



Patara

Hybrid cotton fabric based **Patara semi-rigid thermoplastic counters and toe puffs** are designed for automation production of soft shoes, sneakers, high fashion men and women shoes and boots. **Patara** has excellent shape retention properties and can be used premoulded. CC code for counters and C code for toe-puffs.

PRODUCT CODE	COATING TYPE	THICKNESS*	CUTTING DIRECTION
PATARA 10 CC	EVA, Hybrid PU	1,00 - 1,10 mm	
PATARA 20 CC	EVA, Hybrid PU	1,20 - 1,30 mm	
PATARA 30 CC	EVA, Hybrid PU	1,30 - 1,40 mm	

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*Thickness tolerance may vary with single or double sided sheets with a natural range of +/- 0,05 mm.

Typical Applications:

Can be used for all types of classic shoes, soft shoes, sneakers, high fashion men and women 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. Toe puff is pre-applied to the upper by heated pressing machine, reactivated by pre-heating then moulded by lasting machine. 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 150°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: For counters: Machine direction

For toe puff: Diagonal cutting 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 Patara 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 and impregnated polymers.