


## sphere core S

### Preparation:

1. Cut Sphere.core S and the covering glass layers in the required shape. Sphere.core S 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 S you will need approx. 600 g/m<sup>2</sup>/mm.  
Example: Sphere.core S 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  $\geq 4$ mm, apply up to 30% of the required amount of resin (i.e. approx. 800 g/m<sup>2</sup> for a 4,0 mm core material) onto the glass layers.
6. Then place Sphere.core S onto the resin film. This is to make sure the material is impregnated with resin from the bottom side.
7. Continue by adding resin onto the layer of Sphere.core S and spread resin with a commonly used tool.

Important notice: Sphere.core S absorbs resin quickly. It gets soft when impregnated with resin and can easily be torn apart. We therefore recommend to apply resin carefully. In case fibers stick to the roller while de-aerating, you may add the next glass layer and then de-aerate these layers in one shot. 

8. While de-aerating you can flatten overlapping areas by applying slight pressure onto the roller.
9. Continue to laminate subsequent covering layers and de-aerate them as usually.

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



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