

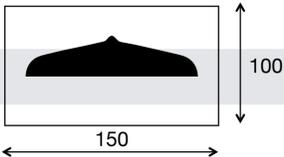
RELION S

RIGID COUNTERS
Two polyester fabric backers
with PU adhesive

PRODUCT DESCRIPTION

RELION S is the latest development in the production of extruded counter materials. It represents the best value for money and performance. It provides excellent shape reproduction and retention. It's produced with polyurethane adhesive and it's suitable for all types of footwear.

TECHNICAL DATA

RELION S	Thickness* (mm)	Cutting direction
RELION S-08	0,80 - 0,90	
RELION S-10	0,95 - 1,05	
RELION S-12	1,10 - 1,20	

* All thickness values have a natural variation of $\pm 0,05\text{mm}$

INSTRUCTIONS OF USE

Relion S can be used both by preheating the material before insertion both placing the cold material between lining and upper.

1) USE WITH PREHEATING

The counter stretched can be warmed to 70-80°C on a Teflon's hot plate that allows optimum control of the temperature. Other heat sources can also be used as ovens, lamps and hot steam.

The counter so heated softens quickly. As the special polymer compound is not sticky fingers, the operator can manually enter the counter between upper and lining without any problem. The counter is then glued and formed with a backpart moulding machine. What optimum working conditions suggest:

- Temperature of the form: from 110°C to 130°C depending on the nature of lining and upper used

(natural or synthetic). - Minimum effective interface temperature: 100°C

- Contact time: from 10 to 15 seconds (high operating temperatures allow contact times reduced and vice versa).

2) USE WITHOUT PREHEATING

The material is placed between liner and upper and formed using a backpart moulding machine. We recommend the following working conditions:

- Temperature of the shape: 140-150°C depending on the nature of lining and upper used

(natural or synthetic). - Minimum effective interface temperature: 100°C

- Contact time: from 10 to 15 seconds (high operating temperatures allow contact times reduced and vice versa).

We recommend that you carry out a preliminary test of bonding as the conditions of application may vary depending on the characteristics of the upper.

In case of backpart moulding machine with two positions, the subsequent cold stabilization allows to obtain a counter perfectly shaped.

ATTENTION: the application of solvent glue can affect the adhesive present on the sheet, causing detachment.

PRODUCT CHARACTERISTICS

RIGIDITY



SHAPE RETENTION



WORKABILITY



RESILIENCE



BENEFITS

-  Ping-pong effect
-  Highly moldable
-  Recyclable
-  Produced with Recycled scraps

RECOMMENDED FOR

-  Sneakers
-  Boots
-  Point shoes
-  Décolleté shoes
-  Casual shoes

 **MADE IN ITALY**

This Statement has been released on request, on the basis of our best actual knowledge

EM 01 11/11/2020

 **VEGAN FRIENDLY**

 **MADE WITH RENEWABLE ENERGY.**

 **RECYCLABLE. SCRAPS REUSED IN THE PRODUCTION PROCESS.**