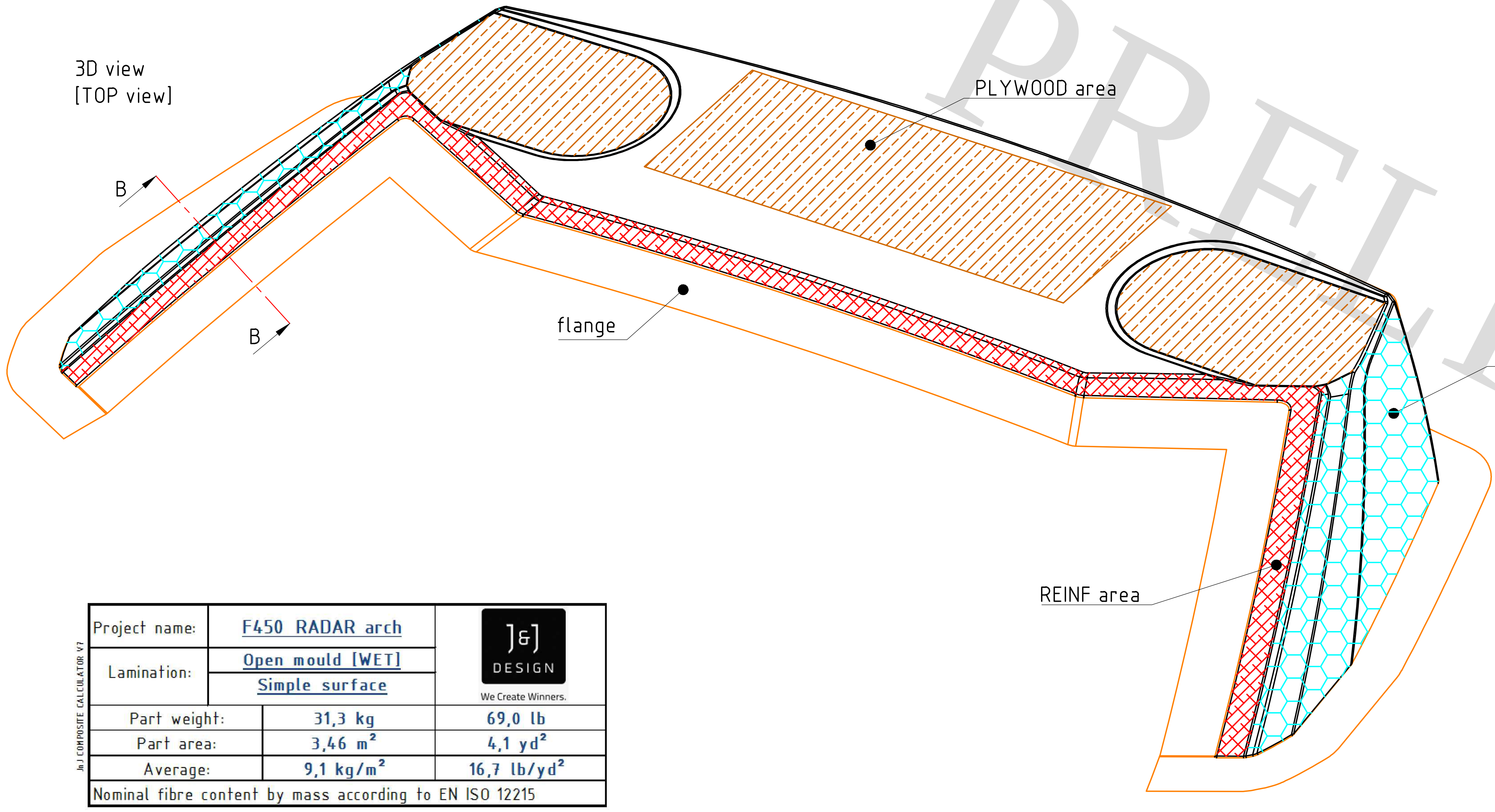
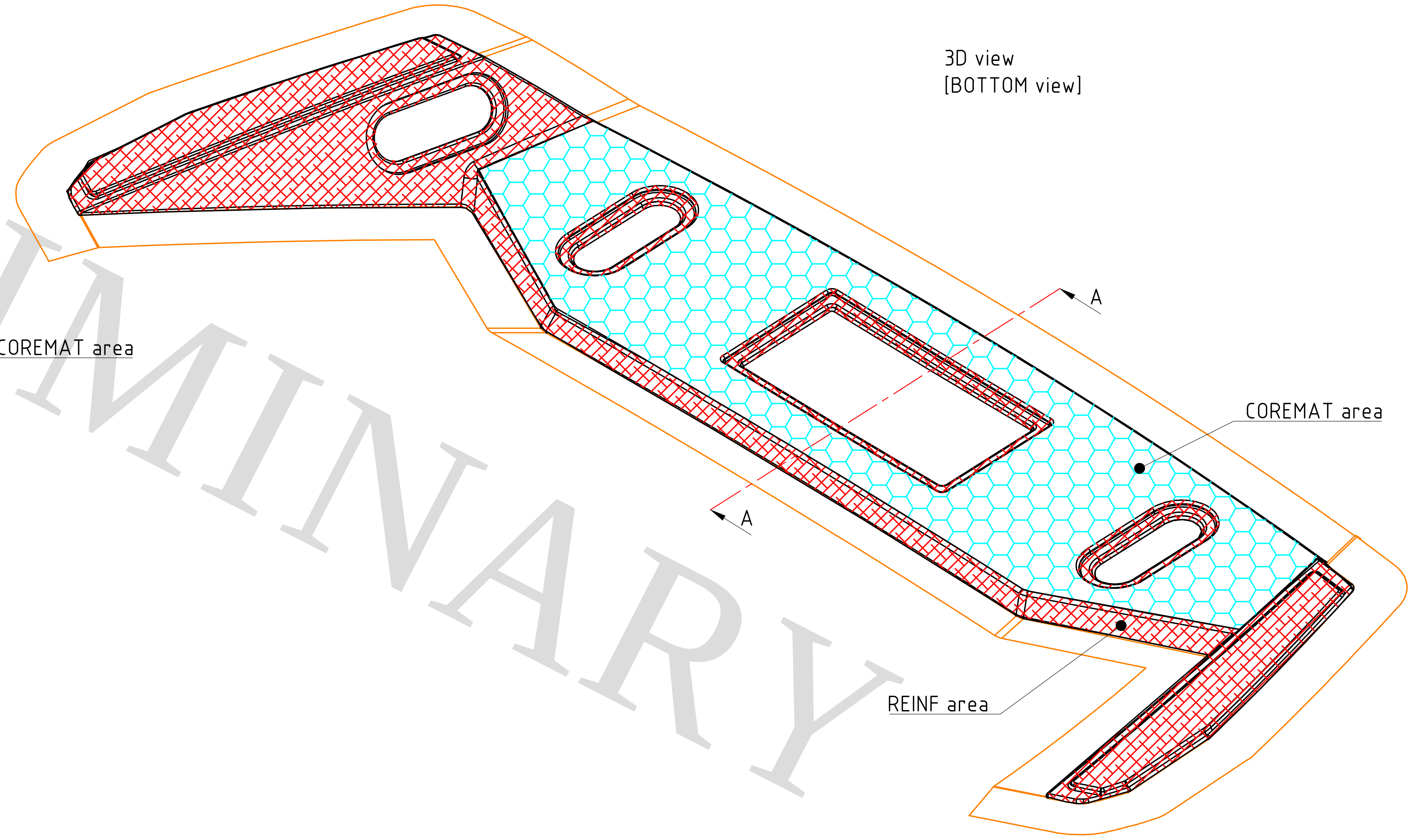
