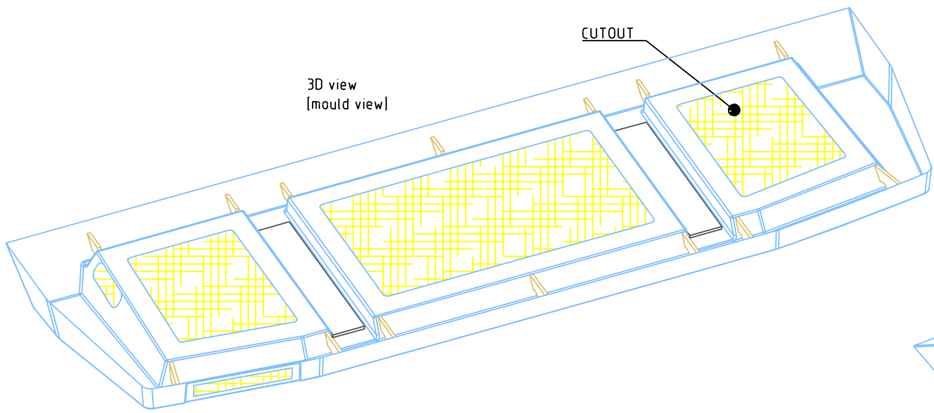
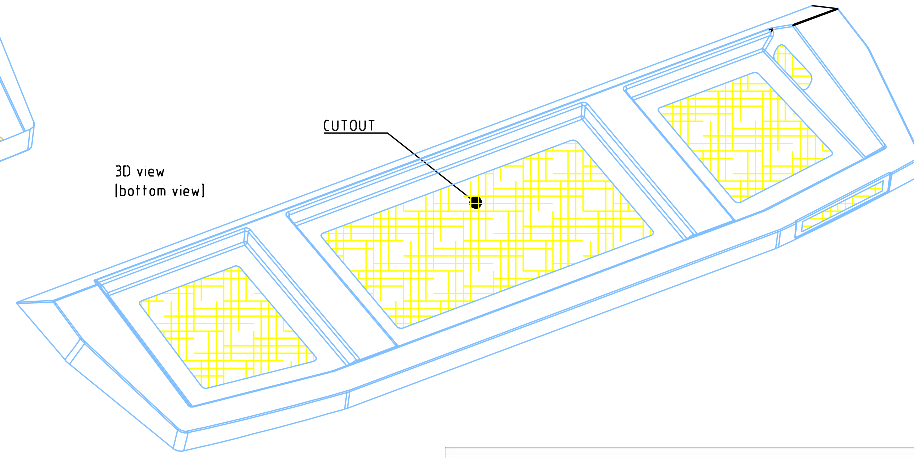
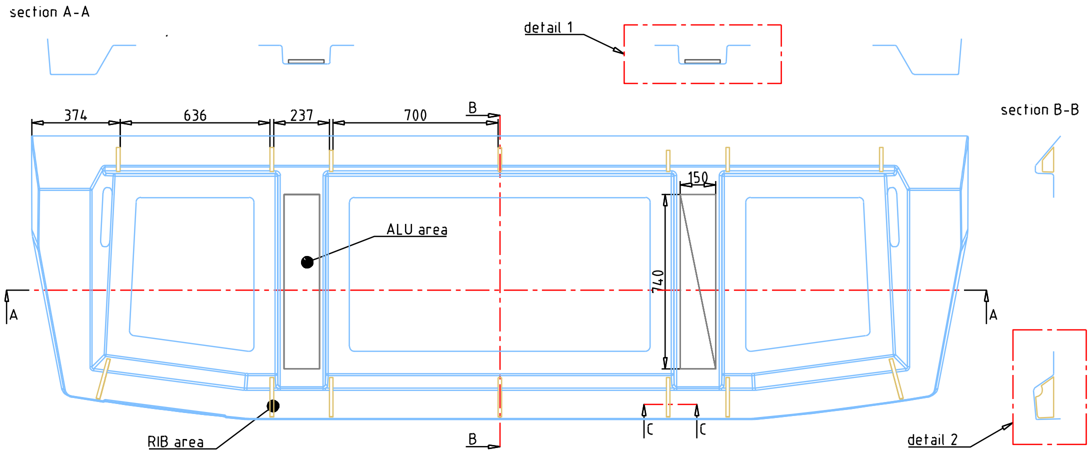
REV NO	REVISION NOTE	DATE	NAME	CHECK

