

TRANS-TIBIAL

Section 1:2 Draped Sockets

Section 1:2:1 Draped Socket

Section 1:2:2 Draped Socket - Hard Liner

Section 1:2:3 Draped Socket - Socket Lock

Section 1:2 Draping Guide

The times and temperatures given are for guidance only, they relate to a properly calibrated Blatchford Oven. To ensure even heating rotate the material 180 ° horizontally after the time shown. The material should be watched approx two thirds through the second heat period.

Part Number	Material	Thickness	Oven Temp. °C	Before Turn	Before 2nd Turn and Invert	Before 3rd Turn	Before 4th Turn	After Turn	Material Application	Shrink Allowance
904060-1	Surlyn	6mm	180	6 min.				7 min.	Flexible soft sockets and check sockets	(1) Wet cast or nylon or latex min. shrinkage
904260	PE MPE	6mm	300	4 min.				4 min.	Flexible sockets	1 cotton stump sock, 1 double nylon + 1 latex
904261	PE MPE	9mm	300	5 min.				6 min.	Large flexible sockets	As above
904270-1	Homopolymer Polypropylene	10mm	220	15 min.				8 min.	Frame sockets	1 Nylon wick over socket
904050	Co-polymer Flesh Polypropylene	9mm	220	12 min.				5 min.	Child's sockets	As required
904051	Co-polymer Flesh Polypropylene	12mm	220	16 min.				12 min.	P.T.B. Nylon wick over P.E-Lite	
904251 904253-4	PETG Co-polymer	9mm	160	5 min	5 min	5 min.	5 min.		Diagnostic socket, large	As above

Temperature °C
(1) When draping Polypropylene over Surlyn inner socket, the Surlyn must have a build up of 1 cotton stump sock and 2 layers of nylon stocking over it to allow for shrinkage of polypropylene.

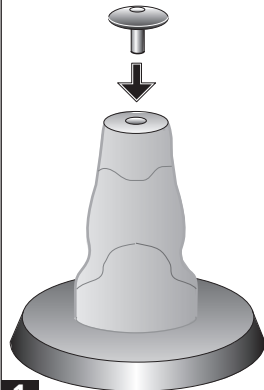
Warning:
Diagnostic sockets walking trials should be carried out between parallel bars for patient safety.

Tools, Equipment and Materials

Number	Description	Number	Description
941129	Drape table, small (Trans-tibial & Trans-femoral)	941174	Drape frame spacer (use with 941114)
941133	Stem for drape tables	941175	Drape frame spacer (use with 941117)
940638	Drape former and spigot, small (Trans-tibial) (reducing alignment)	941176	Drape frame spacer (use with 941118)
940639	Drape former and spigot (Trans-tibial) and small (Knee Disarticulation)	941177	Drape frame spacer (use with 941119)
941167	Cast build up former, small dummy knee	909108	Nylon stockinette
941113	Align mandrel	940625	Cone, latex, small
941117	Drape frame, 305mm sq., blank	940626	Cone, latex, medium
941114	Drape frame, 343mm sq., blank	932327	Stump sock
941118	Drape frame, 406mm sq., blank	940407	Socket end trimming cutter
941119	Drape frame, 420 x 460mm, blank		

Draped Socket Section 1:2:1

- a** Position Drape Former and Spigot 940638 or 940639 depending on size of socket



1

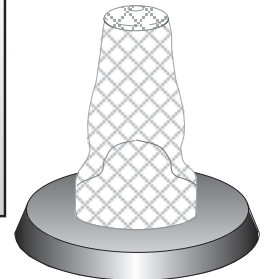
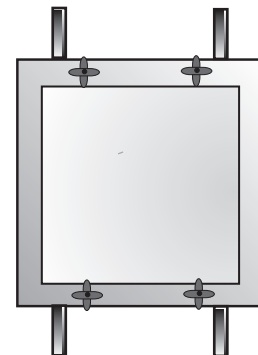
- b** Place the cast and liner centrally on inner drape table.

