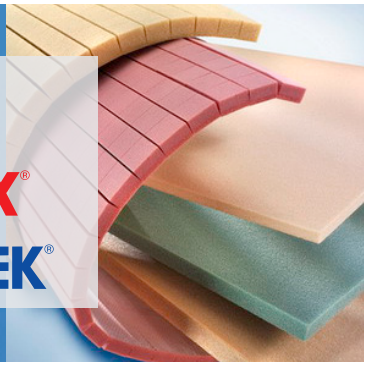


OVERVIEW FINISHING OPTIONS

Issue 01.2012



AIREX[®]
BALTEK[®]



AIREX[®] structural foam core materials

- FlexiCut (FC)
- ContourKore, knife cut (CK kc)
- ContourKore, saw cut (CK sc)
- Mini ContourKore (MCK)
- Grooved & Perforated (GP)
- Perforated drilled (P)
- Perforated punched (P)
- Grooved 50 (G50)
- Precision Thickness (PRE)

BALTEK[®] structural balsa core material

- ContourKore (CK)
- Grooved & Perforated (GP)
- Semi-ContourKore, Grooved & Perforated (sCK GP)

Rating of Finishing Options regarding specific requirements:

most suitable ●●●

suitable ●●

ok ●

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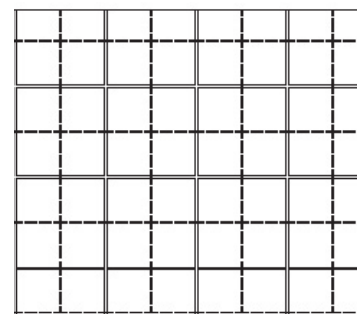
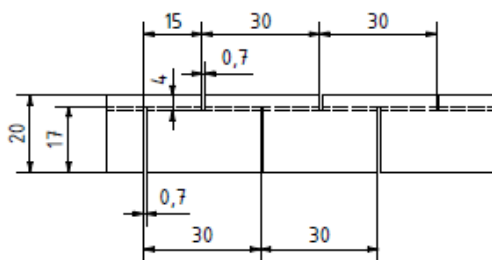
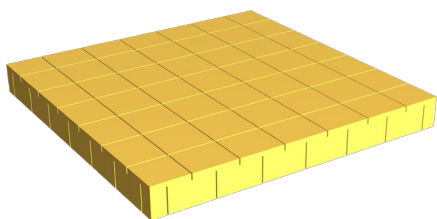
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AIREX® structural foam core materials

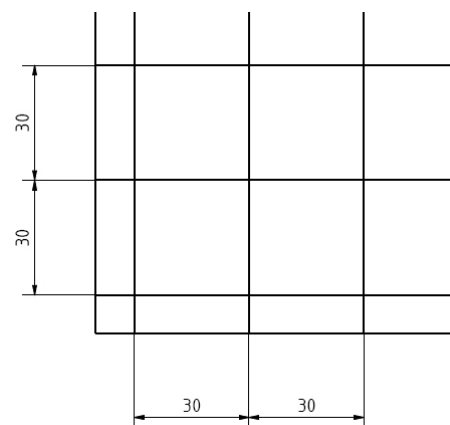
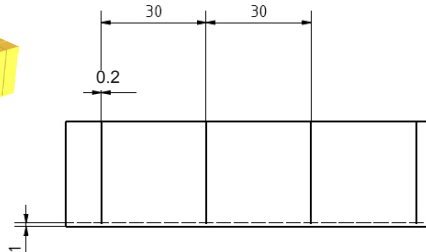
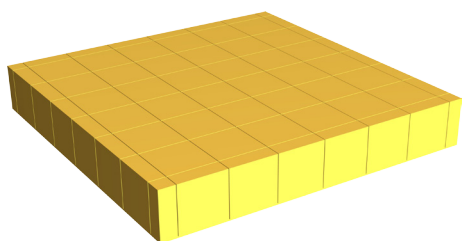
FlexiCut (FC)



- 30 x 30 mm cross-grooved both sides
- kerf depth 85% / 20% of thickness
- kerf width 0.7 mm or 1.2 mm
- 2'200 holes / m²

Sheet flexibility ●● Resin uptake ●● Promotes resin flow in infusion ●● Laminate surface quality ●●● (0.7 mm width)

ContourKore, knife cut (CK kc)

