



TEXON[®] 87 SERIES

Counter/Stiffener - Product Information

Product Description

A range of thermoplastic counter materials which give a firm to hard backpart, intended for counter pocket insertion. They are easy to use and may be slipped immediately the shoe is cold.

Material Composition

Fusion bonded non-woven fabric made from a blend of synthetic fibres and impregnated with styrene copolymer. Formosert can be adhesive coated on one or both sides.

Adhesive Coating

All Texon 87 Series materials are available with 'N' (EVA) hot melt adhesive and powdered 'G' Polyester.

'N' adhesive (EVA) is the standard adhesive. It gives excellent bonds at relatively low activation temperatures to leather and synthetic upper and lining materials. 'N' denotes single coated materials immediately before the product grade (e.g. N487). Double coated materials are denoted by 'N' immediately before and after the product grade (e.g. N587N).

'G' adhesive has been specifically developed to have greater resistance to grease and plasticiser attack but should not be recommended where high heat resistance is required. 'G' adhesive is denoted by 'G' immediately before the product grade, (e.g. G487N).

Grade	Double Coated Gauge (mm)	Double Coated Material Weight (gsm)	Stiffness/ Dome Hardness (Newtons)	Suggested Footwear Application
N387N	0.85 – 1.05	655 - 725	>45	Light children's & women's shoes.
N487N	0.95 – 1.15	690 - 770	>67	Women's casual/fashion shoes, children's shoes and moccasins.
N587N	1.15 - 1.35	795 - 885	>98	Women's, children's & men's lightweight shoes.
N687N	1.25 - 1.45	890 - 990	>134	Boys', youths' and men's shoes, women's boots.
N787N	1.40 – 1.60	1030 - 1130	>169	Men's shoes, women's boots, sports footwear.
N777N	1.40 – 1.60	1073 - 1187	>142	
N887N	1.40 – 1.60	1073 - 1087	>142	
N1087N	1.71 – 1.95	1225 - 1355	>223	Sports footwear, heavy duty boots.

Environment

Texon International actively promotes the protection of the environment through innovation and conscientious process management as an integral part of its global recycling and sustainability business strategy. We are leaders in eco-friendly technology through conservation, adapting manufacturing processes and recyclability of its products.

Method of Use

Cutting

The Texon 87 Series should be cut across the widest width of the sheet. Cutting can be carried out in multiple layers, the amount of layers being determined by the grade of material and cutting equipment used.

Skiving

Materials should be skived on the opposite side to that which was uppermost when cutting. For the best results we recommend the use of a Fortuna SAS V34S or similar cylinder knife skiving machine, with 'Skivezi' or similar silicone based lubricants being applied to the knife-edge. The Texon 87 Series can also be matrix or die roll skived under certain conditions.

Pre-Combining

The Texon 87 Series can be combined to counter linings using suitable laminating machinery. Hot melt adhesive coated linings give the best results.

Pre-moulding

For ease of insertion and location, the Texon 87 Series can be pre-moulded but it must be adequately pre-heated to approximately 80°C prior to moulding. For the best results both top and bottom moulds should be refrigerated, although unrefrigerated moulds can be used.

Methods of Application

For consistent results, loose inserted counters should be accurately positioned. Pre-combined Texon counter units are intended for closing room attachment - an adequate trimming allowance must be left on the counter lining.

Backpart

For optimum activation we recommend the use of backpart activators with heat Activation being applied from an internal mould and an outer band or clamp. The recommended counter/lining and counter/upper interface temperature for 'N' adhesive is 80°C, and a minimum of 90°C for 'G' adhesive; standard activation settings being 180°C inner mould, and 150°C outer band or clamps. Dwell times of between 12 and 25 seconds, depending upon the grade of counter material and thickness of upper and lining materials, are recommended.

Lasting

The Texon 87 Series give optimum results with backpart moulding machinery with pre-heating equipment and refrigerated moulds. When using force lasted sewn-in sock constructions where the counter is either inserted into a pocket or stitched to the sock, the backpart should be sufficiently activated prior to force lasting and preferable heat set.

Forms of Supply

The Texon 87 Series is supplied in sheets.

Storage

The Texon 87 Series should be stored in a cool dry area out of direct sunlight - shelf life is unlimited*.

Customs and Shipping CCCN Ref: 39 21 90 60.

*If the product contains 'G' Adhesive it has a shelf life of 12 months