

## Heel Molder and Flanger Model J (HMF-J)

The Heel Molder Flanger Model J is used for thermo-coated fiber or thermoplastic counters. After being heat softened by heated activator molds and pads, the uppers are shaped and flanged on cool forming molds. The activating temperatures and times are electronically programmed for constant, proper activation. The operation is efficient and can be performed by unskilled operators.

- Mirror allows visual check for back seam straightness.
- Back height accurately set by gauge ensuring correct size by size back height.
- Curved adjustable pincers draft upper and lining tightly around mold.
- Wipers to flange heel seats.
- Adjustable mold positions for accurate heel seat forming.
- Molds and pads can be quickly changed.
- Production rates of up to 125 pairs per hour.
- Regular or custom made molds.

### Sequence:

1. Activator in idle position with mold forward of the pad, allowing ample loading clearance.
2. Pincers stretch upper, mold retracts, pad descends and closes, counter is activated.
3. The pad releases and the mold comes forward for easy upper removal.
4. Molding and flanging station in idle position.
5. Pincers stretch upper and back height is set by gauge. Visual check for straight back seam.
6. Heel pad shaped back and top line and wipers flange heel seat.

### Specifications:

#### Air:

Pressure	80 lbs./in. <sup>2</sup> (5.6 Bar)
----------	------------------------------------

Consumption	5.6 scfm (158/liter/min.) at 125 pairs per hour
<b>Electrical:</b>	220 V, 60 Hz, 4A single phase
	3.3 kW peak, 2.1kW average at 125 pairs per hour
<b>Weight:</b>	775 lbs. (352kg)
<b>Dimensions:</b>	69W x 35D x 66H in.
	(1,755W x 890D x 1,680H mm)