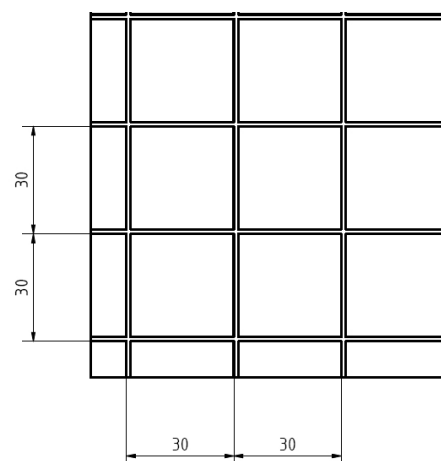
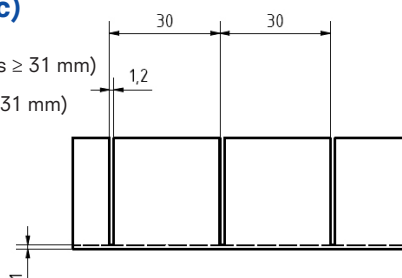
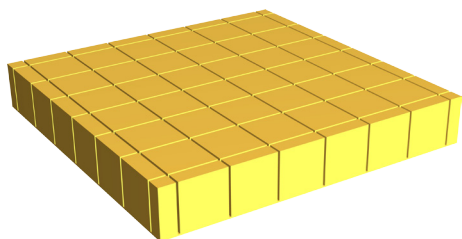


- 30 x 30 mm bloc pattern
- kerf width approx. 0.2 mm
- glass fiber cloth on bottom side of sheet
- blocs are cut almost down to cloth

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

ContourKore, saw cut (CK sc)

- 30 x 30 mm bloc pattern (40 x 40 mm if sheet is ≥ 31 mm)
- kerf width 0.7 or 1.2 mm (1.5 mm for sheets ≥ 31 mm)

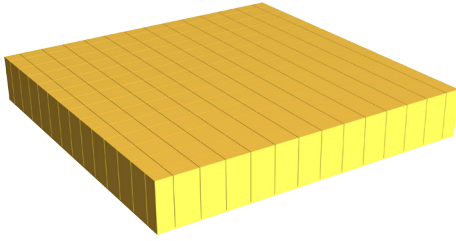


- glass fiber cloth on bottom side of sheet
- blocs are cut almost down to cloth

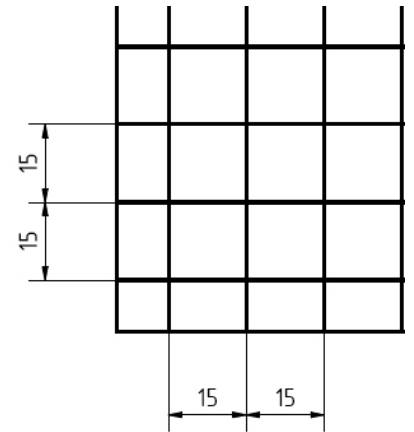
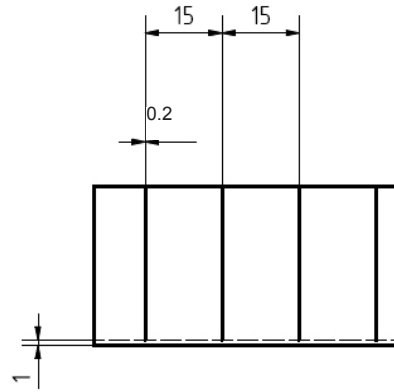
Sheet flexibility ●●● Resin uptake ●● Promotes resin flow in infusion ●● Laminate surface quality ●●

AIREX® structural foam core materials

Mini ContourKore (MCK)

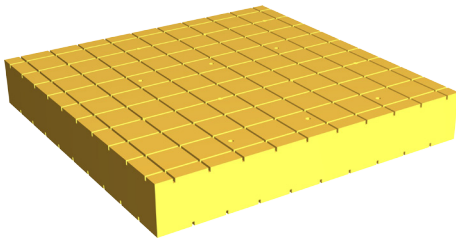


- 15 x 15 mm bloc pattern
- kerf width approx. 0.2 mm
- glass fiber cloth on bottom side of sheet
- blocs are cut almost down to cloth

