

nora® Lunatec fusion 20

EVA expanded sheets, smooth and perforated, trimmed edges

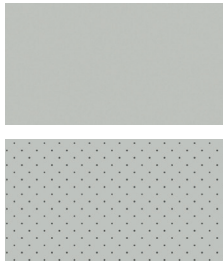
Hardness: approx. 20 Shore A
Density: approx. 0,12 g/cm³
Format: approx. 1050 x 760 mm

▼ SMOOTH

Colour: 60 light grey
Thicknesses: 2 | 3 | 4 mm

▼ PERFORATED

Colour: 60 light grey
Thicknesses: 2 | 4 mm



nora® Lunatec fusion 30

EVA expanded sheets, smooth and perforated, trimmed edges

Hardness: approx. 30 Shore A
Density: approx. 0,15 g/cm³
Format: approx. 1000 x 700 mm

▼ SMOOTH

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

▼ PERFORATED

Colour: 378 blue
Thicknesses: 2 | 4 mm



nora® Lunatec fusion 40

EVA expanded sheets, smooth and perforated, trimmed edges

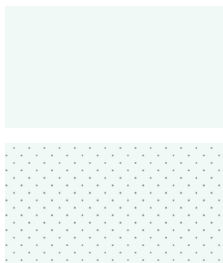
Hardness: approx. 40 Shore A
Density: approx. 0,20 g/cm³
Format: approx. 1040 x 625 mm

▼ SMOOTH

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

▼ PERFORATED

Colour: 09 white
Thicknesses: 4 | 8 mm



nora® Lunatec fusion 50

EVA expanded sheets, smooth and perforated, trimmed edges

Hardness: approx. 50 Shore A
Density: approx. 0,30 g/cm³
Format: approx. 1020 x 675 mm

▼ SMOOTH

Colour: 27 light blue
Thicknesses: 8 | 12 mm

▼ PERFORATED

Colour: 27 light blue
Thicknesses: 4 | 8 mm



Publisher

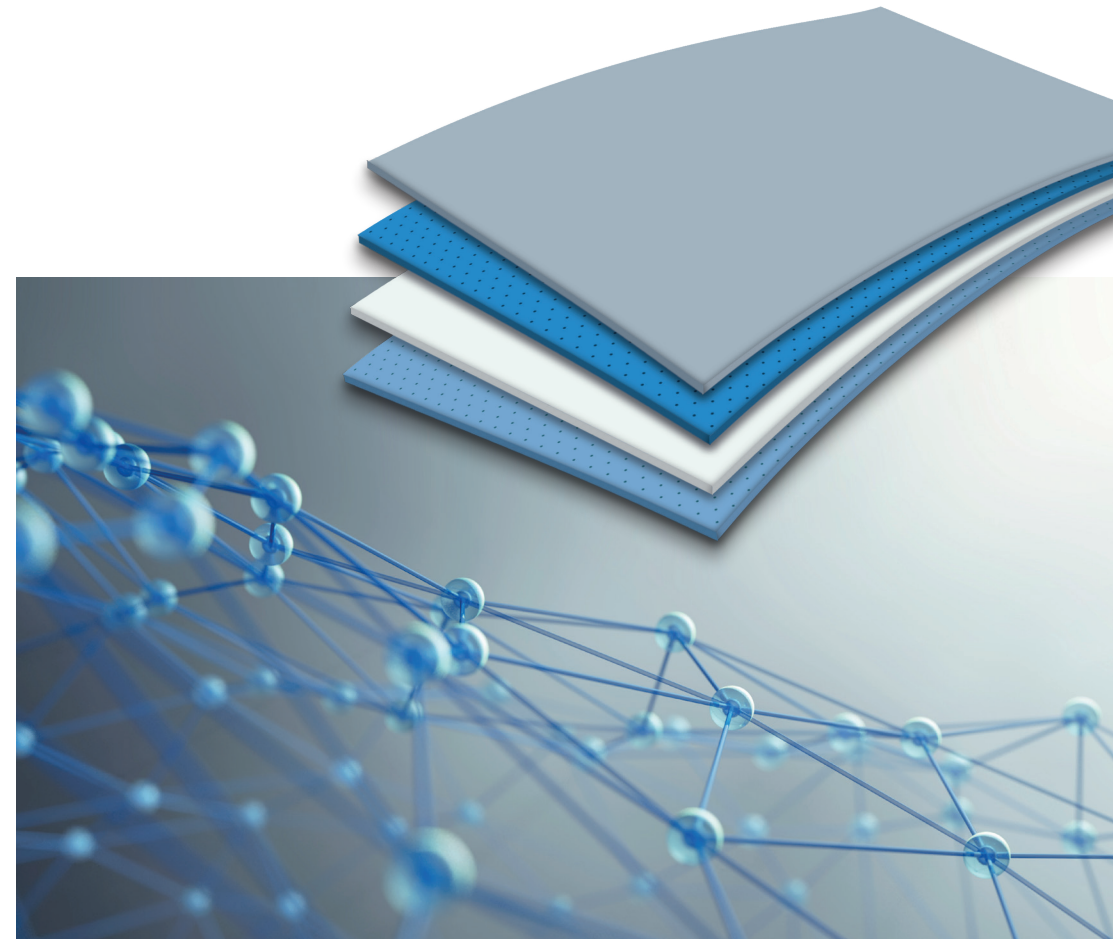
nora systems GmbH
EVA solutions for health and industry
Hoehnerweg 2-4
69469 Weinheim | Germany
www.nora-material.com

We reserve the rights for errors, misprints and changes. No guarantee is given for the correctness, completeness and accuracy of the information. The product images in this document may differ from the original. This document does not constitute a contractual offer and the data contained in this brochure only serves as a non-binding information.

07/2022

Innovative EVA foam: nora® Lunatec fusion

Permanently bonded without any adhesive...



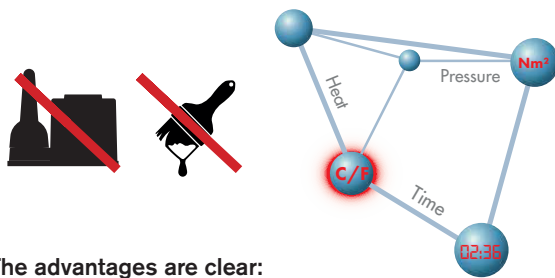
EVA solutions for health and industry
www.nora-material.com

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.

With **Lunatec fusion**, orthopedic insoles and foot beddings can be made entirely **without adhesive**. 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
- clean, fast and healthy friendly working
- no need to apply adhesive
- no discolouration or tangible hardening
- no contamination from glue
- no long drying and waiting times
- ready for use immediately after cooling down

Material 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.

Processing instructions for a reliable bonding...

For a reliable bonding please note the following hints:

- **roughen** the materials used
- 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 smooth materials:

Material	Thick-ness	Heating time	Cooling time
Lunatec fusion 20	2 mm	30 seconds	1 minute
	3 mm	45 seconds	1,5 minutes
	4 mm	1,5 minutes	3 minutes
Lunatec fusion 30 & Lunatec fusion 40	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
Lunatec fusion 50	8 mm	4,5 minutes	9 minutes
	12 mm	7 minutes	14 minutes

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

For the optimal cooling time, please consider the **total thickness** of the materials used.

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.

Individual blanks (e.g. for reinforcing the arch) can also be positioned flexibly and bonded 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

