



LMV009

Alps Suction Valve

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Fabrication Instructions for Alps Suction Valve

Prepare and seal cast to be fabricated. This can be done in a couple of ways:

- A good coat of lacquer or shellac can be applied by brush or spray
- A large casting balloon can be applied

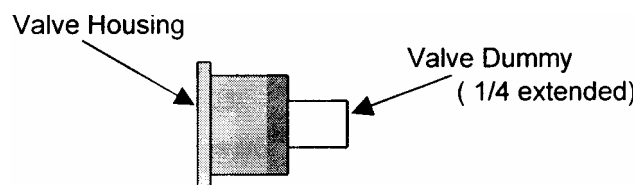
Either method works well.

Once the cast is dry and ready, a decision must be made on whether the prosthesis is to be fabricated in a "One Stage" or Two Stage" method.

One stage method:

Place the cast in a lamination fixture. Take the socket adapter and approximate the placement and alignment. This is done prior to the PVA separator. Once the adapter is in place, trace around it with an indelible pencil, and then seal the cast. This will assure proper placement in later steps.

Next, the flat sheet or cap and bag are applied. Take the valve housing and insert the valve dummy into it. The valve dummy should be flush at the flange side and should extend approximately 1/4" past the valve housing. Cutting the Delrin dummy may be necessary.



Next, determine where the placement of the valve will be. The placement is totally up to your discretion. The only consideration that must be made is that the prong of the socket adapter must not interfere with the valve housing. You will find the valve housing fits rather nicely between the prongs.

Next, flat sheet or cap and bag cast.

This next step is one of the most important. Extra attention needs to take place.

Place the socket adapter on the end of the cast paying attention to the marks on the end of the cast. Use 3M 77 spray adhesive to attach valve seat to cast. Next, either a dacron bag or nyglass is placed over the cast, making sure the placement of the valve seat does not change. Tie off around the base of the valve seat. This will prevent any movement as lay-up progresses.

Once the valve seat is secured lay-up as usual and laminate.

After lamination has cured, sand down lamination over valve dummy. Break out cast, insert valve into valve

Two Stage Method:

All instructions for the One Stage, except, do not draw around socket adapter. After lamination has cured do not break it out. Alignment is made at this time. After alignment has been made, finish laminate, sand down to valve dummy, and break out push valve into valve seat.



900052 Rev B, CAN#1208
LMV009

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CEpartner4U

3951db: 13. NL

tel: +31 (0)6.516.536.26

Alps South Corporation
2895 42nd Avenue North
St. Petersburg, FL. 33714
USA

Tel: 1-727-528-8566

Fax: 1-727-528-8862

Info@easyliner.com

www.easyliner.com