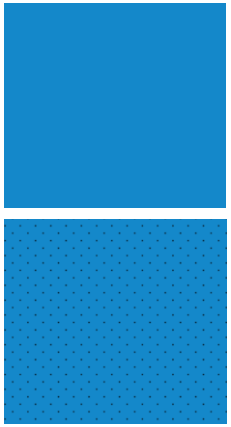
nora® Lunatec fusion 30

EVA expanded sheets, smooth and perforated, trimmed edges

Hardness:	Density:	Format:
approx. 30 Shore A	approx. 0,17 g/cm³	approx. 1000 x 700 mm // 39.4“ x 27.5“



SMOOTH

Colour:	Thicknesses:
378 blue	2 | 3 | 4 | 6 mm

PERFORATED

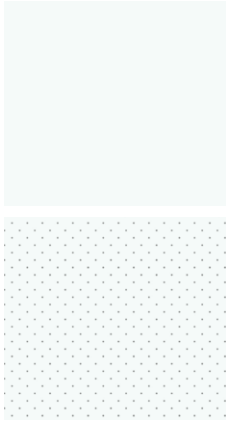
Colour:	Thicknesses:
378 blue	2 | 4 mm

Properties:
Lightweight, dimensionally stable, flexible and elastic, good elastic recovery, comfortable walking. Vegan and free of latex. Thermoformable at approx. 130 °C // 266 °F. Can be washed and disinfected completely hygienically because of closed cell structure.

nora® Lunatec fusion 40

EVA expanded sheets, smooth and perforated, trimmed edges

Hardness:	Density:	Format:
approx. 40 Shore A	approx. 0,22 g/cm³	approx. 1040 x 625 mm // 40.9“ x 24.6“



SMOOTH

Colour:	Thicknesses:
09 white	4 | 8 | 12 mm

PERFORATED

Colour:	Thicknesses:
09 white	4 | 8 mm

Properties:
Lightweight, elastic and dimensionally stable, good recovery capability, comfortable walking. Vegan and free of latex. Thermoformable at approx. 130 °C // 266 °F. Can be washed and disinfected completely hygienically because of closed cell structure.

If you have any questions about processsing, please contact our technical field support. Please visit our website for contact details
www.nora-material.com

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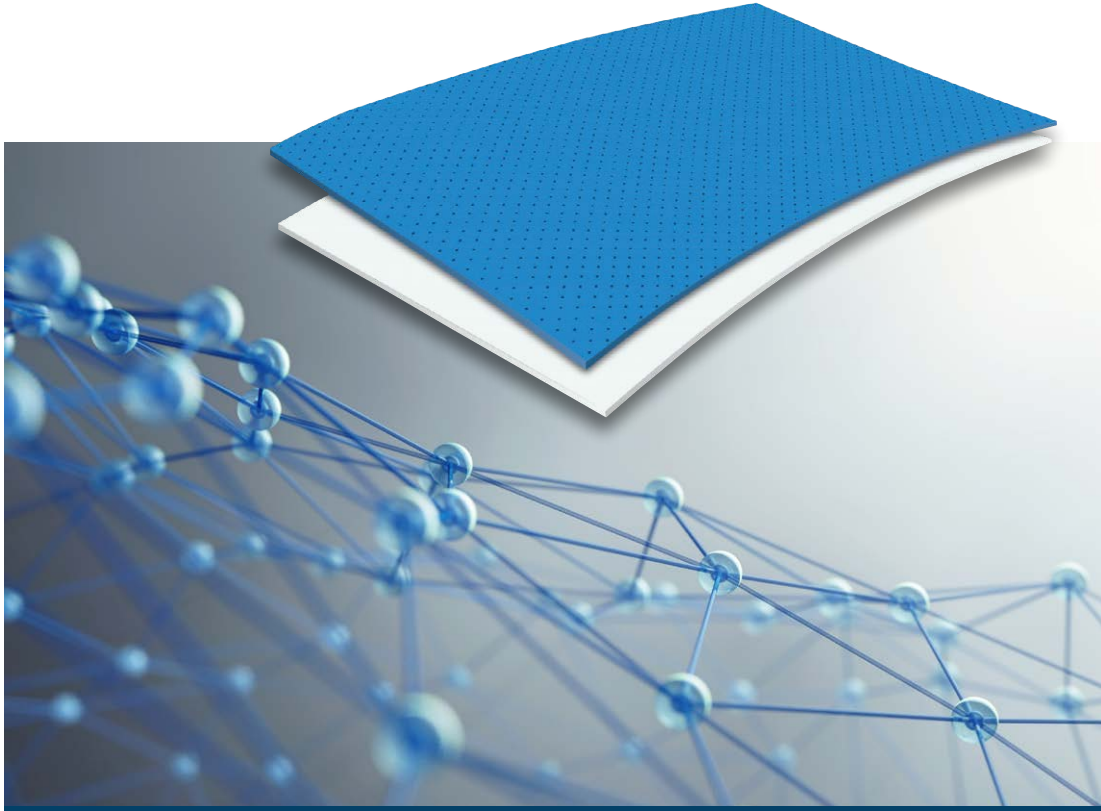
Innovative EVA foam:
nora® Lunatec fusion