- c** Cover with one layer of nylon stocking. Lightly dampen, talc or spray with water to prevent sticking

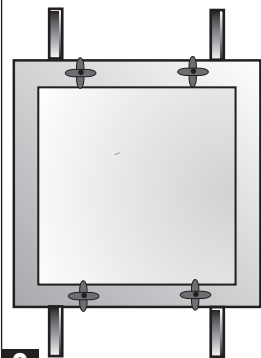


Select from range of plastic materials the required blank and frame size. This is determined by the size of cast and table used. (305mm sq. blank and frame for small table, (small cast)). (343mm sq. blank and frame for large table (medium/large cast)). **Refer to the Draping Guide on opposite page.**

Note: Spacers are required for 6mm thick materials.

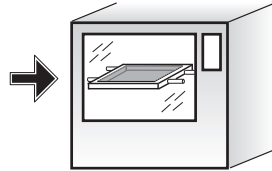


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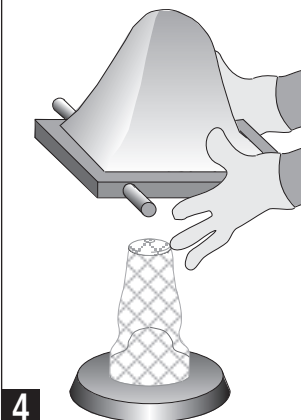
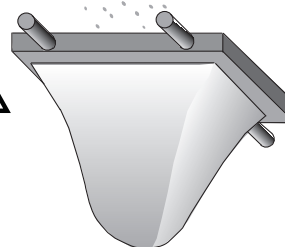
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- a** Place material in oven for required time and temperature.



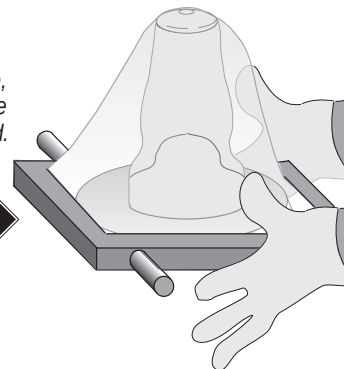
- b** When material has dropped approx. two thirds of length of cast, remove from oven and dust interior lightly with french chalk or talc.

ALTERNATIVE NON-STICK METHOD
Remove plastic from oven and chill interior surface very briefly with compressed air. This will prevent the stockinette wick from adhering to the draping material.

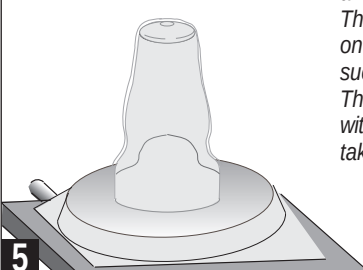


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- a** Quickly invert frame and cone, lower slowly over cast until the cone is supported on distal end.



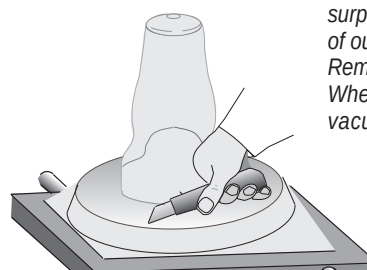
- b** Lower frame down slowly until the material touches the table to form a seal. (Some assistance may be necessary).



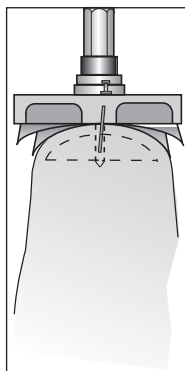
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- a** Switch on vacuum pump (-0.8 bar) and allow vacuum to pull material in. The inner vacuum can be switched on and off as required to control suction. This procedure must be completed within 30 seconds of the initial vacuum taking effect.

- b** As soon as the material returns to its natural colour appearance, cut off surplus material (cut to the top face of outer ring). Remove surplus material and frame. When cooled sufficiently switch off vacuum and remove from table.

