



Partial Hand SOLUTIONS, LLC



Fabrication Instructions Partial M-Finger

Materials Required:

- *Partial M-Finger*
- *Additional accessories (watchband, etc)*
- *Silicone; Factor II, 35 shore*
- *Pigment; Factor II pigments*
- *Lamination materials (nylon stockinette, PVA bag, USG No.1 Molding Plaster, etc)*
- *Pre-Preg carbon fiber (must be refrigerated until ready for use)*
- *60-second epoxy*

Equipment Required:

Silicone Roller

Oven with vacuum

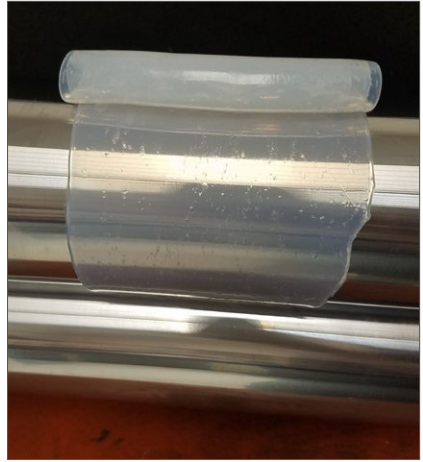
Total Baking Time:

27 hours

Fabrication



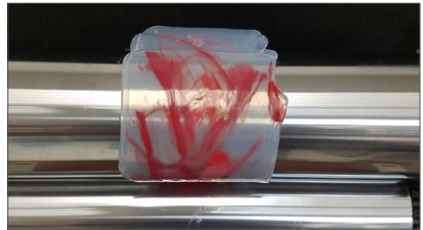
1. Start with clear silicone.



2. Flatten silicone through roller.



3. Add desired pigment color(s)

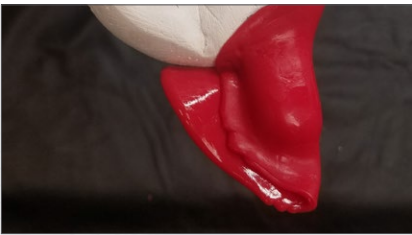


4. Roll the silicone until pigment is thoroughly mixed in.



5. Cut out silicone bases for your anchor(s). Place anchors on top of bases and taper down edges of circles.

6. Add any additional accessories. Watch band, etc



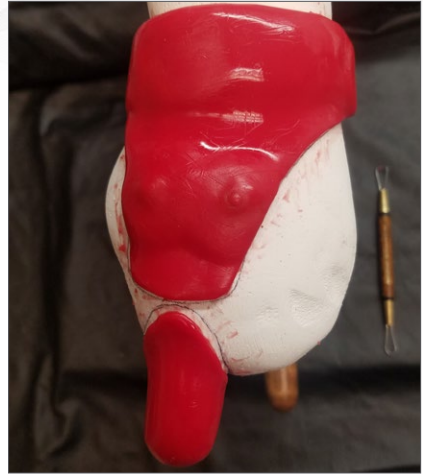
7. Lay down silicone for finger. Pinch excess silicone for trimming.



8. Trim excess silicone



9. Clean up trim lines



10. Lay down next design piece



11. Place 2 layers of nylon over silicone and then cover with plastic bag for vacuum. If possible, approximate amount of vacuum i.e. 10-15 in hg.