REV. NO.	REVISION NOTE	DATE	NAME	CHECK



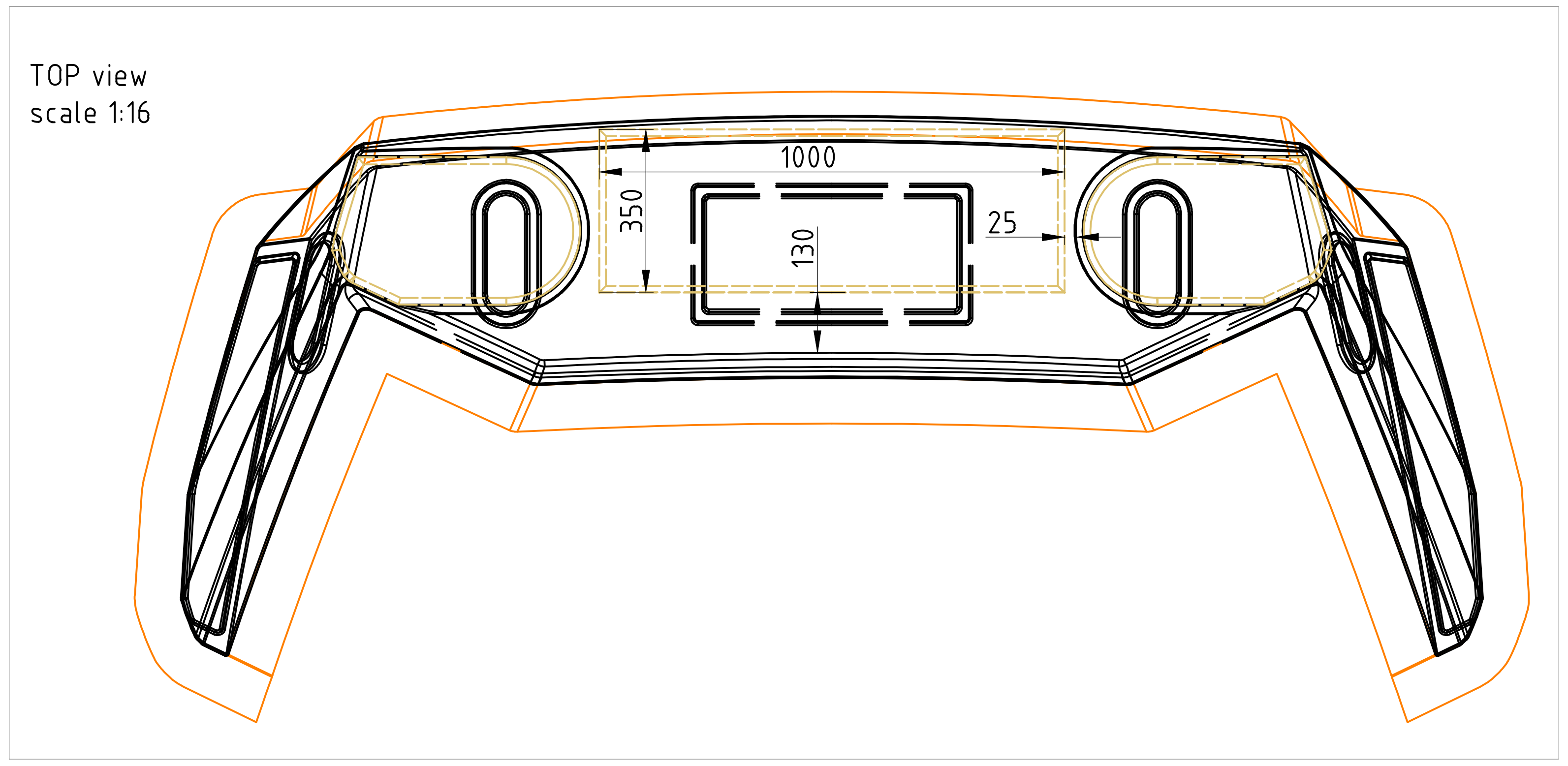


Project name:	F450 RADAR arch	J&J DESIGN We Create Winners.