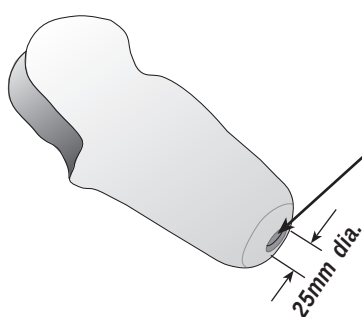


Section 1:2:1 Draped Socket



Drill a 6mm dia. hole in the centre of distal end.
Radius socket using Socket End Trimming Cutter 940407.
Insert airline to assist the removal of socket from cast.
For very shapely casts it may be necessary to chisel out cast from socket.
Ensure an even thickness to interface attachment area.

6



Once socket has been removed from cast, trim socket to patient requirements, radius and polish rim of socket.

Cut a 25mm dia. alignment hole using hole cutter.

Trim P.E-Lite liner to suit. Fill distal hole with a piece of P.E-Lite.

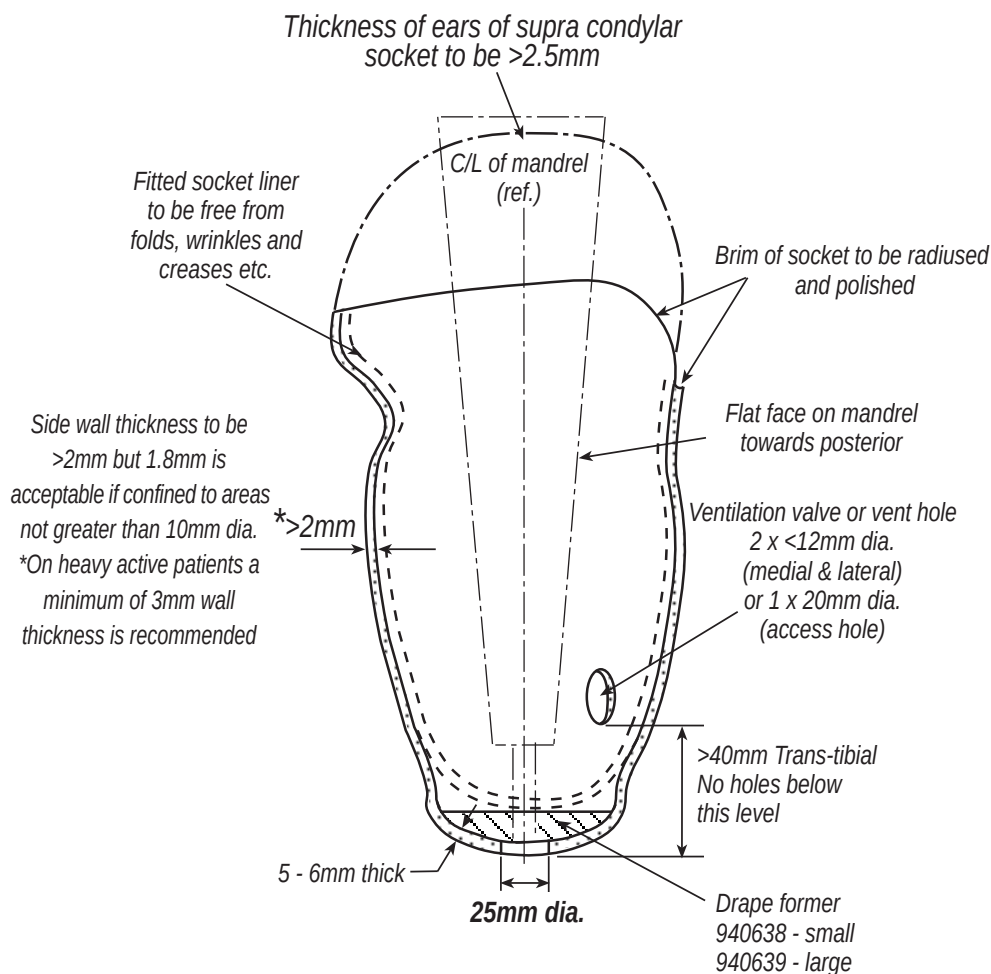
Distal end thickness of socket should be 5-6mm.

Wall thickness should be a minimum of 2mm.

For active patients a minimum of 3mm wall thickness is recommended.

