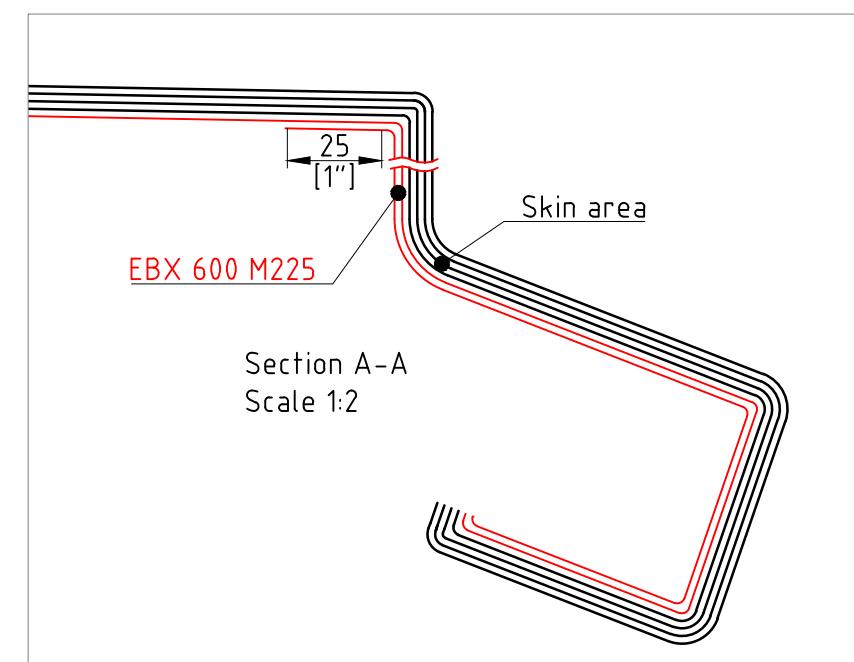
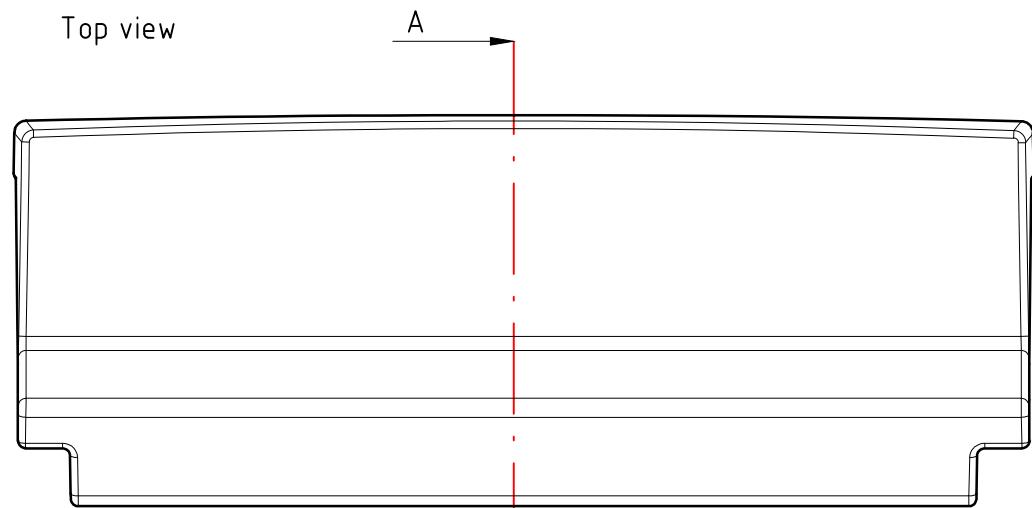
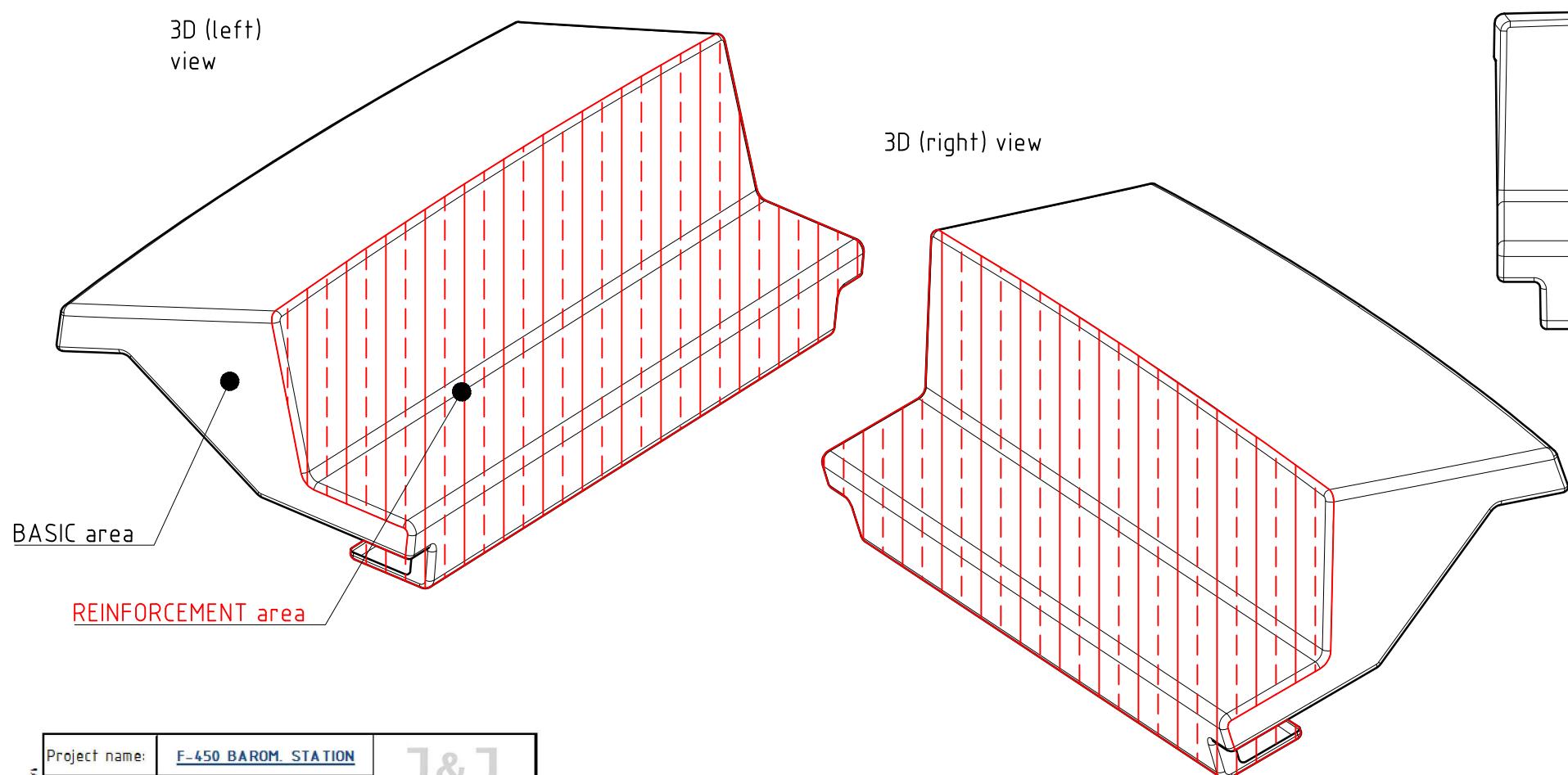


