

MIL-S-22777F

~~18 October 1982~~

SUPERSEDING

MIL-S-22777E

13 October 1976

MILITARY SPECIFICATION

SOLES AND HEELS, RUBBER, TRACTION TREAD, SHOE

This specification is approved for use by all Departments and Agencies of the Department of Defense.

1. SCOPE

1.1 Scope This specification covers the requirements for rubber soles and heels with a chevron tread design.

*1.2 Classification The soles and heels covered by this specification shall be of the following types, grades, classes and sizes (see 6.2 and 6.5).

Type I - Full sole

Grade A

Grade B

Grade C

Sizes - 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15

Type II - Heel

Grade A

Class 1 - Plastic or composition core construction

Grade B

Class 2 - Solid construction

Sizes - 26, 28, 30, 32, 34, 36, 38, 40, 42, 44, 46

Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Officer in Charge, Navy Clothing and Textile Research Facility, 21 Strathmore Road, Natick, MA 01760 by using the self-addressed standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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2. APPLICABLE DOCUMENTS

2.1 Government documents

2.1.1 Specifications, standards, and handbooks Unless otherwise specified the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DODISS) specified in the solicitation, form a part of this specification to the extent specified.

SPECIFICATIONS

FEDERAL

TT-S-735	- Standard Test Fluids, Hydrocarbon
PPP-B-566	- Box, Folding, Paperboard
PPP-B-636	- Box, Shipping, Fiberboard
PPP-B-665	- Boxes, Paperboard, Metal Edged and Components
PPP-B-676	- Boxes, Setup

STANDARDS

FEDERAL

FED-STD-311	- Leather, Methods of Sampling and Testing
FED-STD-601	- Rubber, Sampling and Testing

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MIL-STD-105	- Sampling Procedures and Tables for Inspection by Attributes
MIL-STD-129	- Marking for Shipment and Storage

2.1.2 Other Government documents, drawings, and publications The following other Government documents, drawings and publications form a part of this specification to the extent specified herein.

DRAWINGS

16-1-499	- Soles and Heels, Rubber, Traction-Tread, Shoes - Heels
16-1-500	- Soles and Heels, Rubber, Traction-Tread, Shoes - Soles

(Figures 1 and 2 are miniature reproductions of Drawings No's 16-1-499 and 16-1-500 and are attached for information only).

(Copies of specifications, standards, drawings and publications required by contractors in connection with specific procurement functions should be obtained from the procuring activity or as directed by the Contracting Officer.)

2.1.3 Order of precedence In the event of a conflict between the text of this specification and the references cited herein, the text of this specification shall take precedence.

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RULES AND REGULATIONS

US POSTAL SERVICE MANUAL

(Copies of the manual may be obtained from the Superintendent of Documents, US Government Printing Office, Washington, DC 20402).

2.2 Other publications The following documents form a part of this specification to the extent specified herein. The issues of documents which are indicated as DOD adopted shall be the issue listed in the current DODISS and supplement thereto, if applicable.

AMERICAN SOCIETY FOR TESTING AND MATERIALS

- D-624 -Test for Rubber Property - Tear Resistance
- D-1052 -Test for Measuring Rubber Deterioration - Cut Growth Using
Ross Flexing Apparatus
- D-1630 -Test for Rubber Property - Abrasion Resistance (NBS Abrader)
- D-2240 -Test for Rubber Property - Durometer Hardness
- D-3183 -Preparation of Pieces for Test from Other Than Standard Vulcanized
Sheets

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103).

NATIONAL MOTOR FREIGHT TRAFFIC ASSOCIATION, INC., AGENT
National Motor Freight Classification

(Application for copies should be addressed to American Trucking Association, Attn: Traffic Dept., 1616 P Street, N.W., Washington, DC 20036).

UNIFORM CLASSIFICATION COMMITTEE, AGENT
Uniform Freight Classification

(Application for copies should be addressed to the Uniform Classification Committee, Room 1106, 222 South Riverside Plaza, Chicago, ILL 60606).

3. REQUIREMENTS

3.1 Guide sample Samples, when furnished, are solely for guidance and information to the contractor (see 6.4). Variations from this specification may appear in the sample, in which case this specification shall govern.

3.2 First article When specified (see 6.2), the contractor shall furnish sample unit(s) for first article inspection and approval (see 4.2).