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Socket Detail for Draped Sockets

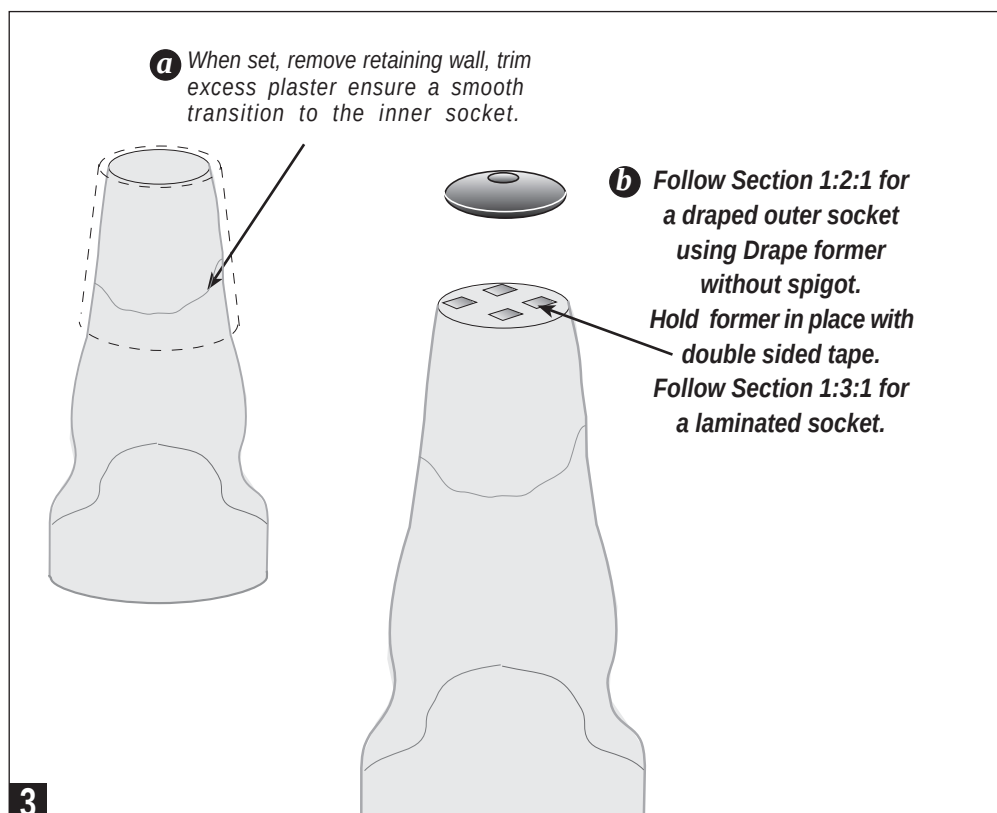
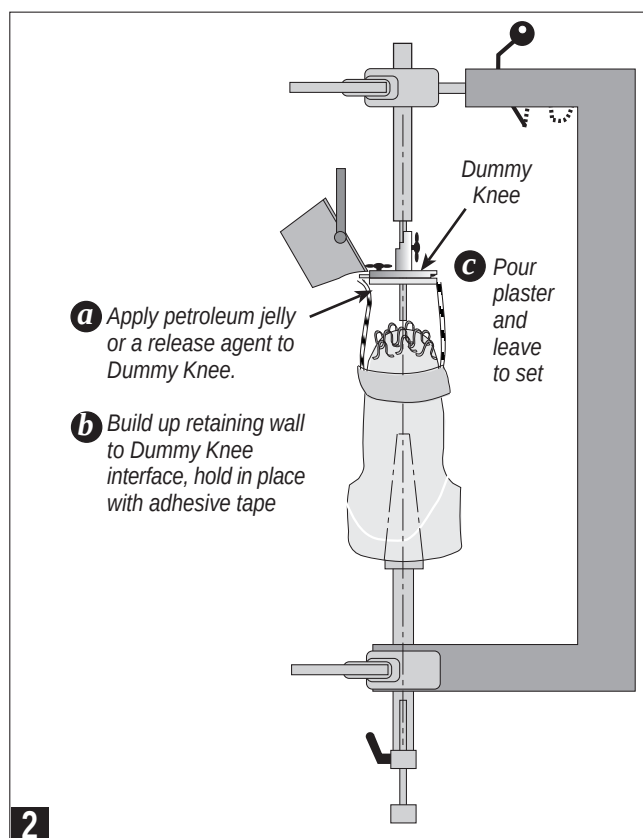
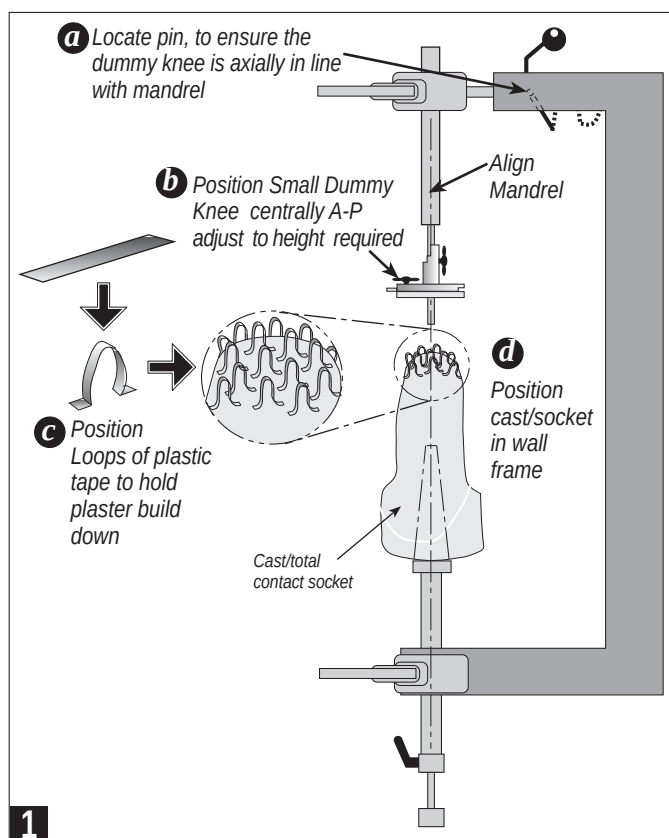


