



Liner Procedures

For this process you will need the following equipment:

- K2 Liner-Heater (119°C)
- Toe caps
- 1 pair of thin ski socks or thin black Intuition stockings
- An additional pair of thin black Intuition stockings
- Adhesive pads (optional)
- Gloves

Procedure:

1. Remove the insole. **(Figure 1)**
2. Insert liners into the ski boots.
3. Place the ski boots on the liner heat stacks and set the timer for 10 minutes. **(Figure 2)**
4. While the liners are heating, prepare the foot with adhesive pads on prominent spots if needed. Place a toe cap over the customer's toes. **(Figure 3)**
5. Carefully put a ski sock over the prepared foot. Then, put on a thin black intuition stocking. No wrinkles! **(Figure 4)**
6. When the timer sounds, turn the timer on for an additional two minutes to keep the second boot warm.
7. Remove the first boot, put the insole into the liner and let the customer step into the boot. Close the buckles. **(Figure 5)**
8. Repeat step 7 for the second boot.
9. Have the customer stand for approximately 10 minutes with knees slightly bent.
10. When the liners have cooled, remove the boots, stockings, and toe caps. Have the customer put on their typical ski socks and assess fit.

Extra Tips:

- Have customer try on boots before heat molding. If the liners feel tight, buckle the boot tight to compress foam and create more room. If the liner feels loose, buckle the boot somewhat loose to avoid compressing foam.
- Liners can be reheated and reformed if they do not take the proper shape during the first forming.
- For extra toe room, use two toe caps on each foot.



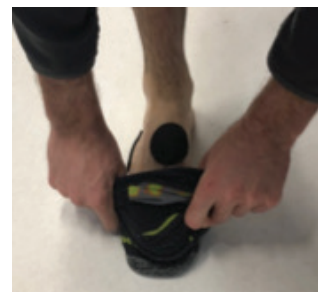
(Figure 1)



(Figure 2)



(Figure 3)



(Figure 4)



(Figure 5)

Shell Procedures (continued on page 2)

For this you will need the following equipment and materials:

- Hot Air Boot Oven (up to 119°C)*
- K2 Liner-Heater (119°C)
- K2 Ski-Boot
- Adhesive pads
- Gloves
- Toe caps
- Optional Cooling Pack or Cold Spray

Ovens used by Atomic, Salomon and Head oven have the correct temperature settings.





Shell Procedures (continued from page 1)

Procedures:

1. Fit test boots. Adjust cuff rack positions and buckle micro adjustment as needed.
After the boots are heated, the buckles will need to be loosely closed on the first hook.
2. Take the liner from the shell (**Figure 1**) and remove the insole (**Figure 2**). Also make sure to remove the bootboard/zeppa from the shell.
3. Place the liners on the liner-heating stack and set the Timer for 10min on setting II (**Figure 3**).
 - At the same time put the shell in the hot air boot oven with the boots placed in a lying down position (**Figure 4**) and set the timer for 10min on a temperature setting of 119° degrees. (*See Appendix A, page 3)
4. While the shell and the liner are heating, prepare the foot with adhesive pads on prominent spots (ankle, navicular bone, instep, 6th toe) if needed (**Figure 5**). In addition you should use toe-caps during the molding process. Carefully put a ski sock over the prepared foot. (**Figure 6**).
5. After 10 minutes take the left shell out of the oven with gloves (attention: shell is hot and will burn skin!) (**Figure 7**) and the left liner off the liner heating stack. Set timers for both boot over and liner heaters an additional 1 minute to keep the right shell and liner hot/warm.
6. Put the left insole into the left liner (**Figure 8**), insert the bootboard/zeppa and slide the liner into the left shell. (**Figure 9**)
7. Let customer step into the boot (**Figure 10**) and pull the liner up using the cords (**Figure 11**) to ensure that the liner sits perfectly in the shell.
8. Close the buckles loosely with the buckle catch on the first hook (make sure not to tighten the buckles) (**Figure 12**).
9. Repeat the steps 5 through 7 with the right boot.
10. For the first 3 minutes during the cool down period the customer should stay in natural ski position on a flat surface without flexing the ski boot (knees slightly bent and hips forward). After 5 minutes the customer can move and walk around.
11. To speed up the cooling down you can use optional cooling pads or Ice Spray. (**Figure 13**).
12. IMPORTANT! The shell needs to be cooled down to room temperature before taking off the boots. Wait at least 3 hours before using the boot on the snow. The boots may be removed once the shell has cooled down to room temperature. Take off the socks and remove pads and toe caps from the foot. Put ski socks back on and try on the boots again to ensure a comfortable fit. (**Figure 14**). The shell can be widened up to 6mm with this heat molding method.

13. Go ski!



(Figure 1)



(Figure 2)



(Figure 3)



(Figure 4)



(Figure 5)



(Figure 6)



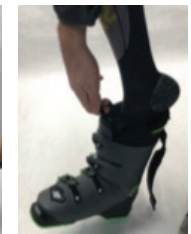
(Figure 7)



(Figure 8)



(Figure 9)



(Figure 10)



(Figure 11)



(Figure 12)



(Figure 13)



(Figure 14)



K2 SKI BOOT COMPANY 2019 LINER AND SHELL FITTING PROCEDURES (page 3)

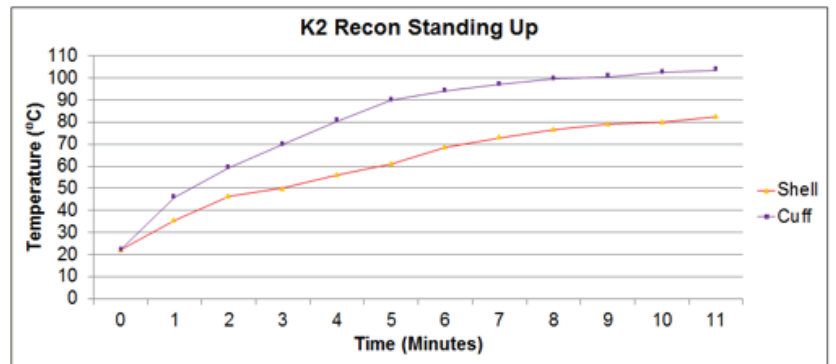
Appendix A

Appendix A

After investigating the performance of the standard ski boot molding oven, it was found that standing the boot in the oven does not provide the most efficient shell mold. The cuff is receiving most of the direct heat because the heat is coming directly from the fan in the back of the oven. To improve the efficiency of shell molding, the shells should be placed into the oven in a lying position so the heat from the oven is blowing directly onto the shell. This also prevents the front of the cuff from sagging from the direct heat. (NOTE: Sagging at the front of the cuff will NOT effect the performance of the ski boot or effect the plastic in any negative way.)The data from these tests can be seen below:



Sagging of the cuff



Red circles indicate area temperature was recorded on the shell and cuff.