3.3 Materials

3.3.1 Rubber Grades A, B, and C rubber shall be synthetic rubber compounds conforming to the requirements specified in Table I (see 6.5). In addition, the rubber shall be non-marking. The color shall be black. Testing shall be as specified in 4.4.

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* Table I - Physical requirements of rubber

Characteristics	Grade A	Grade B	Grade C
Abrasive index (minimum Before and after aging	150	70	150
Hardness			
Before and after aging			
Minimum	60	75	60
Maximum	80	90	80
Volume swell			
Percent, maximum	30	65	30
Cut growth after aging			
Percent, Maximum	250 <u>1/</u>	200 <u>1/</u>	-
Stitch tear			
Before and after aging			
Lbs/inch, minimum	240 <u>1/</u>	-	240 <u>1/</u>
After immersion, lbs/inch minimum	160 <u>1/</u>	-	160 <u>1/</u>
Tear strength			
Lbs/inch, minimum	175 <u>1/</u>	-	175 <u>1/</u>
Cut growth after aging, full thickness of sole-percent maximum	-	-	400 <u>1/</u>
Cut growth at 90°F before aging percent maximum	-	-	250 <u>1/</u>

1/ This requirement is applicable only when the rubber is used for manufacturing the soles.

3.3.2 Heel core The heel core shall be of plastic or composition material. When tested as specified in 4.4., the core shall have a hardness of 65 (+ 5) Shore D before immersion and a minimum of 55 Shore D after immersion; and shall show no evidence of cracking. The thickness of the core shall be 7/32 (+ 2/32, - 1/32) inch.

*3.4 Design and dimensions The soles shall conform to the design and dimensions specified in Drawing No. 16-1-500. The heels shall conform to the design and dimensions specified in Drawing No. 16-1-499. When specified in the end item specification, the tread area for GRADE C soles and heels may be of a design approved by the preparing activity.

3.5 Molds The molds used for the manufacture of the soles and heels shall be furnished by the contractor and approved by the procuring activity.

3.6 Construction

3.6.1 Type I, grades A, B, and C The sole shall be of solid rubber construction.

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3.6.2 Type II, grade A, class 1 The heels shall be constructed with a plastic or composition core. The core shall not be more than 5/16 inch or less than 1/8 inch from the outside wall of the heel from breast corner to breast corner, except that it may be closer than 1/8 inch to the breastline edge. The lateral distance from any inside weight relief well or boss to the outside wall of the heel shall not be less than 7/8 inch. The depth of any relief well shall not be greater than 3/8 inch when measured from the exposed surface of the core. The exposed surface of the core shall have a fine stipple design with a maximum height of 1/64 inch. There shall be no evidence of separation of the core from the heel when tested as specified in 4.4.

3.6.3 Type II, grade B, class 2 The heels shall be of solid rubber construction.

3.7 Marking for size, trademark, and mold identification

3.7.1 Soles The size and mold identification markings shall be inscribed as shown on Drawing No. 16-1-500. The contractor's trademark or name shall be inscribed in the shank area.

3.7.2 Heels The size, trademark, and mold identification markings shall be inscribed on either the wearing surface or on the inside surface.

3.8 Workmanship The finished soles and heels shall conform to the quality established by this specification. The occurrence of defects shall not exceed the applicable acceptable quality levels.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for inspection Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

4.1.1 Certificate of compliance Where certificates of compliance are submitted, the Government reserves the right to check test such items to determine the validity of the certification.

4.2 First article inspection The first article submitted in accordance with 3.2, shall be inspected as specified in 4.3.2 for compliance with design, construction, workmanship, and dimensional requirements.

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4.3 Inspection Inspection shall be in accordance with MIL-STD-105, except where otherwise indicated herein.

4.3.1 Component and material inspection In accordance with 4.1, components and materials shall be inspected and tested in accordance with all the requirements of referenced specifications, drawings, and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.

4.3.2 Examination of the end item The defects found during the examination of the end item shall be classified in accordance with 4.3.2.1 and 4.3.2.2. The applicable inspection levels and acceptable quality levels (AQL's) shall be as indicated in 4.3.2.3.

