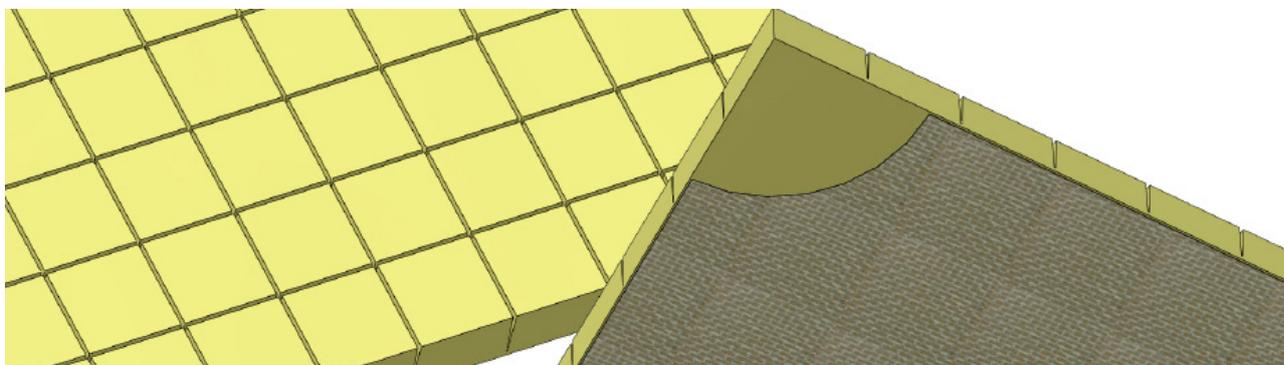


# Finishing | Form

## Grid scored

Grid Scored is material that is cut in two directions, which makes it formable and flexible for use in curved molds and applications.



### Description

The sheet has U-shaped cuts in length and width direction of the sheet almost all the way through the core. To reinforce the sheet a lightweight fiberglass scrim is used on the opposite side of the cuts.

Grid scored material is one of the most widely used and valued finishes, thanks to its flexibility and user-friendly handling. It conforms smoothly to curved surfaces, making it ideal for complex mold applications.

### Benefits

- Formable
- Easy and versatile to use
- Can be combined with other finishes

### Typical application areas

- Hulls
- Decks & Superstructures
- Wind blades & nacelles
- Miscellaneous curved mouldings

### Standard GS finishing types<sup>1</sup>

Configuration	GS10	GS30	GS60	GW30	GW60
Distance between cuts	10mm	30mm	60mm	30mm	60 mm
Depth of cuts	~2mm from bottom of sheet			~2mm from bottom of sheet	
Width of cuts <sup>2</sup>	~0.9mm			~1.3mm	

1. Customized alternatives can be available upon request

2. Thickness and material choice impact cut width.

## Process characteristics

Grid scored core is suitable for curved surfaces, regardless of whether your manufacturing method is hand laminating, vacuum bonding, or infusion.

The grid score grooves are designed solely to accommodate curvature and should not be mistaken for infusion grooving.

This core type is commonly used in hand lay-up or spray-up processes. In wet lay-up techniques, it is recommended to wet-prime the core before placing it into the laminate—preferably onto a chopped strand mat bedding layer.

The preferred method in wet lay-up manufacturing is to use vacuum bonding in combination with a suitable core bedding adhesive.

Grid scored core is an excellent choice when bedding techniques are applied, whether through vibration or vacuum bagging.

In infusion or other vacuum resin transfer molding processes, grid scored core is often combined with additional finishing options to ensure proper wet-out of the core surface. Flow meshes or flow mats may also be used in combination.

For optimal performance, grid scored material should be laid into the laminate or mold with the fibre scrim facing downward, allowing the grid scores to close. This reduces resin uptake, lowers exothermic peaks, and minimizes the risk of surface print-through.

## Limitations and considerations

When the core is correctly positioned in the mold—as outlined above—the grid scores will be closed or nearly closed.

Incorrect placement may cause the curvature grooves to open or widen, resulting in gaps that fill with resin and potentially create race-tracking in resin transfer molding processes.

Resin consumption during infusion increases with core thickness.

## Finishing solutions

Diab offers a comprehensive range of finishing options to deliver optimized solutions tailored to customer requirements and objectives. If the standard range does not meet specific needs, customized cuts and solutions can be developed. However, this is rarely necessary, as Diab's extensive offering and expertise cover the majority of industry demands.

## Kits

To fully optimize cost, performance, and quality, Diab can engineer and supply core kits delivered in lay-up sequence. These kits consist of pre-cut pieces tailored to meet mechanical requirements, lay-up strategy, manufacturing process, and cost and quality goals.

Produced by skilled personnel using a combination of traditional and CNC equipment, the kits ensure precision and consistency.

By working with kits, customers benefit from Diab's full expertise in engineered design, core materials, and manufacturing techniques—key factors in achieving application objectives in terms of cost-efficiency, quality, and performance.

### Disclaimer:

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