



# TEXON<sup>®</sup> RITE<sup>™</sup>

## Counter/Stiffener - Product Information

### Product Description

Texon Rite<sup>™</sup> is an economy range of thermoplastic counter materials, which give a firm backpart, intended for counter pocket insertion. They are easy to use and may be slipped immediately the shoe is cold.

### Material Composition

Needled non-woven fabric made from synthetic fibres and impregnated with a filled styrene copolymer.

### Adhesive Coating

All Texon Rite materials are available with 'N' (EVA) hot melt adhesive. Which give excellent bonds at relatively low activation temperatures to leather and synthetic upper and lining materials.

**Texon Rite can also be supplied single coated for use as a Box Toe Puff.**

Grade	Suggested Footwear Application
1.0mm	Lightweight children's and woman's casual/fashion shoes
1.25mm	Women's, children's and lightweight men's shoes
1.50mm	Boys', youths' and men's shoes
1.80mm	Mens and Women's sport shoes and work boots

When ordering Texon Rite, please order as per the following example: -

### Texon Rite 1.25mm double coated

### 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.

The information given in this sheet is intended to be accurate.  
All purchasers should satisfy themselves the product fully meets their requirements.

## **Method of Use**

### **Cutting**

Texon Rite 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 silicon based lubricants being applied to the knife-edge.

### **Pre-Combining**

Texon Rite 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, Texon Rite can be pre-moulded but it must be adequately pre-heated to approximately 90 °C prior to moulding. For the best results both top and bottom moulds should be refrigerated, although unrefrigerated moulds can be used.

## **Method 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; 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**

Texon Rite materials 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 preferably heat set.

### **Forms of Supply**

Texon Rite is supplied in sheets.

### **Storage**

Texon Rite 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.

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04/06