

Manufacturing instructions

FOR ORTHOPEDIC INSOLES IN SAFETY SHOES ACCORDING TO
DGUV REGULATION 112-191



These manufacturing instructions define the work steps and materials to be considered and used for the orthopedic adaptation of the Baak ESD Softstep+ insole. It is mandatory to follow these instructions in order to ensure conformity with the EU type examination certificate even after processing the insole and using it in Baak safety shoes. Failure to comply with these instructions will result in the loss of the EU type examination certificate.

This insole is already fitted as standard in many models and can be recognized by this symbol.

FUSSBETT
orthopädisch
ANPASSBAR

TO BE USED FOR:

The **Baak ESD Softstep+** insole is particularly suitable for light orthopedic adjustments, such as heel and inner and outer edge elevations, which can be performed by an orthopedic shoemaker. Even after the adjustment, the insole remains fully conductive and is therefore the optimal solution for many Baak-ESD shoes.

WORK STEPS AND MATERIALS

- The basis is a Baak safety shoe that is certified with the Baak ESD Softstep+ insole. An always up-to-date overview of which models these are can be found under baak.de/en.
Many Baak models are already equipped with this insole as standard. It can also be obtained from your Baak dealer or directly from Baak.
- Only EVA Carbostat Antistatik material from the company AFT may be used for the construction of the insole, which corresponds to a Shore hardness of 40-50 Shore A.
For minor loads, we recommend the softer component EVA 40 Shore A, for large loads EVA 50 Shore A.
The adhesive to be used, Köraplast 182 A, can be obtained from specialist retailers.
- Maximum height in the heel area 20 mm
Maximum height in the ball area 10 mm
- Important to note:
The forefoot area, from the ball line forward, must not be covered with soft foam material, otherwise the minimum residual height of the toe protection cap cannot be guaranteed.



Article 4664-4666 Baak ESD Softstep+ (unfinished)



Insole Baak ESD Softstep+ (orthopaedically modified)

Ö-NORM Z 1259

For the Austrian market, Ö-Norm Z1259 regulates the insole supply. Here, the same rules apply, but a slip resistance SRC according to EN ISO 20345 is mandatory. This is the case for almost all Baak items. Which models are certified for the adaptation of the **Baak ESD Softstep+** insole can be found under baak.de/en.

MARKING

The orthopedic change in the shoe below the orthopedic insole must be marked according to the modifying body (orthopedic shoemaker) as follows:

- with the article number of the Baak safety shoe
- with the name of the manufacturer (name of the orthopedic company)