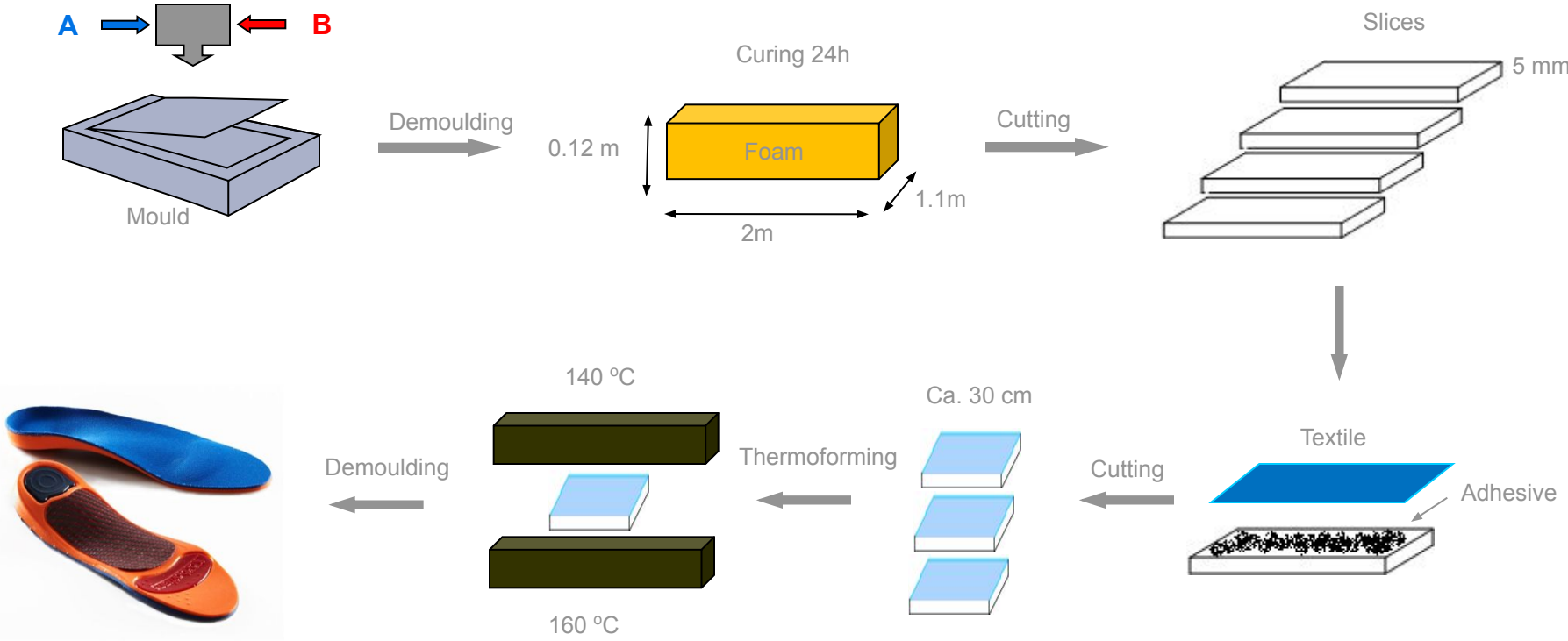


Information – Thermoforming Insoles

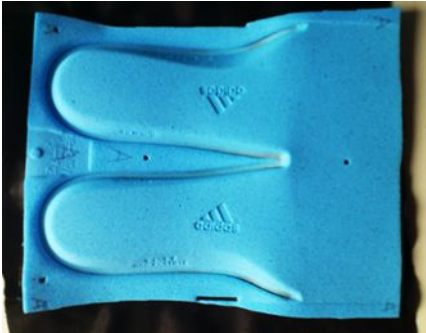
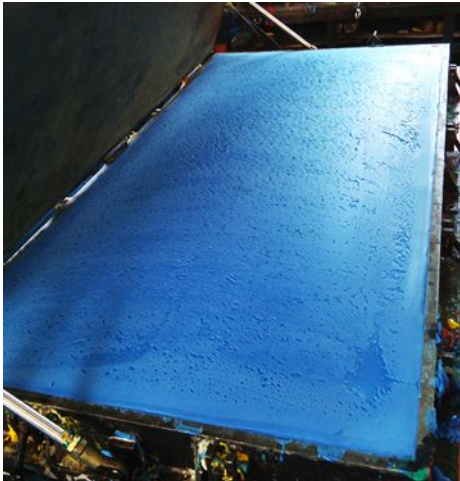
Production process of thermoformed PU insoles



Process to cast low density foam



Moulded foam



Slab foam (free blowing foam)



	Top	Middle	Bottom
Density (kg/m ³)	103	84	109
Hardness (Asker C)	27-29	24-25	33-35
Tensile Strength (kg/cm ²)	6.3	5.1	6.8
Elongation (%)	86	79	92
Tear Strength (kg/cm)	2.4	1.8	2.5
Compression set (%)	26	17	28
Rebound (%)	24	17	17

High pressure foaming equipment



Slabs $2.0 \times 1.5 \times 0,25 = 0.75 \text{ m}^3$
Sliced to 10 mm sheets
Thermoformed with different fabrics on top



Hennecke High Pressure BlocFoamat
Invest ~100,000 €

Comparison of Thermomolding and casting

Application		thermomolding	thermomolding	casting	casting
		S 7579/139	CS7579/100	S 7579/135	
		Iso 137/56	CS 7579/100 C-B	Iso 135/74	
Density	[kg/m ³]	130 ± 5	90 ± 15	280 ± 20	
Hardness	Asker C	35 ± 4	33 ± 4	40 ± 3	
Compression set	[%]	< 20	≤ 25		