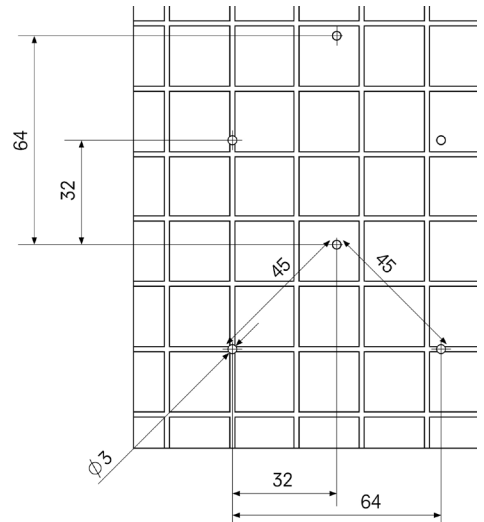
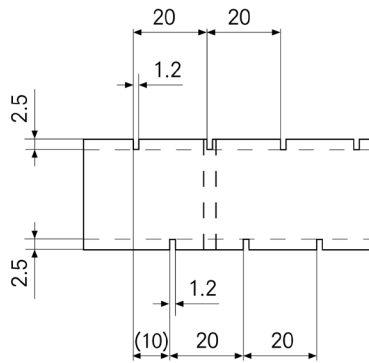


Sheet flexibility ●●● Resin uptake ●● Promotes resin flow in infusion ●●● Laminate surface quality ●●●

Grooved & Perforated (GP)

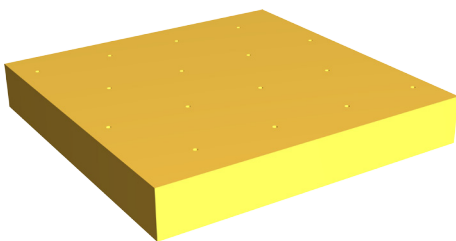


- cross-grooved both sides
- groove width 1.2 mm, depth approx. 2.5 mm
- grooving distance 20 mm
- grooving offset both sides 10 mm
- perforated (drilled), hole diameter 3 mm
- hole distance 45 mm (32 x 64 mm pattern)
- holes may not be aligned with grooves

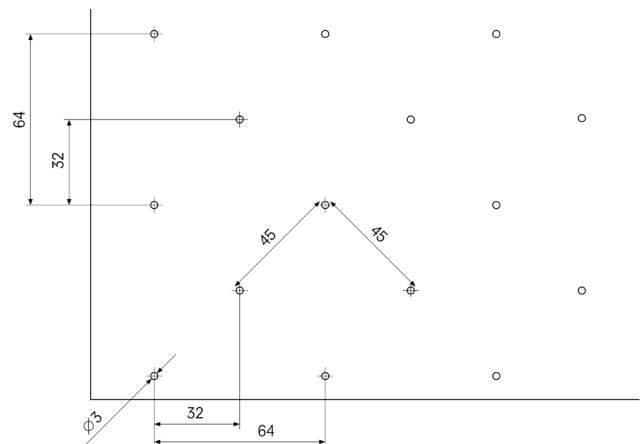


Sheet flexibility Resin uptake ●● Promotes resin flow in infusion ●●● Laminate surface quality ●

Perforated drilled (P)



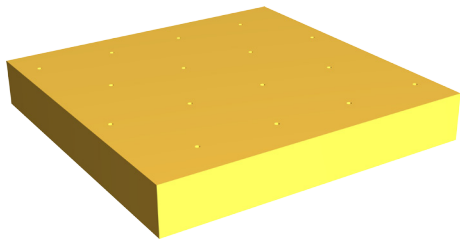
- drilled holes (diameter 3 mm)
- hole distance 45 mm (32 x 64 mm pattern)



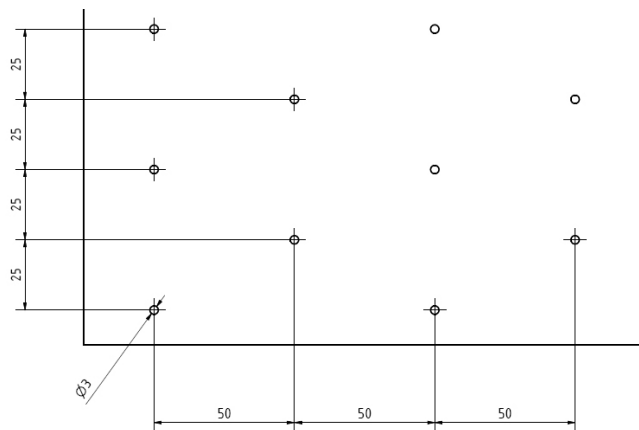
Sheet flexibility Resin uptake ●●● Promotes resin flow in infusion ● Laminate surface quality ●●●

AIREX® structural foam core materials

Perforated punched (P)



