

# 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 50 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

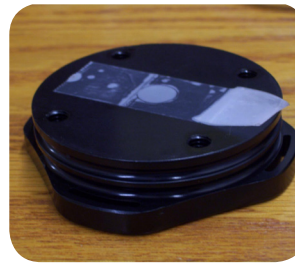
Fabricate a check socket.



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 socket.



Apply the 4-Hole Adapter to the socket.



Press the Proximal Gasket into the Vacuum Pump inlet.



*Note: you should be able to turn the pump upside down without the gasket falling off. If the gasket falls off, it was not properly seated into the recess.*

Attach the Vacuum Pump to the socket 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.*



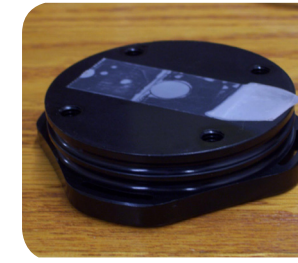
Rough up the surface of the PETG. Clean with rubbing alcohol (do NOT use acetone).

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.

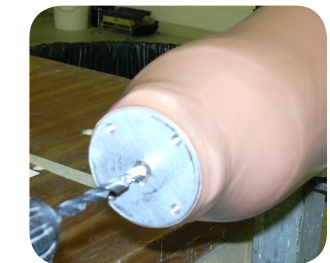


Apply the layup. Tie off in the space between the forming plate and 4-hole Adapter. Pull the rest of the layup down. Laminate.



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.



Press the Proximal Gasket into the Vacuum Pump inlet. Using the four M6 x 50 screws provided, attach the Vacuum Pump to the socket 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).



*Note: you should be able to turn the pump upside down without the gasket falling off. If the gasket falls off, it was not properly seated into the recess.*

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**DO NOT USE ACETONE ON THE SOCKET OR ON THE EXTERIOR OF THE VACUUM PUMP.**