

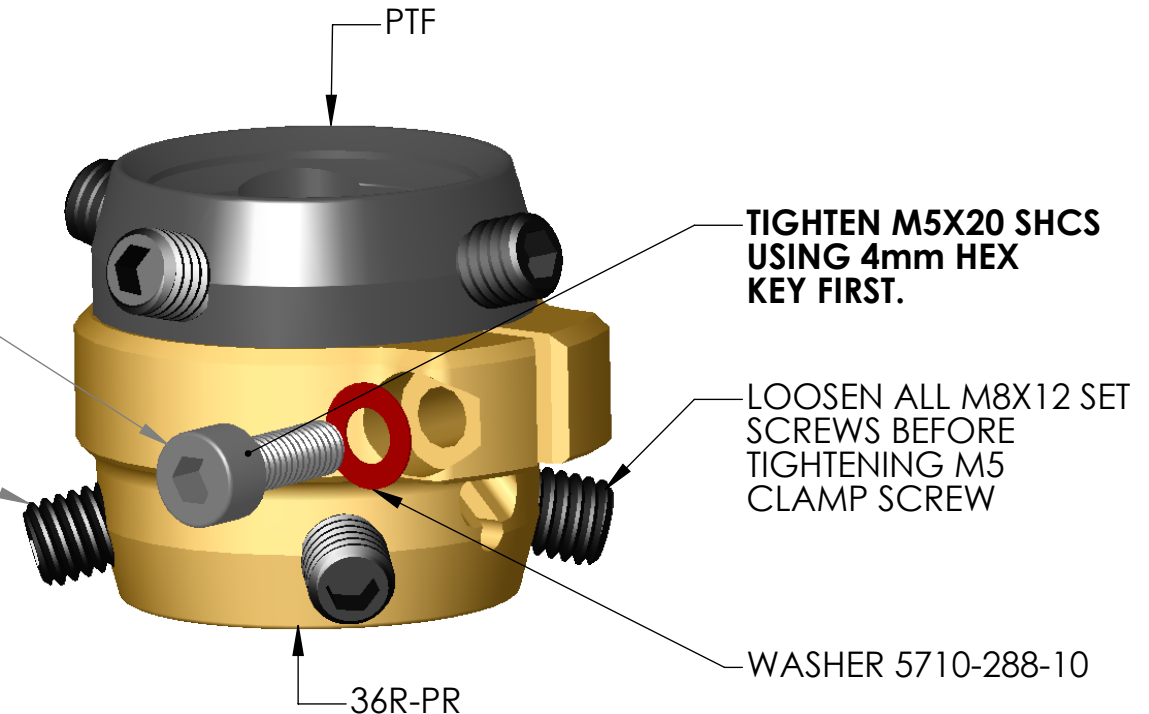
# INSTRUCTIONS 36R-PR

1. Apply Loctite to all threads with a torque setting before first/any tightening and before final adjustments.

2. The clamp screw that secures rotation must be loctited and torqued to 10 newton meters before the four receiver screws are tightened

3. Once the clamp screw has been properly loctited and torqued the four receiver set screws need to be loctited and torqued to 12 newton meters

4. Torque does not equal clamp force, if any adjustments to a clamping screw are made after the screw has been torqued, you must repeat all the above steps with a new clamping and washer, in order to secure rotation.



## Critical Tips on Bolt and Screw Installation

**Apply Loctite to all threads with a torque setting before first/any tightening and before final adjustments.**

**Torque:** It is essential to use a torque wrench when assembling prosthetic components. Too much torque may cause over stressed bolts resulting in failure or stripped threads. Not enough torque will allow improper movement and flexing causing fatigue failure. Torque must be measured on lubricated bolts.

**Locking:** Thread locking compounds, such as locite, not only helps prevent loosening and maintain torque, but also lubricates bolts. Generally, apply Loctite 222 or 242 to each part prior to assembling and follow all instructions including any cleaning and using primer. Hardware locks such as lock washers provide a reliable locking method when properly installed. Use them with the proper torque setting only when specified.

**Inspection and Re-inspection:** All bolts should be periodically inspected for proper torque settings. Determine the inspection interval (not exceeding 6 months) by frequency of loading (i.e., patient weight and activity). Re-inspection is absolutely necessary.

**Record Keeping:** Record the torque settings and dates of re-inspection along with serial numbers in appropriate patient files.

**ALWAYS FOLLOW THE COMPONENT MANUFACTURER'S RECOMMENDATIONS FOR BOLT USE. LONGER SCREWS MAYBE REQUIRED TO ACHIEVE FULL THREAD ENGAGEMENT. USE ONLY BOLTS THAT ARE SUPPLIED BY MANUFACTURER. ONE MANUFACTURER CANNOT GUARANTEE ANOTHER MANUFACTURER'S PRODUCT.**