

Mini G-Lock Fabrication Instructions

**Please read thoroughly before fabricating
a socket using the Mini G-Lock.**

Warranty

The warranty for the Mini G-Lock is one year (allowing three weeks from the date of purchase for installation). Use of the Mini G-Lock for amputees whose modified body weight is more than 132 lbs (60 kg) or who engage in extremely high and abusive activity is against Ohio Willow Wood's recommendations and will void the one-year warranty. Modified body weight is defined as the weight of the amputee plus any loads carried normally or routinely by the amputee. "Extremely high and abusive activities" are defined as activities such as skydiving, karate, and judo; activities that could result in injury to an individual's natural limb; and activities that expose the prosthesis to corrosives such as salt water.

Warranty Disclaimer

Ohio Willow Wood warrants that each product manufactured will, at the time of delivery, be of workmanlike quality and substantially free of defects. **OHIO WILLOW WOOD MAKES NO OTHER WARRANTY, IMPLIED, OR EXPRESSED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** This warranty shall terminate immediately upon an action to combine our products with other materials or in any manner to change the nature of our products. The sole remedy is replacement of the products or credit for the products. Ohio Willow Wood's liability shall not exceed the purchase price of the product. Ohio Willow Wood shall not be liable for any indirect, incidental, or consequential damage.

Ohio Willow Wood Retention of Rights

Ohio Willow Wood retains all intellectual property rights reflected or incorporated in its physical products, regardless of the transfer of the physical products to another party or parties.



OHIO WILLOW WOOD®

free the body...free the spirit®

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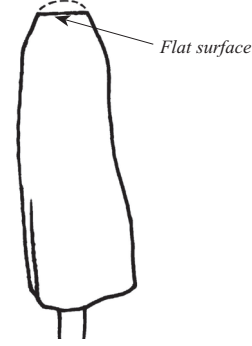


Items included with the Mini G-Lock:

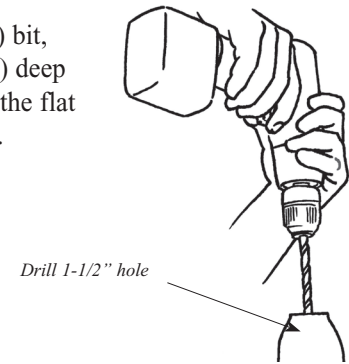
- 1 Mini G-Lock Body
- 1 Mini G-Lock Pin, 1/4"-20 x 38mm
- 1 Fabrication Body
- 1 Attachment Plate
- 1 Fabrication Tooling Bolt

Fabrication Instructions

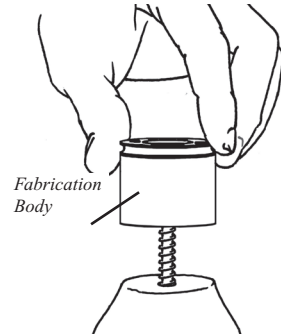
1. Begin by removing 1/2" (15mm) of length from the distal end of the model to ensure a flat surface for the fabrication tooling. The flat surface should be perpendicular to the long axis of the cast in both planes.



2. Using a 3/16" (5mm) bit, drill a 1-1/2" (40mm) deep hole in the center of the flat surface of the model.

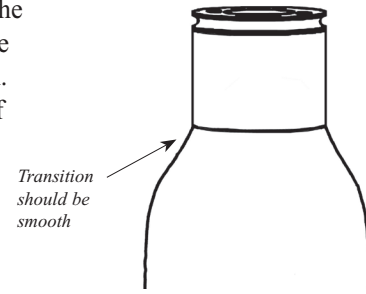


3. Remove the Button Housing from the Fabrication Body.
4. Thread the Fabrication Body and the attached bolt into the hole drilled in the previous step. Position the Fabrication Body so that it is flush with the distal surface of model. Make sure the Fabrication Body is in the desired rotational alignment with regard to the placement of the Button Housing Recess.

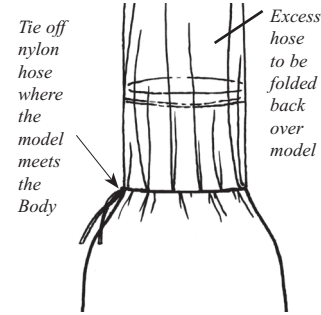


5. Slide the Attachment Plate on to the Fabrication Body so that the dowel pin in the Fabrication Body engages the hole in the Attachment Plate.

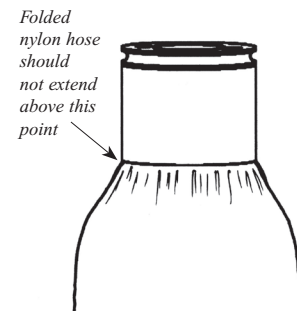
6. The transition between the Fabrication Body and the model should be smooth. Blend with sandscreen if necessary.



