

OVERVIEW FINISHING OPTIONS

Issue 06.2018 –
Replaces 04.2010

AIREX® structural foam core material

- / ContourKore, knife cut (CK kc)
- / ContourKore, saw cut (CK sc)
- / Mini ContourKore (MCK)
- / Double Cut knife cut (DC kc)
- / Double Cut saw cut (DC sc)
- / Perforated (P)
- / Semi-ContourKore, Grooved & Perforated (GPS)
- / Grooved (G)
- / AIREX® SealX surface sealing (SX)
- / Precision Thickness (PRE)
- / Single Cut (SC)

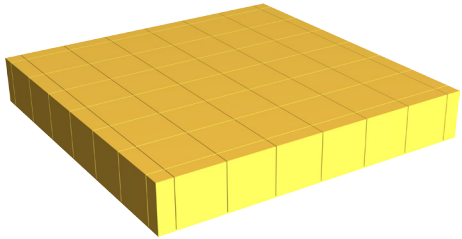
BALTEK® structural balsa core material

- / ContourKore (CK)
- / Grooved (G)
- / Grooved & Perforated (GP)
- / Semi-ContourKore, Grooved & Perforated (GPS)
- / Perforated (P)
- / Precision Thickness (PRE)
- / Surface Finish (LP and AL)

Rating of Finishing Options regarding specific requirements

most suitable ●●● suitable ●● ok ●

ContourKore, knife cut (CK kc)



- / 1.18" x 1.18" bloc pattern
- / kerf width approx. 1/64"
- / glass fiber cloth on bottom side of sheet
- / blocs are cut almost down to cloth

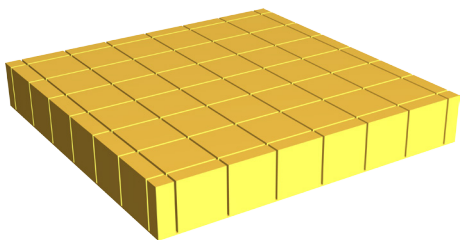
Sheet flexibility ●●●

Resin uptake ●●●

Promotes resin flow in infusion ●

Laminate surface quality ●●●

ContourKore, saw cut (CK sc)



- / 1.18" x 1.18" bloc pattern (1 1/2" x 1 1/2" if sheet is ≥ 1")*
- / kerf width 0.035" (0.055" if sheet is ≥ 1")*
- / glass fiber cloth on bottom side of sheet
- / blocs are cut almost down to cloth
- *may be < 1" depending on product type and density

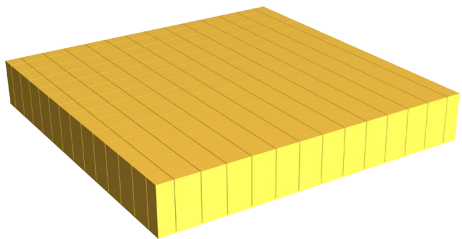
Sheet flexibility ●●●

Resin uptake ●●

Promotes resin flow in infusion ●●

Laminate surface quality ●●

Mini ContourKore (MCK)



- / 0.59" x 0.59" bloc pattern
- / kerf width approx. 1/64"
- / glass fiber cloth on bottom side of sheet
- / blocs are cut almost down to cloth

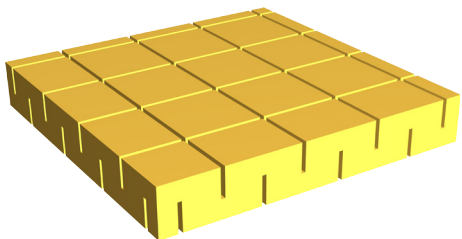
Sheet flexibility ●●●

Resin uptake ●●

Promotes resin flow in infusion ●●

Laminate surface quality ●●●

Double Cut (DC)



- Double Cut, knife cut (DC kc)**
- / cross grooved both sides
 - / groove depth 60% of thickness
 - / 1.18" x 1.18" bloc pattern
 - / kerf width approx. 1/64"
 - / groove offset both sides 0.59"

- Double Cut, saw cut (DC sc)**
- / cross grooved both sides
 - / groove depth 60% of thickness
 - / 1.18" x 1.18" bloc pattern
 - / (1 1/2" x 1 1/2" if sheet is ≥ 1 1/4")*
 - / kerf width approx. 0.035"
 - / (0.055" if sheet is 1 1/4")*
 - / groove offset both sides 0.59" (3/4")
 - * may be < 1" depending on product type and density

