

Velocity V0.3 — Process Guide

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- 1) Cut upper (laser/plotter) — DXF files, 1:1 scale.
- 2) Heat-press TPU reflective overlay: 150 °C, 6 bar, 10–12 s with Teflon sheet.
- 3) Stitch upper to strobel (0.5 mm) with minimal seam allowance.
- 4) Prepare plate bonding: PU primer + Desmocoll; activation 55–60 °C.
- 5) Bond plate to upper with 3D press: 6–8 bar, 12–15 s; ensure alignment at toe and heel cup.
- 6) Finish: trim edges, insert sockliner 2 mm, lace-up; QC weight and flex.

Safety: use ventilation and PPE (A2P3 mask, nitrile gloves).