4.3.2.1 Visual examination The finished soles and heels shall be examined for defects in pairing, design, construction, workmanship and marking, in accordance with the list below. The sample unit shall be one completely fabricated pair of soles or heels of each class. The lot size shall be expressed in units of pairs of soles or heels.

Examine	Defect
Pairing	Not properly mated, i.e., not right and left of same size or class; wide variation in color.
Color	Color other than specified.
Design	Any characteristic of design not in accordance with the specified requirements.
Material	Not material specified.
Construction and Workmanship	Rubber not fully cured, e.g., evidence of tackiness. Any area of porosity or sponginess resulting in loss in density of the rubber stock. Any air check more than one-third the thickness of the sole or heel. More than one air check over 1/16 inch deep but not exceeding one-third of the thickness of the sole or heel. Any press out, tear, blister, loss of tread details, imbedded foreign matter or bloom. Not cleanly trimmed. Any core omitted, damaged, cracked, or improperly located. Any core not firmly or properly bonded to rubber heel base. Any core showing evidence of separation or softening. Exposed surface of core not stippled.
Identification and size marking	Missing, incorrect, illegible or misplaced.

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4.3.2.2 Dimensional examination The soles and heels shall be examined for defects in dimensions. The sample unit shall be one pair of heels or soles of each size. The lot size shall be expressed in terms of pairs of heels or pairs of soles of each size. Any measurement deviating from the dimensions and tolerances specified in Drawing No.'s 16-1-499 and 16-1-500 and in 3.3.2 shall be scored as a defect.

4.3.2.3 Inspection levels and acceptable quality levels (AQL's) The inspection levels and acceptable quality levels (AQL's) expressed in defects per hundred units shall be as follows:

	<u>Inspection Level</u>	<u>AQL (One class)</u>
For defects applicable to 4.3.2.1	II	4.0
For defects applicable to 4.3.2.2	S-3	4.0

4.3.3 Examination of packaging requirements An examination shall be made to determine that packaging, packing and marking comply with Section 5 requirements of this specification. Defects shall be scored in accordance with the list below. The sample unit shall be one shipping container fully packaged with the exception that it need not be closed. Defects of closure listed shall be examined on shipping containers fully packaged. The lot size shall be the number of shipping containers in the end item inspection lot. The inspection level shall be S-2 and the AQL shall be 2.5 defects per hundred units (DNV).

<u>Examine</u>	<u>Defect</u>
Marking (exterior)	Omitted, incorrect; illegible; of improper size, location, sequence or method of application.
Materials	Any component missing, damaged or not as specified.
Workmanship	Inadequate application of components, such as: incomplete closure of container flaps, improper taping, loose strapping or inadequate stapling.
	Bulged or distorted container.
Contents	Number of packages per exterior shipping container is more or less than required. Number of items per package is more or less than required. <u>1/</u>

1/ For this defect, two packages from each exterior shipping container in the sample shall be examined.

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4.4 Testing of the end item The methods of testing specified in FED-STD-601, FED-STD-311, the ASTM Test Methods Standard, and those listed in Table II shall be followed as applicable. All test reports shall contain the individual values utilized in expressing the final results. The sample unit shall be eight (8) soles of each grade of four (4) pairs of heels of each grade and class. The lot shall be unacceptable if any sample unit fails to meet any of the test requirements specified. The sample size shall be as follows:

<u>Lot size (pairs)</u>	<u>Sample size (No. of sample units)</u>
800 or less	2
801 thru 10,000	3
10,001 thru 20,000	5
20,001 thru 50,000	7
50,001 and over	12

TABLE 11 - END ITEM TESTING

Component and unit of product	Characteristic	Specification Requirement paragraph	Reference Test method	Requirement applicable to		No. of determinations per sample unit	Results reported as	Sample unit
				Sample unit	lot average			
Soles and Heels	Abrasive index: Before aging; After aging;	3.3.1	ASTM D-1530	X		3	Nearest whole number	
	Hardness: Before aging; After aging;	3.3.1	D-1530 1/ FED-STD-601 3021	X		3	Nearest whole number	
	Volume swell	3.3.1	3021 1/ 6211 2/	X		3	Percent (nearest whole number)	
	Mat'l Ident. Cut growth After aging	3.3.1 3.3.1	4/ ASTM D-1052 3/	X		2	Percent	
	Non-marking	3.3.1	4.5.1	X		1	Pass or fail	
*Soles	Stitch tear: Before aging After aging After immersion	3.3.1 3.3.1 3.3.1	FEL-STD 311 2141 6/ 2141 1/ 6/ 2141 2/ 5/ 6/ 7/	X X X		3 3 3	Nearest pound/inch	
	Tear strength	3.3.1	ASTM 6/ D-624 Die "C" ASTM 1052 8/	X		3	Nearest pound/inch	
	Cut growth After aging Full Thickness	3.3.1		X		2	percent	
	Cut growth at 0°F before aging	3.3.1	1052 9/	X		2	percent	

