

# FABRICATION INSTRUCTIONS

## ENDOSKELETAL COMPONENT **3- AND 4-PRONG ANCHORS**



### PACKAGE CONTENTS

3- or 4-Prong Lamination Anchor  
Rotatable Threaded Adapter or Receiver  
Lamination Plug  
M6x25 SHCS  
Flat Washer



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# LAMINATION



1. Use contouring bars to bend the anchor arms into position.  
*Caution: Do not overbend the arms.*
2. Place lamination anchor at distal end of socket and set into correct alignment position.
3. Score the surface of the arms for better adhesion

## SINGLE STAGE LAMINATION:

- Apply inner PVA bag over model.
- Add double layer of perlon stockinet, with distal carbon or nyglass reinforcement.
- Tie unidirectional carbon strips or tape through the prong holes. Secure in AP/ML position.

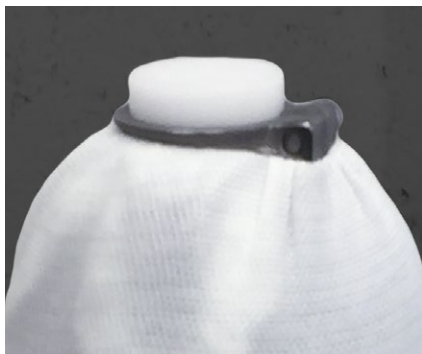


## TWO STAGE LAMINATION:

- All surfaces must be roughened prior to applying the second lamination.
- Transfer alignment and fix the lamination anchor to the inner socket layer with bonding agent (i.e. resin mixture, putty, adhesive, etc).



4. Apply mold release to threads of lamination plug and tighten into anchor.  
*Caution: To prevent pinching, do not laminate anchor without lamination plug installed.*
5. If necessary, apply nyglass or carbon layers under anchor arms for reinforcement.



6. Add double layer of perlon stockinet.
7. Apply resin deterrent to anchor threads, slot, washer, and cap screw.  
*Caution: Do not squeeze anchor.*



8. Proceed with layup materials appropriate for the individual.
9. Apply outer PVA bag and laminate socket. Ensure that resin saturates all layup material.
10. Once cured, remove excess resin and PVA bag. Then remove lamination plug.

## THREADED ADAPTER/RECEIVER ASSEMBLY

1. Screw threaded adapter or threaded receiver completely into anchor.  
*Caution: Rotation should not exceed ¼ turn counterclockwise.*
2. Apply Loctite 242 to clamp screw threads and torque to 10 N-m.



### **WARNING**

- Do not expose this product to corrosive materials, salt water or pH extremes.

## TECHNICAL ASSISTANCE / EMERGENCY SERVICE 24/7/365

College Park's regular office hours are Monday thru Friday, 8:30 am – 5:30 pm (EST). After hours, an emergency Technical Service number is available to contact a College Park representative.



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