



BALLOTTA[®]

Fabricación de Embarcaciones con Fibra de Vidrio

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KSS 46

CONSTRUCTION PROPOSAL

Description of the job to be done:

Materials Used:

- DIAB Divinycell foam in the thickness specified.
- Vectorply E-LR 1208 Unidirectional reinforcement.
- ASHLAND AROPOL 63301 – 90 poliester and AME 60 vinilester resins for infusion. (vinilester only for hulls)
- ASHLAND HETRON vinilester resin for hull joining work.
- CRISTALAN 4807 poliester resin for interior joining work.
- AWLGRIP H8087 2 part polyurethane paint for the whole exterior.

Infusion:

- All parts specified in the plan will be infused as single pieces in a fiberglass table.
- Hardness tests will be made randomly to the infused parts with a Barcol impressor to certify quality.

Hull Shaping:

- Shaping of the hulls will be done with a steel frame both sides at once.
- Hand lamination after shaping will be done with full layers of unidirectional fiber as specified by plan using Hetron vinilester resin. Peel ply will be applied as a final layer to give a smoother finish before sanding and painting.

Assembly and joining:

- Special care will be taken for proper level up before joining. Laser equipment will be used.
- Joining is done with two layers of biaxial fiber with a final layer of 300 CSM of approximately 15 cms to each side.
- All joints will be sanded to a smooth finish.

Exterior finish:

- Fairing will be done sanding with long boards and flat machine sanders applying SIKA polyester putty several times. Our guaranty will be to fair until the costumer is pleased with the look of the boat although Kelsall's system of construction in the table is particularly good at leaving a fairness right out of the table mold.



