

# INSTRUCTION PROTOCOL **REPAIR OUTSOLES**

## **RECEIPT**

- You will receive the following component:**
  - Outsole sheet material: dim. 29 x 37 cm
  - Available to order in black and light grey
  - The outsole has been roughed and primed (halogenated); optimal performance is within two weeks of receipt.



37 cm

29 cm

## **PROCESSING**

- Shape the sheet as required for a full replacement of the outsole.**
  - Buff the bonded outsoles and the treading surface according to the desired concept.**
  - Prepare the contact surfaces for bonding:**
    - Remove dust and degrease the bonded blocks thoroughly (for example with acetone).
    - Halogenate the outsole one more time.
- **Important:** Take into account the dwell time after halogenation for optimal performance. Refer to the instructions on the packaging of the halogen primer.

## **BONDING THE OUSOLE (MANDATORY FOR 4ALLWORKS/RECOMMENDED FOR 4ALLTIMES)**

- Follow these steps to attach the outsole:**
  - Apply a PU primer with 5% hardener to both contact surfaces.
  - Allow the primer to dry for at least 15 minutes.
  - Apply PU contact adhesive/PUR adhesive with 5% hardener to both contact surfaces.
  - Allow the bonded parts to dry for 45-60 minutes.
  - Heat the bonded blocks and activate the outsole to approximately 80°C.
  - Join both contact surfaces accurately within 20 seconds.
  - Press the assembly at a minimum of 5 bar for at least 15 seconds.

## **FINISHING**

- Allow the footwear to cool for 24 hours before further processing.**
- After attaching the outsole, rough up the rand area with a sharp abrasive belt to ensure the outsole adheres properly.**

## **GENERAL NOTES**

- The indicated drying and heating times are indicative and may vary depending on the temperature and humidity in your workshop. Always consult the specific instructions from your material supplier.
- **Please use only the materials supplied by Neskrid** for this modification, with the exception of the adhesives to be used.
- Neskrid does not accept warranty claims regarding the outsole or its bonding.
- For work and safety footwear, the outsole must be replaced **in its entirety**. There must be no cut seams in the outsole. Replacing individual parts, such as the heel only, is **not permitted**; this will **void the certification!**