

## Material Description And Process Recommendation

**Future** is a cork and EVA material blend specially formulated to allow the possibility of thermoforming in typical thermoforming processes such as those used in insole production and molded orthopedic components.

### Material Description

Available format	Sheets: 1,5 to 6 mm <sup>(1)</sup> Rolls: 1,5 to 3 mm <sup>(1)</sup>
Material	Cork and prime EVA formulation
Color	Light brown (cork color)
Density (kg/m <sup>3</sup> )	320–430
Hardness (Shore A)	55–75
Other characteristics	<ul style="list-style-type: none"><li>• PVC free</li><li>• Latex free</li><li>• Formaldehyde free</li><li>• Adapts to the foot anatomy</li><li>• 100% cork natural aesthetics</li><li>• 100% Vegan (cork and EVA only)</li><li>• 100% recyclable</li></ul>

<sup>(1)</sup> Other thickness only under request.



## Process Recommendations <sup>(2)</sup>

Thermoforming process recommendation

### Mechanical and vacuum (membrane) Thermoforming

## Material Reception And Preparation

- Material should be unpacked at least 3–5 hours prior to heating and molding; maintaining a stable environment.
- Precutting forms/pieces recommended for a better material optimization and molding results.

## Molding Process

- Deep drawing and sharp edges caution should be taken at material above 4mm thickness.
- Multiple sheets of FUTURE can be piled to obtain thickness above 6mm.
- Multilayer combinations or piling (with other materials) follow standard practices.
- Material should be inserted in the heating chamber (oven), at temperatures between 120–160 °C, for a time period ranging from 30s to 1min depending on material thickness, size and component design.
- Molding time should be defined based on component complexity size, thickness and mold temperature. Typically refrigerated mold result in lower cycle times (within seconds).
- Demold and trim according to custom practices.
- CNC machining and sanding can be performed for custom shaping.

<sup>(2)</sup> These conditions are indicative and should be adjusted for customer process.



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