Permanently bonded without any adhesive...



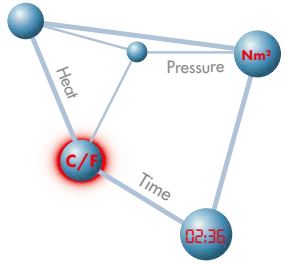
EVA solutions for health and industry
www.nora-material.com

nora® by Interface®

Work fast, clean and environmentally friendly...

Lunatec fusion is a global innovation in expanded EVA materials which ensure a reliable, permanent bond **without the additional use of adhesive**. This allows fast, clean, environmentally friendly and healthy work at the highest level of quality that's made in Germany.

Lunatec fusion 30 and **Lunatec fusion 40** mark the first step towards a new, contemporary way of working that allows **manufacturing without the additional use of adhesives**. These unique new materials bond directly with each other through thermoplastic moulding solely as a result of heat, time and pressure and fuse to create a permanent bond. The materials bond directly, without any glue or adhesive lamination.



The advantages are clear:
Massive savings on time and costs as well as clean and fast, healthy and environmentally friendly working, without any adhesive at all. There's no need to apply adhesive, thus avoiding contamination, later discolouration, tangible hardening and long drying times. The insole is ready for use immediately after cooling down.

Lunatec fusion 30 and **Lunatec fusion 40** are just the first step, the range will be completed shortly with a softer cushioning material and a harder stabilising material.

Processing instructions for a reliable bonding...

For a reliable bonding please note the following hints:

- **roughen** smooth materials
- use **a perforated** material
- oven setting: **130 °C //266 °F** and stick to the **recommended times**
- make sure of sufficient **pressure of the drawing bladder** and **press material** firmly
- **rule of thumb**: heating time x 2 = ideal cooling time

Recommended heating and cooling times for Lunatec fusion 30 and Lunatec fusion 40 (smooth):

With **perforated materials**, the heating time can be shortened by about a third as the heat spreads through the material faster.

Material thickness	Heating time	Cooling time
2 mm	45 seconds	1,5 minutes
3 mm	1 minutes	2 minutes
4 mm	2 minutes	4 minutes
6 mm	3 minutes	6 minutes
8 mm	4 minutes	8 minutes
12 mm	6 minutes	12 minutes

Because vulcanised EVA sheets consist of closed cells, the process works best when the material is **roughened by sanding** before processing. This increases the size of the surface for full-surface bonding. A similar effect is achieved by **perforation**, which also prevents the formation of air bubbles.

In addition to various material layers, **individual blanks**, e.g. for reinforcing the arch, can be positioned flexibly and bonded to each other in a single deep drawing process.

And that's how easy it works...

1. cut out and roughen in contact areas

2. heat and place all materials on last

3. press firmly while deep drawing and cool down

4. grind to shape