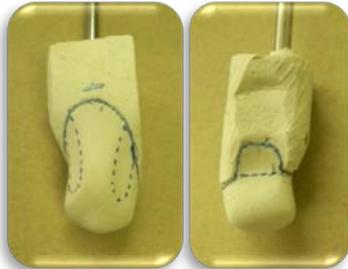


Partial M-Finger Fabrication Guidelines

1. Take silicone impression of Limb



2. Pour and modify mold



3. Prepare Partial M-Finger Base

1. Seal all holes and channels
2. Dip in plasti dip (Home Depot, Lowes, Ace Hardware). *****This step is necessary to insure no resin leaks into holes*****



4. Apply Vinyl glove finger over mold to act as a PVA bag. Add one layer of bi-directional carbon fiber over mold. *****use vinyl gloves as they do not stick to the pre preg*****. Tip: apply carbon over half of the mold (splitting the socket in



half) and leave distal end open. Turn model over and apply the other half and allow it to overlap the first half by ¼ inch on both sides. Then cut out a

circle of carbon to cover the distal end. Apply 2nd Vinyl glove and connect vacuum tubeHeat in over under vacuum at 200 degrees for 3 hours

5. Rough up first layer of Carbon fiber and align and trim the partial M-Finger base. Cut off medial and lateral tabs to reduce ML width. Cut Anterior/Posterior tabs just short of desired trimlines. When positioned, secure in place with superglue and clamp.



6. Apply final layer of carbon fiber to mold. Pull a final vinyl glove finger over model and heat in over under vacuum for 3 hours



7. Trim socket to desired trimlines



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Partial M-Finger Fabrication Guidelines

8. Install fingertip with provided rivet, washer and retaining ring



9. Install spring. Insert spring into fingertip and secure with 0-80 X 1/2 inch screw provided. Loop sewing thread through spring loop and guide both ends of thread through hole in finger base and exit both out of the top of the finger base. Pull back on both ends of thread to pull spring loop into screw hole. Insert 0-80 X 3/8 inch screw provided into hole to secure spring



10. Install cable assembly. Route both ends of cable through top of finger base and into fingertip. Pull cables out of hole using tweezers provided. Set cable length so the silicone sleeve is positioned over the knuckle. Tie two knots in cable and superglue knot. Cut off excess cable and pull knot into hole. Secure in place with set screw provided