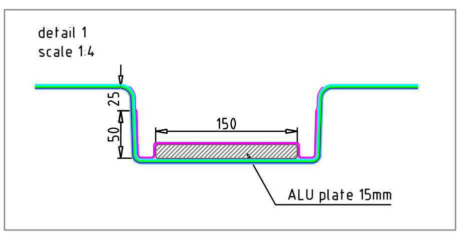






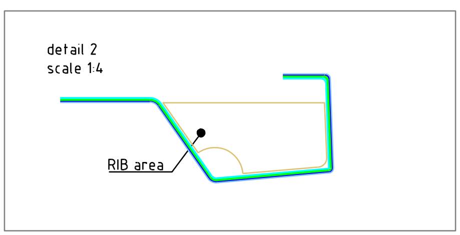
Project name:	F450 PLATFORM-B	J&J DESIGN We Create Winners.
Lamination:	Open mould (WET) / Simple surface	
Part weight:	38,4 kg	84,7 lb
Part area:	$4,5\ m^2$	$5,4\ yd^2$
Average:	$8,5\ kg/m^2$	$15,7\ lb/yd^2$
Nominal fibre content by mass according to EN ISO 12215		

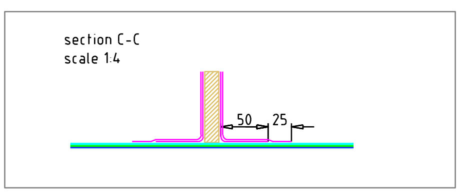
	Area		4,3 m2	0,2 m2	0,1 m2
		Ply	BASIC area	ALU area	RIBS area
		1	GC (type II)	GC (type II)	
		2	CSM 300	CSM 300	
		3	CSM 300	CSM 300	
		4	EBXS 600 M225	EBXS 600 M225	
		5	EBX 800	EBX 800	
		6		ALU plate 15mm	
		7		EBXS 600 M225	
		8		EBXS 600 M225	
		9			Plywood 15mm
		10			EBXS 600 M225
EU	Total dry fibre:		3.271 g/m2	45.433 g/m2	8.631 g/m2
	Total with resin:		6.100 g/m2	49.520 g/m2	9.760 g/m2
	Thickness:		4,1 mm	21,0 mm	16,0 mm
USA	Total w/dry:		96,5 oz/yd2	1340,0 oz/yd2	254,6 oz/yd2
	Total w/resin:		179,9 oz/yd2	1460,5 oz/yd2	287,9 oz/yd2
	Thickness:		0,16 in	0,83 in	0,63 in



INSTALLED material:	Weight:		Area:		Marg. [%]:
	[kg]	[lb]	$[m^2]$	$[yd^2]$	
GC (type II)	4,7	10,3	4,5	5,4	0
CSM 300	2,8	6,3	9,5	11,3	5
EBXS 600 M225	4,4	9,7	5,3	6,3	5
ALU plate 15mm	8,9	19,6	0,2	0,3	0
Plywood 15mm	0,7	1,5	0,1	0,1	0
EBX 800	3,8	8,3	4,7	5,7	5
POLYESTER (resin)	12,8	28,3			0
POLYESTER (hardener)	0,26	0,58			0
Total:	38,4 kg	84,7 lb	24,3 m2	29,0 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
EBXS 600 M225	(0/90 deg)	629	1,39	Double biaxial + matt
ALU plate 15mm	Solid	0	0,00	Aluminium plate
Plywood 15mm	Solid (5 layers)	500	1,10	Marine Plywood
EBX 800	(+45/-45 deg)	800	1,76	Double biaxial
POLYESTER (resin)	0			Resin
POLYESTER (hardener)	0			Hardener

