

NITRO VULC® COUNTER and BOX TOE MATERIAL

The new Nitro Vulc® material is an extension of our Verge, Vantage, and Sportoe family. This high-quality thermoplastic material is infused with Nitrogen. The infusion of gas allows us to reduce the weight without compromising the performance. Nitro Vulc® provides excellent shape retention, remains resilient, and has a great feel. It is everything you want from a material and more.

In addition to all the performance advantages of unmatched resiliency, shape retention and moisture resistance, Nitro Vulc® has over 65% recycled content and is available in our Zero Waste program. Nitro Vulc® provides a very sustainable, high quality and cost-effective solution for your counter and box toe needs.

Nitro Vulc® has been modified to work within the autoclave environment where temperatures reach over 100°C for extended periods of time. Back part molding is still the preferred method of manufacture. If not available, pre-heating the counter, or pre-shaping prior to lasting allows the counter to better form around the last and is recommended for best shape and ease of manufacture. The high temperatures and time in the autoclave oven however will insure proper activation of the counter. The counter should be allowed to cool to room temperature, roughly 30°C, before de-lasting for best shape retention.

GRADE	GAUGE (±5%)
NITRO VULC® 0.5	0.50 mm
NITRO VULC® 0.7	0.70 mm
NITRO VULC® 0.9	0.90 mm
NITRO VULC® 1.1	1.10 mm
NITRO VULC® 1.3	1.30 mm

Composition

A proprietary blend of resins with infused Nitrogen and a hot melt adhesive layer on both sides. This construction best aligns with factory processing for cold cement and autoclave production. The adhesive offers superior bonding strength to all upper and lining materials including some of the most difficult materials.

Work Preparation

Cutting: Nitro Vulc® is a multi-directional material. It can be cut in horizontal, vertical and diagonal direction. This will allow for optimum cutting yields.

Heat Activation: Recommend Bond Line temperature of over 90°C but product is designed to work within a range of 90°C - 110°C. This product activates especially well when using an autoclave oven.

Cooling.: Product should be allowed to cool for sufficient time to allow bond-line temperature reaches roughly 30°C. before de-lasting to ensure shape is confirmed and set.

Zero Waste Program

Nitro Vulc® is part of our Zero Waste Program and is ordered by the part instead of sheet format. This allows all the cutting waste to be recycled in house and provides a more sustainable solution. All that is required is a DXF file of the full size run and we will deliver ready for production toe puff and counters.

General Information

Sheet Size: 40" x 60" (101.6cm x 152.4cm)

Area: 1.852 SY – 1.548 SM

Packaging: Sheets are put on pallets of 500 sheets per pallet.

Storage: Store in a dry cool area. Recommended shelf life is 2 years.

Patent: NITRO VULC ® products are approved and protected under US patent number 12,138,900