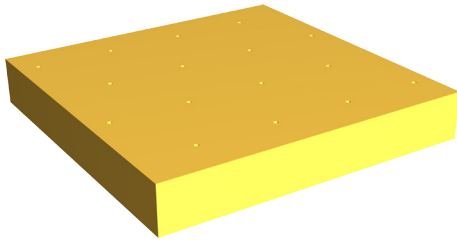
Sheet flexibility ●●

Resin uptake ●

Promotes resin flow in infusion ●

Laminate surface quality ●●

Perforated (P)



- / punched holes (dia. approx. 0.079"), if sheets $\leq 2"$
- / drilled holes (dia. $\frac{1}{8}"$)
- / hole distance 2"
- * required for certain densities (max. sheet width 24")

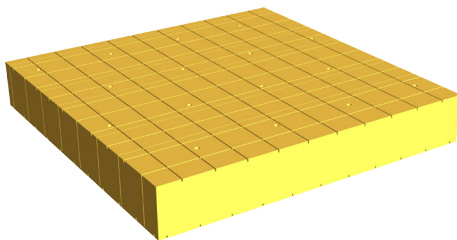
Sheet flexibility

Resin uptake ●●●

Promotes resin flow in infusion ●

Laminate surface quality ●●●

Semi-ContourKore, Grooved & Perforated (GPS)



- / CK in one direction 1.18" block (1 $\frac{1}{2}"$)
- / cross grooved both sides
- / groove width 0.024", depth approx. $\frac{1}{16}"$
- / grooving distance $\frac{3}{4}"$ (no offset)
- / perforated hole dia. approx. 0.079"*; hole distance 2"
- * some products may require drilled holes (dia. $\frac{1}{8}"$), max. sheet width 24"

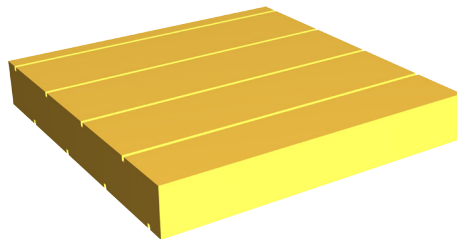
Sheet flexibility

Resin uptake ●●

Promotes resin flow in infusion ●●●

Laminate surface quality ●

Grooved (G)



- / parallel or crosswise grooves
- / one side or both sides
- / groove width 0.024", depth approx. $\frac{1}{16}"$
- / grooving distance $\frac{3}{4}"$ (no offset)

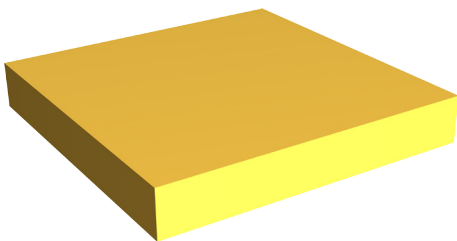
Sheet flexibility

Resin uptake ●●

Promotes resin flow in infusion ●●●

Laminate surface quality ●●●

AIREX® SealX surface sealing (SX)



- / surface sealing for AIREX® PET foams
- / available for AIREX® T90 and T92 (densities up to 130 kg/m³)
- / designed for resin infusion
- / considerable reduction of resin uptake in infusion processes

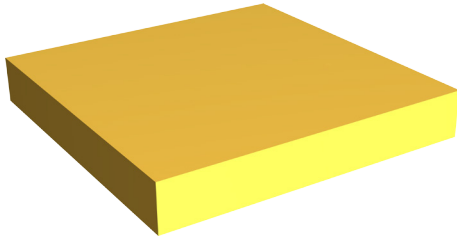
Sheet flexibility

Resin uptake ●●●

Promotes resin flow in infusion

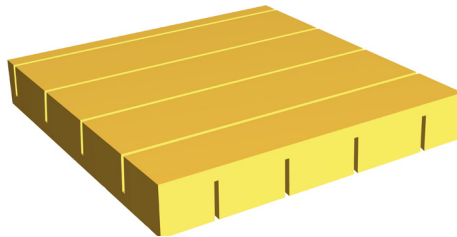
Laminate surface quality

Precision Thickness (PRE)



/ -0.010" / +0.010" (-0.25mm / +0.25mm)

Single Cut (SC)



