

Assembling Instruction

for Shoe Modification according to DGUV-Regel_112-191

This assembling instruction outlines the individual work steps and specifies the necessary materials that must be used for the modification of BAAK safety shoes. It is essential to follow these instructions to ensure the conformity of the EU examination certificate even after orthopedic modification. Failure to adhere to or deviate from this work instruction will result in the invalidation of the EU type examination certificate, and there may be a liability risk.

FOR USE WITH:

Safety shoes from the Baak Industrial Go&Relax series.

WORK STEPS AND MATERIALS

1. Cut the outsole of the BAAK safety shoe parallel to the insole but below the joint or puncture protection (see Sketch 1). It is advisable to draw a line on the side frame of the sole for better guidance of the knife. Follow this marking all around to achieve a clean cut. Roughen the shoe bottom and outsole thoroughly and wash with acetone



Sketch 1

2. Cut the front cap wedge from heel plate material „Elite 6 mm 95 Shore“ (Sketch 2). The wedge should extend 4 cm beyond the toe cap end. Bevel the straight edge and roughen the wedge. Apply „Körplast 182A“ to both the shoe bottom and the wedge, adding 10% „Körakur TR 280 (hardener)“ twice. Allow to air-dry for 30 minutes. Activate the material and shoe bottom with an oven or hot air blower at 70-80°C and immediately press for 30 to 40 seconds



Sketch 2

3. Cut, grind, and adhere the antistatic „SG Star Pur build-up plate“ according to the required modification, extending it forward over the front cap wedge. Mechanically sand and clean all surfaces of the „SG Star PUR build-up plate“ with acetone before gluing. It is also necessary to apply the material twice. Allow the glue „Körplast 182A and a 10% addition of Körakur TR 280 (hardener)“ to air-dry for 30 minutes. Activate the material with an oven or hot air blower at 70-80°C and immediately press for 30 to 40 seconds.

4. The rolling aid must not exceed a thickness of 10 millimeters, including the front cap wedge (Sketch 3). The maximum heel height is 30 millimeters (Sketch 3).



Sketch 3

5. Once the required modification has been glued, pressed, and sanded, the outsole can now be glued. Again, it is necessary to apply the material twice. The glue „Körplast 182A and a 10% addition of Körakur TR 280 (hardener)“ should be allowed to air-dry for 30 minutes. Activate the material with an oven or hot air blower at 70–80°C and immediately press for 30 to 40 seconds.

6. The shoes should now rest for 24 hours before trimming.

7. Possible modifications include ball roll, metatarsal roll, butterfly roll (limited without damaging the puncture protection), directional roll, rigidus roll, heel compensation, rolling heel, inner and outer edge increases. Maximum increases of 10 mm in the ball and 30 mm in the heel should be observed.

8. Please in general observe the guidelines of the **Central Association of Orthopedic Shoe Technology**.

9. Certified orthopedic insoles in combination with shoe modifications: **Springer Basic AS and Comfort AS**.

10. Material List:

- Körplast 182A Adhesive, Hardener Körakur TR 280 from Fuller.
- For the front cap wedge: Elite Heel Material 95 Shore.
- Build-up plates: SG (Schomburg and Graf) Antistatic.
- Acetone for cleaning materials

11. The continuously updated overview of models with orthopedic shoe modifications covered by this work instruction can be found in the download section on baak.de

12. Your contact at Baak if you have any questions:

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