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TABLE 11 - END ITEM TESTING (cont'd)

Component and unit of product	Characteristic	Specification reference		Requirement applicable to		No. of determinations per sample unit	Results reported as	Sample unit
		Requirement paragraph	Test method	Sample unit	Lot average			
Plastic or composition core	Mat'l ident.	3.3.2	4/					
	Thickness	3.3.2	4/					
	Hardness:	3.3.2	ASTM D-2240	X		4	Nearest whole number	
	Before immersion							
	After immersion		D-2240 and 4.5.3	X		4	Pass or fail	
	Cracking	3.3.2	4.5.2	X		1	Pass or fail	
	Bond test	3.6.2	4.5.3	X		1	Pass or fail	
Washer	Mat'l ident.	3.3.3	4/					
	Diameter (outside)	3.3.3	4/					
<p>1/ Aging shall be accomplished in accordance with Method 7221 of FED-STD-601. The soles and heels shall be aged 24 hours at 212 ± 1.8 degrees Fahrenheit.</p> <p>2/ The immersion medium shall conform to type III of TP-S-735.</p> <p>3/ Except that test results shall be reported as percent cut growth after 50,000 cycles and readings after each 100 percent increase in cut growth shall not be reported.</p> <p>4/ A certificate of compliance shall be submitted and will be acceptable for the stated requirement.</p> <p>5/ Immersion time shall be 48 hours.</p> <p>6/ Buffing and preparation of samples shall be in accordance with ASTM D-624.</p> <p>7/ The hole for the stitch tear test shall be made prior to immersion of the test sample in the test fluid.</p> <p>8/ The stitch tear test shall be made immediately after the test specimen is removed from the test fluid.</p> <p>9/ The cut growth test shall be performed at full thickness of the sole and reported as percent of cut growth after 50,000 cycles. A reading for each 100 percent increase in cut growth is not required.</p> <p>10/ The specimens shall be clamped in the flexing machine and conditioned for one hour at 0°F then run at 0°F, and the percent cut growth shall be reported after 50,000 cycles. A reading after each 100 percent increase in cut growth is not required.</p>								

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4.5 Test methods

4.5.1 Non-marking test The corner edge of the sole or heel shall be drawn across a sheet of white paper using moderate pressure. If only a light mark is made which is easily erased by rubbing with the fingers, the heels and soles shall be classified as non-marking.

4.5.2 Cracking test The heel containing the plastic or composition core shall be conditioned as specified in Method 5111 of FED-STD-601 to an equilibrium temperature of 0°F (+ 1.8°F). The specimen shall be removed after 3 hours and 5 heeling nails shall be immediately hammered by hand into the exposed core to a depth greater than 10/32 inch. Each nail shall be spaced more than 1/2 inch apart along the rear center and sides. The core shall then be examined for evidence of cracking.

4.5.3 Bonding and hardness tests The stippled surface of the plastic or composition core shall be sanded smooth. The heel shall then be immersed in fluid type III of TT-S-735 for 24 hours at standard atmosphere as specified in FED-STD-601. The heel shall then be removed and wiped. The core and heel shall be examined for evidence of separation. The conditioned core shall be tested for hardness on its smoothened surface by Shore D Durometer in accordance with ASTM Test Method D-2240.

5. PACKAGING

5.1 Preservation-packaging Packaging shall be level A or C as specified (see 6.2).

5.1.1 Level A

5.1.1.1 Type I - Full soles Six pairs of soles of one grade and size only, with the soles of the individual pairs face to face, shall be stacked so that all edges are even and then securely tied with cotton tape or twine.