REV. NO.	REVISION NOTE	DATE	NAME	CHECK
REV. B	UPDATED GEOMETRY	12.05.2016	E.Bugrova	J&J



Project name:	F-450 BAROM. STATION	J&J
Lamination:	Open mould [WET]	
	Simple surface	
Part weight:	2.7 kg	5.9 lb
Part area:	0.5 m ²	0.6 yd ²
Average:	5.4 kg/m ²	9.9 lb/yd ²
Nominal fibre content by mass according to EN ISO 12215		

Area	0.238		0.27
	Ply	BASIC area	REINF area
1	GC (type II)	GC (type II)	
2	CSM 300	CSM 300	
3	CSM 300	CSM 300	
4	EBX 600 M225	EBX 600 M225	
5	EBX 600 M225	EBX 600 M225	
Total dry fibre:	2,471 g/m ²	3,302 g/m ²	
EU Total with resin:	4,500 g/m ²	5,960 g/m ²	
Thickness:	3.2 mm	4.1 mm	
USA Total w/dry:	72.9 oz/yd ²	97.4 oz/yd ²	
Total w/resin:	132.7 oz/yd ²	175.8 oz/yd ²	
Thickness:	0.12 in	0.16 in	

INSTALLED material:	Weight:		Area:		Marg. [%]:
	[kg]	[lb]	[m ²]	[yd ²]	
GC (type II)	0.5	1.2	0.5	0.6	0
CSM 300	0.3	0.7	1.1	1.3	5
EBX 600 M225	0.7	1.5	0.8	1.0	5
POLYESTER (resin)	1.2	2.6			0
POLYESTER (hardener)	0.02	0.05			0
Total:	2.7 kg	5.9 lb	2.4 m²	2.8 yd²	

NEEDED material:	Weight:		Area:		Marg. [%]:
	[kg]	[lb]	[m ²]	[yd ²]	
GC (type II)	0.58	1.27	0.55	0.66	10
CSM 300	0.35	0.77	1.16	1.39	10
EBX 600 M225	0.74	1.63	0.89	1.06	10
POLYESTER (resin)	1.3	2.8			10
POLYESTER (hardener)	0.03	0.06			10
Total:	3.0 kg	6.5 lb	2.6 m²	3.1 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 [g]:	Resin uptake [lb]:	Material description:
GC (type II)	SPRY application	0	0.00	GelCoat
CSM 300	RANDOM	700	1.54	Chopped strands matt
EBX 600 M225	[+45/-45 deg]	629	1.39	Double biaxial + matt
POLYESTER (resin)	0			Resin
POLYESTER (hardener)	0			Hardener

Drawing name:	Barometric station	Scale:	1:5	Date:	7.4.2016	Drawn by:	U.Mirjanic	Page:
Subject:	F-450							
File name:	F45000-00-ST-34-T01-ST-STD-3-EU-B-- Laminazione carter stazione barometrica- Barometric station lamination.dwg	J&J						
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