- punched holes (hole diameter approx. 2 mm, tool 3 mm)
- hole distance approx. 50 mm



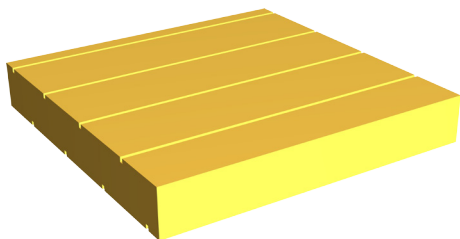
Sheet flexibility

Resin uptake ●●●

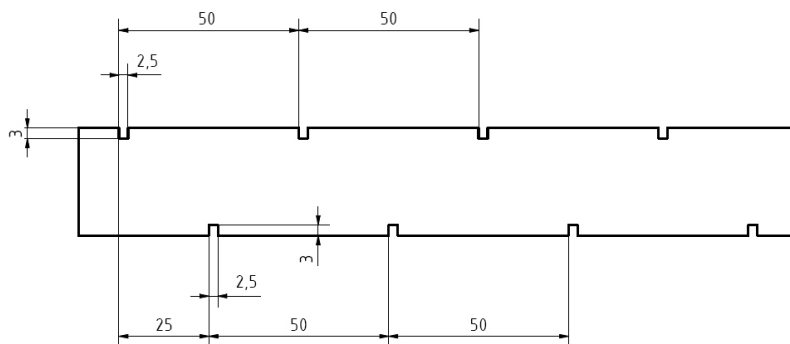
Promotes resin flow in infusion ●

Laminate surface quality ●●●

Grooved 50 (G50)



- parallel or crosswise grooves
- one side or both sides
- grooving distance 50 mm
- groove depth approx. 3 mm
- groove width 2.5 mm



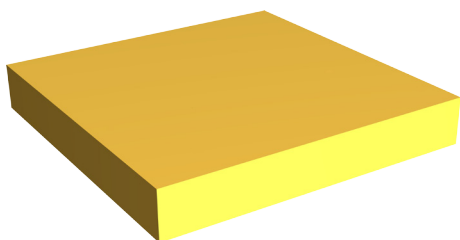
Sheet flexibility

Resin uptake ●●●

Promotes resin flow in infusion ●

Laminate surface quality ●

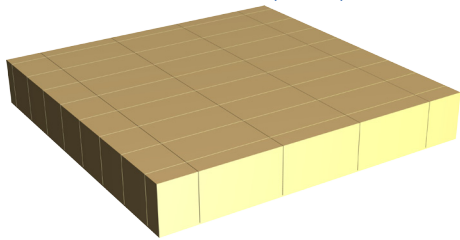
Precision Thickness (PRE)



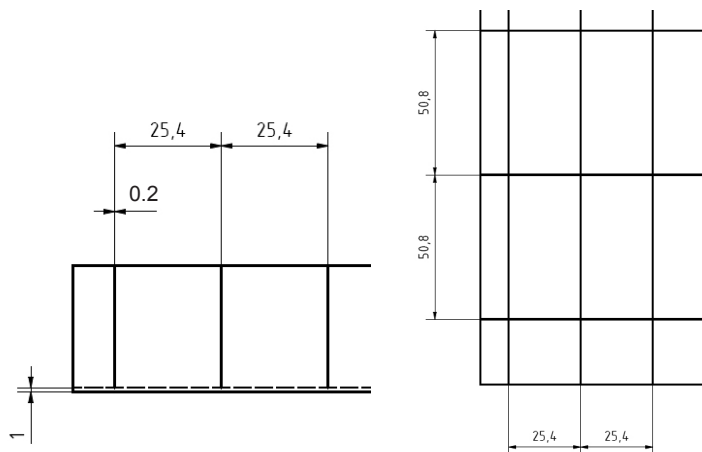
- improved thickness tolerance of sheet:
PRE1: +0.2 / -0.4 mm (0.6 mm range)
PRE2: +0.1 / -0.2 mm (0.3 mm range)

BALTEK® structural balsa core material

ContourKore (CK)

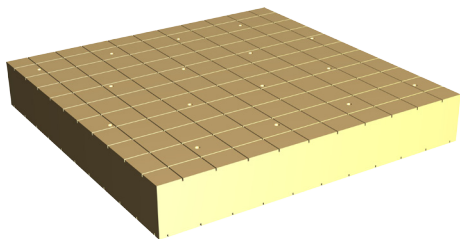


- 25 x 50 mm bloc pattern (50 x 50 mm if sheet is ≥ 50 mm)
- kerf width approx. 0.2 mm (knife cut)
- glass fiber cloth on bottom side of sheet
- blocs are cut almost down to cloth

