

OKM ELAX and OKM SOLE

FLEXIBLE PU FOR INSOLES

PRIOR CONSIDERATIONS

- Read the information on the labels of each of the products to be used carefully.
- Use protective glasses, gloves and apron.
- Shake the drum well before use.
- Close the drum properly after each use.
- Observe mixture proportions.
- Weight using precision scales.
- Use clean, smooth and dry receptacles.
- Only mix using OKM shakers.
- The working temperature should be around 22 °C. Any changes in temperature and ambient humidity can alter the properties of the products.
- Store the products between 15° and 25 °C.

RECOMMENDATION

For a better finish, we recommend the use of OKM Ortoevas, polythenes and polypropylenes (check our OKM thermoplastic catalogue) and OKM DUR or OKM FOAM 450-700 for preparing moulds for insoles (check our okm solutions catalogue).

TECHNICAL SPECIFICATIONS

PRODUCT	OKM ELAX	OKM SOLE	
POLYURETHANE TYPE	FLEXIBLE EXPANSIVE	FLEXIBLE NON EXPANSIVE	
ISOCYANATE	ISO 180	ISO 110	
MIXTURE PROPORTION	100/48	100/13	
MIXING TYPE	2500 rpm	Manual	
MIXING TIME (sec)	10"-15"	20"-30"	
CREAM TIME (sec)	20"-22"		
TOUCH TIME (sec)	70"-75"	5'-7'	
DENSITY (GR/L)	500	1000	
EXPANSION	2		
SHORE HARDNESS	20A	20A	

MATERIAL TO USE FOR ELAX INSOLES (packaging)

PRODUCT	2 KG	5 KG	25 KG	250 KG
OKM ELAX	EX-100-02	EX-100-05	EX-100-25	EX-100-250
OKM ISO 180	IS-180-02	IS-180-05	IS-180-25	IS-180-250

MATERIAL TO USE FOR SOLE INSOLES (packaging)

PRODUCTO	2 KG	5 KG	25 KG	250 KG
OKM SOLE	SO-02N	SO-05N	SO-25N	SO-250N
OKM ISO 110	IS-110-02	IS-110-05	IS-110-25	IS-110-250

SEE REVERSE > PROCESS ➤

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DIRECTIONS FOR USE

- 1 Once the patient's mould has been rectified, mould an ORTOEVA of suitable hardness and thickness (usually hardness 30 and thickness 3 mm).
- 2 Staple the ORTOEVA to the mould (it is advisable to stretch the ORTOEVA well).
- 3 Apply a thin layer of impact glue.
- 4 Using 1 mm polyethylene make a stapled container also to the mould making sure no spaces are left through which the mixture can leak.
- 5 **PREPARATION OF THE MIXTURE WITH OKM SOLE AND OKM ISO 110.**
 - 5.1 > Pour the required amount of OKM SOLE in a glass or bucket.
 - 5.2 > Add OKM ISO 110 (13 parts per each 100 parts of OKM SOLE).
 - 5.3 > MANUALLY stir until a homogenous mixture is obtained (Approx. 12 seconds).
 - 5.4 > Before the PU has time to react, pour the mixture in the mould making sure the whole insole is covered.
- 6 **PREPARATION OF THE MIXTURE USING OKM ELAX AND OKM ISO 180**
 - 6.1 > Pour the required amount of OKM ELAX in a glass or bucket.
 - 6.2 > Add OKM ISO 180 (48 parts per each 100 parts of OKM ELAX).
 - 6.3 > Mix at 2500 rpm for 12 seconds.
 - 6.4 > Before the PU has time to react, pour the mixture in the mould making sure the whole insole is covered.
- 7 When the mixture has been poured in, wait for around 30 minutes before polishing the insoles made using OKM ELAX and around 2 hours before polishing when using OKM SOLE.