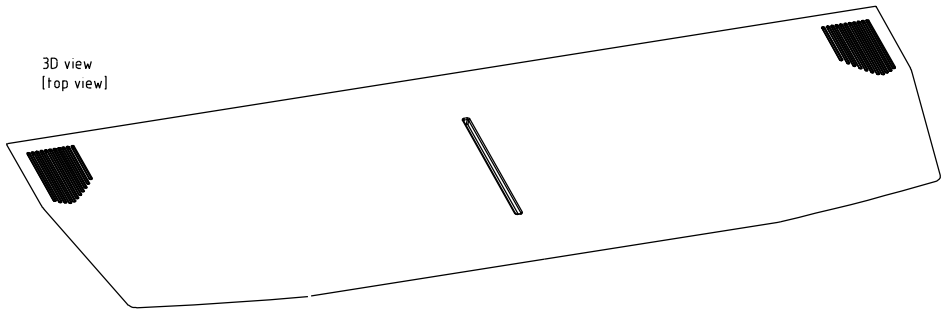


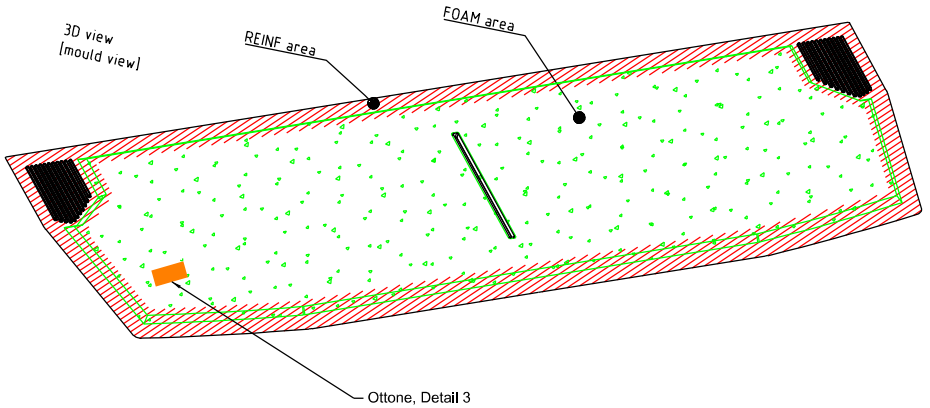


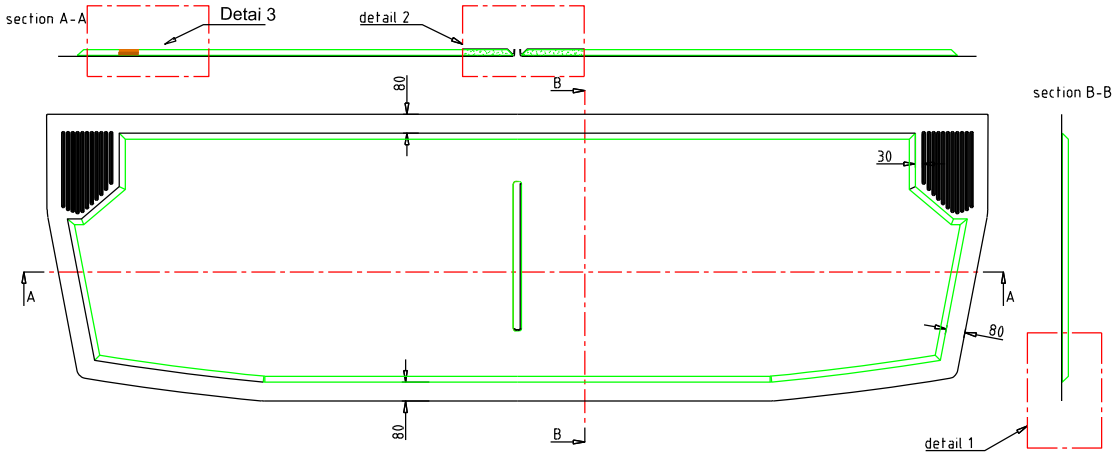
Important:
- during the lamination process environment temperature and humidity needs to be checked and recorded with temperature and humidity logger and comply with technical data sheets from suppliers
- resin/hardener ratio needs to be correct for ambient temperature
- all built in materials MUST have 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

