

## Manufacturing instructions for the orthopaedic preparation of safety shoes in accordance with DGUV 112-191    ÖNORM Z1259

**PROTECT safety shoes must only be processed in accordance with these processing instructions. No materials other than the listed components may be used. If these instructions are not adhered to, the type examination certificate is invalidated and the supplying company is liable for any damages that arise therefrom.**

These manufacturing instructions apply for the use of the following preparatory materials:

010693003	PROTECT Starpur, black ESD, 150 x 350 x 3 mm	010693612	PROTECT Starpur, black ESD, 600 x 430 x 12 mm
010693006	PROTECT Starpur, black ESD, 150 x 350 x 6 mm	010693618	PROTECT Starpur, black ESD, 600 x 430 x 18 mm
010693009	PROTECT Starpur, black ESD, 150 x 350 x 9 mm	010696055	PROTECT Star HD heel sheet, 5,5 mm, dark brown
010693018	PROTECT Starpur, black ESD, 150 x 350 x 18 mm	R10625010	PROTECT Köraplast 182 A, anti-static, 600 g
010693606	PROTECT Starpur, black ESD, 600 x 430 x 6 mm	R10628001	PROTECT Köracur TR 280, transparent , 100 g
010693609	PROTECT Starpur, black ESD, 600 x 430 x 9 mm		

**These preparatory materials can be used with the shoes with the article numbers  
048585 Safety, 048570 Power, 048555 Flash, 048560 Guard, 048511 Hammer and 048500 Steel.**

### Processing

- 1 The sole of the safety shoe is cut parallel to the insole, below the puncture protection.
- 2 The reinforcement material 'Star HD' is adhered to the cut surface at the tip of the shoe according to the last shape, up to 10 mm behind the cap edge.
  - 2.1 Roughen the tip material and sole material in the area to be glued.
  - 2.2 Brush both surfaces with the anti-static adhesive Köraplast 182 A (article number: R10625010) from Kömmerling as a pre-coat and main coat. The adhesive Köraplast 182 A should be mixed with 5% of the curing agent Köracur TR 280 (article number: R10628001).
  - 2.3 Allow drying time of 15–20 minutes.
  - 2.4 Activate the adhesive surfaces with an oven or hot-air gun at 70–80 °C.
  - 2.5 Compress using a sole press immediately after the activating process.
- 3 The Starpur material is cut to size according to the required preparation, sanded and glued over the front cap section. The same adhesion instructions as described in points 2.1 to 2.5 apply.

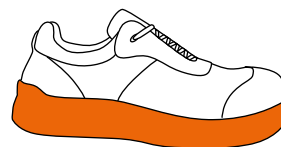
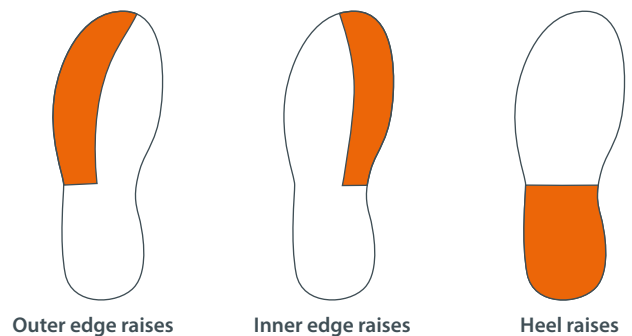
The following orthopaedic preparations can be carried out:

- Shoe raises of up to 30 mm (measured in heel area)
- Raises of up to 15 mm on the ball of the foot
- Inner and outer edge raises
- Soles for foot rolling
- Heel raises

- 4 The cut sole should be adhered to the 'Starpur' shoe raise material from below. The same adhesion instructions as described in points 2.1 to 2.5 apply.
- 5 For optical reasons, the outer edges of the sole should be broken by grinding the contour.

### Labelling

The orthopaedic adjustment is to be labelled in the shoe accordingly by the body carrying out the adjustments:  
With the name of the manufacturer (name of the orthopaedic organisation)



### Shoe raises

Up to 15 mm on the ball of the foot  
Up to 30 mm (measured on heel)

**Orthopaedic foot rolling aids**  
e. g. to relieve strain on the forefoot

Schein Orthopädie Service KG  
Hildegardstr. 5  
42897 Remscheid, Germany  
Tel. +49 2191 910-0  
Fax +49 2191 910-100  
remscheid@schein.de  
www.schein.de

