

OVERVIEW FINISHING OPTIONS

Issue 10.2020 –
Replaces 06.2018

AIREX[®] structural foam core material

- / ContourKore, knife cut & saw cut (CK kc & CK sk)
- / Single Cut (SC)
- / Double Cut, knife cut & saw cut (DC kc & DC sk)
- / Perforated (P)
- / Grooved (G)
- / Grooved & Perforated (GP)
- / Grooved, Perforated & Semi-ContourKore (GPS)
- / Cross Cut (XC)
- / SealX surface sealing (SX)
- / Precision Thickness (PRE)

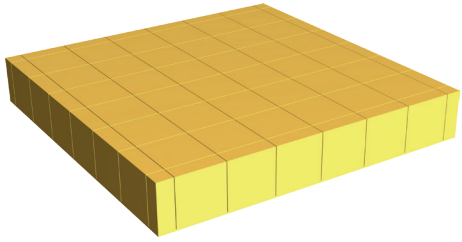
BALTEK[®] structural balsa core material

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

Rating of Finishing Options regarding specific requirements

most suitable ●●● suitable ●● ok ●

ContourKore (CK)



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
- / max. thickness 1 1/4" depending on product type and density

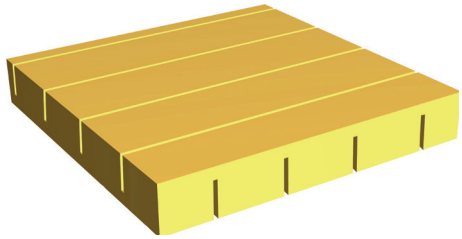
ContourKore, saw cut (CK sk)

- / 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
- / max. thickness 2"

* may be < 1" depending on product type and density

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|-------|-------------------|--------------|---------------------------------|--------------------------|
| CK kc | ••• | •• | • | •• |
| CK sk | ••• | • | • | • |

Single Cut (SC)

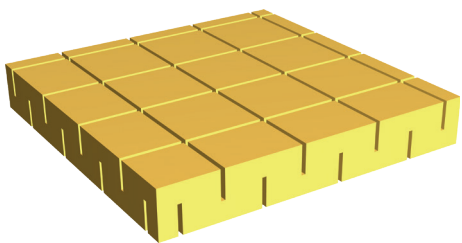


- / grooved both sides (opposite direction)
- / groove depth 85% of thickness
- / groove distance 1.18" (1 1/2" if sheet is ≥ 1") *
- / kerf width 0.035" (0.055" if sheet is ≥ 1") *
- / groove offset 0.59" (3/4")
- / max. thickness 2"

* may be < 1" depending on product type and density

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|----|-------------------|--------------|---------------------------------|--------------------------|
| SC | • | • | • | • |

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"
- / max. thickness 1" depending on product type & density

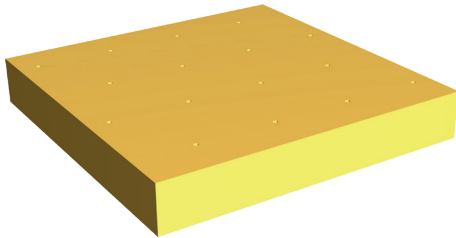
Double Cut, saw cut (DC sk)

- / 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")
- / max. thickness 2"

* may be < 1" depending on product type and density

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|-------|-------------------|--------------|---------------------------------|--------------------------|
| DC kc | •• | •• | •• | •• |
| DC sk | ••• | • | • | • |

Perforated (P)



P40 (standard)

- / AIREX® T90/92 - drilled holes (dia. approx. 0.098")
- / AIREX® C70/71 - punched holes (dia. approx. 0.079")
- / hole distance 1.57"
- / square pattern

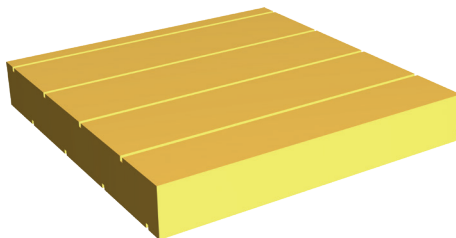
P20

- / punched holes (dia. approx. 0.079")
- / hole distance 0.79"
- / squared pattern

- / max. thickness 2" (depending on density)
- / >2" thick & other options available by CnC only

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|-----|-------------------|--------------|---------------------------------|--------------------------|
| P40 | | ••• | • | ••• |
| P20 | | •• | •• | ••• |

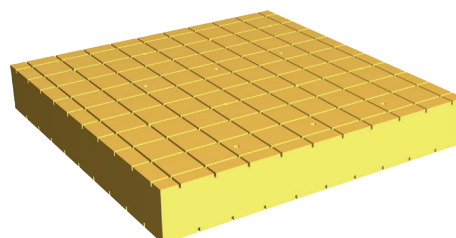
Grooved (G)