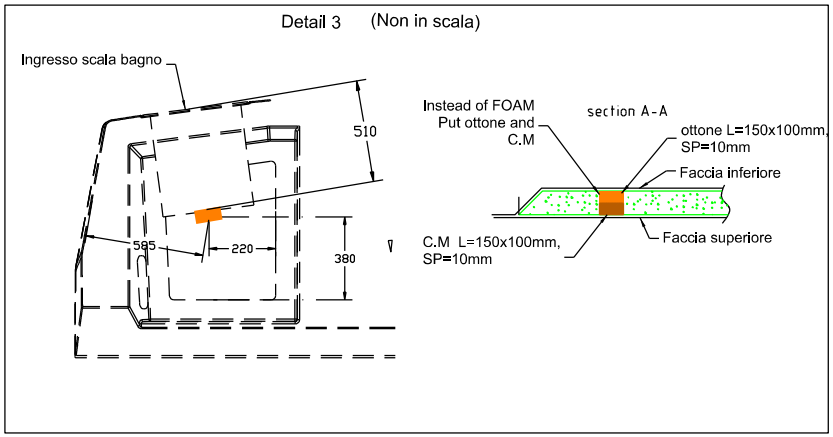
Drawing name:	Scale:	Date:	Drawn by:	Page:
BOTTOM part	1:16	13.5.2016	M. Prus	1 / 3
Subject: Ferretti F450				Page format: A2
File name: F450-00-00-ST-37-T00-ST-STD-3EU-B-Laminazione plancetta di poppa mobile-Swimming platform lamination.dwg				Approved: J&J

REV. NO.	REVISION NOTE	DATE	NAME	CHECK
A	□		J&J	
B	Aggiunto ottone per fissaggio scala bagno	24-11-2016	CH.MA□	









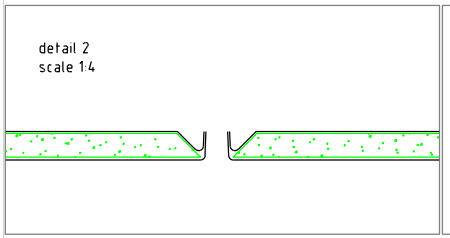
Project name:	F450 PLATFORM T	
Lamination:	Open mould (WET)	
	Simple surface	
Part weight:	42,7 kg	94,1 lb
Part area:	4,7 m²	5,6 yd²
Average:	9,1 kg/m²	16,7 lb/yd²

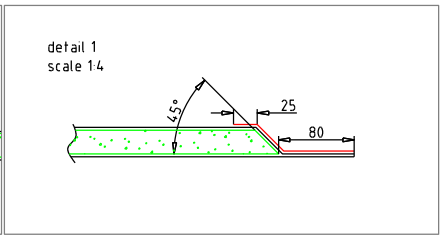
Nominal fibre content by mass according to EN ISO 12215

