



# Heat Molding Procedure

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All Jackson Ultima leather outsole products can be heat molded to enhance the comfort and fit of the boot right in your store. The ideal oven for heating boots is convection, which allows for an even distribution of heat. Jackson ovens are highly acceptable while Blademaster or Bauer ovens can also be used. **DO NOT USE A REGULAR HOUSEHOLD OVEN.** The heat from radiant elements is too direct and will damage the boot and void the warranty.

Follow these simple steps to help provide your customers with a customized fit.

1. Set skate oven to temperature of 165 – 170° F or 74 - 77° C. Remove the footbed and lace the skates up loosely to help the customer easily slip on the skates after they are heated.
2. Place the boots in the oven, once the ideal temperature has been reached for at least 3 to 5 minutes. Use the chart below as a guideline for heating times.

Model Name	Model	From <b>COLD</b> Oven	From <b>HOT</b> Oven
Elle	DJ2000/DJ2130	5 minutes	3 minutes
Freestyle	DJ2100/DJ2190/DJ2102/DJ2192	6 minutes	4 minutes
Competitor	DJ2470	6 minutes	4 minutes
Premiere	DJ2500/DJ2602	7 minutes	5 minutes
Finesse	DJ2510	7 minutes	5 minutes
Elite 4200/Elite	DJ4200/ DJ2952	8 minutes	6 minutes
Synchro	DJ3400/DJ3410	8 minutes	6 minutes
Coach	DJ3405	8 minutes	6 minutes
Elite 4500	DJ4500 / DJ4500S / DJ4500U	9 minutes	7 minutes
Elite Supreme	DJ3802/DJ3852/DJ3902/DJ3952	9 minutes	7 minutes
Low Cut	DJ4400/DJ4452	9 minutes	7 minutes
5000 Series		6 minutes	4 minutes

3. Remove the skates from the oven, replace the footbed and have the customer immediately put on both warm boots. Have the customer push their toes all the way to the front of the boot and then lightly kick back their heels in place. This will allow the heel to sit in the correct position at the back of the boot underneath the Achilles/heel padding. Lace the boots slightly tighter than they normally would for skating.
4. If any other adjustments need to be done such as stretching, punching for ankle discomfort, bone spurs, etc. carry out before cooling time has elapsed.
5. Have the customer remain seated until the boot is completely cool. Make sure that the customer does not stand up or walk around until the boot is completely cool (approximately 10 minutes).
6. If the heat molding process needs to be repeated several times to achieve comfort, it is likely that the customer has been fitted incorrectly in the wrong length/width.

**This fitting process must be carried out by a competent skate technician.  
Failure to follow the above procedure may void the warranty.**