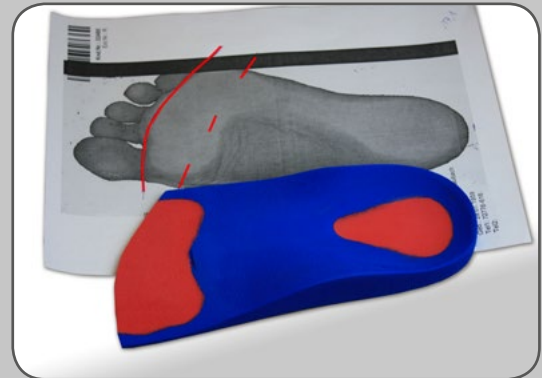


1

The Secosol® insole blank is supplied with a long sole and needs to be cut to $\frac{3}{4}$ length in the forefoot area. Ideally, cut the blank directly behind the toes, according to the shape of the impression. Please note the measurement points in the safety shoes.



The blank can then be individually adapted to the corrective features of the foot by means of sanding. If, for example, you want to incorporate padding for a heel spur and/or the plantar tendon, use only the azure blue or red shock absorber material.

If you would like to add extra material in order to make major changes to the blank, please only use the Secosol® lifting material (see „ACCESSORIES“ order form). You have the option of ordering this from us.

A truss pad can be positioned and mounted at your own discretion. The truss pad is then covered with a thin layer of the Hartmann Safety-pren special adhesive and is pressed onto the Secosol® insole. The truss pad is then sanded accordingly.



2

Evenly coat the top material and the insert blank with glue. The adhesive should not be applied too thickly, to prevent it from seeping through. When gluing the top part, please note that the area approximately 5 cm from its tip should not be coated, to prevent the perforations from getting clogged.



After allowing for a flash-off time of approximately 5 to 30 minutes, the adhesive is activated using a heating device (hot air blower). The blank is now positioned on the top part at a distance of approx. 0.5 cm from the end of the top part – please make sure that the top material does not warp.

3

The Secosol® insole is precisely adjusted to the shoe and foot with the aid of the sanding machine and is then inserted into the type-tested safety shoe.

Please note: The Secosol® insole should not exceed a thickness of 8 mm at the mid-heel or of 3 mm in the region of the forefoot (under the protective cover) (only the black EVA of the top part should be left in place).

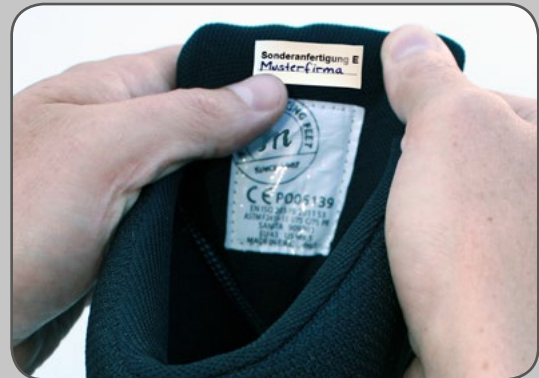


4

Thermolabel for identification.

The procedure for attaching this is as follows:

1. Write the name of your company on the label with a waterproof, thin, black pen.
2. Use a standard iron to iron the label into the shoe tongue so that any existing label remains legible.



5

We recommend that you quickly check the anti-static from the combination of the shoe and Secosol® insole before each delivery. However, this is not obligatory.

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Processing Secosol® milling blocks

Fix the milling block in your milling machine and start your milling programme as usual. Please refer to the “Manufacturing instructions for the Secosol® insole kit” for the further procedure.

The declaration of conformity can be found on our website at “www.secosol.de/downloads”.



Processing Secosol® thermoforming blanks

1. Heat the 3 mm-thick padding of the Secosol® insole that is to be worked up at a temperature of 80° to 90°C for one to two minutes. The front and rear foot pads that come with the kit can be used as required.

2. The 8-mm thick lifting material that is supplied is heated at a temperature of 100° to 120°C for four to six minutes.

3. Be sure to observe the specified values, otherwise the material will shrink too much and the Shore values will increase significantly. When it comes to gluing and the minimum and maximum thicknesses, please refer to the procedural instructions for the insole kit.



The declaration of conformity can be found at “www.secosol.com/downloads”. This must be enclosed with the safety shoes, together with your instruction manual for the insoles

Note:

Only material components from the company Matthias Hartmann Orthopädie + Sport GmbH may be used to manufacture the insoles. Violations contravene the procedures for manufacturing and finishing orthopaedic safety, protective and occupational footwear specified in German Social Accident Insurance (DGUV) Regulation 112-191 from March 2017 under point 4.2.2.1.