Area		1,1 m2	3,6 m2	1,2 m2
	Ply	BASIC area	FOAM area	REINF area
	1	GC (type II)	GC (type II)	
	2	CSM 300	CSM 300	
	3	CSM 300	CSM 300	
	4	EBXS 600 M225	EBXS 600 M225	
	5		PVC 80 25mm (S)	
	6	EBXS 600 M225	EBXS 600 M225	
	7			EBX 800
EU	Total dry fibre:	3.302 g/m2	5.302 g/m2	0.800 g/m2
EU	Total with resin:	5.960 g/m2	9.335 g/m2	1.600 g/m2
EU	Thickness:	4,1 mm	29,1 mm	1,0 mm
USA	Total w/dry:	97,4 oz/yd2	156,4 oz/yd2	23,6 oz/yd2
USA	Total w/resin:	175,8 oz/yd2	275,3 oz/yd2	47,2 oz/yd2
USA	Thickness:	0,16 in	1,15 in	0,04 in

INSTALLED material:	Weight: [kg]	Weight: [lb]	Area: [m²]	Area: [yd²]	Marg. [%]:
GC (type II)	4,9	10,8	4,7	5,6	0
CSM 300	3,0	6,5	9,9	11,8	5
EBXS 600 M225	8,2	18,1	9,9	11,8	5
PVC 80 25mm (S)	7,2	15,9	3,6	4,3	0
EBX 800	1,0	2,2	1,3	1,5	5
POLYESTER (resin)	18,0	39,8			0
POLYESTER (hardener)	0,37	0,81			0
Total:	42,7 kg	94,1 lb	29,3 m2	35,0 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
EBXS 600 M225	[0/90 deg]	629	1,39	Double biaxial + matt
PVC 80 25mm (S)	Solid	1375	3,03	PVC foam
EBX 800	[+45/-45 deg]	800	1,76	Double biaxial
POLYESTER (resin)	0			Resin
POLYESTER (hardener)	0			Hardener