- / one or two directions
- / single side or both sides
- / groove width 0.024", depth approx. 1/16"
- / grooving distance 3/4" (offset <1/2" thick)
- / max. thickness 2"

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|---|-------------------|--------------|---------------------------------|--------------------------|
| G | | ••• | ••• | ••• |

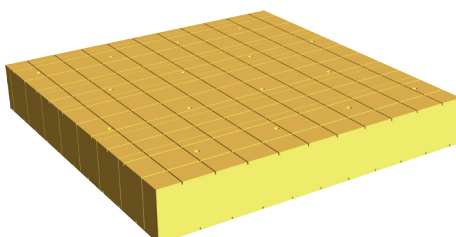
Grooved & Perforated (GP)



- / Grooved (G) in two directions
- / Option 1 cross grooved both sides, perforation pattern P40 (GP)
- / Option 2 cross grooved one side only, perforation pattern P20 (G1SP)

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|------|-------------------|--------------|---------------------------------|--------------------------|
| GP | | •• | ••• | ••• |
| G1SP | | ••• | ••• | ••• |

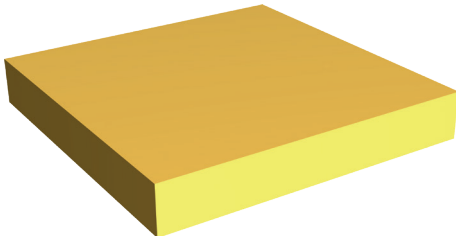
Grooved, Perforated & Semi-ContourKore (GPS)



- / CK in one direction 1.18" block (1.38" certain densities & thickness)
- / Option 1 cross grooved both sides, perforation pattern P40 (GPS)
- / Option 2 cross grooved one side only, perforation pattern P20 (G1PS)

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|------|-------------------|--------------|---------------------------------|--------------------------|
| GPS | • | •• | ••• | ••• |
| G1PS | • | ••• | ••• | ••• |

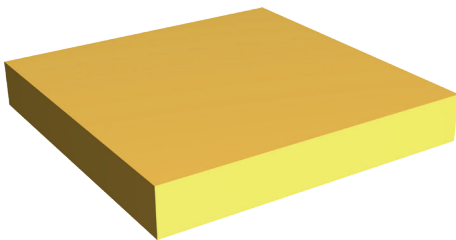
Cross Cut (XC)



- / ContourKore, knife cut
- / plus diagonal cuts across the sheet (45°)
- / kerf width approx. 1/64"
- / diagonal kerf spacing 75 mm
- / limited product densities & thickness range

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|----|-------------------|--------------|---------------------------------|--------------------------|
| XC | ●●● | ●● | ●● | ●● |

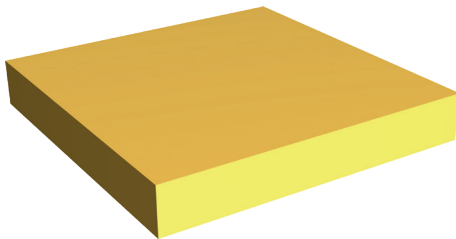
SealX surface sealing (SX)



- / min. thickness 1/2" (3/8" by special order only)

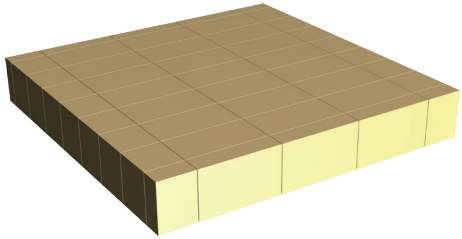
| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|----|-------------------|--------------|---------------------------------|--------------------------|
| SX | | ●●● | | |

Precision Thickness (PRE)



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

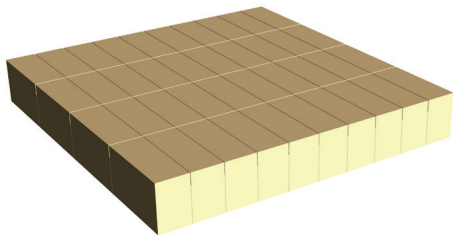
ContourKore (CK)



- / 1" x 2" bloc pattern (l x w)
- / kerf width 1/64"
- / glass fiber cloth on bottom side of sheet
- / blocs are cut almost down to cloth
- / SB.50/100: sheets up to 2 1/4" thickness
- / SB.150: sheets up to 1 1/2" thickness

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|----|-------------------|--------------|---------------------------------|--------------------------|
| CK | ●●● | ●● | ●● | ●● |

Adaptive ContourKore (ACK)