12. Smooth out edges of silicone and any lumps you feel.



13. After removal of bag and nylon



14. Trim silicone to desired trimlines and taper edges down for final look





15. Bake in oven for 2 hours (more if needed)



16. Prep for pre-preg carbon fiber



17. Double up nylon stocking and tie on pipe



18. Place PVA bag over nylon and tape to secure vacuum



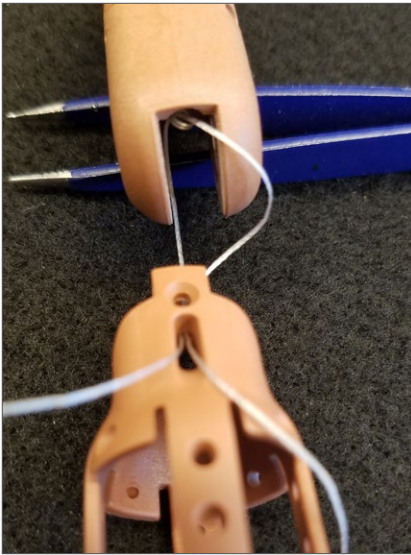
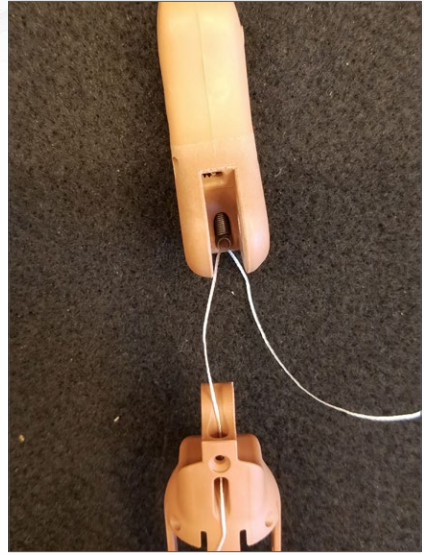
19. Place pre-preg carbon on desired areas. Layer up one at a time



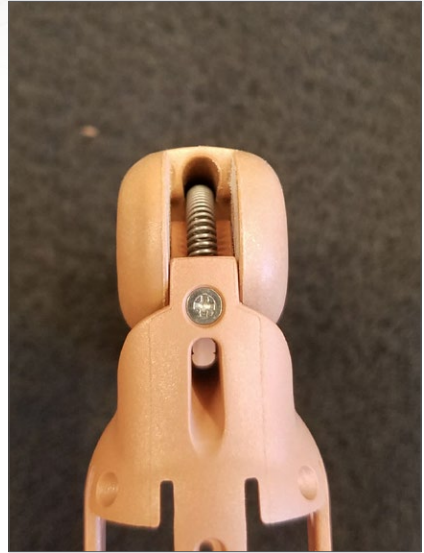
20. Once all layers are placed, add another PVA bag over pre-preg layers and “bake” in oven for 15 hours at 75°C



