

4019 ULTRA6 CARBON BRAID

Fabrication Layup Suggestions

The concept for layups includes tying off and reflecting layers, not cutting to length if possible.

We believe layers should be equalized for best results. (Each line represents 1 layer)

⚠NOTE: It is best to reduce tying the braid or stockinette into tight large knots as this diminishes the ability of the resin to saturate adequately.

BK layup – Single shot (Up to 100Kg)

- Perlon, or flexastretch (sew end) (Can put Dacron Felt first layer if needed)
- Ultra6 Braid (tie to socket adapter and reflect remainder 33% of length)
- Carbon Unidirectional Tape 0-90 (Anterior to Posterior, Medial to Lateral) and brim circumference
- (may need to split tape to veer around braid/stockinette) (See Fig. 1)
- (Note: Width of tape should be minimum 25 to 37mm.)
- Nyglass
- Ultra6 Braid (full length)
- Perlon or Nylon hose

BK Layup – 2 stage lamination (Up to 100Kg)

1st lamination: (Will end up with 2 full length Ultra6 braid layup)

- Perlon, or flexastretch (sew end) (Can put Dacron Felt first layer if needed for sanding for bony relief)
- Ultra6 Braid (full length, tie to reflect remainder later)
- Carbon Unidirectional Tape 0-90 (Anterior to Posterior, Medial to Lateral) and brim circumference (may need to split tape to veer around braid/stockinette)
- Reflect down 2nd layer of Ultra6 Braid (full length)
- 2 scuffing layer for finish lamination
- (Note: Width of tape should be minimum 25 to 37mm.)

2nd lamination:

- Ultra6 Braid (50% of length - tie to reflect remainder later)
- Reflect Ultra6 Braid
- Nylon Hose (or outer finish material/design)

These recipes are recommendations. This will help familiarize you with the characteristics of Ultra6. The concept of equalized layers should be utilized when altering layup dependent on patient characteristics (weight/activity)

P/N	Description
4019-3.10	Ultra6 BRAID, 3 in x 10 ft
4019-3.50	Ultra6 BRAID, 3 in x 50 ft
4019-4.10	Ultra6 BRAID, 4 in x 10 ft
4019-4.50	Ultra6 BRAID, 4 in x 50 ft
4019-5.10	Ultra6 BRAID, 5 in x 10 ft
4019-5.50	Ultra6 BRAID, 5 in x 50 ft
4019-6.10	Ultra6 BRAID, 6 in x 10 ft
4019-6.50	Ultra6 BRAID, 6 in x 50 ft
4019-8.10	Ultra6 BRAID, 8 in x 10 ft
4019-8.50	Ultra6 BRAID, 8 in x 50 ft
4019-10.10	Ultra6 BRAID, 10 in x 10 ft
4019-10.50	Ultra6 BRAID, 10 in x 50 ft



(Fig 1 -Example of split tape to veer around braid or studs)



(Fig 2: example of loose tie off of braid to facilitate full fabric saturation)

CE Conformity

This product meets the requirements Council EU 2017/1745 (MDR).

for medical products. This product has been classified as a class I product according to the classification criteria outlined in appendix IX of the guidelines. Please keep this manual in safe place for future use.

Useful Life

Service life of the product is covered by the warranty period.

Disposal

The device and its packaging must be disposed of in accordance with respective national/local environmental regulations.



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⚠ NOTE: It is best to reduce tying the braid or stockinette into tight large knots as this diminishes the ability of the resin to saturate adequately.

AK layup – Single shot (Up to 100Kg)

- Perlon (Sew end) (Can put Dacron Felt first layer if needed)
- Ultra6 Braid (tie off to socket adapter to be reflected down later)
- Carbon Unidirectional Tape 0-90 (Anterior to Posterior, Medial to Lateral) and brim circumference (may need to split tape to veer around braid / stockinette)
- Nyglass
- Reflect Ultra6 Braid (100% of length)
- Nyglass (sew up end and layup over socket adapter/or tie in if adapter needs to be tied in)
- Ultra6 Braid (sew up end and layup over socket adapter/or tie in if adapter needs to be tied in)
- Nylon hose
- (Note: Width of tape should be minimum 25 to 37mm.)

AK Layup – 2 stage lamination (Up to 100Kg)

1st lamination: (Will end up with 2 full length Ultra6 braid layup)

- Perlon, or flexastretch (Can put Dacron Felt first layer if needed)
- Ultra6 Braid (tie to reflect remainder later)
- Carbon Unidirectional Tape 0-90 (Anterior to Posterior, Medial to Lateral) and brim circumference (may need to split tape to veer around braid / stockinette)
- Reflect Ultra6 Braid (100% of length)
- 2 Nyglass (scuffing layers for finish lamination)

2nd lamination: (Final lamination total layup 3 full, and ½ length for both stages)

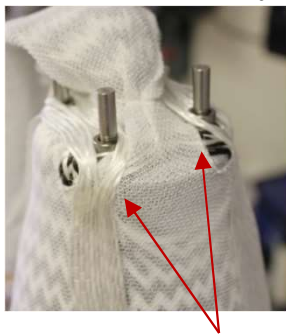
- Ultra6 Braid (full length. Tie into adapter to reflect down later)
- Nyglass
- Ultra6 Braid (full length)
- Nylon Hose

Environment:

Store at room temperature, and avoid extremely hot, cold, or moist storage environments Storage

Temperature Range: between temperatures of -20°C to 80°C [-4°F and 176°F]

Do not store in wet or very hot environment.



(Fig 1 -Example of split tape to veer around braid or studs)



(Fig 2: example of loose tie off of braid to facilitate full fabric saturation)

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