



## sphere : core SP

### Preparation:

1. Cut Sphere.core SP and the covering glass layers in the required shape. Sphere.core SP can easily be cut by using scissors or a knife.
2. Calculate the amount of resin needed for covering layers and core materials. For Sphere.core SP you will need approx. 600 g/m<sup>2</sup>/mm.  
Example: Sphere.core SP 3,0 mm: 600g\*3mm = approx. 1800 g resin per m<sup>2</sup>.

### Lamination:

3. Apply gelcoat if required and let it cure.
4. Laminate the covering glass layers as usually and de-aerate them.
5. In case the core material is  $\geq 3$  mm, apply approx. 30% of the required amount of resin (i.e. 600 g/m<sup>2</sup> for a 4,0 mm core material) on one side of Sphere.core SP.
6. Then place this side of Sphere.core SP onto the previously laminated glass layers.
7. Continue by adding resin onto Sphere.core SP and spread it by using the lamb wool roller.
8. De-aerate Sphere.core SP.
9. Continue to laminate subsequent covering layers and de-aerate them as usually.

**The result after curing is a homogenous laminate  
with good mechanical properties.**



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