*5.1.1.2 Type II - Heels Twelve pairs of heels, of one grade, class and size only, shall be neatly arranged in a snug-fitting folding paperboard box conforming to variety 1, style III, type C, class i, group 1 of PPP-B-566 or a setup paperboard box conforming to type 1, variety 1, class A, style 4 of PPP-B-676, or a metal edged paperboard box conforming to class 1, style A of PPP-B-665. Closure of boxes shall be accomplished with a commercial grade of 2 inch wide gummed tape.

5.1.2 Level C (Commercial packaging) Soles and heels shall be packaged to afford adequate protection against physical damage during shipment from the contractor to the first receiving activity. The package and the quantity per package shall be the same as that normally used by the contractor for retail distribution.

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5.2 Packing Packing shall be level A, B, or C as specified (see 6.2).

5.2.1 Level A

*5.2.1.1 Type I - Full Soles Thirty-six pairs of soles, of one grade and size only, packaged as specified in 5.1.1.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF, class weather-resistant, variety DW, grade V15c of PPP-B-636. Level A packages shall be packed flat, three in length, one in width and two in depth, with each package reversed end to end and the length of the packages parallel to the end panels of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Each shipping container shall be closed in accordance with Method III, waterproofed with Method V, and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes of one grade only may be packed within the same container.

*5.2.1.2 Type II - Heels Seventy-two pairs of heels, of one grade, class and size only, packaged as specified in 5.1.1.2, shall be packed flat in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, class weather-resistant, variety DW, grade V15c, of PPP-B-636. Each container shall be closed in accordance with method III, waterproofed in accordance with method V and reinforced as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes of one grade only may be packed within the same container.

5.2.2 Level B

5.2.2.1 Type I - Full soles Thirty-six pairs of soles of one grade and size only, packaged as specified in 5.1.1.1, shall be packed in a snug-fitting fiberboard shipping container conforming to style RSC-L, type CF, class domestic, variety DW, grade 275 of PPP-B-636. Level A packages shall be packed flat, three in length, one in width and two in depth, with each package reversed end to end, and the length of the packages parallel to the end panels of the container. Each container shall have the contents completely covered on the top and bottom with a sheet of commercial grade kraft paper. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636. Toward the end of the contract, or when there are less than the required amount per container of the same size, mixed sizes of one grade only may be packed within the same shipping container.

5.2.2.2 Type II - Heels Seventy-two pairs of heels of one grade, class and size only, packaged as specified in 5.1.1.2, shall be packed flat in a snug-fitting fiberboard shipping container conforming to style RSC, type CF, variety DW, class domestic, grade 275 of PPP-B-636. Each shipping container shall be closed in accordance with method II as specified in the appendix of PPP-B-636. Toward the end of the contract or when there are less than the required amount per container of the same size, mixed sizes of one grade only may be packed within the same container.

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* 5.2.2.3 Weather-resistant fiberboard container When specified (see 6.2), the shipping container for the soles and heels shall be a grade V3c, W5c, or W6c fiberboard box fabricated in accordance with PPP-B-636 and closed in accordance with Method III as specified in the appendix of the box specification.

5.2.3 Level C (commercial packing) Soles and heels packaged as specified in 5.1, shall be packed in a manner to insure carrier acceptance and safe delivery at destination at the lowest transportation rate for such supplies. The quantity per shipping container shall be the same as that normally used by the contractor for retail distribution. Containers shall comply with the US Postal Service Manual, Uniform Freight Classification Rules or National Motor Freight Classification Rules, as applicable.

5.3 Marking In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.

5.3.1 Labels, mixed sizes Each shipping container packed with mixed sizes of one type and grade only, shall have securely attached to the end and side, directly under the printing or stenciling, a white paper label 5 by 4 inches with the words "MIXED SIZES" plainly stamped or printed thereon and under these words shall be legibly stamped or printed the correct quantity of pairs and sizes contained therein.

6. NOTES

6.1 Intended use The soles and heels covered by this specification are intended for use as components of work and safety footwear.

6.2 Ordering data Procurement documents should specify the following:

- a. Title, number, and date of this specification
- b. Type, grade and size required (see 1.2)
- c. Whether first article sample is required (see 3.2 and 6.3).
- d. Selection of applicable levels of packaging and packing (see 5.1 and 5.2)
- e. When weather-resistant grade fiberboard shipping containers are required for level B packing (see 5.2.2.3).

