

## NITRO FORCE® HEEL COUNTER & BOX TOE MATERIAL

NITRO FORCE® is a new, revolutionary extruded material that has NITROGEN gas infused into the polymer core. The nitrogen gas displaces a portion of the polymer core and still maintains the Stanbee edict of thinner, stronger, more resilient and now with the nitrogen gas infused, even lighter in weight. When performance is pinnacle, brands choose NITRO FORCE®.

| GRADE            | GAUGE (±5%) |
|------------------|-------------|
| NITRO FORCE® 0.8 | 0.80 mm     |
| NITRO FORCE® 1.0 | 1.00 mm     |
| NITRO FORCE® 1.2 | 1.20 mm     |

### Composition

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The polymer core is 100% rPET from the one-time use plastic bottle waste stream and Nitrogen gas. The core is surrounded on both sides with our proprietary hot melt adhesive that will bond to all uppers, including oily leathers.

### Work Preparation

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**Cutting:** NITRO FORCE® can be cut in any direction allowing for optimum cutting yields.

**Heat Activation:** Recommend bond line temperature of 85°C/ 194°F but product is designed to work within a range of 80°C to 90°C

**Cold Mold:** Recommend to use cold mold with temperature of 0°C to -5°C and sufficient dwell time to secure minimum bond-line temperature of 30°C or less.

### Zero Waste Program

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NITRO FORCE® is eligible for Stanbee Zero Waste program and can be ordered as net cut part instead of in sheets. This allows all the cutting waste to be recycled in house which provides a more sustainable solution. All that is required is a DXF file for our fully automated computer cutting system.

### General Information

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

**Area:** 1.852 SY – 1.548 SM

**Packaging:** 500 sheets to a pallet.

**Storage:** Store in a cool dry area away from any source of direct heat. Recommended shelf life is 2 years from DOM

**Patent:** NITRO FORCE® is protected under U.S. patent number 12,138,900 B2.