Notes

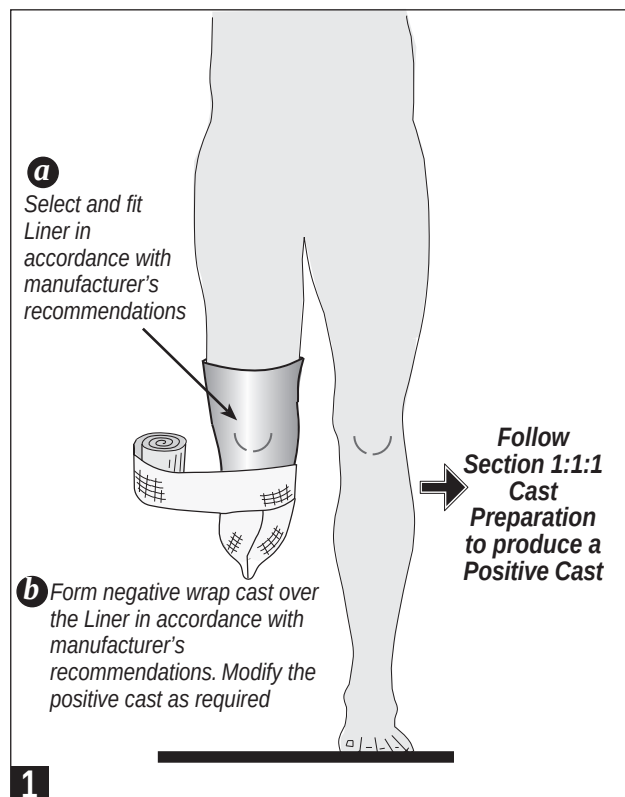
1. Select appropriate blank, size to suit size of socket.
2. All changes of form or shape to achieve a gradual blend, abrupt changes are unacceptable.
3. There should be no stress whitening of the polypropylene.
4. Ensure that the socket is free from any sharp edges.
5. Inner and outer surfaces of distal end of socket to be smooth.

