PUSH LOCK FORMER INSTRUCTIONS

Aluminum Push Lock Fabrication Former
Part #: LOC-ALUM-FRMR

Fabrication

Mold Preparation

1. Align the M10 set screw with center line of the model.
2. Set the hex socket within the plaster mold.
3. Set the M10 set screw to protrude about 1" (2.5 cm) above the end of the model to allow enough room to attach the fabrication former.
4. Screw the former over the exposed set screw.
5. Blend the distal end of the model to the inner flair of the fabrication former with plaster.
6. Vacuum holes may be required, especially near former. If model is wet, use a casting balloon.

Thermoforming or Lamination

Thermoforming

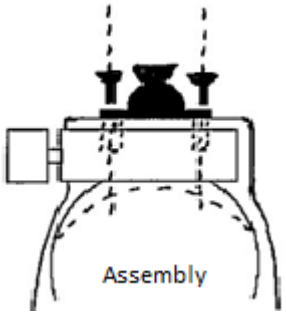
Apply standard drape or blister forming techniques to make check or definitive socket. Special care should be taken around the area of the push button dummy (bolt) to prevent wrinkles, especially when blister forming. Be sure that the 4 M6 set screws protrude above the distal end of the former about ¼" prior to vacuum forming.

Lamination

Apply inner PVA bag and tie off around protruding M10 set screw. Add a wax coating to the former and to the set screws to protect them from resin contact. Vaseline inner former cup and screw gently into place to avoid cutting PVA bag. Be sure the 4 M6 set screws protrude above the distal end of the former about ¼". Lace 1" carbon fiber tape over the fabrication former, extending up several inches and fanning out over the distal section of socket. Add appropriate stockinette and strengthening fabrics appropriate for weight and activity level of the patient. Pour resin into the outer PVA sleeve, thoroughly saturating materials around the fabrication former.

Assembly

Sand the distal surface of the socket smooth and flat to expose the distal set screws. Use 6.5 mm drill for attachment holes and a 10mm drill for push button hole. When using locks without a removable push button, it may be necessary to grind hole larger in order to insert lock. Align the 4-hole patterns of the lock, socket, and distal adapter. **Secure with M6x25 screws by applying 11 ft lbs or 15 Nm of torque to each screw.** Over torqueing may result in poor function. Always Loctite and assure the attachment screws are long enough to fully engage the threads in the lock. While the M6x1x25mm Flat Head screws included will work with many common 4-hole attachment devices, the required screw length will depend upon the thickness of the socket and the distal attachment component.
Never modify the lock housing or the locking mechanism.



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