22. Break out pre-preg sockets and prep for alignment of finger and assembly



23. Thread string through spring hole and pull finger tip to the base



24. Use the smaller of the 2 screws in parts package to secure spring into place



25. Cut off tabs on base



26. String gray PMF cord through m-finger base up to the right side of finger



27. Scuff prepreg socket for adhesion of 60 sec epoxy and align finger to patient



28. Add 60 sec epoxy to bottom of base. Smooth any excess

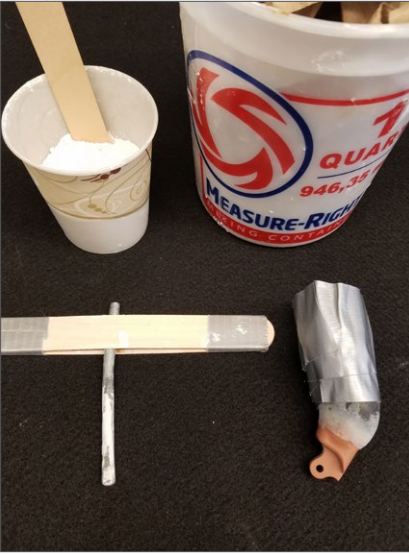


29. Add additional epoxy and continue to smooth

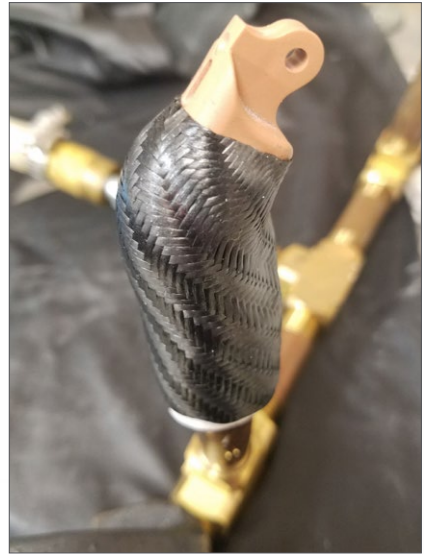


30. Smooth epoxy for a seamless transition between base and socket





31. Prep for plaster pour and last layer of prepreg



32. Apply layer of prepreg and trim off excess and apply bag.
Bake in oven for 10 hours at 75° C.



33. Draw trimlines, cut out and break out



34. Clean up silicone edges



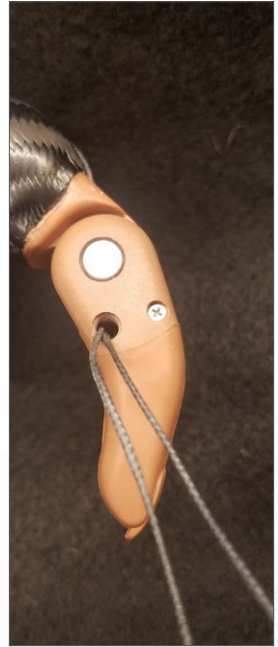
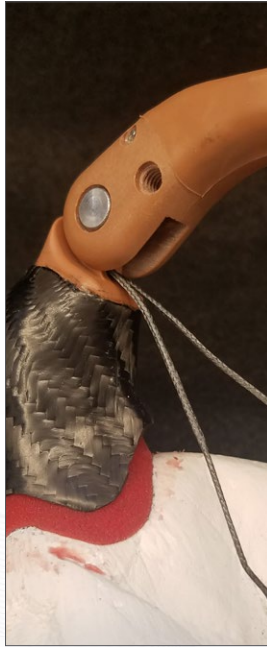
35. Prep for assembly



36. Insert pin. Place flat washer 1st, then place beveled washer above. Using light even pressure, push beveled washer down. *If you push washer too far down, finger won't spring back up properly.*



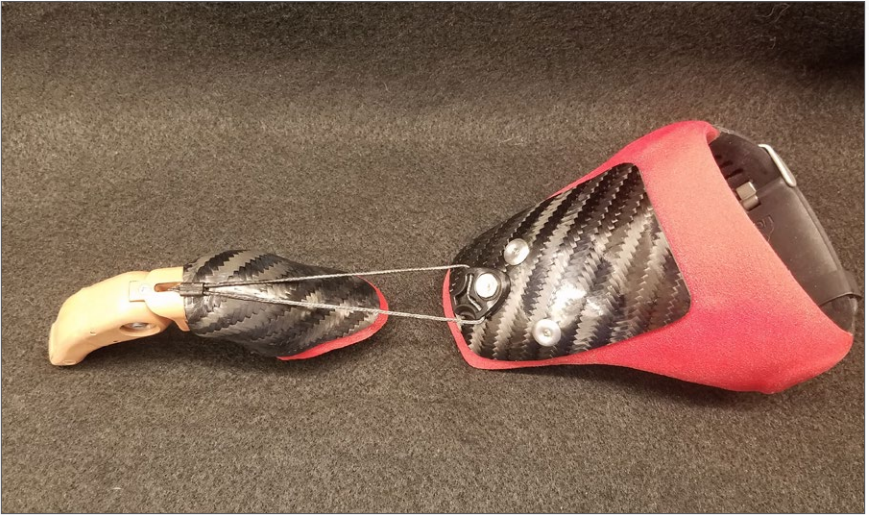
37. Restrung to pull spring down and screw onto base



38. Attach PMF anchor and pull up to finger base slot and out the tip



39. Tie knot close to opening. Trim excess and insert inside along with set screw



Finished product!



M-Fingers are distributed by:



college park

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TECHNICAL ASSISTANCE/ EMERGENCY SERVICE 24-7-365

College Park's regular office hours are Monday thru Friday, 8:30 am - 5:30 pm (EST). After hours, an emergency Technical Service number is available to contact a College Park representative.



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