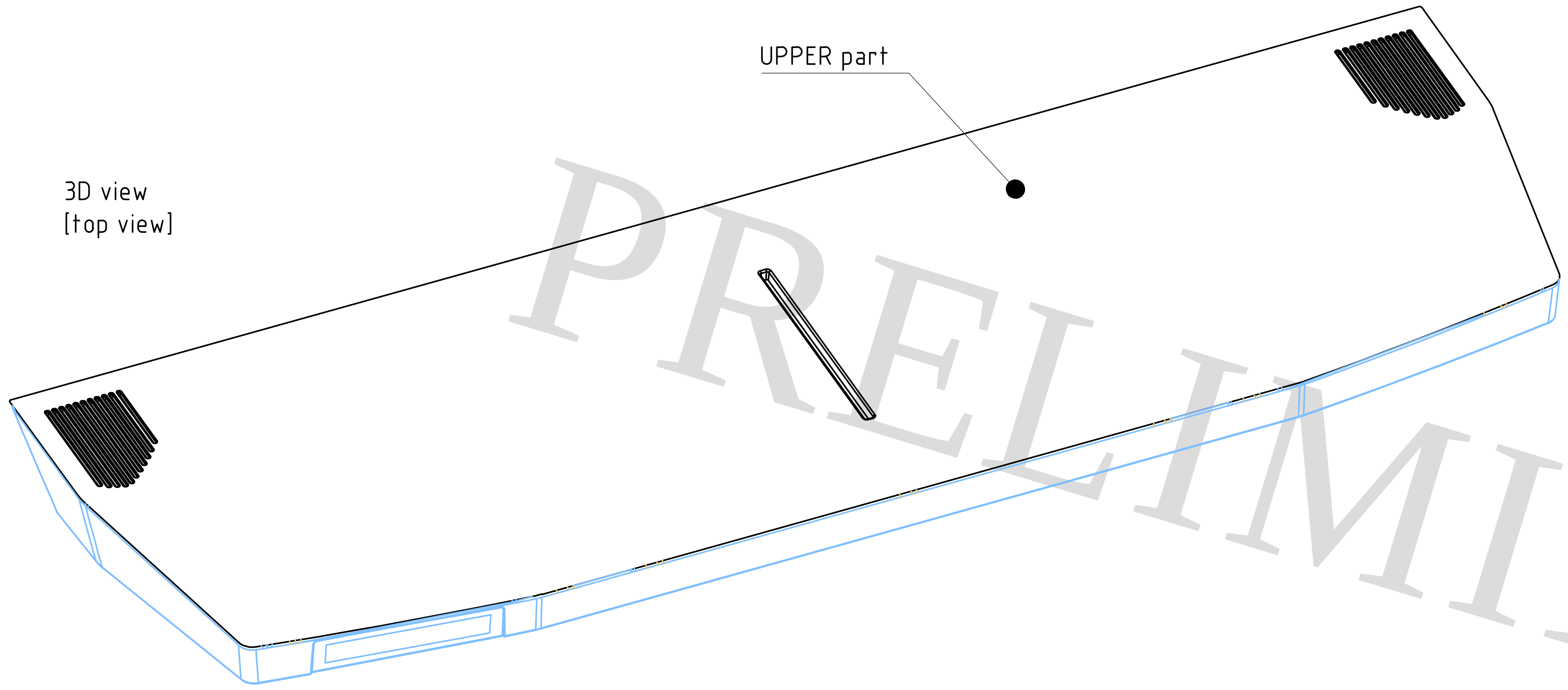


Important:
- during the lamination process environment temperature and humidity needs to be checked and recorded with temperature and humidity logger and comply with technical data sheets from suppliers
- resin/hardener ratio needs to be correct for ambient temperature
- all built in materials MUST have 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

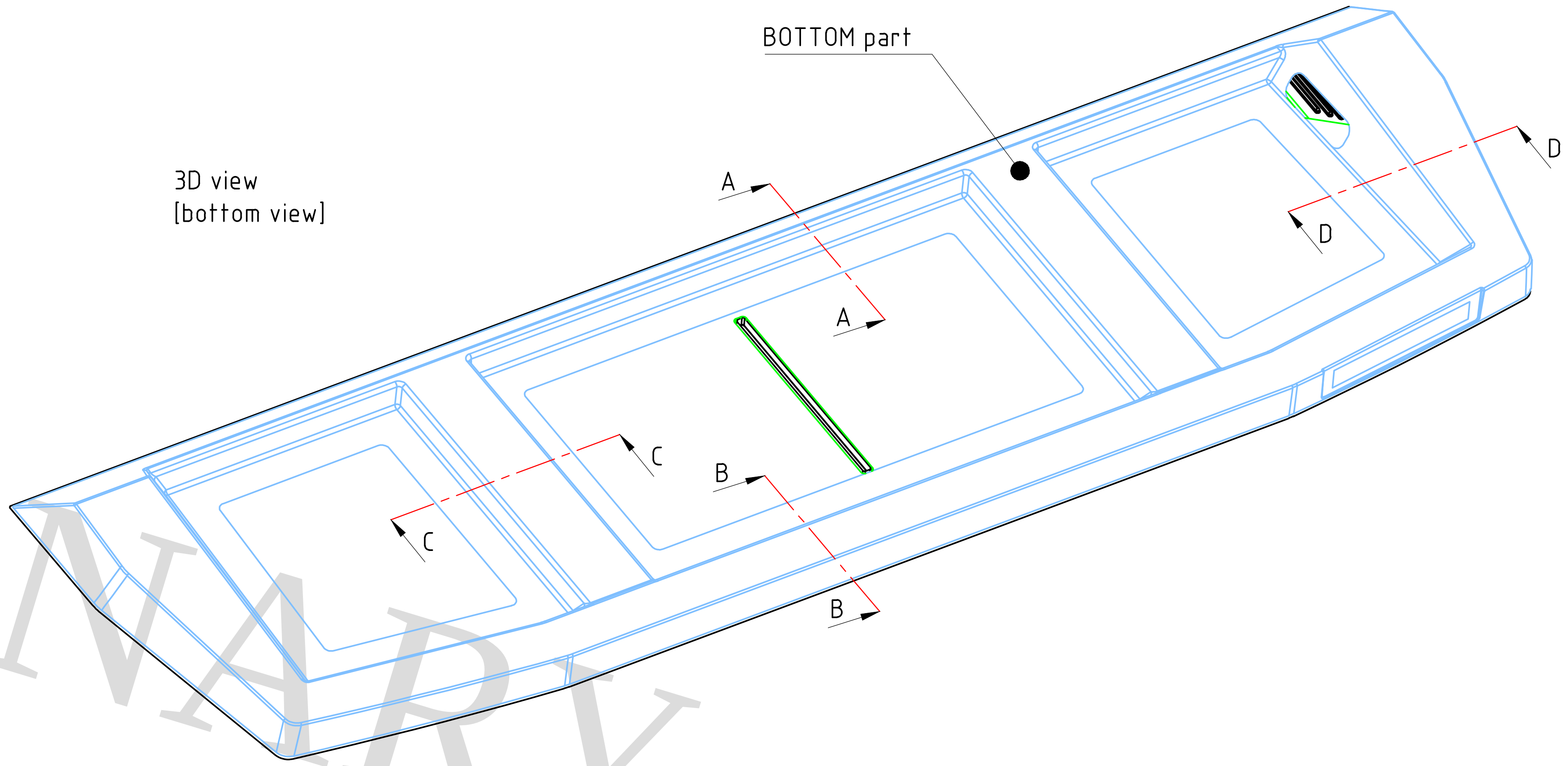
	Drawing name: UPPER part	Scale: 1:16	Date: 13.5.2016	Drawn by: M.Prus	Page: 2 / 3
	Subject: Ferretti F450				Page format: A2
File name: F450-00-00-ST-37-T00-ST-STD-3EU-B-Laminazione plancetta di poppa mobile-Swimming platform lamination.dwg					Approved: J&J