Lamination:	Open mould [WET] / Simple surface	
Part weight:	31,3 kg	69,0 lb
Part area:	3,46 m^2	4,1 yd^2
Average:	9,1 kg/m^2	16,7 lb/yd^2
Nominal fibre content by mass according to EN ISO 12215		

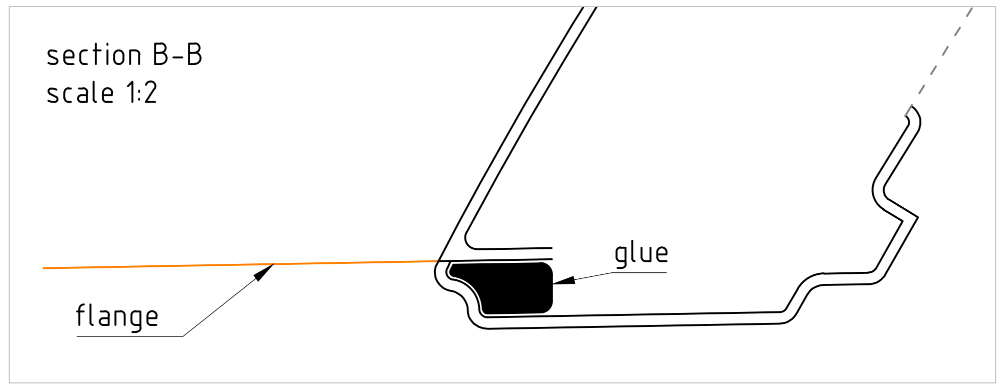
JnJ COMPOSITE CALCULATOR V7

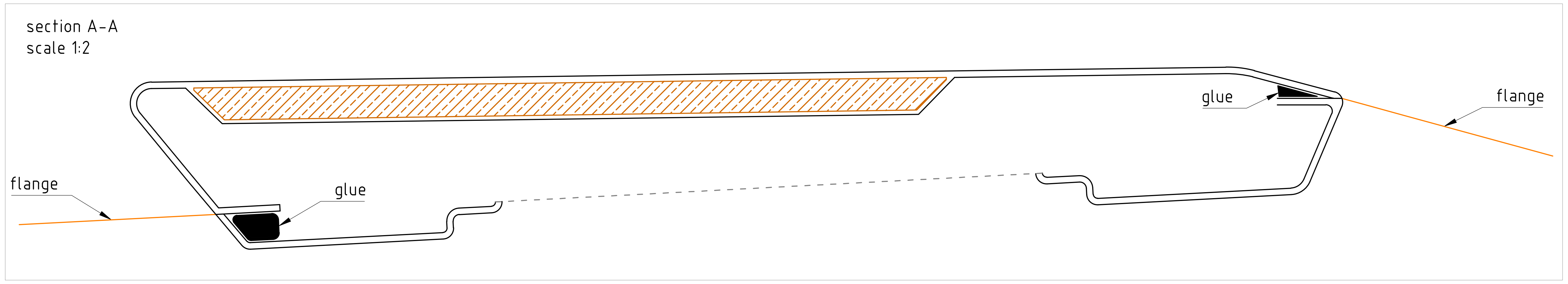
	Area		1,8 m2	0,65 m2	1,0 m2	1,0 m2
		Ply	BASIC area	PLYWOOD area	COREMAT area	REINF area
	Skin	1	GC (type II)	GC (type II)	GC (type II)	
		2	CSM 300	CSM 300	CSM 300	
		3	CSM 300	CSM 300	CSM 300	
		4			XM 3 (3 mm)	
		5	EBXS 600 M225	EBXS 600 M225	EBXS 600 M225	
		6		Plywood 15mm		
		7	EBXS 600 M225	EBXS 600 M225	EBXS 600 M225	
		8				EBX 800
		9				EBX 800
EU	Total dry fibre:		3.302 g/m2	11.102 g/m2	3.430 g/m2	+1.600 g/m2
EU	Total with resin:		5.960 g/m2	14.260 g/m2	7.588 g/m2	+3.200 g/m2
EU	Thickness:		4,1 mm	19,1 mm	7,1 mm	+2,0 mm
USA	Total w/dry:		97,4 oz/yd2	327,4 oz/yd2	101,2 oz/yd2	+47,2 oz/yd2
USA	Total w/resin:		175,8 oz/yd2	420,6 oz/yd2	223,8 oz/yd2	+94,4 oz/yd2
USA	Thickness:		0,16 in	0,75 in	0,28 in	+0,08 in

INSTALLED material:	Weight:		Area:		Marg. [%]:
	[kg]	[lb]	[m^2]	[yd^2]	
GC (type II)	3,6	7,9	3,5	4,1	0
CSM 300	2,2	4,8	7,3	8,7	5
EBXS 600 M225	6,0	13,3	7,3	8,7	5
XM 3 (3 mm)	0,1	0,3	1,0	1,2	0
Plywood 15mm	5,1	11,2	0,7	0,8	0
EBX 800	1,7	3,7	2,1	2,5	5
POLYESTER (resin)	12,4	27,3			0
POLYESTER (hardener)	0,25	0,56			0
Total:	31,3 kg	69,0 lb	21,7 m2	26,0 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
XM 3 (3 mm)	Core material	1500	3,31	Core material&Print through barrier (OPEN MOULD process)
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:
RADAR arch	1:10	12.5.2016	M. Prus	1 / 1
Subject: Ferretti F450				Page format: A2
File name: F450-00-00-ST-26-T00-ST-STD-3EU-A-Laminazione roll bar-Radar arch lamination.dwg				Approved: J&J

Drawing location: