

# 617H119 Orthocryl Lamination Resin 80:20 PRO



Quality for life



# 617H119 Orthocryl Lamination Resin 80:20 PRO

Orthocryl Lamination Resin 80:20 PRO is a lamination resin for the fabrication of components with a low proportion of resin. It has a lower viscosity than Orthocryl Lamination Resin 80:20 (617H19) but the same mechanical characteristics. Thanks to the lower viscosity the reinforcement material can be penetrated more effectively, allowing air to escape faster from the reinforcement. Hardener and colour pastes are easier to mix with Orthocryl Lamination Resin 80:20 PRO.

The reinforcement materials are soaked more effectively when processing with Orthocryl Lamination Resin 80:20 PRO (617H119) instead of Orthocryl Lamination Resin 80:20 (617H19). The air that is pushed out and subsequently rises can escape from the resin during lamination and is not locked into the resin. This increases the quality and stability of the end result.

## Winning Combinations

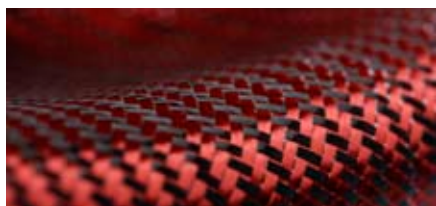
Orthocryl Lamination Resin 80:20 PRO is outstanding when used in combination with a Reinforcement Kit (5Z14) or with CarbonTex (616G120 or 616G180). The application associated with each combination is explained.



### • CarbonTEX

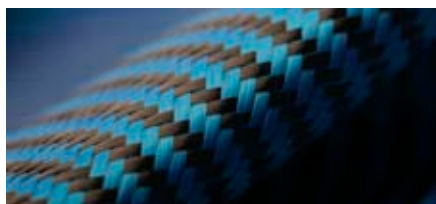
- For individual dyeing with lamination technique
- Good absorption of all Ottobock lamination resins
- Good draping characteristics
- Conventional lamination process
- No additional technical knowledge or workshop facilities required
- Extensive choice of designs

# Carbon Fibre Cloth



## Carbon Fibre Cloth "red"

Article Number	616G120=2-2	616G120=5-2	616G120=10-2
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Red (2)	Red (2)	Red (2)



## Carbon Fibre Cloth "blue"

Article Number	616G120=2-5	616G120=5-5	616G120=10-5
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Blue (5)	Blue (5)	Blue (5)



## Carbon Fibre Cloth "green"

Article Number	616G120=2-3	616G120=5-3	616G120=10-3
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Green (3)	Green (3)	Green (3)

# Fibreglass Cloth



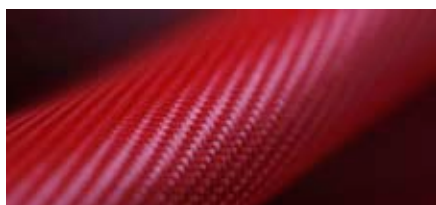
## Fibreglass Cloth "silver"

Article Number	616G180=2-16	616G180=5-16	616G180=10-16
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Silver (16)	Silver (16)	Silver (16)



## Fibreglass Cloth "light silver"

Article Number	616G180=2-16.4	616G180=5-16.4	616G180=10-16.4
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Light silver (16.4)	Light silver (16.4)	Light silver (16.4)



## Fibreglass Cloth "light red"

Article Number	616G180=2-2.4	616G180=5-2.4	616G180=10-2.4
Length	2 m	5 m	10 m
Width	1 m	1 m	1 m
Colour	Light red (2.4)	Light red (2.4)	Light red (2.4)

# Practical Recommendations for CarbonTex



1 Sand the surface of the socket being laminated, clean with Isopropyl Alcohol (634A58) and mark the position of the subsequent CarbonTEX seam on the socket with a pencil.

Measure the socket length and circumference. Cut a corresponding piece of CarbonTEX with a width and length that is 10 cm larger than the respective measurement. To prevent the fibres from fraying, tape off the outside of the cut edges.



1 Apply spray adhesive for joints that can be disassembled (636K40) to the socket, starting on the side opposite the marked CarbonTEX seam. Then continue wetting the socket gradually, applying the layer of CarbonTEX around the socket without wrinkles and pressing it into place in the direction of the seam.

2 Attach one end of the layer of CarbonTEX to the previously marked seam with Double-Sided PVC Adhesive Tape (616F10=6) and trim the excess material with Carbon Scissors (719S21). Then press any protruding fibres in place again. Repeat this procedure on the opposite side. In order to do so, apply a new strip of PVC adhesive tape to the cut edge of the CarbonTEX side. Overlap and attach the second end of the layer of CarbonTEX, trim the excess material and press any protruding fibres in place.



3 Clean the soaked PVA Bag (616F4) with paper towel on both sides and pull it over the model with the desired side (matt or gloss). Tie off the PVA bag on the proximal end. Tie off temporarily in the distal region and create a vacuum.

Mix the desired quantity of Orthocryl Lamination Resin 80:20 PRO (617H119), without adding colour paste, with 2% hardener and fill into the bag. Then tie off above the resin filling, without any air inclusions. Orient the model as shown in figure 3. Undo the temporary tie in the distal area between the resin and socket, and extract rising air bubbles with the vacuum. Then laminate the socket, with the even penetration of resin running at a 90° angle to the socket axis.

After hardening, cut the socket and sand it down.

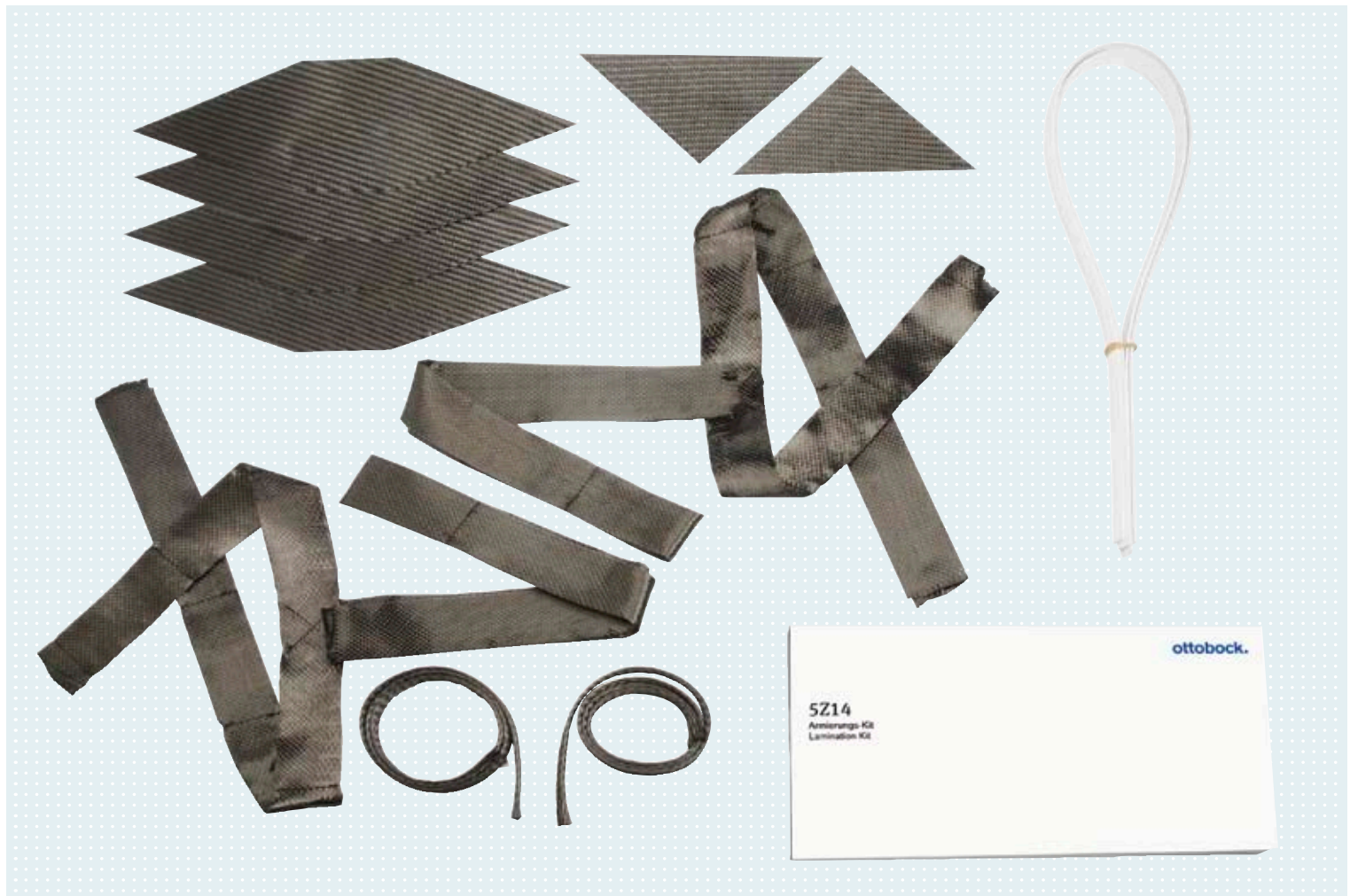


## Practical recommendation:

- Use with acrylic and epoxy resin systems is possible
- Suitable for decorative purposes but not as structural laminate component
- Laminate without colour paste to prevent distortion of the colour result

• Chemical Protection Gloves (641H17), protective eyewear and a breathing mask should be worn for occupational safety reasons. Perform all process steps under an extractor hood.

# 5Z14 Reinforcement Kit



Article number	5Z14
Weight	0.466 kg

## 5Z14 Reinforcement Kit

- For frames and container sockets, e.g. for ISNY sockets, M.A.S.® sockets, knee disarticulation sockets and ischial containment sockets
- For distal residual limb cap: 4 naps of bidirectional carbon fibre cloth
- For frame construction: 2 T-shaped carbon fibre cloth straps (3 layers) with reinforcing seams
- For medial torsion reinforcement: 2 triangles of bidirectional carbon fibre cloth
- For axial frame reinforcement: 1 profile rod, 1 woven carbon fibre stockinette
- For radial frame reinforcement: 1 profile rod, 1 woven carbon fibre stockinette

# Frame Construction over Flexible Inner Socket



- 1 99B25 Tube Sock layer
- 1 PVA Bag (e.g. 99B81=70x27x5)
- 1 623T3=20 Perlon Stockinette layer

Optional for patients weighing 125 kg and over: 17Y106=1000x16 PVC Profiles axially and radially including 616G15=20x50 Carbon Fibre Cloth.

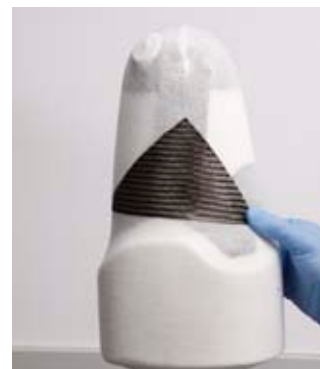
- 1-2 naps (carbon fibre cloth) for residual limb cap



- 1 T-shaped part (carbon fibre cloth strap) for frame construction



- 1 triangle (carbon fibre cloth) for medial torsion stiffening
- 1 623T3=20 Perlon Stockinette layer



- 1 triangle (carbon fibre cloth) for medial torsion stiffening



- 1 T-shaped part (carbon fibre cloth strap)



- 1-2 naps (carbon fibre cloth) for residual limb cap



- 1 Perlon stockinette double layer
- 1 PVA Bag (e.g. 99B81=70x27x5)
- Laminating

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