6.3 First article When a first article inspection is required, the item will be tested and should be a preproduction sample. The contracting officer should include specific instructions in acquisition documents regarding arrangements for examination, quantity, testing, and approval of the first article.

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6.4 Guide samples For access to guide samples, address the procuring office issuing the invitation for bids.

6.5 Formulation It is recommended that rubber compounds be formulated so that they are compatible with adhesive bond strength requirements of end item specifications wherever applicable.

6.6 Size 44 and 46 heels of Drawing No. 16-1-499 are intended for full welt construction of MIL-S-43860; Shoe, Safety, Men's, Electrical Hazard, High and MIL-S-43897; Shoes, Safety, Men's, Electrical Hazard, Oxford.

6.7 Changes from previous issue The margins of this specification are marked with an asterisk to indicate where changes (additions, modifications, corrections, deletions) from the previous issue were made. This was done as a convenience only and the Government assumes no liability whatsoever for any inaccuracies in these notations. Bidders and contractors are cautioned to evaluate the requirements of this document based on the entire content irrespective of the marginal notations and relationship to the last previous issue.

Custodians:

Army - GL
Navy - NU
Air Force- 11

Preparing Activity:

Navy - NU

Project No. 8335-0147

Review activities:

Army - MD
Navy - AS
Air Force - 82, 99
DLA-CT

User activities:

Navy - MC, CG, OS

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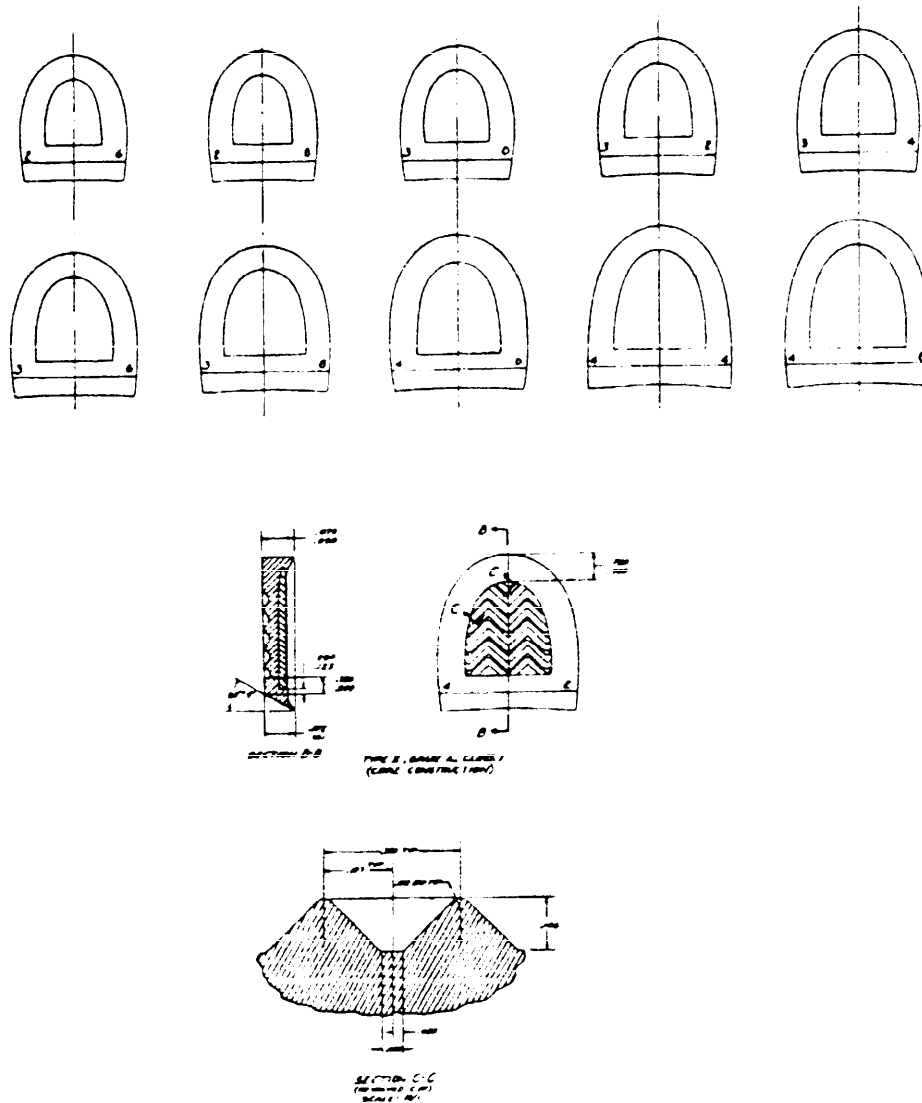