Draped Socket with Hard Liner Section 1:2:2

Manufacture a total contact draped socket over positive cast following draping instructions shown in Section 1:2:1
Cut off excess material and leave socket on cast.

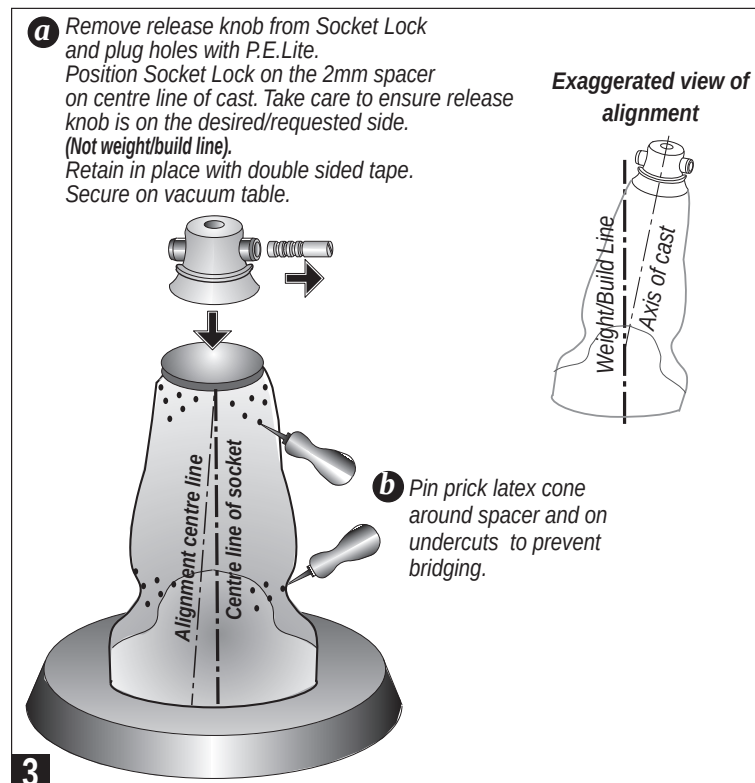
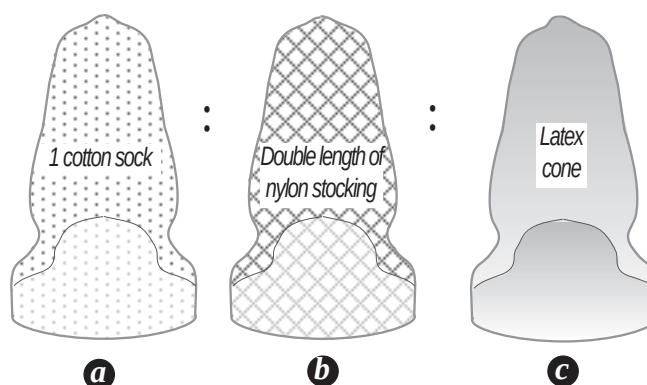


Section 1:2:3 Draped Socket - Socket Lock

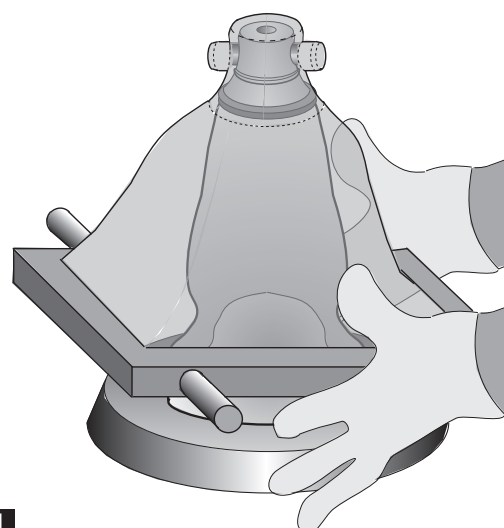


If required manufacture a Socket Liner following Section 1:1:2 Stages 1 to 8.

To allow for shrinkage cover cast/liner with:-



Drape inner socket using suitable material following Section 1:2:1 for guidance After material has returned to its natural colour trim to base of cast.



Draped Socket - Socket Lock Section 1:2:3

