

**Instructions for the CPF 400 series
Single Stage Preform Adapter**

Please Read These Instructions for Proper Use

The CPF-400 model is a 4-hole European adapter with a 36mm center hole. It fits products with a mating male thread such as threaded shuttle locks and rotatable adapters. There are (3) 4mm setscrews located in the groove, designed to lock these components in place (Fig1). All 7 set screws are coated with paraffin to minimize any resin infiltration in the thread holes. The adapter and laminating cap are designed to allow a single stage lamination with the materials of your choosing (Fig 2). The proximal edge of the adapter is designed with 2 anti-rotation flats (Fig 3).



Fig 1

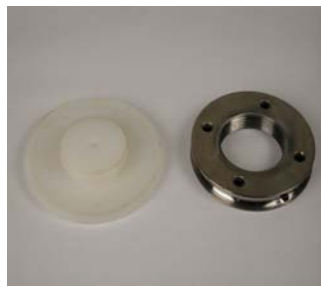


Fig 2



Fig 3

Below are some useful guidelines.

- If your model is not flat the adapter can be attached to the PVA bag with putty.
- If you are transferring from an existing alignment use putty in the same way. Note: Use putty sparingly and do not cover the center hole of the cap. (Fig 2)
- A cover layer will be needed to hide the adapter at the bottom of the socket. If you are using a screw in shuttle lock, do not cover the distal end of adapter with layup material.



Fig 4

- We have pictured a carbon layup for these instructions (Fig 4). Excess carbon braid can be cut and tucked under the proximal brim for extra strength and thickness.
- The three 4mm set screws should protrude enough to aid in locating them after lamination, but not so much that PVA bag can be compromised.
- Apply release or putty to any exposed threads or openings, such as set screw heads.
- Check the alignment, screw in the resin cap, making sure the adapter doesn't rotate out of alignment and apply the outer PVA bag.
- Over PVA bag, carefully wrap one layer of tape around outside edge of cap. Pour resin in and allow it to saturate your lay-up through the center hole and ports.

Technical Tips:

- Tuck excess carbon or fiberglass under at socket brim to increase thickness, strengthen the laminate and reduce waste.
- Vacuum should be run at a maximum of 29 in hg. The strongest composites have as little resin as possible. Do not over string because you can starve the laminate. Let the vacuum do the work for you, string in one direction and keep a wave of resin ahead of your string.
- Give the resin ports in the cap time to do their work. This should only take 2-3 minutes. Then run it as described above.
- Use 250-400 grit sandpaper and sand under running water to finish socket edge after rough sanding on router.
- Painting with lacquer and sanding with fine sandpaper will create a great finished edge.
- If attaching a threaded component to center threads of finished socket, use Loctite™ 232 thread locking compound on the 4mm set screws and tighten to 2 Nm.



Questions, please call American Prosthetic Components, LLC at (920) 406-9550 or (800) 772-7508.