**CD117L Easy-Off Locking Lanyard**

**Fabrication Instructions**

Weight limit: 265 lbs.

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

*Patent No. 6334876     Made in U.S.A.*

*419 N. Curtis Rd., Boise, Idaho 83706   (208) 429-0026 | www.coyotedesign.com*

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**Installing Anchor and Lock on Mold** - If using casting handle, begin with Step 1. If NOT using casting handle, skip to Step 4.

1. Cast limb with casting handle in place to create shape of lock in mold.
2. Insert anchor in cast handle of mold. Fill mold.
3. Mold and anchor are ready for fabrication.
4. Remove internal components from lock with a 2mm allen wrench. Be careful not to lose springs during removal. Casting Handle users skip to step 11.
5. Place lock on mold. Trace lock.
6. Flatten mold to fit to lock. Do not flatten beyond tracing of lock.
7. Drill a 1/8” diameter hole. Angle hole to help anchor adhesive.
8. Place anchor in lock.
9. Fill hole with Coyote Quick Adhesive or fast-setting epoxy.
10. Place anchor and lock on mold. When glue sets, remove lock.
11. Apply nylon over mold. Reflect and twist nylon around base-of-ring of the anchor.
12. Install 4-hole fab plug. Snug tighten screws only DO NOT overtorque.
13. Place rectangle foam on fab plug.
14. Place lock on mold. Mark desired location of release lever.
15. Refer to transferring alignment section starting with #23.
16. Blister forming: use a piece of flat plastic to compress distal end to reduce grinding at finishing. Drape forming: push in excess plastic on distal end for extra strength and to reduce grinding at finishing.
17. Expose foam rectangle and remove it.
18. Expose foam, using care not to hit posts. Remove socket with socket extractor or traditional methods.
19. Remove 4-hole plug with screw, smooth and polish area.

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**Drape Molding Check Socket** - Drape mold and blister molding instructional videos are available at www.coyotedesign.com/soe-lock.

20. Flatten distal end and polish.
21. Use 5/8” screws provided and Loctite® Blue 242 when attaching pyramid. Torque provided connector screws to 10 Nm. (See Caution #2 and #4).
22. Use Coyote alignment coupler CD106 for alignment during fitting.
23. The hole in the 5 Degree AK Connector is designed for adjusting alignment.
24. Make sure the bottom post of the lock is not blocked by attachment.
25. A hole is pre-drilled in the bottom of the lock to be plugged with the silicone plug during fabrication.
26. The apical disks can be helpful for building the correct height.
27. The better the access to the post bottom the easier finishing is.
28. If you don’t use apical disks make sure your not nesting on the pin post.
29. Push the lock forward to clear the connector you choose.

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**Transferring Alignment**

30. Run bead of Coyote Quick Glue or 5 minute epoxy around inner funnel of lock.
31. Place lock on anchor and ensure release button is in desired location. Smooth out excess adhesive.
32. Place mold and lock into connector in desired location.
33. Make sure the string exit hole is clear of finish connector for string to exit.
34. Use Coyote Quik Glue to attach lock in desired alignment.
35. Creating a buildup behind the lock can help reinforce in the lamination process.
36. Once glue is set remove from jig, place silicone plug and fill gap between lock and 5 Degree Connector with Quik Glue.
37. If silicone plug is under the 5 Hole Plate trim it to fit at the height of posts on the connector plate.

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**Preparation for Lamination**

38. Make sure ORing is in place on lamination dummy insert.
39. Install lamination dummy and orient in the desired direction of lever.
40. Tighten screws. Do not overtorque.
41. Lubricate screw heads with petroleum jelly or clean clay.
42. Full inner PVA bag over mold. Heat bag to form to distal end. Tie PVA bag to anchor twist-ring.
43. Trim excess PVA between twist-ring and o-rings. Keep o-rings clean.
44. Run bead of Coyote Quik Glue or 5 minute epoxy around inner funnel of lock.
45. Place lock on anchor and ensure release lever is in desired location. Smooth out excess adhesive with finger.
Lamination Lay-up

Make Hole for Lanyard Cord

Installing Lever Assembly

Practitioner Instructions

Liner threads vary. Begin threading pin into liner by hand whenever possible. A wrench will be needed in cases of tight threads.

Regardless of threading, always use Loctite® Blue 242 on lock pin threads. If installing into a plastic distal adapter Loctite® Blue 242 should also be used.

If using a flexible inner liner, do not leave plastic over locking, this can cause air leakage and other issues. You should laminate directly over housing. Contact Coyote for more information, or visit the video gallery at coyotedesign.com, see the video titled "CD103FD Flexible Inner Socket with and without Coyote Design Fabrication Dummy."

If you have a pin you cannot install, contact Coyote for a replacement.

Partial vacuum is created between.

Some relevant points to consider:

1. Typically release button is oriented medially.
2. Typical Coyote® components use the 6x18mm screws. In otophysical setups, longer screws may be needed. Always use screws class 10.9 or better.
3. Do not lubricate inside of lock, this will attract debris. If you have a noise issue, it is typically due to seating. Call for technical assistance.
4. Always use screws provided during lamination to ensure proper depth is created for attachment.
5. Never exceed 3 pin spacers.
6. 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.
7. Note number of clicks for engagement. There should be at least 2 to 3 clicks engagement prior to any ambulation and more clicks should occur after a few steps. 5 to 6 clicks (depending on liner) are required for full/ proper seating and engagement.

For tracking purpose, write LOT number (from funnel of lock) here:

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