REV. NO.	REVISION NOTE	DATE	NAME	CHECK

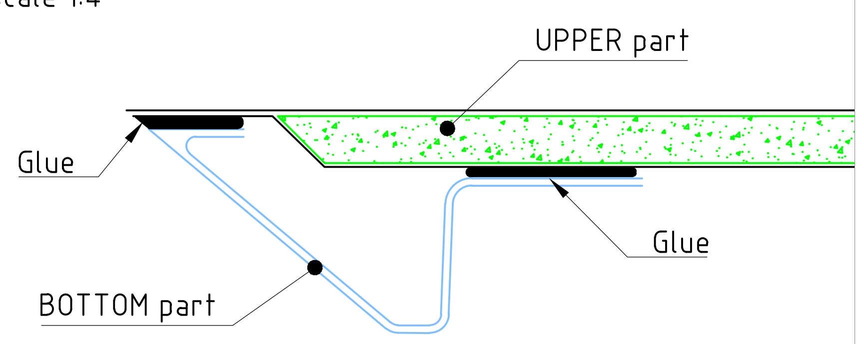
3D view
[top view]



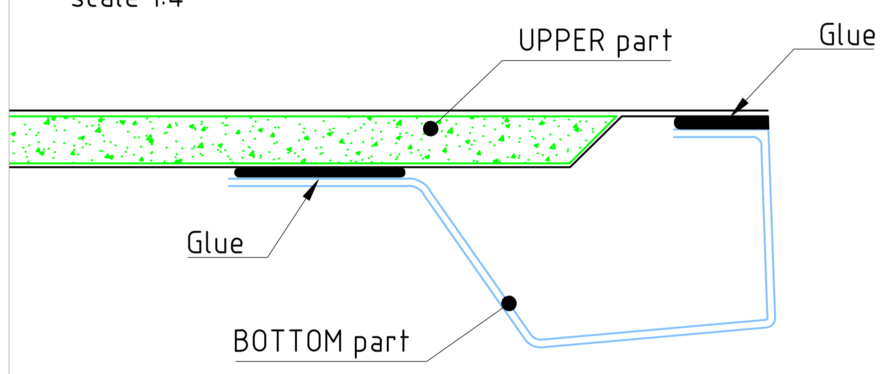
3D view
[bottom view]