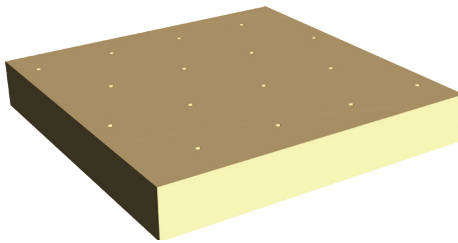


- / CK cut with alternative block size

| FORMAT | BLOC SPACING (across length) | BLOC SPACING (across width) | AVAILABLE THICKNESS RANGE * | SHEET FLEXIBILITY | RESIN UPTAKE |
|-------------------|------------------------------|-----------------------------|-----------------------------|-------------------|--------------|
| ACK 1x1 | 1" | 1" | 1/4" - 1 1/4" | ●●●●● | ● |
| ACK 2x6 | 2" | 6" | 1/4" - 2 1/4" | ●●●● | ●● |
| ACK 3x6 | 3" | 6" | 3/4" - 2 1/4" | ●●● | ●●● |
| ACK 2x0 (semi-CK) | 2" | - | 1/4" - 2 1/4" | ●● | ●●●● |
| ACK 6x0 (semi-CK) | 6" | - | 3/4" - 2 1/4" | ● | ●●●●● |

* max. thickness 1 1/2" for SB.150

Perforated (P)



P50 (standard)

- / punched holes (dia. approx. 1/8")
- / distance between holes:
2" across width; 4" across length
- / staggered pattern
- / max. thickness 2 1/4"
- / max. thickness 1 3/4" for SB.150

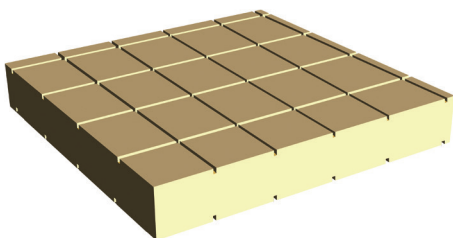
P20

- / punched holes (dia. approx. 1/8")
- / hole distance 0.79"
- / square pattern
- / max. thickness 2"
- / max. thickness 1 3/4" for SB.150

- / other option available by CnC only

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|-----|-------------------|--------------|---------------------------------|--------------------------|
| P50 | | ●●● | ● | ●●● |
| P20 | | ●● | ●● | ●●● |

Grooved (G)

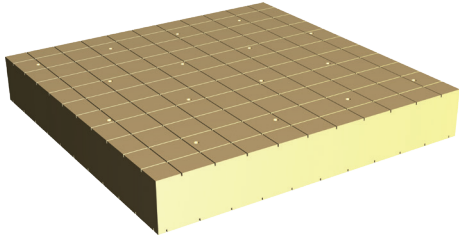


- / one or two directions
- / single side or both sides
- / groove width 0.024", depth approx. 1/16"
- / groove distance 3/4" (offset <1/2" thick)
- / max. thickness 2 1/4" (1 3/4" for SB.150)

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|---|-------------------|--------------|---------------------------------|--------------------------|
| G | | ●●● | ●●● | ●●● |

Note: limitations of availability may apply for specific products, densities or thicknesses

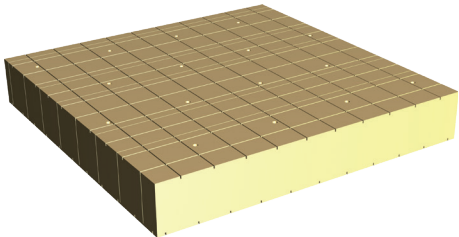
Grooved & Perforated (GP)



- / Grooved (G) in two directions
- / Option 1 grooved both sides, perforation pattern P50 (GP)
- / Option 2 grooved one side only, perforation pattern P20 (G1SP)

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|------|-------------------|--------------|---------------------------------|--------------------------|
| GP | | •• | ••• | ••• |
| G1SP | | ••• | ••• | ••• |

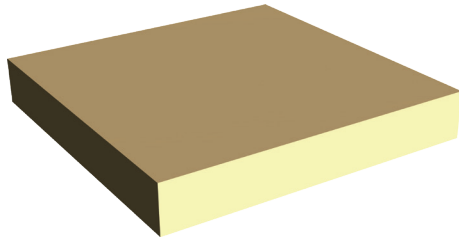
Grooved, Perforated & semi-ContourKore, (GPS)



- / Adaptive CK in one direction; 2" block (ACK 2x0)
- / Option 1 grooved both sides, perforation pattern P50 (GPS)
- / Option 2 grooved one side only, perforation pattern P20 (G1PS)

| | Sheet flexibility | Resin uptake | Promotes resin flow in infusion | Laminate surface quality |
|------|-------------------|--------------|---------------------------------|--------------------------|
| GPS | • | •• | ••• | ••• |
| G1PS | • | ••• | ••• | ••• |

Precision Thickness (PRE)



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

* standard thickness tolerance is -0.030" / +0.010"
(-0.75 mm / +0.25 mm)

Surface Finish

- / **LamPrep (LP)** [uncoated]
specialized sanding for all types of lamination processes
- / **AL600 (AL)** [surface coated]
reduced porosity for vacuum bagging & lower moisture uptake
- / **SealX** [surface sealer]
revolutionary coating to dramatically reduce resin uptake for closed molding (epoxy resin only)