- / grooved both sides (opposite direction)
 - / groove depth 85% of thickness
 - / groove distance 1.18" (1 1/2" if sheet is ≥ 1")*
 - / kerf width 0.035" (0.055" if sheet is ≥ 1")*
 - / groove offset 0.59" (3/4")
- * may be < 1" depending on product type and density

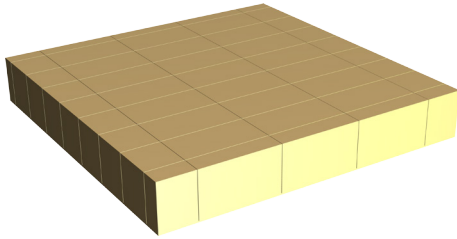
Sheet flexibility ●●

Resin uptake ●

Promotes resin flow in infusion ●●

Laminate surface quality ●

ContourKore (CK)



- / 1" x 2" bloc pattern (2" x 2" if sheet is $\geq 2'$ *)
- / kerf width $\frac{1}{64}$ "
- / glass fiber cloth on bottom side of sheet
- / blocs are cut almost down to cloth
- * SB.150 $\geq 1'$

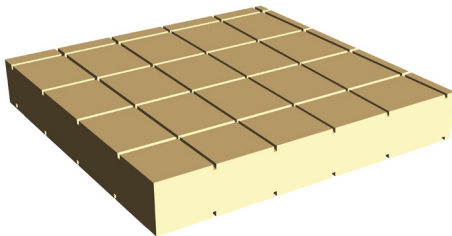
Sheet flexibility ●●●

Resin uptake ●●●

Promotes resin flow in infusion ●●

Laminate surface quality ●●●

Grooved (G)



- / cross grooved both sides
- / groove width 0.024", depth approx. $\frac{1}{16}$ "
- / groove distance $\frac{3}{4}$ " (no offset)

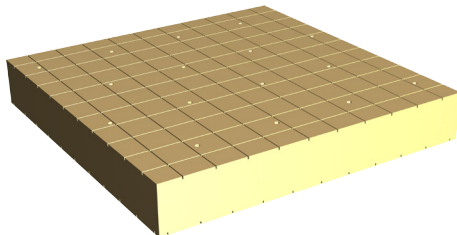
Sheet flexibility

Resin uptake ●●

Promotes resin flow in infusion ●●●

Laminate surface quality ●●●

Grooved & Perforated (GP)



- / cross grooved both sides
- / groove width 0.024", depth approx. $\frac{1}{16}$ "
- / groove distance $\frac{3}{4}$ " (no offset)
- / perforated hole dia. approx. $\frac{1}{8}$ "*
- / hole distance 2", option: hole distance 1", sheets $\leq 2'$
- * drilled holes (dia. $\frac{1}{8}$ " for sheet thickness $> 2'$ and all SB.150)

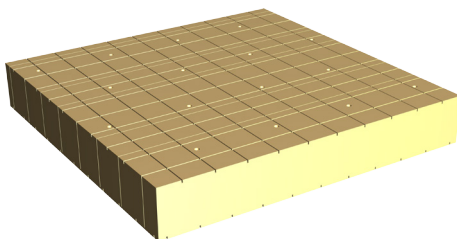
Sheet flexibility

Resin uptake ●●

Promotes resin flow in infusion ●●●

Laminate surface quality ●●●

Semi-ContourKore, Grooved & Perforated (GPS)



- / CK in one direction, 2" block
- / cross grooved both sides
- / groove width 0.024", depth approx. $\frac{1}{16}$ "
- / groove distance $\frac{3}{4}$ " (no offset)
- / perforated hole dia. approx. $\frac{1}{8}$ "*
- / hole distance 2", option: hole distance 1" or CK 1" block, sheets 2"
- * drilled holes (dia. $\frac{1}{8}$ " for sheet thickness 2" and all SB.150)

Sheet flexibility ●●

Resin uptake ●●

Promotes resin flow in infusion ●●●

Laminate surface quality ●●●

Perforated (P)

- / punched holes (dia. approx. $\frac{1}{8}$ "),
 - / sheets ≤ 2 "
 - / drilled holes (dia. approx. $\frac{1}{8}$ ")
 - / hole distance approx. 2",
 - / option: punched holes, distances (1"), sheets ≤ 2 "
- * all SB.150

Precision Thickness (PRE)

- / -0.010 " / $+0.010$ "
(-0.25 mm / $+0.25$ mm)

Surface Finish

- / LamPrep (LP) [uncoated]
- / AL600 (AL) [special surface sealer]