

Guideline



Prerequisites for external lasting:

- The last must be in good condition since up to 6 bar of pressure is generated during the process of gluing the outsole. (We offer a service which makes a one-to-one copy of old lasts in wood. This service is charged)
- The last should be divided into 3 parts if possible. The reconditioning with a lasting machine means that the upper is positioned very tightly against the last and the upper may otherwise be damaged when removing from the last.
- To place the last on the lasting machine, a stand socket or drilled hole with a diameter of 12 mm is necessary. The stand socket should be located approximately 3.5 cm from the rear heel ridge. Leg lasts of up to a height of 28 cm may be processed with the lasting machine.
- Please make sure that your insert is cleanly processed at the transitions since the counter made from thermal materials or nonwoven chemical solvent materials to dissolve with solvent will show all unevenness in the upper.
- When making sandals, please shorten the footbed as required for the finished shoe.
- If you wish to process shell-shaped soles from our components brochure, you should grind the shape according to our insole template. Please consult the components brochure to determine which insole shape you require.
- When using shell-shaped soles it is also necessary to grind the right heel spring into the bed. We offer heel wedges as tools which will enable you to grind the spring easily. In the components brochure, you can read off the heel spring of each individual outsole on the front of the heel and the end of the heel. Please grind 5 mm more into the bed if you are using a shank piece.
- When using foam rubber soles, you do not need to maintain an insole shape. Here, you only need to grind the heel spring into the bed with the help of the original sole.
- For safety footwear you must adapt the toe of your last to accommodate the aluminium toe-cap in addition to completing the insole shape and spring. To do this, use our transparent test caps. The last plus footbed must fill this cap. This will ensure that you have sufficient space while manufacturing to accommodate the insole and the lining when attaching the aluminium toe-cap. The incorporation of aluminium toe-caps results in a loss of toe spring of 5 mm. Take this into account when grinding the bed.
- Please always use a pencil to draw in how high you wish to have the low shoe upper lasted. These markings are also useful for low outside ankle bones.
- For boots, the height is measured on the outside of the upper. Please remember that some upper designs have a spoiler pointing up or a dip at the heel. If you do not want this, you must specify this information.
- When it comes to counters it is also very helpful if you can specify the length and height or mark them on the last using a pencil.
- Please make detailed specifications regarding materials and thicknesses for the counter. When combining materials, we also require information regarding transitions and gaps.
- Toe caps may be incorporated in a variety of materials and shapes. Please draw special features of the cap shape onto the last using a pencil.
- Please make specifications regarding the insole materials or any reinforcements in carbon or fibreglass.



Insole templates



Test wedge for heel spring












Heel spring with foam rubber soles



Adapting using test caps

Guideline

Check list:

- The last should be in good condition. 
- The last should be divided into 3 parts if possible. 
- Stand socket or drilled hole in last. 
- Clean transitions on the beds. 
- Footbed shortened for sandals. 
- For shell-shaped soles, bed is ground according to insole template. 
- Heel spring ground with test wedge. 
- For foam rubber soles only grind the heel spring. 
- For safety footwear, adapt the last toe to the aluminium toe-cap. 
- Last height of low shoe upper is drawn in. 
- For boots, the height of the upper is draw onto the outside of the leg last. 
- For counters, draw the length and the height. 
- Specifications have been made regarding counters. (Materials and thicknesses) 
- Toe cap materials and shapes specified or drawn. 
- Insole materials determined. 
- Specifications regarding shank pieces made under the insole. 
- Specifications regarding sole reinforcement shapes and materials. 