



C12 | Suction Lanyard Fabrication Instructions

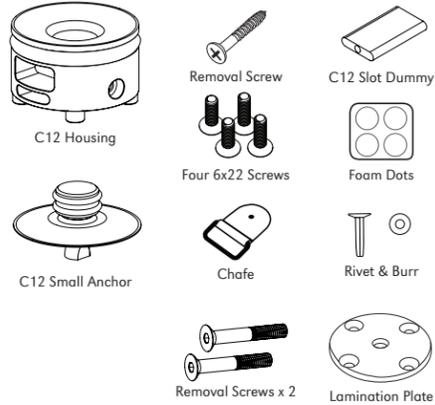
C12S | Suction Lanyard Standard



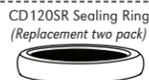
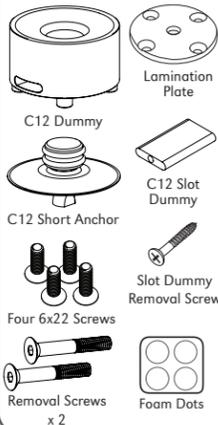
C12LS | Suction Lanyard Straps



C12SD | Suction Lanyard Drop-In



C12DD | Suction Lanyard Drop-In Tooling Dummy



Do not use lock as fabrication dummy. Repeated insertion will degrade the blue sealing ring.

Weight limit: 265 lbs.

2-year warranty against manufacturer defects, excessive wear or breakage on the housing.

6-month warranty against manufacturer defects, or breakage on the strap.

U.S. Patent No. 11,517,455

External Prosthetic Components

C12SD.revFabA.08062025



EN | Instructions for Use
DE | Gebrauchsanweisung
FR | Notice d'utilisation
ES | Instrucciones para el uso
IT | Istruzioni per l'uso
NO | Bruksanvisning
DA | Brugsanvisning
SV | Bruksanvisning
EL | Οδηγίες Χρήσης
FI | Käyttöohjeet
NL | Gebruiksaanwijzing

PT | Instruções de Utilização
PL | Instrukcja użytkowania
CS | Návod k použití
TR | Kullanım Talimatları
RU | Инструкция по использованию
JA | 取扱説明書
ZH | 中文说明书
KO | 사용 설명서



www.coyote.us/instructions



Manufactured by Coyote®
419 N. Curtis Rd., Boise, Idaho 83706 USA
(208) 429-0026 | www.coyote.us



Installing Dummy on Mold



1 Place lock dummy on mold. Trace dummy. Do not use lock as fabrication dummy.



2 Flatten mold to fit the anchor and dummy. Do not flatten beyond the traced lines



3 Drill 1/2" or 13mm diameter hole. Angle hole to help anchor adhesive.



4 Fill hole in cast with Coyote QUIK GLUE, fast-setting epoxy, or wet plaster mix.



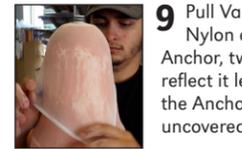
5 Place C12 Anchor in hole and Tooling Dummy until glue sets.



7 If there is a little lip or gap between the anchor and the cast fill it with plaster and smooth it out. If this stage is skipped it will be difficult to remove Tooling Dummy.

If laminating with: the C12 Tooling Dummy skip to step 25. the C12 Housing skip to step 42.

Drape Molding Check Socket



9 Pull Vacuum Nylon over the Anchor, twist and reflect it leaving the Anchor uncovered.



8 During blister forming or drape molding, it is recommended to use a vacuum nylon with applicable plastics to improve wicking.



10 Put some Compound 4 or release agent on Anchor O-rings and slide dummy over Anchor.



11 Mark desired position of the lanyard slot. Remove Dummy and glue it on with QUIK GLUE or 5 minute epoxy. Put Dummy back on Anchor in correct position.



12 Place the adhesive foam dots on the dummy posts. Put Compound 4 or release agent on Slot Dummy and insert into the lanyard slot.



13 Remove any gapping between the dummy and the cast. Shoot a bead of QUIK GLUE into the gap and smooth it out with finger.



14 Drape or blister mold. When Drape molding for extra strength, fold excess seam on distal end of connector.



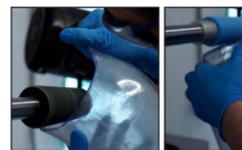
15 Cut out trim lines.



16 Expose and remove small adhesive foam and expose Slot Dummy. Grind distal end of socket flat. Take care not to sand metal posts. Foam can be left in place to act as a guide for flattening.



17 Remove socket in traditional fashion or with socket extractor.



18 Shape and finish your edges.



19 Drive removal screw into Slot Dummy and remove it. Screw long Removal Screws into Tooling Dummy posts.



20 Keep part of the screws unthreaded. Hold on to the socket and force your weight against the screws. This should remove the dummy.



