

Sound Horse  
“Sigafos” ***Series II*** System

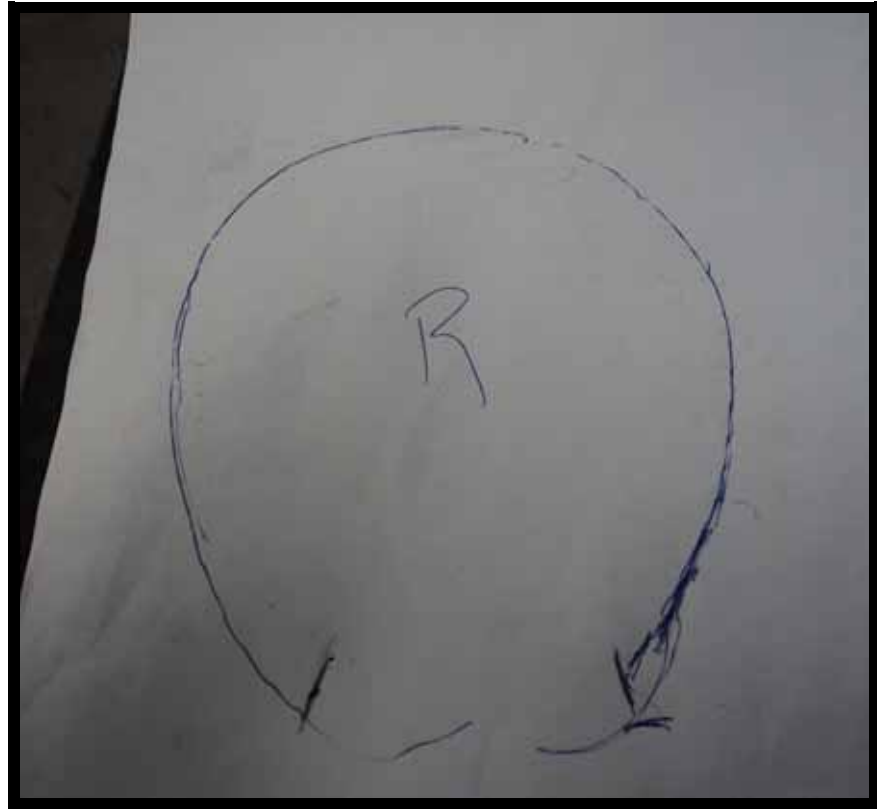
-- Assembling the Therapeutic Shoe --

Jeff Henderson C.J.F

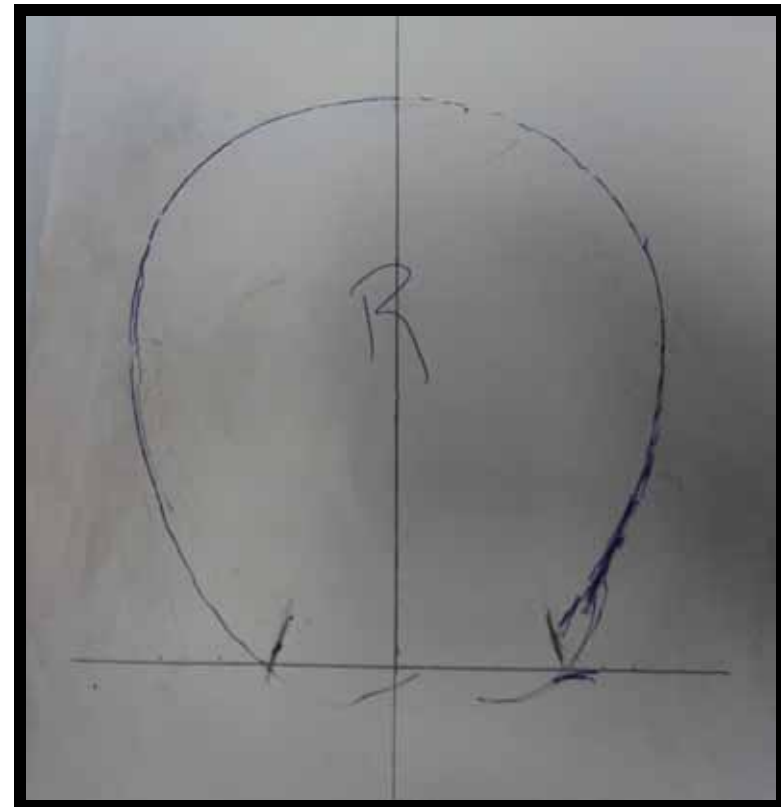
Manuel Cruz

Rood & Riddle – Lexington, KY

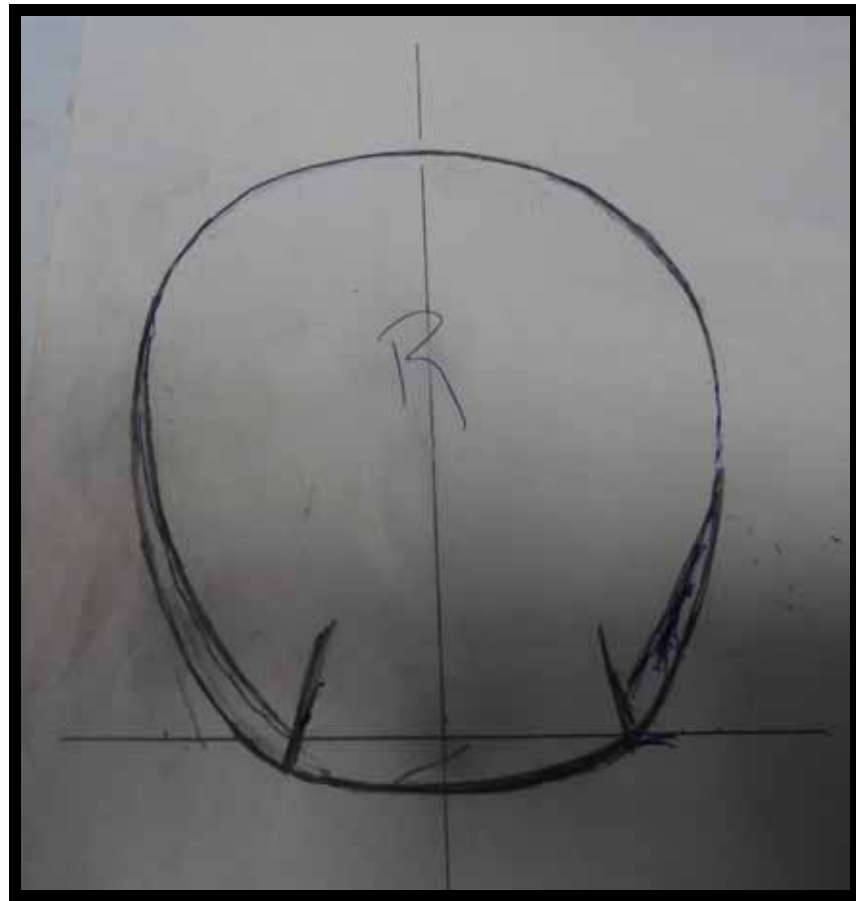
If you are using a supplied sketch, the process begins with a photocopy of the foot tracing, so you can file the original for future reference.



- Draw a lines across the photocopied tracings to help with symmetry.
- The first line should be across the end of the heels on the tracing.
- The second line should be through the center of the frog and the center of toe.



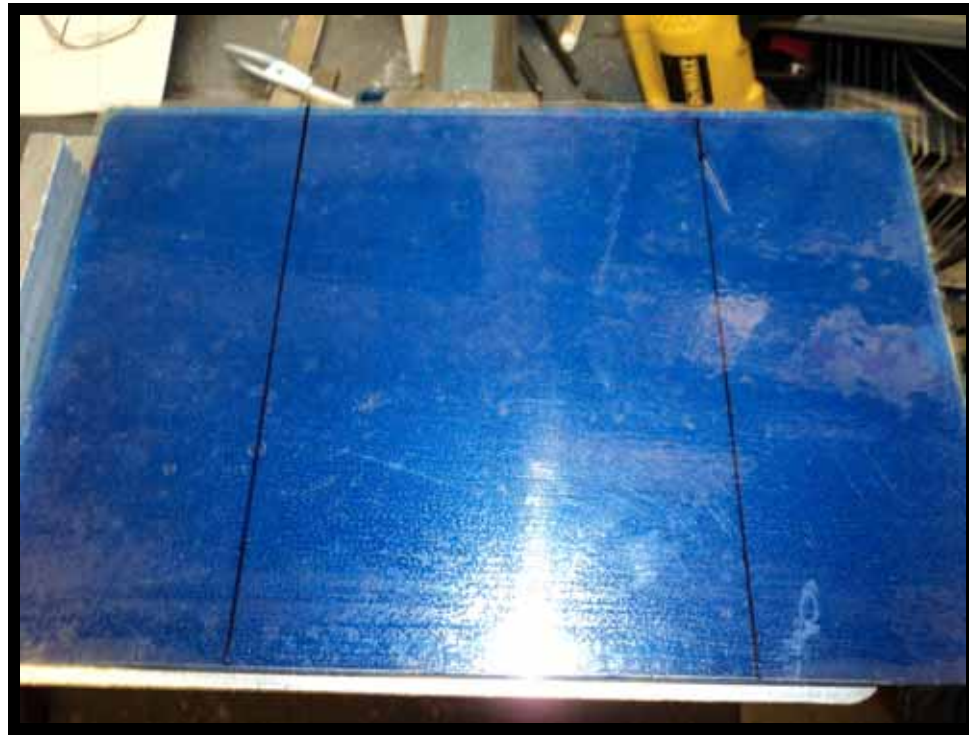
- Make the tracing symmetrical even if the foot and tracing are not.
- Extend the lines to where you want the heels to end and allow for heel expansion.



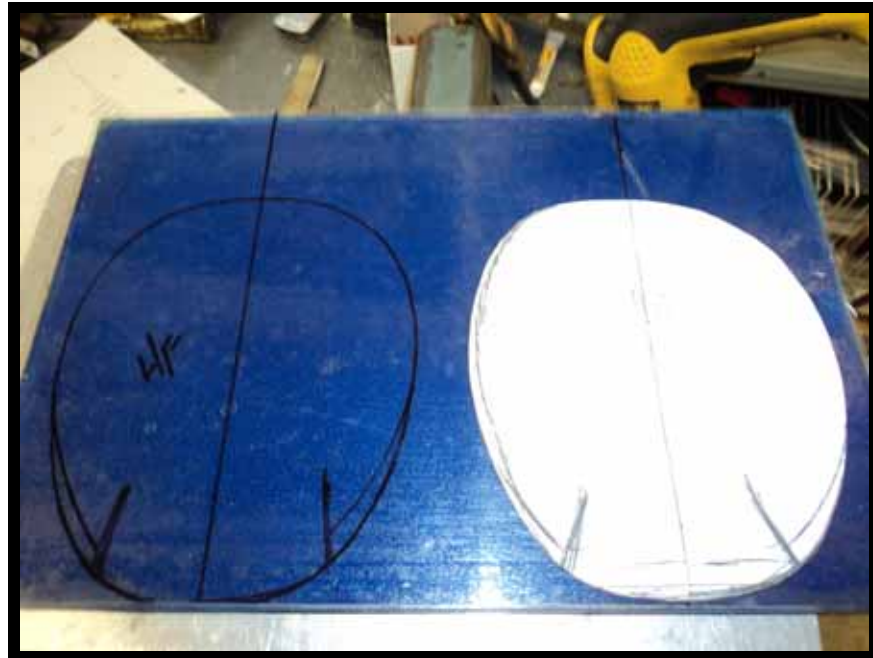


Decide whether you need a treaded flat  
or a treaded wedge plate.

- Draw a line 3-1/8 inches from the left side of plate.
- Draw a line 8-7/8 inches from the left side of plate.
- These lines will center the shoe up on the either side of plate.



- Transfer the tracing onto the plate with a marker.
- This is the last chance to fix any symmetry problems with the tracing.



- Use the bi metal jig saw blades and change them often.
- One blade is usually good for two shoes.



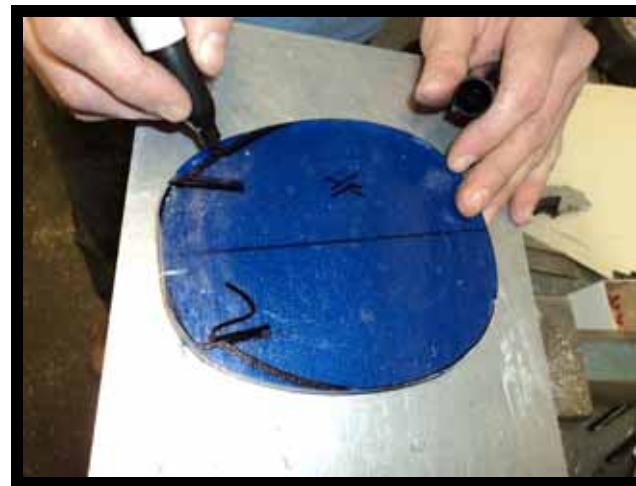
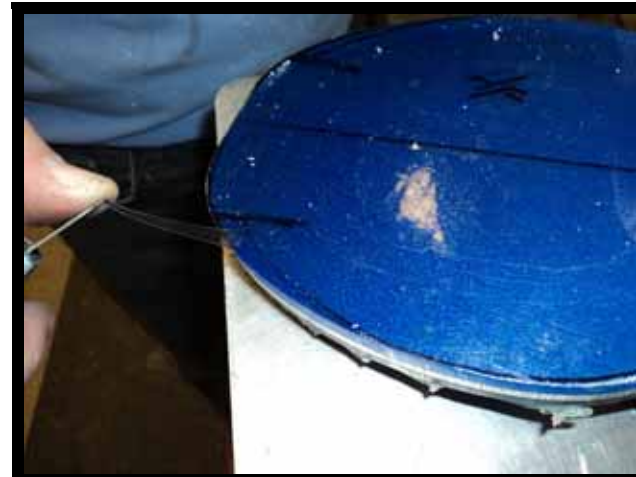
- Use the jigsaw with the plate firmly in the vise to cut out the shoe – keep the release film on the plate while you work.
- Cut on the line.
- Cutting outside the line may make the shoe too big.



- Grind or rasp the shoe to fix any imperfections from cutting process.



- Cut and remove protective film from the heel expansion area.
- Mark the heel expansion with the marker in preparation for rasping.



- Rasp along the heel expansion area at a 45 degree angle.
- The cuff will follow this line and it marks the heels.



- Mark the center of the cuff and the center of the shoe so you can easily line them up.
- Cut the cuff to length at the heels and cut notches (triangular darts) into the inside edge of cuff to help it flex into tight bends at toe.



- Remove plastic film from back of shoe and cuff before putting them in oven.
- Fabric cuff needs to be protected with piece of leather to keep it from melting in oven.



- Use a standard toaster oven to heat the cuff and shoe pieces.
- The shoe needs to be raised up a little closer to the heat source because it will require slightly more heat than the cuff.



- Cuff and shoe need to heat for roughly one minute and six seconds (1:06 min.) at 500°F oven temp or at the broil setting.
- The heating is used to soften & activate the adhesive on the bonding surfaces



- Remove both pieces from the toaster oven.
- Place heated cuff onto perimeter of the shoe starting in the center and working toward the heels.
- Press firmly as you go to assure adhesive contact.



- Place the shoe assembly between two plates in the arbor press for a couple minutes as it cools to finish bonding the cuff to the shoe.



- Mechanics can now be rasped into the shoe.
- Cut the treaded plastic bottom with a hoof knife around perimeter to save a bit of rasping.



- The break-over has now been relieved into the toe of the shoe and all around the ground surface edge.



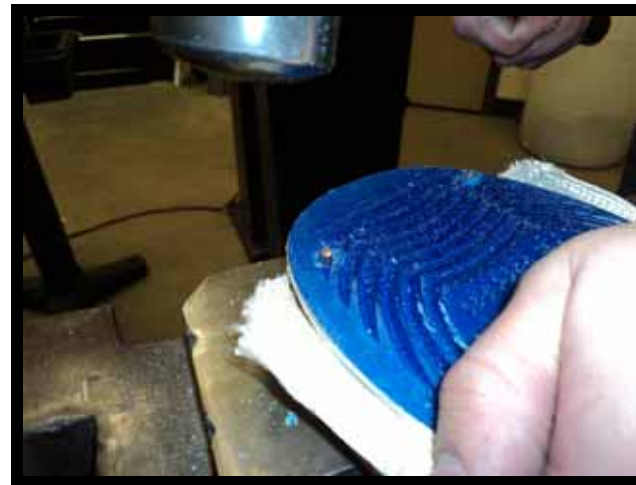
- 1 inch copper rivets are used to reinforce the cuff at toe & heel.
- 5/32 drill bit is used for the holes.
- Rivets can be purchased through Grainger.



- Drill four holes for the rivets with a 5/32 drill bit.
- Two rivets in the toe and one in each heel.
- Countersink the polyurethane tread bottom to make riveting easier.



- Install rivets from the foot surface and hammer them from the ground surface .
- Make sure the rivet heads are not sticking up from cuff as they can make a horse sore.



- Trim the cuff at an angle towards the toe to help keep the glue off of the heels.
- Use the shears from Sound Horse Tech. These shears are designed to cut the polymer fabric cuff.

