



SPHAERA PROFILES – ASSEMBLY INSTRUCTIONS

TOOLS



A4 TYPE SELF-DRILLING SCREW
Oval head style (TGS)
Phillips Screw Size N.10, Head 9.5 Mm, Shank 4.8
Mm Specific codes: din7983 or uni6956, also iso 7051
WARNING: A2 TYPE SCREWS NOT TO BE USED



Drill and screwdriver



Tip 4/4.2 Mm



Gummed tape



PROJECTED AND DESIGNED BY TESSILMARE IN ITALY

PATENTED



1. APPLICATION OF PVC BASE



*TIP: warming up the
profile base will
simplify the procedure.
This can be obtained
by keeping the base in
a warm environment
for 8-12 hours.*

Prop the soft profile of the base against the entire length of the boat
and hold in place with vertical strips of gummed tape

2. APPLICATION OF THE STAINLESS STEEL BOARD



We recommend starting from the bow. Bend the board in the middle so that both sides have about the same length.



For technical reasons, do not place a hole in the center of the bow bend or in the center of the stern corners.



Then cut the side strips to the correct size and complete the installation using the supplied joint covers.



The drill spindle must not touch the countersink of the screw: we recommend inserting a plastic or aluminum stop buffer on the drill bit; this simple operation will prevent the iron material of the spindle from damaging the steel. It is advisable to apply silicone to the hole making screwing smoother and sealing the hole itself.

According to an ancient sailing tradition, screws should be tightened so that the heads form a cross and not an X.



We recommend the use of cut-off wheels for stainless steel only.



Cut any loose pvc material with a box cutter.



When done put the end covers into place.

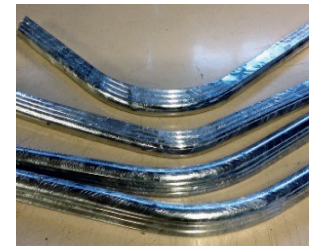
3. STAINLESS STEEL PROFILE BENDING



Horizontal bends with a radius of curvature greater than 40 cm can be performed directly on the boat by alternatively bending and screwing the profile into place. The boat itself will act as template and guideline.



Bow and the stern bends with a radius of curvature less than 40 cm can be performed using simple tools by cutting in series equal lengths of horizontal or vertical bended profiles; optionally, Tessilmare offers a custom-cut and -bending service.



Small side bends can be performed directly on the boat.



In case of very sharp or difficult bends, please contact our technical offices.

4. CLEANING

Use polish cream on stainless steel and polish to a high gloss.
Use liquid degreaser on pvc.

WARNING

Some pvc degreasing products if not diluted properly will damage the profile irreparably.