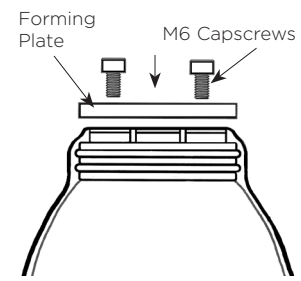


LOCK INSTALLATION

1. Reinstall the Metal Forming Plate with the four M6 x 12 cap screws.

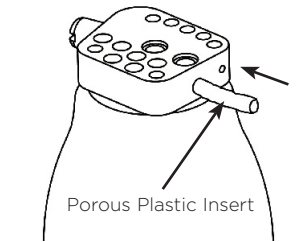


2. Drill a 1/4" (6 mm) hole through the fifth hole.
3. Remove the Metal Forming Plate.
4. Deburr the holes.



5. Install the Lock Body with Duckbill Expulsion Valve onto the Distal Adapter, making sure that the button is pointing to medial side.

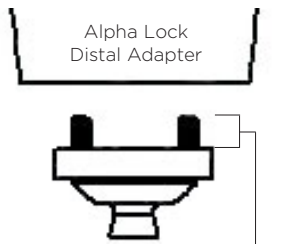
6. Push the Porous Plastic Insert into the Lock Body air expulsion hole and cut with a knife so that it is flush with the lock.



7. Take the rest of the Porous Plastic Insert and press into the hole in the Distal Adapter and cut or sand to fit adapter surface.

8. Insert the Rubber Plug into hole on the opposite side of the expulsion valve, so that air will be expelled through Porous Plastic Insert.

9. Attach the WillowWood 4-hole adapter of choice, using Loc-Tite on the four M6 screws. Check to make sure that the length of exposed screw to engage with the Alpha Lock Distal Adapter is between .16" (4 mm) and .35" (9 mm). Tighten the screws to 9 ft.-lbs. (12 Nm). Assemble the rest of the prosthesis.



The length of exposed screw to engage with the Distal Adapter must be between .16" (4 mm) and .35" (9 mm).

10. Apply removable Loc-Tite to threads on the Locking Pin and tighten the pin into the Alpha Locking Liner until the base of the pin meets the umbrella.

NOTE: The Pin Seal must come in contact with the Distal Adapter to seal properly.
If the Pin is too long, grind to the appropriate length, leaving a minimum of five ribs.



When trimming the Pin to length, grind the Distal Rib to a smaller diameter to ease Lock engagement.

11. Have the patient don the Alpha Locking Liner and the prosthesis. Once the pin is fully engaged in the lock, insert the Lock Key into the slot in the button and turn the button to pull the pin seal against the Distal Adapter.

DO NOT OVER-TIGHTEN THE BUTTON.

To remove the prosthesis, press the button to release the lock.

WARRANTY

The warranty for the Alpha Lock is one year from date of invoice. Use of the Alpha Lock for amputees whose modified body weight is more than 250 lbs (115 kg) or who engage in extremely high and abusive activity is against WillowWood's recommendations and will void the one-year warranty. Modified body weight is defined as the weight of the amputee plus any loads carried by the amputee. "Extremely high and abusive activities" are defined as activities such as skydiving, karate, and judo; activities that could result in injury to an individual's natural feet; and activities that expose the prosthesis to corrosives such as salt water.

WARRANTY DISCLAIMER

WillowWood warrants that each product manufactured will, at the time of delivery, be of workmanlike quality and substantially free of defects. **WILLOWWOOD MAKES NO OTHER WARRANTY, IMPLIED, OR EXPRESSED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** This warranty shall terminate immediately upon an action to combine our products with other materials or in any manner to change the nature of our products. The sole remedy is replacement of the products or credit for the products. WillowWood's liability shall not exceed the purchase price of the product. WillowWood shall not be liable for any indirect, incidental, or consequential damage.

WILLOWWOOD RETENTION OF RIGHTS

WillowWood retains all intellectual property rights reflected or incorporated in its physical products, regardless of the transfer of the physical products to another party or parties.

WillowWood®

Alpha® Lock Instructions



WHAT'S IN THE BOX

- 1 Alpha Lock Body
- 1 Distal Adapter Assembly:
 - 1 Distal Adapter
 - 1 Fabricating Post
 - 1 Metal Forming Plate
 - 4 M6 x 12 Socket Head Capscrews
- 1 Transfer Block
- 1 Hardware Kit:
 - 1 AIS Lock Pin, 10 mm x 38 mm
 - 4 Finishing Nails
 - 4 M6 x 30 Flat Head Capscrews
 - 1 Porous Plastic Insert
 - 1 Duckbill Expulsion Valve
 - 1 Rubber Plug
 - 1 Post Ring
 - 1 Round Sticker / Set of Post Stickers
 - 1 Lock Key
- 1 Titanium 4-Hole Pyramid (700-AIS481 only)

NOTE: The Alpha Lock is not compatible with the small size of Alpha Liners.

