

Hints & Tricks For EVA SPEZ Material

1. Oven Setting: 130° – 150° C (266° – 302° F)

At this temperature setting, the material will receive a continuous and ideal temperature of 120°C – 130°C (248° - 266°F)



- **Please note:** The different activation times on each material
- The temperature setting is very important for the successful use of the material

2. Material Cooling



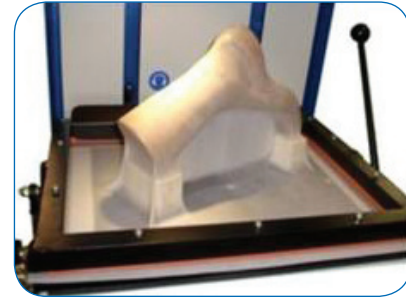
- Activation time x multiplier 2 = "normal" cooling time
- By applying a wet, cold cloth the cooling process can be speeded up about 30%
- The cooling time can be reduced about 75% by using an integrated COOL-TEC-SYSTEM

3. Shrinkage Behavior

- The shrinkage behaviour values of the material sheets do not correspond to values of single-layered EVA materials
- **Note:** You have already saved material at pre-cut stage, as shrinkage of the material is lower and all over / evenly on all layers



4. Silicone Beater Mat



- 100% pure silicone
- High elongation (400%)
- Excellent heat resistance — 250° C / 482° F
- Transparent
- No sticking — also not on PP

It is important to follow the instructions when using the silicone beater mats

5. Metatarsal Pad Pressure



- For providing better forming of the materials at the retro-capital area, it is suggested to use a metatarsal pad (durometer of approximately 50 Shore A)
- During the deep drawing process, you can apply the metatarsal pad on the material that will be formed. **Do not work it in.**

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» Continued

6. Smooth / Glazed Surface



- By using a test-shoe-foil, a smooth / glazed surface can be achieved
- Short activation of the EVA materials by a hot air gun (max. 400°C / 752°F) creates a smooth / glazed integral-skin

8. Working on Place Holder



- The place holder will be cut to the dimensions of the requested insole
- The the deep-drawing process, this contour will be copied to the materials
- With this contour, it will be easier to cut the edge of the insole
- The place holder and last should be stored for later treatment

7. Place Holder



- As place holder for the cover (that will be worked in later on), it is suggested to use "Thermoflex" hard-cellular material
- The place holder will be formed directly on the last, and stays during the working-process with other materials (do not stick)
- **Additional advantage:** due to the smooth / glazed surface of hard-cellular "Thermoflex" material, the unevenness of the last will be concealed.

9. Brushing



- It is possible to brush the surface of EVA materials with a colourless horsehair-brush. This will make the surface more smooth / glazed.



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