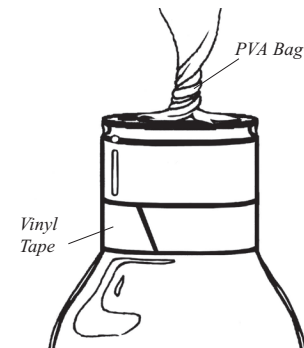
7. Pull a nylon hose that is twice as long as the model over the Fabrication Body and the model. Tie off the nylon hose where the model meets the Fabrication Body, then fold the rest of the hose back onto the model.



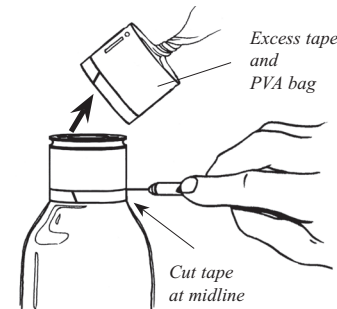
Note: Do not allow the nylon hose to extend above the tie-off point on the Fabrication Body. Air leaks may occur in the finished socket if the nylon hose extends past the tie-off point.



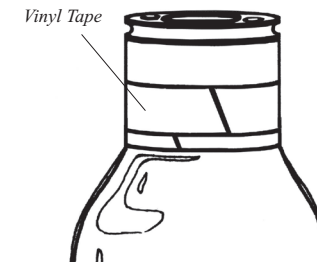
8. Pull a PVA bag over the Fabrication Body and the model. Tightly wrap one lap of vinyl tape over the PVA bag and around the circumference of the Fabrication Body.



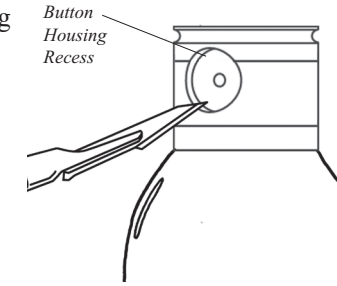
9. Cut through the tape and the PVA bag along the midline of the tape. Remove the excess.



10. Wrap one layer of vinyl tape over the remaining half-width of tape to completely seal the cast from resin leakage.



11. Trim any tape and PVA bag from the Button Housing Recess.

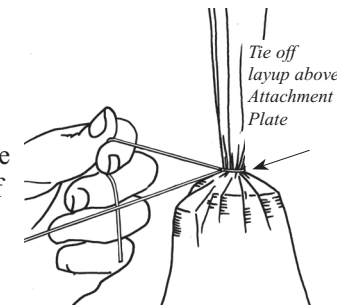


12. Make sure that the rotational alignment is still correct, then insert the Button Housing into the Button Housing Recess.

13. Lubricate the M4 x 20 Button Housing Bolt. Install the Button Housing onto the Fabrication Body using the lubricated bolt, then fill the bolt head with putty.

14. Apply the desired socket lay-up over the cast and tooling.

Tie off the lay-up above the Attachment Plate on top of the Fabrication Body.



15. Proceed with the lamination, using standard procedures. Ensure adequate resin penetration of the lay-up.

16. After the socket has cured sufficiently, remove the outer PVA bag and rough up the lamination surface using sandpaper.

17. Attach the endoskeletal or exoskeletal connecting method of choice to the socket. Laminate according to the instructions provided by the manufacturer of the adapter.

18. After the socket has cured, remove the outer PVA bag, then unscrew the Button Housing Bolt a few turns. Use the Button Housing Bolt to remove the Button Shield Tooling.

19. Remove the model and Fabrication Body from the socket in the usual manner.

20. Cut and finish the socket trim lines as needed to achieve a comfortable fit.

21. Clean the interior of socket thoroughly.
22. Remove the Button Assembly from the Mini G-Lock.
23. Insert the Mini G-Lock into the socket, lining up the Button Stem Hole with the hole in the socket. Using a 4mm ball driver, tighten the two M5 x 10 Stainless Steel Attachment Plate Bolts into the Attachment Plate.

Note: the Stainless Steel Attachment Plate Bolts are already installed in the Mini G-Lock.

24. Reinstall the Button Assembly back into the Mini G-Lock, applying a drop of Loctite 242 Removable Threadlocker (or equivalent) to the threads on the end that attaches to the Mini G-Lock. Tighten until snug using a flathead screwdriver.

25. Apply Loctite 242 Removable Threadlocker (or equivalent) to threads of the gold-colored pin that is supplied with the Mini G-Lock, and tighten the pin into the Alpha[®] Locking Liner until the base of the pin meets the umbrella.

Note: the silver-colored pins that are supplied with the Alpha Lock and the Alpha Lamination Lock are not compatible with the Mini G-Lock.

26. Have the patient don the Alpha[®] Locking Liner and the prosthesis.

27. To ensure that the pin is secured in place at the closest groove, turn the Button Retention Device clockwise until it contacts the lock body. To remove the prosthesis, turn the Button Retention Device counterclockwise until the button can be pushed in.

