [lb]	Area: [m^2]	Area: [yd^2]	Marg. [%]:
GC (type II)	0,9	2,1	0,9	1,1	0
CSM 300	0,6	1,3	1,9	2,3	5
CSM 450	0,4	0,9	0,9	1,1	5
EBXS 600 M225	0,8	1,7	0,9	1,1	5
POLYESTER (resin)	2,7	6,0			0
POLYESTER (hardener)	0,06	0,12			0
Total:	5,5 kg	12,1 lb	4,7 m2	5,6 yd2	

Material:	Fibre orientation:	Resin uptake [g]:	Resin uptake [lb]:	Material description:
GC (type II)	SPRY application	0	0,00	GelCoat
CSM 300	RANDOM	700	1,54	Chopped strands matt
CSM 450	RANDOM	1050	2,31	Chopped strands matt
EBXS 600 M225	[0/90 deg]	629	1,39	Double biaxial + matt
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:	Scale:	Date:	Drawn by:	Page:
	Bow thruster detail lam.	1:8	13.5.2016	E.Bugrova	1 / 1
	Subject: F-450				Page format: A3
File name: F450-00-00-ST-55-T00-ST-STD-3EU-B-Laminazione dettaglio elica di prua-Bow thruster detail lamination.dwg					Approved: J&J

Drawing location: E:\WORKING FILES\FERRETTI\F450\04 Engineering\4.1 Composite\4.1.5 Lamination_archive\4 Small parts\15 BOW THRUSTER DETAIL\WORKING\F450-00-00-ST-55-T00-ST-STD-3EU-B-Laminazione dettaglio elica di prua-Bow thruster detail lamination.dwg