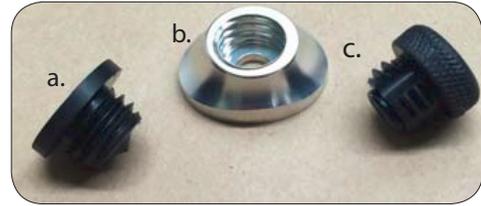# Expulsion Valve Instructions

WHAT'S IN THE BOX

a.   Expulsion Fabrication Dummy
b.   Expulsion Base
c.   Expulsion Valve
     Instructions

ADDITIONAL MATERIALS REQUIRED

Modified positive model
Fabtech 60 Second Adhesive
Vaseline
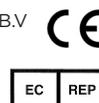Standard fabrication supplies

1.   Complete the first lamination over the model, using standard practices.

2.   Remove the outer PVA bag and roughly sand the entire model to improve the bonding of the remaining components.

3.   Determine where to place the Expulsion Base on the socket. Keep the following considerations in mind:

   •   Place the Expulsion Valve as far distal as possible.

   •   If placing the Expulsion Valve on the posterior aspect of the socket, check for adequate knee clearance.

4.   Apply Vaseline to the Expulsion Fabrication Dummy threads.

5.   Insert the Expulsion Fabrication Dummy into the Expulsion Base.

6.   Apply a puddle of Fabtech 60 Second Adhesive to the Expulsion Base, making sure to fill the hole.

7.   Gently apply the Expulsion Base to the socket at the previously determined location. **Do not press the Expulsion Base all the way against the socket.**

8.   Smooth any excess adhesive.

9.   Once the adhesive has hardened, use clay to mask the hex hole in the Expulsion Fabrication Dummy.

10. Apply desired layup.

11. Proceed with the second lamination, using standard practices.

12. Remove the socket from the model.
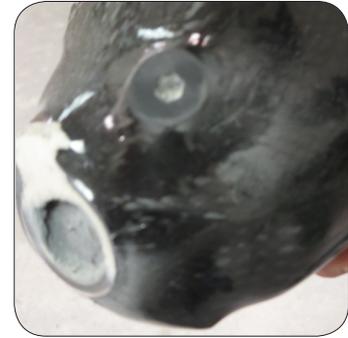

WillowWood®

13. Sand to expose the Expulsion Fabrication Dummy.

14. Using an Allen wrench, remove the Expulsion Fabrication Dummy.

15. Carefully sand away the protruding lamination until the expulsion base is flush with the surrounding socket"

16. Sand the exposed edge of the lamination by hand.

17. Drill and de-burr a 9/32" hole through the valve port. Use the point that was formed by the Expulsion Fabrication Dummy as a centering guide.

18. Clean the socket thoroughly. Install the Expulsion Valve.

WARRANTY

The warranty for the Expulsion Valve is ??? from the date of invoice. Use of the Expulsion Valve for amputees whose modified body weight is more than 350 lbs/160 kg (300 lbs/135 kg for Level 4*) 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 normally or routinely 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 limb; and activities that expose the prosthesis to corrosives such as salt water.

*Level 4: Has the ability or potential for prosthetic ambulation that exceeds basic ambulation skills, exhibiting high impact, stress, or energy levels. Typical of the prosthetic demans of the child, active adult, or athlete.

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.

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