21 Spray rubbing alcohol on the Suction Lanyard Drop-In before inserting.



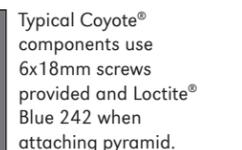
22 Insert Suction Lanyard Drop-In into socket.



23 Attach pyramid with supplied 6mm x 22mm screws. Then remove them. This should seat the Drop-In.



24 Use Coyote alignment coupler CD106 for alignment during fitting.



Typical Coyote® components use 6x18mm screws provided and Loctite® Blue 242 when attaching pyramid. Torque provided connector screws to 10 Nm. (See Attention for more information)

Laminating with Tooling Dummy



25 Pull one layer of vacuum nylon. Tie it off to the anchor and cut away the excess nylon.



26 Pull one layer of PVA bag. Tie it off to the anchor and cut away the excess PVA bag.



27 Run an even bead of QUIK GLUE around edge of Tooling Dummy to keep resin from seeping in.



28 Put Compound 4 or release agent on O-rings. Put Tooling Dummy on Anchor and adjust for proper positioning.



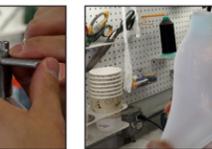
29 Fill any gaps on the edge of tooling and smooth out. This will help with removing the tooling after lamination



30 Paint the tooling with acetate or some other release agent such as Vaseline or Compound 4.



31 Put Compound 4 or some other release agent on C12 Slot Dummy. Insert it into slot on Tooling Dummy.



32 Pull and reflect nylon over tooling and cast.



33 Pull the nylon stockinette, or other materials, over the Tooling and mold.



34 Tie the nylon stockinette and reflect it.



35 Ensure holes of connector are exposed. A hot nail or awl can be used.



36 Reinforce with carbon tape between posts.



37 Pull composite over the socket. Tie off the composite and reflect it for a second layer of composite over mold.



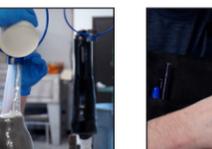
38 Ensure the Tooling posts are exposed.



39 Lubricate screws and install five hole plate. (See Attention #4)



40 Pull bag and laminate as usual. Initially restrict flow to force lamination through the center hole on plate, forcing out air pockets.



41 Toward end of lamination, tape can be placed over five hole plate to squeeze excess resin out of lamination.

Laminating with C12 Housing



42 Pull one layer of vacuum nylon. Tie it off to the anchor and cut away the excess nylon.



43 Pull one layer of PVA Bag. Tie it off to the anchor and cut away the excess PVA.



44 Put Compound 4 or release agent on O-rings. Run even bead of Quik Glue around edge of Lanyard Housing put on anchor in correct position.



45 Remove excess glue and smooth out edge of housing. Put Compound 4 on Slot Tooling and insert in slot. Fill any gaps with putty.



46 Pull nylon stockinette or other material over housing and mold. Tie off to housing using indent at edge housing and reflect.



47 Layup as desired. One layer of composite with distal reinforcement.



48 Reflect vacuum nylon over composite and pull a PVA bag for laminating. Laminate first layer.



49 After cured remove PVA bag, riff first laminate with sandpaper. Prep distal end for connector.

Choose connector and lamination method of choice.

If you are using Coyote's 3 Prong Connector, refer to next 7 steps.



50 If using Three Prong Connector, remove shine and bend arms to fit distal end of socket.



51 Wipe Compound 4 on the faces of black Exterior Tooling and wipe some on the threading on the large white Male Tooling.



52 Place the 3 Prong Connector on distal end of socket, shaping it to the socket.



53 Put QUIK GLUE or 5 minute epox in center of 3 Prong to hold in place.



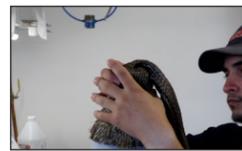
54 Glue connector to distal end of socket. Fill gaps with QUIK GLUE.



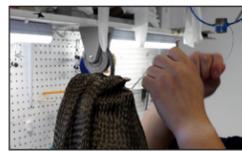
55 Install black screw. Any holes or cracks, you don't want resin to get into, fill with putty.



56 Reinforce with carbon tape around the sides of connector and metal arms against the composite covered cast.



57 Pull composite half way over the socket. Depending on layup for patient.

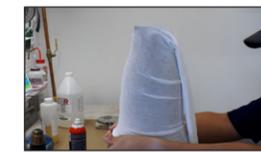


58 Tie the composite off to the connector and reflect it for 2 and a half layers of composite over mold.



59 Leaving only black Exterior Tooling and white Male Tooling visible. Fill in the holes and slots with putty, for easy removal.