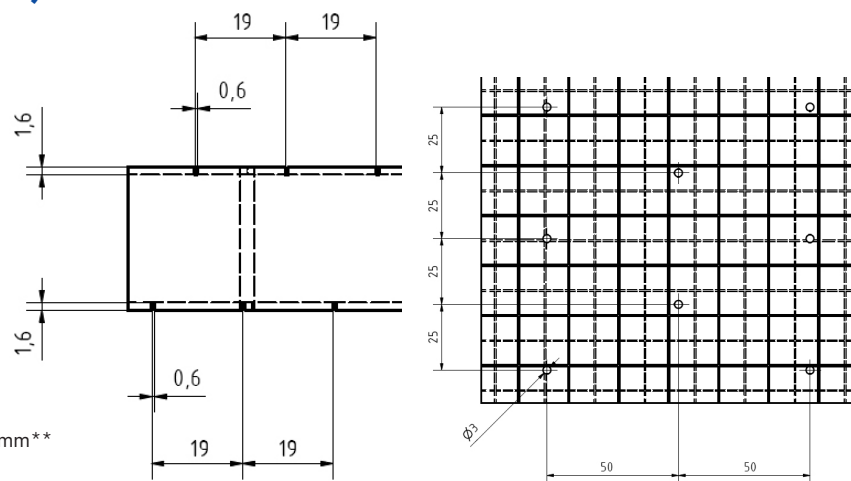


Sheet flexibility ●●● Resin uptake ●●● Promotes resin flow in infusion ●●● Laminate surface quality ●●●

Grooved & Perforated (GP)



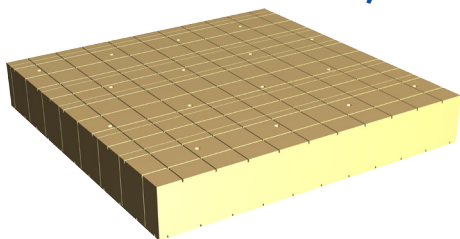
- cross-grooved both sides
- groove width 0.6 mm, depth approx. 1.6 mm
- grooving distance 19 mm
- grooving offset both sides 10 mm
- perforated (punched), hole diameter approx. 3 mm**
- hole distance approx. 50 mm



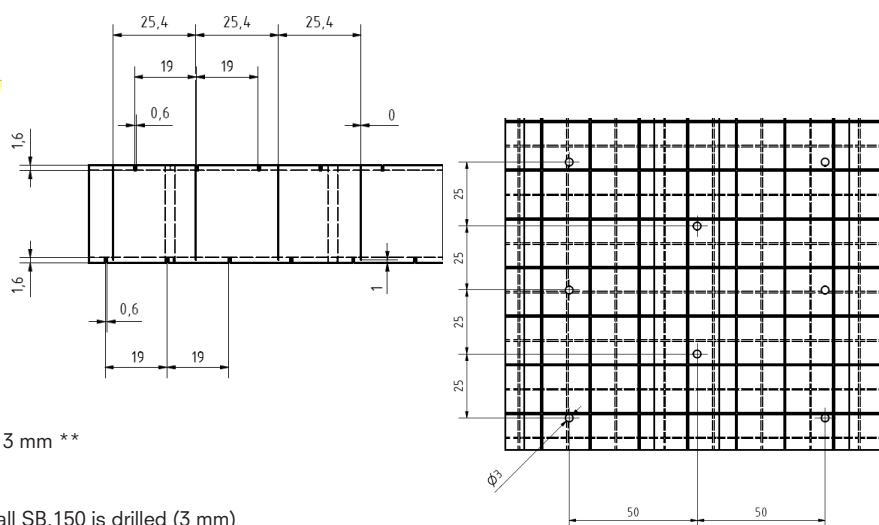
** perforation of SB.100 thicker than 50 mm and all SB.150 is drilled (3 mm)

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

Semi-ContourKore, Grooved & Perforated (sCK GP)



- CK only in one direction; spaced 25 mm
- cross-grooved both sides
- groove width 0.6 mm, depth approx. 1.6 mm
- grooving distance 19 mm
- grooving offset both sides 10 mm
- perforated (punched) hole diameter approx. 3 mm**
- hole distance approx. 50 mm



** perforation of SB.100 thicker than 50 mm and all SB.150 is drilled (3 mm)

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