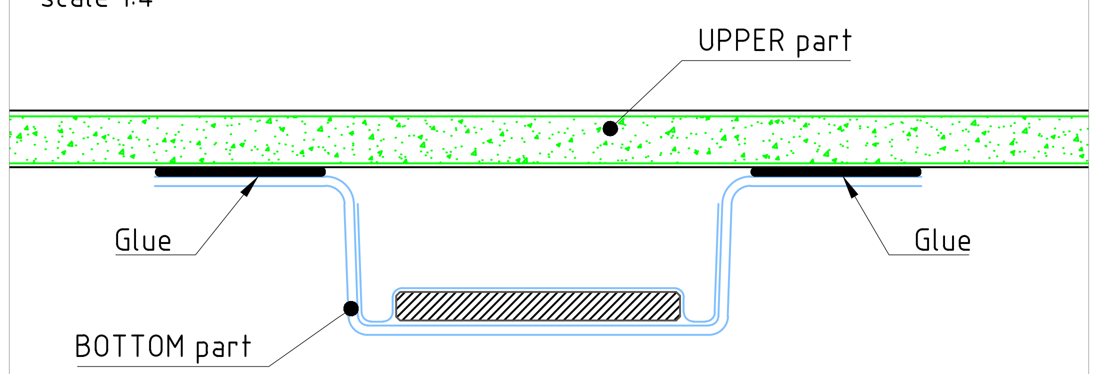
section A-A
scale 1:4



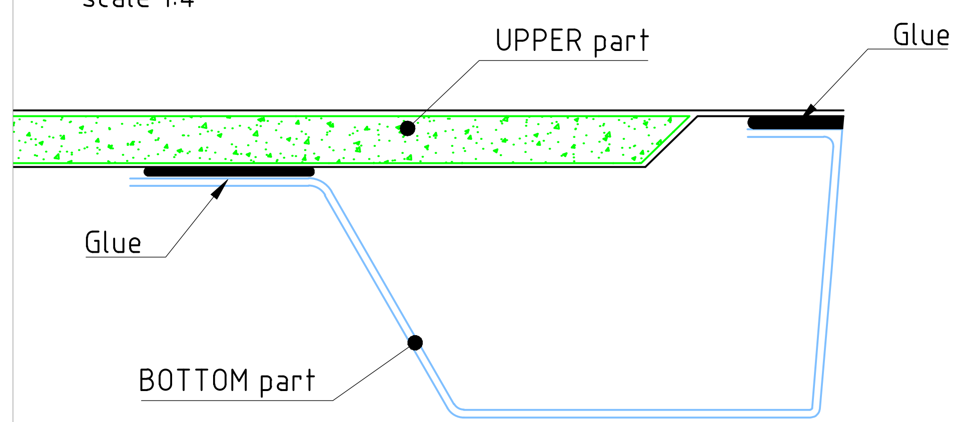
section B-B
scale 1:4



section C-C
scale 1:4



section D-D
scale 1:4



Note:

-UPPER part	42,7kg
-BOTTOM part	38,4kg
-GLUE	2,0kg
Total weight:	83,1 kg

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
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Drawing name:	Scale:	Date:	Drawn by:	Page:
ASSEMBLY	1:16	13.5.2016	M. Prus	3 / 3
Subject: Ferretti F450				Page format: A2
File name: F450-00-00-ST-37-T00-ST-STD-3EU-A-Laminazione plancetta di poppa mobile-Swimming platform lamination.dwg				Approved: J&J

Drawing location: