



FENICE

# FENICE NEWS!

FENICE SPA HOUSE ORGAN



IT IS BETTER TO  
TRAVEL HOPEFULLY  
THAN TO ARRIVE DISENCHANTED



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SHOES AND LEATHERGOODS



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LEATHER FINISHING

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# AUTOMOTIVE RESISTO® 78



The current qualitative standards required for Automotive leathers, both for car interior seats and steering wheels, very high and first class physical-mechanical fastnesses together with chemical resistances, such as acid or alkaline sweat, hydrocarbons and types of grease.

Amongst these, particularly complex are the resistances to oleic acid and ethanol, for achieving this it is important to carefully select the ingredients of the coatings used, and in particular the polymeric binders that make up the main component.

RESISTO® 78 represents a valid answer to this necessity and forms the ideal polyurethane binder to use in Automotive finishing in order to reach the desired fastnesses, both in terms of mechanical parameters as well as resistance to chemical agents, ethanol and oleic acid.

RESISTO® 78 is used as a formulation component during mixtures being made in tanneries, but also as a compound ingredient that Fenice prepares in supplying an all-in-one ready to use product after pigmentation.

RESISTO® 78 is a medium hard film-forming product with excellent print retention and very high general physical properties.



 NATURE

 USE

 PHYSICAL CONSTANTS

## TECHNICAL DATA RESISTO® 78

REV DATE: 05/22

Aliphatic polyurethane in water dispersion.

RESISTO® 78 is a PU binder for the finishing of leathers, principally destined to Automotive.

It forms a glossy film of medium hardness and it allows to obtain covering basecoats with high physical-mechanical performances and excellent chemical resistance.

RESISTO® 78 may be used also in topcoats formulations and it is particularly appreciated when a high grade of fastness to oleic acid and ethanol is requested.

RESISTO® 78 has polyester character but it shows good hydrolysis resistance.

	STANDARD VALUE	TEST METHOD
Appearance	_____ opalescent liquid	MDA 008
Dry content (%)	_____ 31 ± 2	MDA 010/011
pH (1:10)	_____ 8.5 ± 1	MDA 004
Density (g/cm <sup>3</sup> )	_____ 0.65 ± 0.05	MDA 018



All our information and suggestions are supplied on the basis of our present knowledge and are subject to careful tests. However, we cannot accept responsibility for the use of the product, which must be verified and evaluated for its suitability or otherwise by the customer. Declared physical constants are monitored in production and guaranteed by FENICE S.p.A.

# AUTOMOTIVE ROD 300



## INTERMEDIATE FIXATION FOR AUTOMOTIVE

To promote the operations of embossing and horseing to carry on after basecoat that have had the application, it is necessary to spray a specific product, with non-thermoplastic isolation functions that Fenice S.p.A. proposes with the name **ROD 300** that corresponds to most of the specifications currently required by Automotives.

**ROD 300** is light resistant and does not contain V.O.C. (volatile organic compounds).

The particular characteristics of **ROD 300** also consist in its resistance to (MEK) solvent when in contact as it is present in the glues used for the assemblage of steering wheels and some parts of car interior seats.

The excellent characteristics of adhesion in overspraying of **ROD 300** guarantee the ideal anchorage for the following levels of finishing which contribute to improving the physical resistances of finished leathers.



## TECHNICAL DATA ROD 300

REV DATE: 05/22



### NATURE

Aliphatic polyurethanes and dulling agents in water dispersion.



### USE

**ROD 300** is used for the intermediate fixation of upholstery and Automotive leathers.

It forms a matt film of medium hardness, with dry and slippery feel. Applied by spray before embossing, **ROD 300** promotes excellent plate release during embossing and horseing operations.

**ROD 300** guarantees the perfect adhesion of the finishing layer that is applied after dry-milling, colour-coat or topcoat as well.

**ROD 300** has aliphatic character and is resistant to hydrolisis and light.

**ROD 300** is applied by spray, diluted 1:1 with water.



### PHYSICAL CONSTANTS

	STANDARD VALUE	TEST METHOD
Appearance _____	whitish liquid	MDA 008
Dry content (%) _____	15 ± 2	MDA 010/011
pH (1:10) _____	8.0 ± 1	MDA 004
Density (g/cm3) _____	1.01 ± 0.05	MDA 018



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# AUTOMOTIVE CAR-BINDER 250

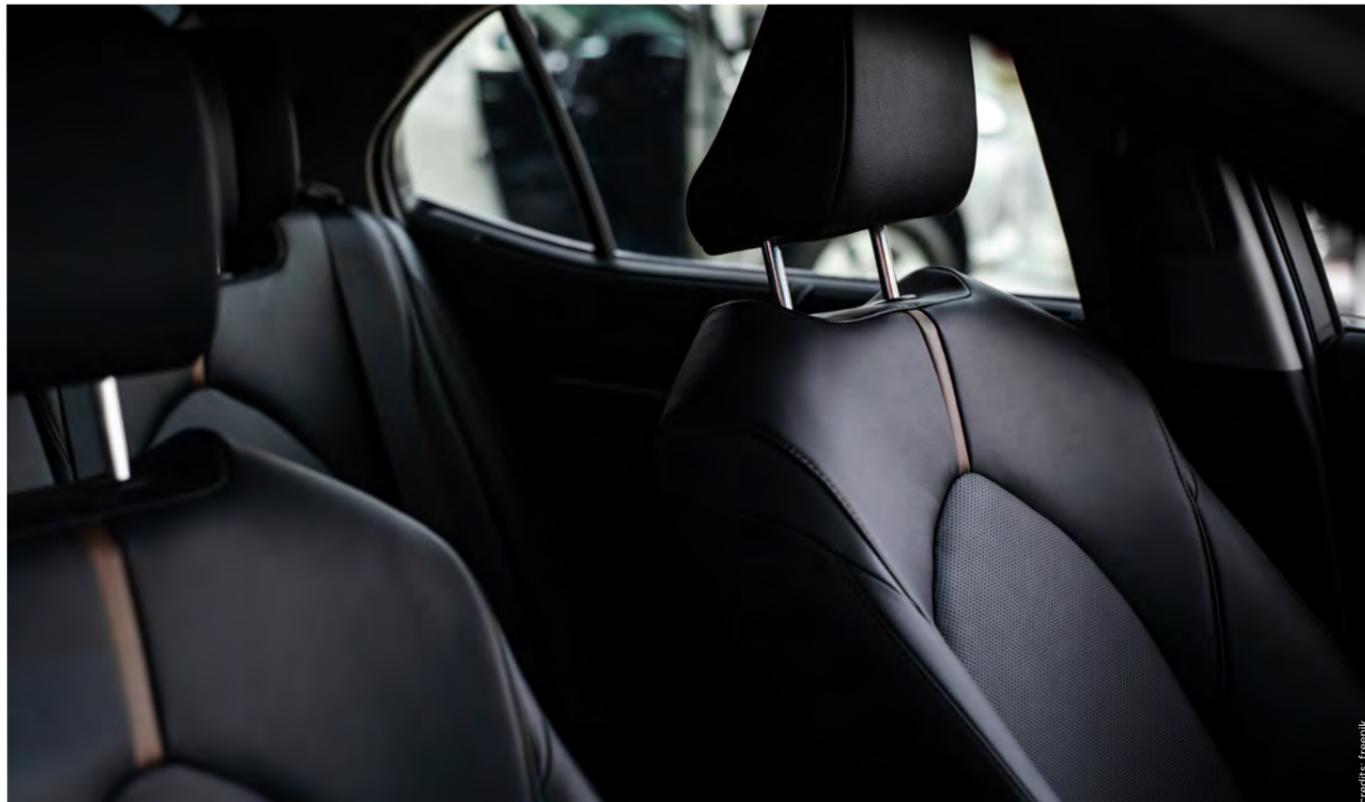
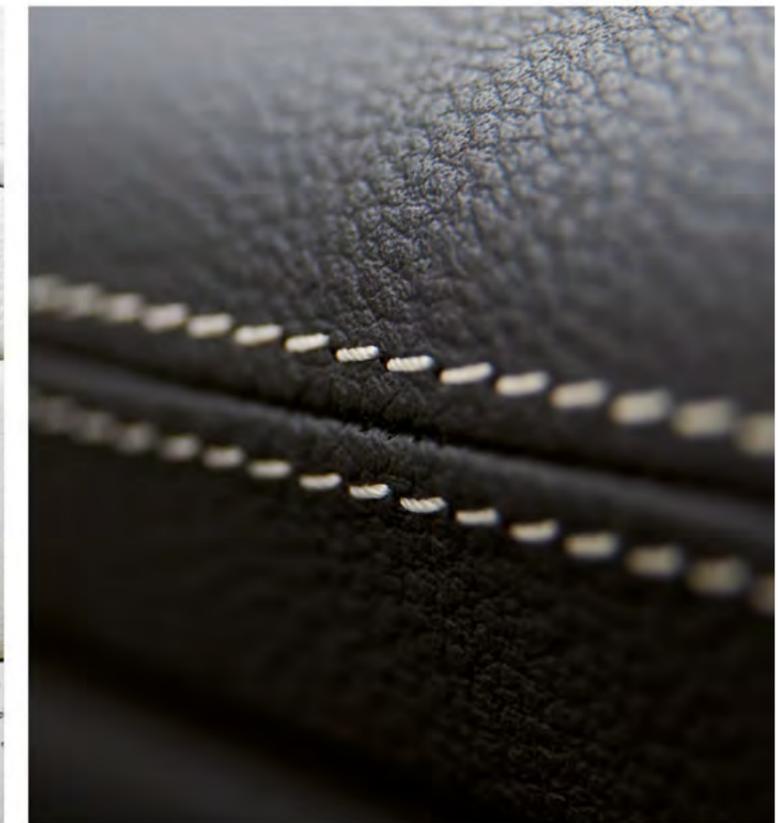
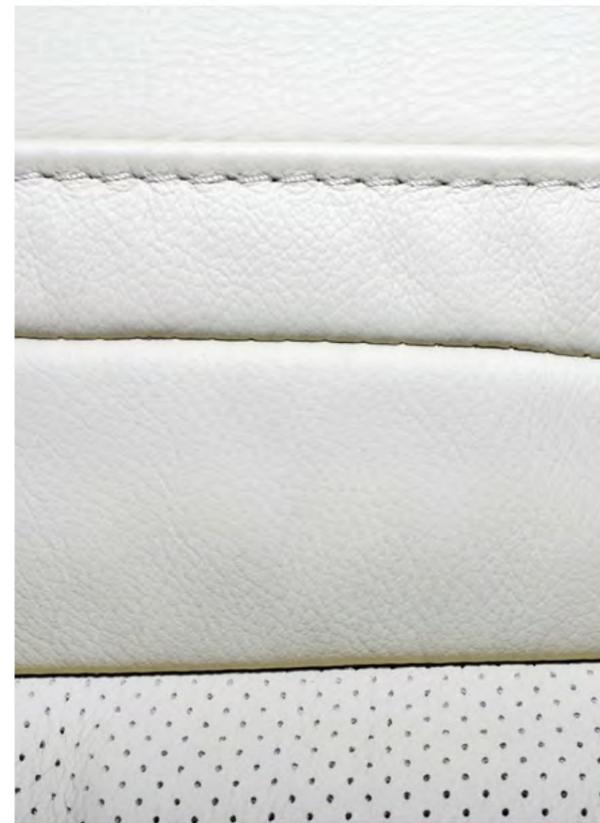


CAR-BINDER 250 is the ready-to-use compound for achieving covering basecoats for leathers destined to the Automotive sector.

The continual research of ever better performing leathers has led us to add products for automotive sector to the Fenice S.p.A. range. CAR-BINDER 250 allows one to reach the maximum level of general fastnesses and above all guaranteeing the rub resistance against ethanol and oleic acid.

For spray or rollercoater application the CAR-BINDER 250 compound is added in a ratio of 10:1 with MICRODYNE pigment pastes.

In order to guarantee the physical properties of the compound after ageing due to UV rays, the CT 33 crosslinker can be added if necessary, in a quantity of 1-2% and with the UV PROTECTOR auxiliary.



## AUTOMOTIVE CAR MAKE-UP® 60



CAR MAKE-UP® 60 is the thermo-expanding sealing prebottom for split leathers, particularly suitable for the preparation of leathers for the automotive sector.

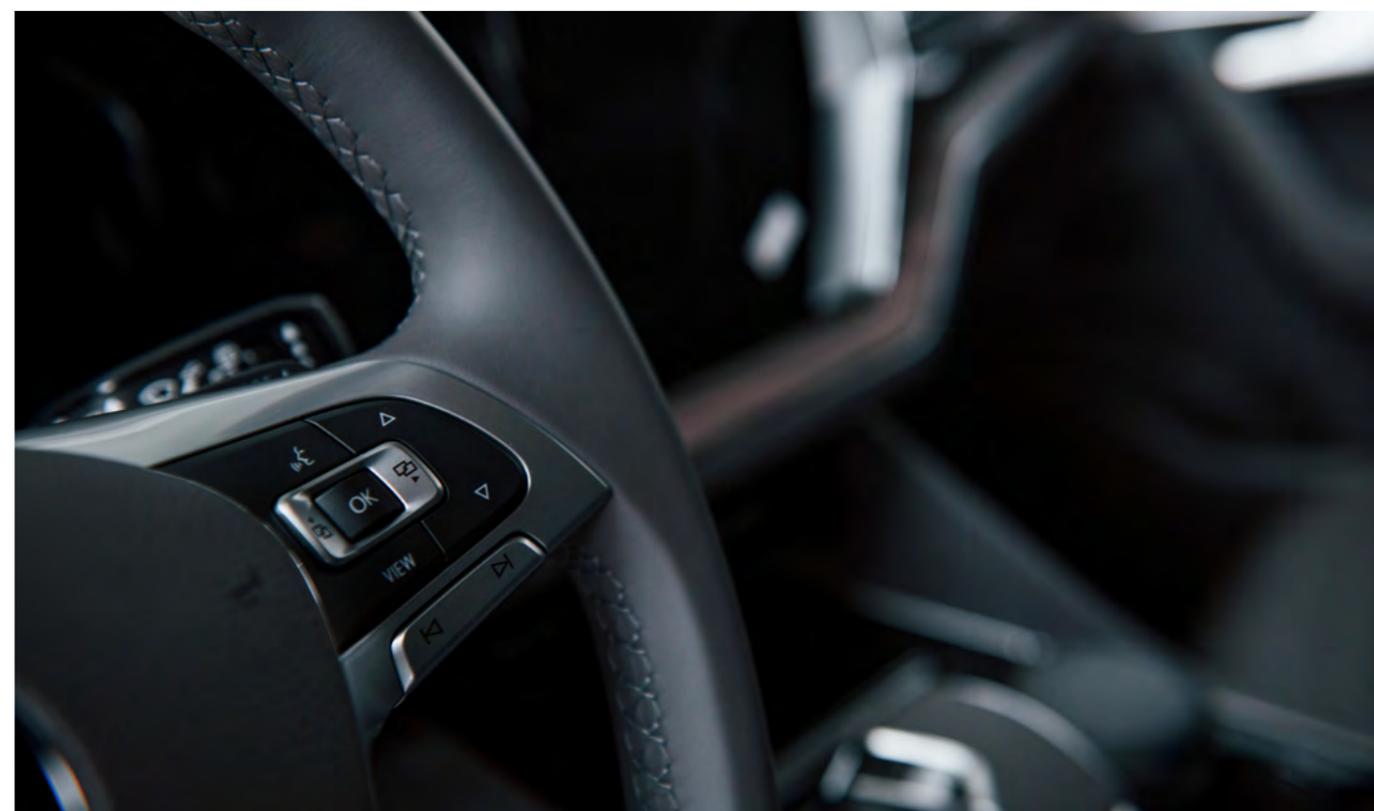
CAR MAKE-UP® 60 has a uniform sealing action on the surface, to which it confers a pleasant velvet feel after sandblast at 120°C and buffing with 400 paper.

CAR MAKE-UP® 60 is applied by rollercoater with a SS type of cylinder in the form it is supplied, possibly adding 2-4% of water if necessary, according to climatic conditions, in order to lower the viscosity and keep it stable in the machine.

CAR MAKE-UP® 60 differs from its corresponding CAR MAKE-UP® 33 for greater softness in the treated leather, due to its minor impregnating effect.

The technician's choice between the two products require a careful evaluation of the specific needs. For an optimal sealing effect of the surface together with an efficient action in just a single application, we suggest CAR MAKE-UP® 33.

To preserve the softness and greater sealing of the surface, without a heavy impregnating action we suggest CAR MAKE-UP® 60.



## UPHOLSTERY

# NU-SHINE



In view of Fenice's matured experience in production, renewal and care for leather after dry cleaning, we can benefit from these specialities in order to revive natural leathers, the so called nubuck or suede.

**NU-SHINE** confers to treated leather an intensity of the tone with the addition of a pleasant and nourished touch.

Already widely used in the manufacturing of footwear and leathersgoods, also today it finds itself as being excellent and useful in the upholstery sector, in particular as a reconditioner, reviver and final topcoat for vintage hand buffed articles, guaranteeing a very appreciated texture.



## TECHNICAL DATA

### NU-SHINE

REV DATE: 06/2021



NATURE

Softeners in hydro-alcoholic solution.



USE

**NU-SHINE** is the specialty for nubuck and suede reviving.

Spray applied to this kind of leathers, **NU-SHINE** improves the brightness and the writing power without affecting the colors.

**NU-SHINE** also imparts a natural, pleasantly silky feel to the leather.



PHYSICAL CONSTANTS

	STANDARD VALUE	TEST METHOD
Appearance	_____ colourless liquid	MDA 008
Density (g/cm <sup>3</sup> )	_____ 0.89 ± 0.05	MDA 018
Flashpoint (°C)	_____ <23	MDA 003



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## UPHOLSTERY

# CORRECTIVE FEEL MODIFIERS IN THE MILLING DRUM



An important part of finishing leather is represented by the application of the touch during the final milling of the leather.

A large part of leathers, especially those for upholstery, are worked with the objective of obtaining the best texture possible on finished leathers.

The nebulization of a diluted mixture of a feel modifier in dry milling provides the leather with a particularly full and pleasant touch. Of course, this depends on the product used and is more efficient than a final nebulization by spray. Additionally, the leathers move more freely in the drum that get tangled and where the surface is protected.

The best result obtainable with the technical application in the drum is due to the feeling of softness that can be reached in the flesh side.

The following specialities are suitable for the nebulization inside the drum by means of automatic and programmable systems.

The quantity to be used varies according to the desired effect.

- |             |   |
|-------------|---|
| ✓ OLEAL® TZ | GREASY TOUCH  |
| ✓ MT 722    | WAXY TOUCH  |
| ✓ MT 728    | WAXY TOUCH WITH ANTIFOG/CLEANSING ACTION  |
| ✓ MT 750    | SILKY TOUCH   |
| ✓ MT 75/2   | WAXY/SILKY TOUCH  |
| ✓ DC 185    | SOFTENER WITH OILY TOUCH WITH A CLEANSING FUNCTION FROM UNDESIRABLE EFFECTS OF SPEW |

Average use is 5 kg of product diluted in 10 kg of water for every 100 whole hides.



# ALIPHATIC POLYUREA CROSSLINKER

## CT 160



CT 160 is the innovative polyureic crosslinker allowing to overcome limitations in use typical of conventional polyurea thanks to its aliphatic nature and its presentation in a glycol solution.

Well used in the textile tanneries, the polyureic crosslinkers are important additives that improve the general fastnesses of a polymeric coat, in particular the wet rub resistances and enhancing the layer by layer adhesion.

Thanks to this they exalt the technical characteristics of the finishing and the reproducibility of the results.

Unfortunately, the conventional polyureic crosslinkers have an aromatic nature and are available as solid particles in water dispersion.

This affects its use in the finishing of light colours (for potential yellowing problems with light) in the waterbased topcoats, both glossy and matt, for possible "glazes" that can affect the final appearance of the finished leathers.

CT 160 however overcomes these limitations as its aliphatic nature and the perfect solubilization of the active ingredient, can be used in the finishing of any colour both for crosslinking basecoats as well as for glossy or matt topcoats.

CT 160 is also characterized by a very long shelf-life that allows (different from other crosslinkers such as isocyanate or polyaziridine ones) one to appreciate the efficiency even after a relatively long time from the moment that it is added to the finishing mixtures.

CT 160 can be added to the mixtures in its ready-made supply or prediluted in water, in a quantity that can vary generally from 3 to 6% in weight. The complete crosslinking of the polymers occurs within 36-48 hours, which can be accelerated according to the temperature.



NATURE



USE



PHYSICAL CONSTANTS

## TECHNICAL DATA

### CT 160

REV DATE: 07/2022

Aliphatic polyurea in glycol solution.

CT 160 is an aliphatic polyureic crosslinker that is used in leather finishing for the curing of basecoats and waterbased topcoats as well.

CT 160 improves wet resistances and adhesion without compromising the light fastness of the finish thanks to its aliphatic character.

CT 160 can be dosed easily and it can be added directly to the mixtures or pre-diluted in water, in quantity generally between 1 and 3% by weight.

Curing process takes about 36-48 hours and it can be faster by heating. Pot-life of the mixtures after addition of CT 160 is about 24 hours.

	STANDARD VALUE	TEST METHOD
Appearance _____	withish fluid	MDA 008
Dry content (%) _____	40 ± 2	MDA 010/011
pH (1:10) _____	9.0 ± 1	MDA 004
Density (g/cm3) _____	1.06 ± 0.05	MDA 018



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## COVERING DEFECTS AND IMPERFECTIONS

# VEIN MASKING SYSTEM:



It is very common amongst tanneries that produce full grain leather for footwear, and in particular Box Calf types, that there is the problem of veins that are not sufficiently eliminated during the wet working phases and which are very visible even on finished leathers.

Here we are speaking in particular of calf and bovine sides, generally finished not milled, with a semi-aniline or slightly pigmented appearance, often with a moderate haircell emboss, not larger.

The system that we propose to efficiently resolve the problem foresees the application of a prebottom in 2 phases: the first involves using a very penetrating mixture, the second is a mixture of a more uniforming prebottom.

The combination of the two prebottoms allows for an excellent haircell embossing by static press at 100°C - 80/100 atm - 3 seconds, that is very effective on the veins, which will be well masked resulting in a pleasant and uniform surface. After embossing, proceed with the regular coverage and finishing as normally foreseen for the article.

VEINS THAT ARE NOT SUFFICIENTLY ELIMINATED DURING THE WET WORKING PHASES AND WHICH ARE VERY VISIBLE EVEN ON FINISHED LEATHERS



## SUGGESTED FINISHING FORMULATION



Customers \_\_\_\_\_

Nature of hide FULL GRAIN CALF

Item/Use LINING

Tipo di rifinitura VEINS RECOVERY AND MASKING SYSTEM

Our Ref. L RIF E C 4601

Date 01/06/2022



### PRODUCTS (parts by weight)

<b>MIX A</b>	
DC WAX 77	600
AR 701	370
PE 115	30 - 40
<b>MIX B</b>	
AR 701	75
SEALER MB	770
WATER	115
SHELL MIX	40
<b>MIX C</b>	
ROD G2	1000



### PROCEDURES

- 1 x medium wet spray mix A approx 5-6 g/sqft
- 1 x medium spray mix B approx 2-3 g/sqft
- 1 x medium light spray mix C, to avoid plate tackiness if necessary
- Emboss static press haircell at 90°C - 100 - 3 sec

Quanto sopra corrisponde alle nostre migliori conoscenze ed esperienze, tuttavia se la presente viene rilasciata ai Sigg. Clienti si intende senza assunzioni di responsabilità, date le notevoli variabili applicative possibili. In ogni caso il nostro personale altamente specializzato è a disposizione per consentire impieghi ottimali dei nostri prodotti e sicurezza di risultati.

## PREBOTTOM FOR FULL GRAIN FP 55



FP 55 is the prebottom developed with plating for the application on full grain or even buffed leathers that require a very elegant and soft equalising of the surface, that can be dry milled, with a natural touch.

FP 55 is not to be considered as a sealing prebottom for upgrading action but rather a prebottom with an excellent preparative action for leathers for the following coverage.

FP 55 is ready-to-use or can be diluted 20-30% in water if necessary. It has non ionic character that enables it to be compatible with all finishing products.

It is applied by spray, pigmented up to 10% of its weight, creating an elegant brightness when ironed at 100 - 120°C with a fine, regular grain, waxy-silky feel appreciated for its surface uniformity.

The application of FP 55 allows to reduce the quantity of basecoat for the following coverage having the advantage also for its softness and naturalness.



## TECHNICAL DATA FP 55

REV. DATE: 02/22



NATURE

Waxes, oils and PU binders in water dispersion.



USE

FP 55 is a film-forming waxy soft prebottom that, due to its good filling capacity, is used on full grain or buffed leathers for rebuilding the grain and promoting uniform absorption.

FP 55 forms a soft and waxy film, with low tackiness, and it does not influence the leather softness.

It gives a high sealing effect of the leather surface, creating an elegant brightness when ironed at 100-110°C.

FP 55 is non-ionic and therefore it has wide compatibility with other products. It is applied by spray, normally with addition of pigments.



PHYSICAL CONSTANTS

	STANDARD VALUE	TEST METHOD
Appearance	_____withish fluid	MDA 008
Dry content (%)	_____ 16 ± 2	MDA 010/011
pH (1:10)	_____ 8.0 ± 1	MDA 004
Density (g/cm3)	_____ 1.01 ± 0.05	MDA 018



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## RIFINISHING - EVOLUTION

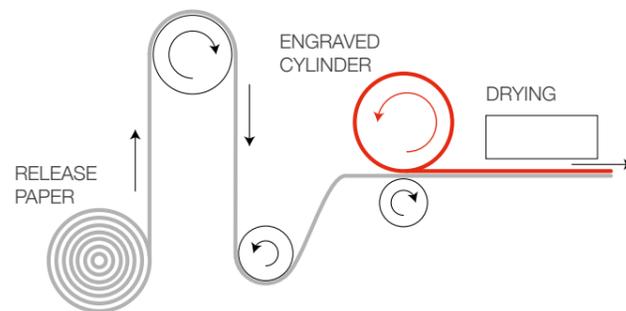
# ROD G20- ROD G25

### TRANSFER TECHNOLOGY



The method of leather finishing with transfer technology by means of coating on release paper is becoming ever more diffused especially in the footwear and leathergoods sector.

In developing products for achieving this technology Fenice S.p.A. proposes 2 new specialities: ROD G20 and ROD G25, an excellent answer in achieving the pre-skin also called releasing agent purposefully created for the latest generation machinery.



#### RELEASE PAPER

Release paper is a special embossed paper that bears the negative engraving of the print design that will be transferred to the leather during the process.

Before it is coupled with the leather it needs a kind of "preparation" that comes by using our specialities that have been purposefully created for this purpose. It is spread through an embossed cylinder and dried; according to the article and print dimension that can be treated in 1 or 2 coats (using a machine with 1 or 2 coating heads).

ROD G20 and ROD G25 display the following qualities after their application:

- ✓ TRANSPARENCY OF THE FILM GENERATED,
- ✓ EXCELLENT FLOW OUT POWER,
- ✓ WATER DROP RESISTANCE / RUB RESISTANCE,
- ✓ SUFFICIENT ADHESION FOR THE FURTHER FINISHING COATS

ROD G20 is formulated for an application of 2-4 gr./sqft on release paper, with a dry content of 10%.

ROD G25 is the more concentrated version ideal for the application with low containing cylinders of 1-2 gr./sqft on release paper, with a dry content of 20%.

This family of pre-skin allows to obtain leathers for leathergoods with excellent characteristics such as rub resistances and water drop resistance even when the process foresees a single finishing with NC emulsion without the pigmented color coat.



# FOAM TECHNOLOGY

## KEBINDER® NW



During the upgrading process of any type of leather, particularly defective, the aim is to keep the finishing as high on the surface as possible, to avoid the leather hardening, chemical wastage or performing any unnecessary processes.

The finishing is formulated to give quick, uniform coverage and upgrading, granting sufficient penetration to guarantee good adhesion, elasticity, softness and embossing power.

The experimentation done on the techniques used to achieve such results may be summarised as follows:

- ✓ Reduction and standardisation of leather absorbency
- ✓ Using finishing auxiliaries
- ✓ Foam technology

### FOAM TECHNOLOGY

The banning of the use of halogen gas in the mid 1970's for ecological reasons gave the impetus for the development of a replacement technology needed in particular by the textile industry, which used air rather than water as the diluent in the finishing system.

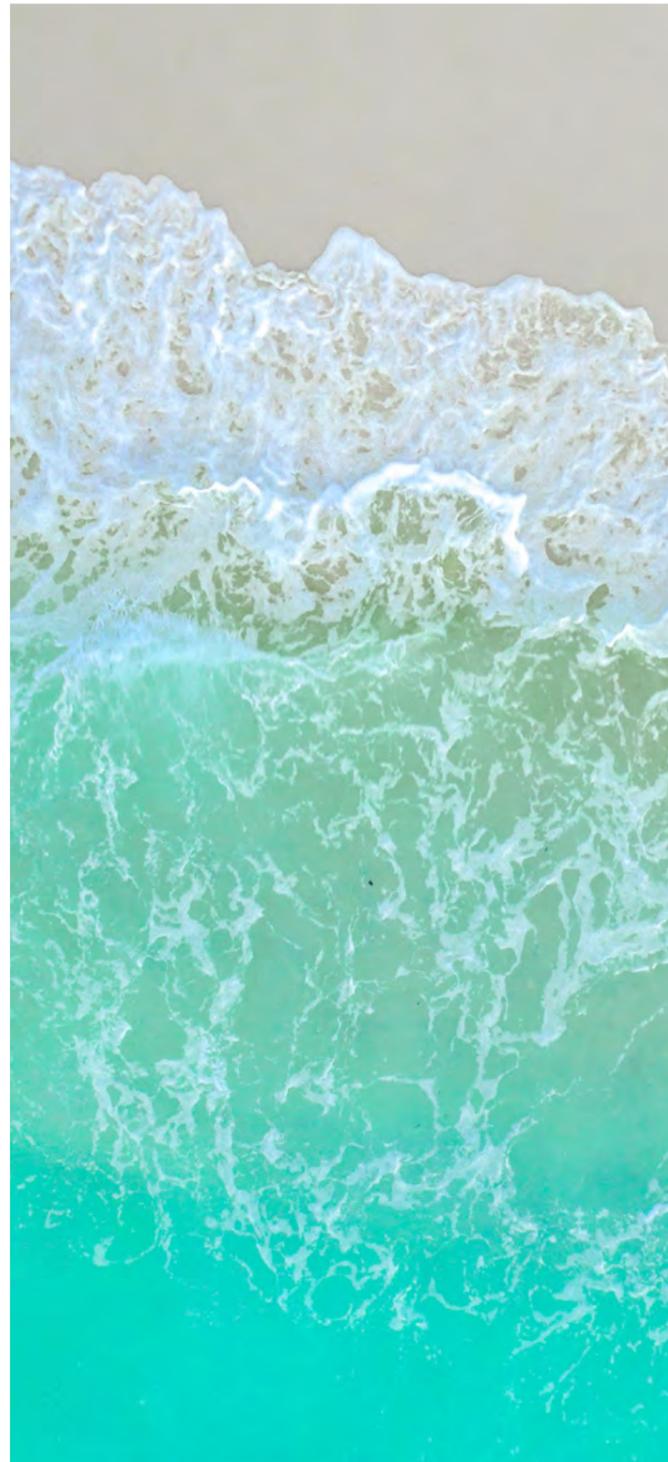
From now on, we will refer to foam application as leather finishing. Foam is defined as a dispersion of gas in a liquid. The structure of the foam we prepare is an important variable and very important in the process. Foam with large bubbles will be less compact and will collapse well.

It is produced using non-ionic surfactants with a dulling point of 40°C and traces of anionic charged ones (normally already present in resins). The air/product ratio is to be kept at around 30/70.

The general fastness values obtained are good. This type of foam generally has a low half-life. Here, half-life is defined as the time required for half the foam to return to its liquid state.

The foam should have a sufficient degree of stability to guarantee constant results in time, whilst using the same application method. An over-stable foam will collapse irregularly, causing serious problems of flowout and covering. Half-life is normally over 4 hours in this case.

When the air ratio is lower, the foam is slow to collapse and is normally produced using anionic surfactants.



A correctly prepared foam should have an optimised life span, meaning fast birth, fast collapse and uniformity during drying.

Air is the phase forming gas bubbles contained by film-forming substances and generates a dynamic system where the film surrounding the bubbles tends to drain the liquid downwards and decrease in thickness.

The liquid percolates from the various spherical surfaces and the bubbles tend to form a single compact mass.

### IDENTIFICATION OF THE ELEMENTS OF A FOAM TO BE CHECKED

Air Ratio defined as:

WEIGHT OF THE FINISHING SOLUTION

VOLUME PRODUCED BY ADDING AIR

### SPEED OF COLLAPSE

The foam must maintain its characteristics during the time required for application, including any foreseeable pauses and should not be affected by the application used on leather.

As already mentioned, it should not be too stable, as this would prevent collapses, with consequently low flexometer values. The main difference between foam systems for the leather industry compared to the textile industry, is not so much the saving in energy, even if this is important, but their capacity to produce thick films in a single application, which will dry without creating problems in conventional tunnels running at high speed.

The foam is produced in a rotary "foamer" machine which adds air to the liquid and measures and feeds the two components continually.

The foamer machine is equipped with a pump for feeding the foamer with the liquid and by a flow meter for the air dosage.

Once produced, the foam is applied by rollers or by spray. The machinery for applying the foam may be produced through simple modifications to existing machinery, but any foam applying machinery should also be capable of producing conventional finishes. Not all finishes may be applied as foams.

The general rule for all processes involving 1-2 coats, rather than the traditional 3-6, is that the greater the thickness of each coat, the more accurate and finely adjustable the control device must be to obtain acceptable uniformity.

### CONCLUSIONS

From the results of the tests performed, it may be concluded that (based on the modification of traditional finishing products), foam technology may be successfully used on buffed and impregnated leather with good results but seems less suitable for full grain and split.

In terms of operations, it can be seen that the best results are obtained in a single application, which is not too compact, but quite voluminous and made stable.

KEBINDER® NW is FENICE's foaming binder for general use.

## HOW TO ENHANCE THE QUALITY OF CRUST FILLER CRUST 10



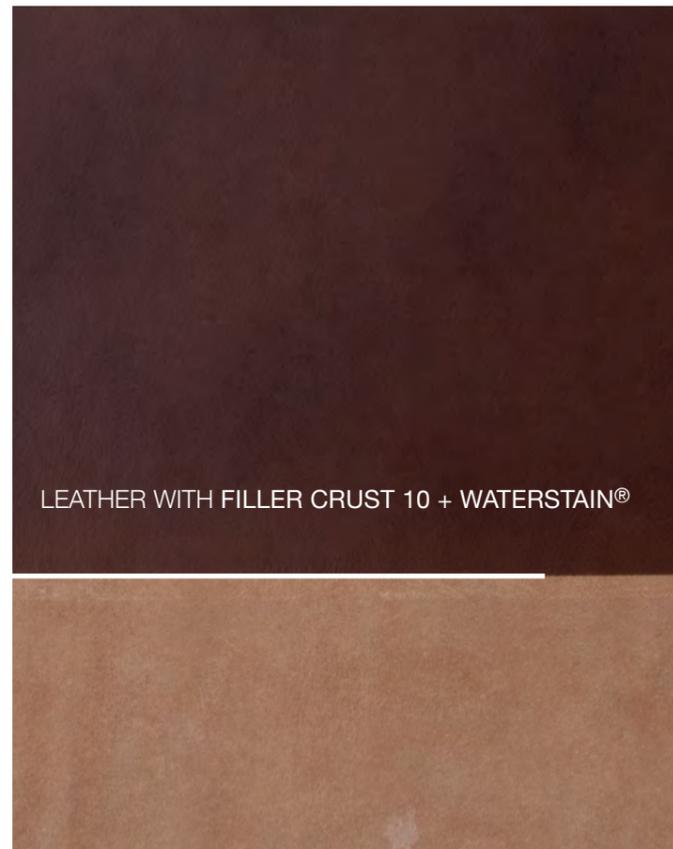
**FILLER CRUST 10** is a product that uniformizes the surface, for an excellent finishing of articles in crust, where the reduction of natural leather defects is required. It regularizes the absorption of the leather and guarantees a superior level of finish.

**FILLER CRUST 10** is sprayed directly on crust leather in one or more light coats, or diluted in water where a greater penetration is necessary.

One can use the neutral for all colours with the exception of black where we suggest using the black version of this product.

Leather treated with **FILLER CRUST 10** are perfectly ready for the following application by spray of the **WATERSTAIN®** series of fluid dyeing creams.

The quality of the finished product is highly exalted.



THE RIGHT ANSWER FOR THE CORRECT PROTECTION, MAINTENANCE AND CLEANING OF LEATHER FOOTWEAR AND TECHNICAL FABRICS.

## THE WINNING TRIO



**STAIN AWAY:** Cleaner based on selected solvents that allow for a very efficient cleaning of footwear in nubuck and suede without altering the colours, writing effect and softness. Excellent also for finished leathers.

**STAIN AWAY** is suggested as a stain remover for dirt and glues during working operations and refill pen marks.

For general cleaning of nubuck and suede footwear, it is suggested to spray a medium quantity on the suede leather and rub immediately with a cotton or microfibre cloth glove, preferably white.

For finished and delicate leathers, it is better to apply the product on a cloth in a good quantity and rub delicately on the areas to be cleaned. Repeat the operation where the dirt is persistent.

Stains or residues of glue become softened when spraying a good quantity of product; then proceed to rubbing the part to be cleaned with a rubber piece (para) or leather to remove the glue while it is reactivated.

We suggest a following treatment with our **RAINSTOP** speciality that protects from water and dirt.



**RAINSTOP:** is the excellent fluorine-free waterproofer for nubuck, suede and finished leathers. It is also very efficient on leather footwear and technical textile footwear. **RAINSTOP** confers an excellent waterproofing resistance to water and dirty substances without altering the touch. It revives the colours.

Spray the product in a uniform way in an open and well ventilated environment: leave to dry well naturally for at least 30 minutes before use. Reapply the product periodically according to its use and renew the waterproofing effect.



**EASY SHINE:** is used as a glossy finish and reviver for finished leather footwear. It gives back a pleasant natural shine to used leather articles.

For application spray one or two light and uniform coats from a distance of about 30 cm and let dry well. **EASY SHINE** does not require any brushing.

Do not use this product on nubuck, suede or white leathers. For these kinds of leathers we suggest our **STAIN AWAY** speciality.

## A FOCUS DEDICATED TO THE TOP RANGE OF FOOTWEAR CREAMS

# VICTORIA CREMES® FENICE STYLE



### TOUCH AND SOFTNESS VAL

The very fine emulsions of the waxes used in the VAL series confer to footwear a pleasantly soft and silky touch.

Its special formulation guarantees a easy, secure, fast application suitable for ironing.

The application of VAL by sponge in one or two coats, after brushing, grants leather with a natural gloss that exalts its attractiveness.



### ESTREMELY GLOSSY AND TRANSPARENT DC 4000/WT

The new proposals of the DC 4000/WT series of creams are characterised by an extremely glossy shine, excellent with a natural transparency.

They are applied by sponge and have an excellent flow out. We suggest the use as a second coat, after the application VAL series of soft creams.

The final polishing by woollen brush and DC 3700 carnauba wax increases the brightness keeping the appearance of high quality.



### FLUID AND GLOSSY DC 4000/LP

The fluid structure of the DC 4000/LP series of fluid creams allows for a practical and fast spray application, as well as an excellent sealing of the surface of leather footwear.

They are fluid and brushable creams obtained by the emulsion of prestigious natural and synthetic wax emulsions.

The application of DC 4000/LP on leather boots is very common and much appreciated.

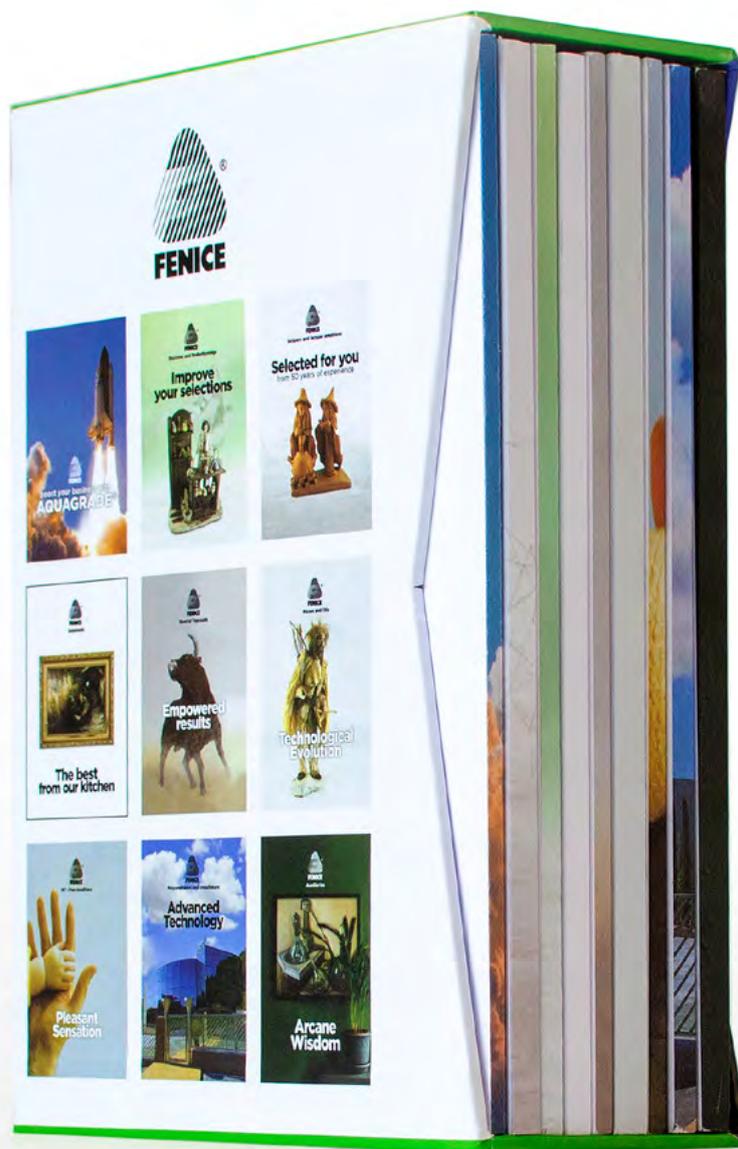
All of the DC 4000/LP series of fluid creams are granted with good repolishability, excellent brightness and natural transparency.





**Play your  
winning ball!**

# THE CATALOGUE



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