TECHNICAL DATA SHEET

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JANUS

Composite extruded materials for rigid and very elastic counters and toe-puffs

Product	*Thickness (*)*	*Tolerance*
JANUS 70	**0,85 mm**	**± 0,05 mm**
JANUS 80	**0,95 mm**	**± 0,05 mm**
JANUS 90	**1,05 mm**	**± 0,05 mm**
JANUS 110	**1,25 mm**	**± 0,05 mm**

(*) The value of thickness doesn't include the extra two-side hot-melt adhesive coating. The increase of thickness for every side-coating is between 0,05 and 0,08 mm.

Technical Features

JANUS series are composite extruded materials suitable for rigid and very elastic counters and toe puffs.
Janus is indicated for the realization of counters and toe-puffs characterized by high stiffness, high elasticity and resilience.
The particular polymeric nature of which is composed, besides giving excellent characteristics of stability over time, allows to produce footwear of high-quality finish with excellent properties of dimensional stability and that does not deteriorate over time under different weather conditions.
The standard version of the JANUS for counters is provided with polyurethane coating NL.
With this type of coating the different temperatures of reactivation of the two thermoadhesive are the solution to the problems of bonding of the counters on the upper side.
The colorless side of the fabric (is the one with thermoadhesive L with reactivation at about 70°C) must be set facing the upper (where the heat reactivation received is lower), while the side of pink (is the one with thermoadhesive N with reactivation at about 100°C) should be positioned facing the lining (where the heat reactivation received is greater as is the side in direct contact with the press).
For applications such toe-puffs on request version thermal-adhesive on one side (ON). In addition always on request is version available with polyester fabric in black on one side.
JANUS is available in different thickness and it is therefore suitable for various shoe models.

Mode of use

As counter cut the shape along the biggest-side direction (with reference to the sheet).
The material has to be thermoformed at 90-120°C for 10-15 seconds at 3-4 bar. Temperature and pressing time are a function of the materials used .Time can be reduced if the counter thermoforming machine includes the heated cushion.
For closing the underlying flap a preheating is recommended.
As toe-puff the shape has to be preferably cut along the biggest side direction or along oblique direction (with reference to the sheet).
After beveling the lower edge, the toe puff has to be jointed to the internal part of upper through hot pressing at temperature between 130 and 160°C, pressure around 3-4 bar and pressing time between 5 and 7 seconds (it's depend from leather and toe puff thickness). Then, before shoe-mounting, is recommended for closing the underlying flap a preheating is required.

The information contained herein is based on our technical knowledge and experience. Since it is the user's responsibility to determine the suitability of the product for his own use, he should thoroughly test any application.