


# Optimum

Non-woven based Optimum™ rigid counters are designed for automation production of shoes. Optimum™ has very good shape retention properties.

PRODUCT CODE	COATING TYPE	THICKNESS*	CUTTING DIRECTION
OPT 502	EVA	0,80 - 0,90 mm	
OPT 105	EVA	1,00 - 1,10 mm	
OPT 115	EVA	1,20 - 1,30 mm	
OPT 120	EVA	1,40 - 1,50 mm	

\*Thickness tolerance may vary with natural range of +/- 0,05 mm.

### Typical Applications:

Can be used for all types of shoes and boots.

### Mode of Use:

The counter is put between upper and lining, then moulded by a backpart moulding machine. It can also be pre-formed before the backpart moulding process. Application temperature, pressure and timing are critical for best results. Make sure to run a test trial for your specific application style.

**Temperature of the mold:** 130°C to 160°C according to the type of lining and upper used (natural or synthetic). **Minimum** effective interface temperature: 120°C

**Contact time:** 10 to 20 seconds (higher temperature allows shorter contact time).

**Cutting:** Any direction. Diagonal and Machine Direction will provide best results.

**Skiving:** Silicone and air lubricated skiving machine will provide best results.

**Pressure:** 5-15 psi depending on the thickness of upper and lining used.

We recommend you to carry out a preliminary test of application as the conditions may vary depending on the characteristics of the upper. We recommend a subsequent cold stabilization of the counter after backpart moulding for perfect shape retention.

Application of solvent based glue at any stage of the manufacturing can degrade the adhesive layer present on the sheet, which may cause detachment from the upper.

### Storage:

Pallets of Optimum should be stored in a dry atmosphere, with an ambient temperature of under 40°C. The sheets and pallets should be kept away from direct sunlight or any other UV radiation source to protect from premature degradation of polymer coating.