



Project name:	Stern mooring COVER		JG DESIGN
	Vacuum bag	Vacuum bag	
Lamination:			Na Coats Winona
Part weight:	5,3 kg	11,6 lb	
Part area:	0,46 m ²	0,6 yd ²	
Average:	11,5 kg/m ²	21,1 lb/yd ²	
Nominal fibre content by mass according to EN ISO 12215			
Area	0,19 m ²	0,27 m ²	0,003 m ²
Ply	BASIC area	FOAM area	ALU area
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)	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 II)	GC (type II)
Total dry fibre:	4,240 g/m ²	5,140 g/m ²	21,385 g/m ²
EU Total with resin:	9,080 g/m ²	12,290 g/m ²	26,225 g/m ²
Thickness:	6,6 mm	21,6 mm	13,0 mm
Total w/dry:	125,1 oz/yd ²	151,6 oz/yd ²	630,7 oz/yd ²
USA Total w/resin:	267,8 oz/yd ²	362,5 oz/yd ²	773,5 oz/yd ²
Thickness:	0,26 in	0,85 in	0,51 in

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

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INSTALLED material:	Weight:		Area:		Marg. (%):
	[kg]	[lb]	[m ²]	[yd ²]	
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 (S)	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	

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 [kg]:	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	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:					
Ferretti F450					
File name:					
F450-00-00-ST-39-T00-ST-STD-3EU-B-Laminazione vasca cime tonneggio-Stern mooring lines cover lamination.dwg					
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