

# K2 SKI BOOT LINER HEAT FORMING MANUAL

## WARNING

1. *K2 Sports does not recommend using ovens for molding liners due to variation in temperature and potential for overheating.*
2. *Overheating liners will not only damage the liner but can cause serious injury including burns to the boot fitter and/or the customer.*
3. *Heat stacks vary in temperature. The boot fitter must check liner temperature by hand to make sure liners aren't too hot.*
4. *Never mold wet liners. They are likely to overheat.*

## EQUIPMENT

1. K2 Heat Stack
2. 1 pair thin ski socks (knee length) or 1 pair thin black nylon K2/Intuition stockings.
3. 1 pair Intuition molding toe caps.
4. A second pair of thin black nylon K2/Intuition stockings.

## PROCEDURE

1. Remove packaging and foot beds from the inside of the boot liners. It may be necessary to remove liner from boot to remove the foot bed. (FIGURE A)
2. Place boots on heat stacks (with liners) so that both tubes are inside the liners.
3. Position the boots so that the toes point up towards the ceiling.
4. Turn heater onto high setting, position II.



FIGURE A

5. Set timer for 10-12 minutes. (FIGURE B)
6. Put knee length thin ski socks on customer. For tighter fit use thin black nylon K2/Intuition stockings instead of ski socks.
7. Put toe cap over customer's toes (FIGURE C). Place additional soft material (i.e. tissue, etc.) inside the toe caps if more toe volume is desired or to aid toe comfort during molding.
8. Hold K2 foot bed under customer's foot and slip additional black nylon K2/Intuition stocking over the sock, toe cap and foot bed (FIGURE D, E). K2 does not recommend using the customer's custom foot bed during the molding process. Most custom foot beds are created by heat molding and could deform during liner heat molding.



FIGURE B



FIGURE C



FIGURE D



FIGURE E

9. Ensure any wrinkles are removed and that the toe caps and foot beds are in position before continuing.
10. When timer sounds take the first boot off the heat stacks and turn the timer for an additional 2-3 minutes (this ensures that the second boot doesn't lose heat while the first boot is fitted).
11. Put on first boot as quickly as possible.
  - a. Liner should feel warm but NEVER painfully hot.
12. Buckle first boot so that it is snug, but not too tight.
  - a. Toe caps may be uncomfortable to the customer during molding, this is normal. Toe caps are necessary to get proper toe box height during molding.
13. Position a 1-2 inch lifter underneath the toes of the first boot so that the customer's foot is pushed firmly into the heel. A piece of 2X4 lumber works well. (FIGURE F)
14. Put on second boot as quickly as possible.
15. Buckle second boot so that it is snug, but not too tight.
16. Position the lifter underneath the toes of the second boot.
17. Have the customer stand for approx. 10 minutes with knees slightly bent, toes on the lifter, and heels down on the ground. (FIGURE F)
18. After the boots have cooled remove them.
19. Remove the stockings, toe caps and foot beds from the customer's feet.
20. Replace the foot beds in the boot liners.
21. Test and assess fit with customer's ski socks. If customer prefers to wear thicker ski socks then use thicker ski socks for test fitting.



FIGURE F