

LimbLogic® 4-Hole Adapter instructions

Fabricating an airtight socket is critical to the proper operation of the system.

WHAT'S IN THE BOX

- 1 LimbLogic 4-Hole Adapter
- 4 M6 X 55 mm Flat head Capscrews
- 1 Forming Plate with 4 M6 X 10 mm Capscrews
- 1 Poron Filter
- 1 Proximal Sealing Gasket
- Instructions

ADDITIONAL MATERIALS REQUIRED

- LimbLogic Vacuum Pump
- FabTech 60 Adhesive
- PETG
- Standard lab supplies

FOR A DIAGNOSTIC SOCKET

Fabricate a check socket.



Lightly sand the socket. Wrap with casting tape.



Tape off the hole in the 4-Hole Adapter. Tape off any holes in the socket.



Drill a 9/32" hole in the socket.



Lightly sand the distal surface of the socket. Apply Fabtech 60 Adhesive to the inner surface of the 4-Hole Adapter.



Push the filter into the hole. Cut it flush with the the socket.



Apply the 4-Hole Adapter to the socket.  
Orient correctly.



Install the LimbLogic Vacuum Pump with the Proximal Gasket between the pump and 4-Hole Adapter and with the on/off button oriented correctly. To prevent the pump from becoming clogged with debris, make sure the Fabtech 60 Adhesive is fully cured before activating the pump.



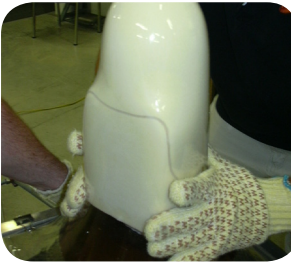
FOR A LAMINATED SOCKET

Pull a thin sheet of PETG over the model.

Tip: leave a gap between the model and the forming table so that wrinkles can be pulled underneath the model.



Rough up the surface of the PETG. Clean with rubbing alcohol (do NOT use acetone).  
Do a thin lamination over the PETG.



Tape off the entire surface of the 4-Hole Adapter to protect from resin.

Note: the slots on the 4-Hole Adapter are for the lamination to pass through to help prevent rotation.



Lightly sand the surface of the socket.  
Attach the 4-Hole Adapter to the socket using Fabtech 60 Adhesive. Orient correctly.



Apply the carbon tape around the 4-Hole Adapter.



Attach the Forming Plate with lubricated M6 capscrews.

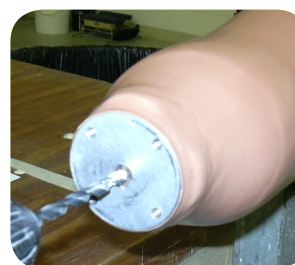


Apply the layup. Tie off in the space between the forming plate and 4-hole Adapter. Pull the rest of the layup down. Laminate.



Remove capscrews and Forming Plate.

Remove the model. Trim as desired.  
Drill a 9/32" diameter hole in the socket.



Push the filter into the hole. Cut it flush with the socket.



Using the four M6 x 55 screws provided, install the LimbLogic Vacuum Pump with the Proximal Gasket between the pump and the 4-Hole Adapter and with the on/off button oriented correctly.

If using the socket in a definitive prosthesis, apply Loctite 242 Removable Threadlocker (or equivalent) to the screws, and torque the screws to 9 ft-lbs (12 Nm).

