


## sphere core SBC

### Preparations:

1. Cut Sphere.core SBC and the covering glass layers in the required shape. Sphere.core SBC can easily be cut by using knife or scissors.
2. Calculate the required amount of resin for all layers. For Sphere.core SBC you will need approx. 400-450 g/m<sup>2</sup>/mm: e.g. Sphere.core SBC 8,0 mm = approx. 3,2 kg resin.
3. Sphere.core SBC is compatible with UP and VE resin. We recommend to use standard resin for hand lay up process. Best results are achieved when using resin with a viscosity of approx. 350-600 mPas. If you are not sure if your type of resin can be used, you may laminate a small piece of Sphere.core SBC for testing. If the resin is absorbed from the material within 20-30 seconds, the resin can be used for laminating Sphere.core SBC.

### Lamination:

4. Laminate the first glass layers on the gelcoated mold as usually and de-aerate these layers.

Important notice for thick laminates: Adjust your resin system to control exothermic reaction at low level. 

The first glass layers can be laminated in one shot and cure before continuing with the core. However, Sphere.core SBC should always be laminated onto one glass layer wet-in-wet to ensure perfect bonding of core and covering layers.

5. Firstly impregnate the zig-zag side of Sphere.core SBC with approx. half of the resin amount that is required for the core.
6. Place Sphere.core SBC onto the previously laminated glass layers with the zig-zag side facing the mold. Impregnate Sphere.core SBC until the recommended amount of resin is used and de-aerate the material.
7. While de-aerating, Sphere.core SBC can easily be shaped. The edges are flattened by slight pressure of the roller. During this step you may also flatten overlapping parts or connect adjoining layers of Sphere.core SBC
8. Continue by laminating the covering glass layers onto Sphere.core SBC and de-aerate them as usually

**The result after curing is a light and yet strong laminate with high impact, bending and shear strength.**



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