WillowWood®

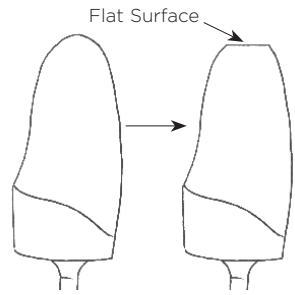
15441 Scioto Darby Road
Mt. Sterling, Ohio 43143 USA
Phone: 740.869.3377 or 800.848.4930
Fax: 740.869.4374
www.willowwoodco.com

Ohio Willow Wood Company B.V. 
Keizersgracht 62/64
1015 CS Amsterdam
The Netherlands 
Patent www.willowwoodco.com/education-and-resources/patents

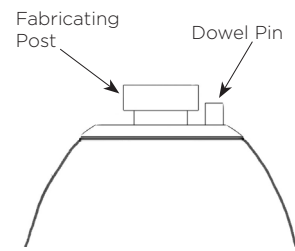
PN-1335-U 10 MAR 2015

PREPARATION OF THE POSITIVE MODEL

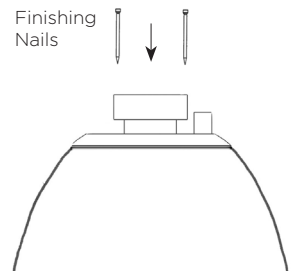
1. Modify the positive model according to the Alpha Liner Instructional Booklet.
2. Shave ½" (12 mm) off the distal end of the positive model to provide a flat surface that is the same diameter as the Fabricating Post.



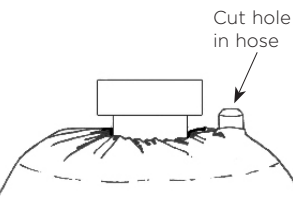
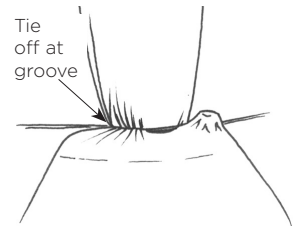
3. Place the Fabricating Post on the distal end of the model, with the Dowel Pin oriented to the lateral side. Secure the Fabricating Post with the four Finishing Nails that were included with the Fabricating Post. Drive the nails in until they are just below the surface of the Fabricating Post.



Note: The transition between the Fabricating Post and the model should be smooth. Blend in with sanding screen if necessary.



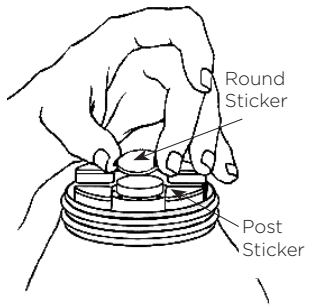
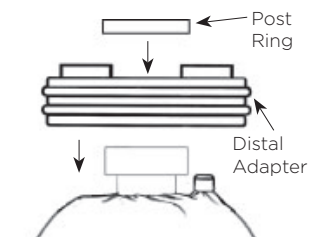
4. Pull a nylon hose over the Fabricating Post and the model. Tie off the hose at the groove on the Fabricating Post. Pull the rest of the nylon hose down onto the model. Cut a small hole in the nylon hose to expose the Dowel Pin.



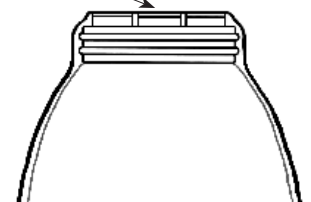
5. To fabricate a thermoplastic socket, proceed to the next section. To fabricate a laminated socket, proceed to **"For a Laminated Socket"**.

FOR A THERMOPLASTIC SOCKET

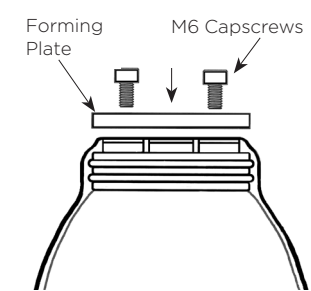
1. Snap the Distal Adapter into place on the Fabricating Post. The side of the Distal Adapter marked "Lateral Side" should point toward the lateral side of the model. Snap the Post Ring onto the Fabrication Post.
2. Place a Round Sticker in the center of the Distal Adapter, and place a Post Sticker onto each of the four raised surfaces of the Distal Adapter.
3. Place the Metal Forming Plate in an oven (set at the same temperature that is used to heat the socket material) for fifteen to twenty minutes.
4. Fabricate a thermoplastic socket using standard procedures.
5. After the socket has cooled sufficiently, sand material away to expose the stickers. Remove the stickers.
6. **Wearing protective gloves,** remove the heated Metal Forming Plate from the oven.



Sand away thermoplastic material to expose the Post Sticker

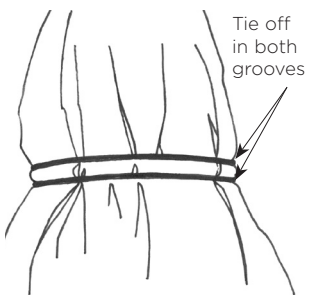
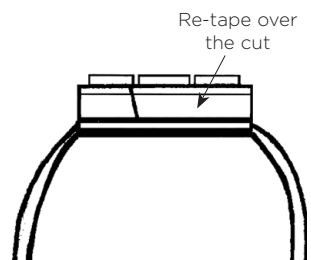
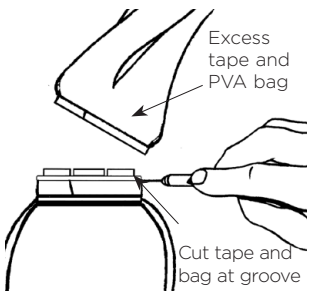
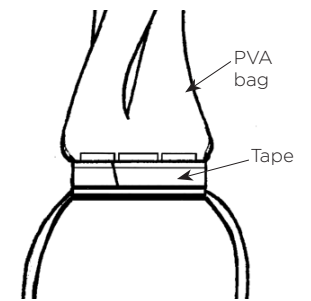
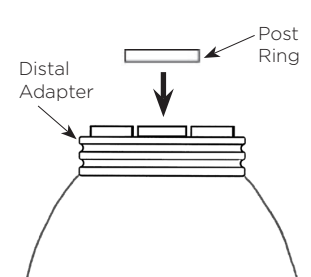
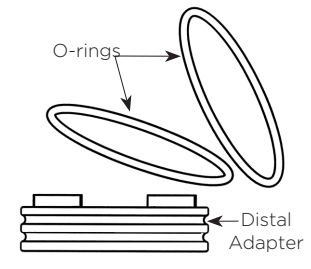


7. Attach the Forming Plate to the Distal Adapter with the four M6 x 12 capscrews. Tighten the capscrews until the Metal Forming Plate is flat against the raised surfaces of the Distal Adapter.
8. Allow the Metal Forming Plate to cool.
9. Remove the Metal Forming Plate.
10. Remove the model from the socket. Trim the socket as desired, and proceed to **"Lock Installation"**.



FOR A LAMINATED SOCKET

1. Remove and discard the two o-rings from the Distal Adapter.
2. Snap the Distal Adapter into place on the Fabricating Post. The side of the Distal Adapter marked "Lateral Side" should point toward the lateral side of the model. Snap the Post Ring onto the Fabrication Post.
3. Apply a PVA bag over the nylon hose and the Distal Adapter. Tape the bag off in the upper groove of the Distal Adapter.
4. Cut the tape and the bag off in the groove and remove the excess.
5. Re-tape over the cut so that resin cannot flow behind the bag.
6. Pull carbon braid or a stockinette onto the model and tie it off in both grooves of the Distal Adapter. Pull the rest of the stockinette or braid back onto the model.



7. Fold the carbon tape (included with the Alpha Lock) lengthwise into thirds so that it will fit completely within the channels on the Distal Adapter.
8. Place the strips of carbon tape into each of the channels on the Distal Adapter.
9. Fill the pinholes in the Fabrication Post and the pinhole in the Metal Forming Plate with putty.
10. Apply lubricant to the threads of the four M6 x 12 capscrews. Attach the Metal Forming Plate to the Distal Adapter with the four M6 x 12 capscrews.
11. Apply the desired layup, and tie the layup off in the groove formed between the Metal Forming Plate and the Distal Adapter. Pull the rest of the layup down onto the model.
12. Proceed with the lamination, using standard procedures.
13. After the lamination has set, remove the M6 x 12 capscrews and the Metal Forming Plate.
14. Remove the socket from the model. Trim the socket as desired, and proceed to **"Lock Installation"** on the next page.