FIG. 1 - HEELS (SEE 2.1.2)

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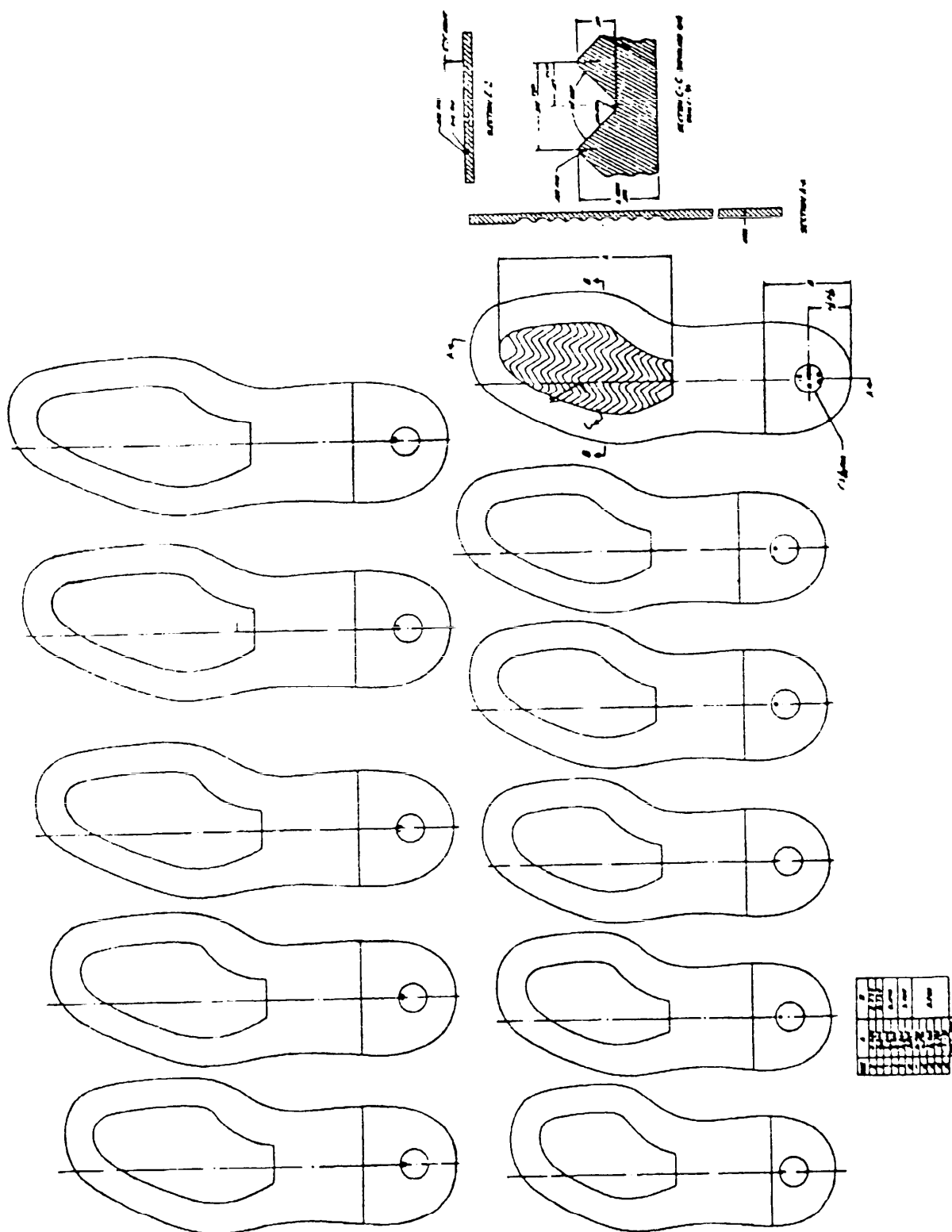


FIG. 2 - SOLES (SEE 2.1.2)

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