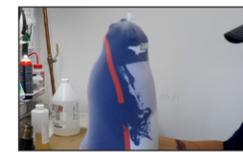
Need more help?
Fabrication videos can also be viewed at www.coyote.us/video



60 Pull, twist, and reflect vacuum nylon over cast.



61 Pull, twist, and reflect nylon stockinette over cast.



62 Add any exterior design material at this time and pull vacuum nylon over it.



63 Pull PVA bag and Laminate



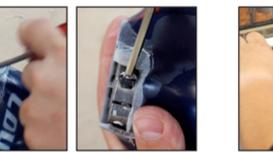
64 Remove socket in traditional fashion or with socket extractor.



65 Flatten distal end, reveal slot dummy, screw in Removal Screw and remove tooling.



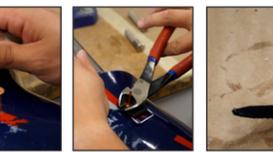
Finish edges, replace black screw with stainless screw.



66 Mark position of Chafe and drill hole.



67 Set rivet and burr on Chafe.



68 Run lanyard through housing and chafe.



69 Mark correct length. Try to leave enough strap reinforcement to aid patient in pushing through slot.



70 Check for prestitching and cut the strap into a point so it helps align with the slot when being engaged.



71 Melt the leading edge of the lanyard with a hot tool to keep it from fraying.



72 Install the lanyard confirming its final length.

Checking the seal



73 Make sure the lanyard plug is fully engaged into the housing with strap through chafe holding it in place.



74 To check the seal on the Suction Lanyard fill the socket with water.



75 Check for any leaks.



76 If there are leaks fill the cracks around the housing with silicone.

Basic 3D Printing Instructions

- 1 Prepare final digital medium for lock attachment with your standard modifications.
- 2 Place digital dummy on distal end of the model in accordance with standard procedure. Digital dummy should be flush with end of socket for best fit.
- 3 Create cavity for drop-in 33mm inner height and 62.5mm diameter. We recommend at least 5 mm socket thickness depending on your printer and materials used. (.stl file is available from Coyote, call 208-429-0026)
- 4 Print your socket as required. Printing instructions are helpful hints on how to work with the lock and connector. Actual printing thickness and materials are the responsibility of the technician and/or practitioner.

Finish

- 5 Wipe down O-ring on Suction Lanyard Drop-In Housing with alcohol before inserting.
- 6 Press lock into place and attach pyramid with supplied 6mm x 22mm screws.
- 7 Attaching pyramid to connector will draw lock into place.
- 8 Use 6x22mm screws provided (see Attention #1 and #5) and Loctite® Blue 242 when attaching pyramid. Before torquing screws to specification hand tighten all four screws. Do not torque single screw by itself. Torque provided connector screws to 10 Nm.



Need assistance?
Call us, we would love to help.
(208) 429-0026

Strap Attachment and Removal

- 1 Put Blue Loctite™ 242 on Swivel Screw threads.
- 2 Finger tighten the Swivel Screw into the liner making sure not to cross thread.
- 3 Once tight, use an Allen wrench to give it a 1/4 turn more.
- 4 Observe slot on lanyard plug.
- 5 Slide Lanyard Plug slot through the slot on the Swivel Screw.
- 6 Press the Strap Clip tooth into the Swivel Screw Slot.
- 7 Make sure it locks the lanyard plug in place.
- 8 The Strap Clip is designed for one time use and should be replaced with a spare if damaged on removal.
- 9 The Strap Clip Removal Tool is designed to aid in the removal of the Strap Clip to remove the lanyard from the liner.
- 10 Make sure both sides of the clip are being spread out evenly by the Removal Tool.
- 11 Push a little with your index finger against the lanyard plug as you are pushing against the Strap Clip with the Removal Tool in the other direction.
- 12 The Removal tool will stay against the plug as the clip slides away.
- 13 If you can't get this to work try dental picks.

Documenting Suction

We view suction not as a component or a code, but as a function. Pistoning and milking can be reduced by maintaining a suction socket when using this lock.

- The suction feature of the lock can be demonstrated and documented very simply.
- Have the amputee step into the lock and seat completely.
- Walk the patient normally.
- Amputee may experience a difference in how the socket feels immediately after some ambulation. Patient feedback should be documented.

* It is the practitioner's responsibility to demonstrate, document, and select appropriate codes for insurance billing.

Detach here and keep everything below with patient records

For tracking purpose, write LOT number (from Packaging) here: _____

ATTENTION

1. Typical Coyote® components use the 6x18mm screws. In atypical setups, longer screws may be needed. Always use screws class 10.9 or better. Make sure screw length fully seats into connector base not just post, longer screws may be needed depending on pyramid and material thickness. (See image 1a)
2. Lay-up instructions are helpful hints on how to work with the lock and connector. Actual lay-ups are responsibility of the technician and/or practitioner.
3. Always use screws provided during lamination to ensure proper depth is created for attachment.
4. Always use Loctite® Blue 242. Before torquing screws to specification hand tighten all four screws. Do not torque single screw by itself. Torque settings of connector screws are 10Nm.

