



# TEXON<sup>®</sup> X8R SERIES

## Box Toe Puff - Product Information

### Product Description

A range of **recyclable** thermoplastic extruded film materials which depending on the grade used, produce toes that are either soft and flexible or firm and extremely resilient. They all have excellent shape retention in wear. They are quick, clean and easy to use, the shoe can be slipped immediately it is cold.

### Material Composition

A blend of thermoplastic ethylene copolymers laminated to a fabric backer and coated with a hot melt adhesive on the film surface.

### Adhesive Coating

Texon X8R series materials are available with 'E' (EVA) hot melt adhesive only. 'E' adhesive gives excellent bonds to leather and synthetic upper materials for pulling and lasting and in wear. It is denoted by 'E' immediately before the product grade (e.g. E418R).

Grade	Coated Gauge (mm)	Coated Material Weight (gsm)	Suggested Footwear Applications
<b>E268R</b>	0.33 – 0.43	302 – 376	Ladies' lightweight footwear, sports shoes
<b>E368R</b>	0.40 – 0.50	377 – 450	Ladies' and men's casual and fashion footwear,
<b>E418R</b>	0.50 – 0.61	471 – 511	wear, string and force lasted lightweight footwear
<b>E468R</b>	0.59 – 0.70	561 – 607	Ladies', lightweight men's and children's footwear
<b>E518R</b>	0.73 – 0.85	689 – 739	Men's footwear, ladies' boots
<b>E568R</b>	0.84 – 0.96	788 – 844	Heavy men's high walled toes
<b>E968R</b>	0.98 – 1.10	923 – 987	Heavy men's athletic/leisure boots

### Method of Use

#### Cutting

We recommend that Texon X8R box toe puff materials are cut on the bias between an angle of 35° and 55° from the horizontal with the adhesive side uppermost. Alternatively they may be flat cut across the widest width of the material.

Cutting can be carried out in multiple layers, the number of layers being regulated by grade 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 lubricant being applied to the knife-edge.

## **Method of Application**

### **Patterns**

Cement lasted work requires that the toe puff shape should accurately follow the contour of the upper lasting margin. It is important to position the toe puff 8mm to 10mm back from the lasting margin when fusing. This is because it is highly desirable to have as much of the lasting margin as possible in direct contact with the insole after forepart lasting.

### **Fusing**

We recommend the use of a curved block fusing press with a thermostat temperature control and a fusing dwell time control. To ensure good results the air pressure must remain constant and the fusing head pad must be kept clean and in good condition.

### **Fusing Press**

When attaching box toe puffs to the upper using a conventional fusing press we recommend a Head temperature of 180°C and a constant air supply pressure of 4.2 kg/cm<sup>2</sup>. Dwell times are dependant upon the grade of toe puff material and the upper material. Generally, lighter grades of Texon X8R material require a dwell time of 3-5 seconds, medium weight grades 4-7 seconds and heavy grades 6-12 seconds.

The optimum interface temperature for 'E' adhesive coated grades is 90°C.

### **Lasting**

The use of a toe lasting heater or steamer is recommended for all Texon X8R grades. A minimum temperature of 80°C should be achieved with these grades prior to pull toe lasting.

### **Forms of Supply**

Texon X8R material is supplied in uncoloured form only. Sheets have a length of 1.0m and a typical width of 1.45m. They may be supplied packed in 40-sheet cartons or bulk packed on a 700-sheet pallet (1000 sqm), except E568 and E968, which are on a 500-sheet pallet (approximately 750 sqm).

### **Storage**

Store Texon X8R in a cool dry area out of direct sunlight - shelf life is unlimited\*.

### **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

Customs and shipping CCCN Ref: 3921 90 60 999.

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