

Grommet™ Lock

CD104TM

Lock pin with 10mm thread

Weight limit 99 lbs

7450 W Lemhi, Boise, ID 83709
(800) 819-5980 or (208) 429-0026
www.coyotadesign.com



The Grommet™ works in conjunction with a four hole connector of your choice. Connectors are sold separately.

Other lock pin thread options available. Contact Coyote Design.

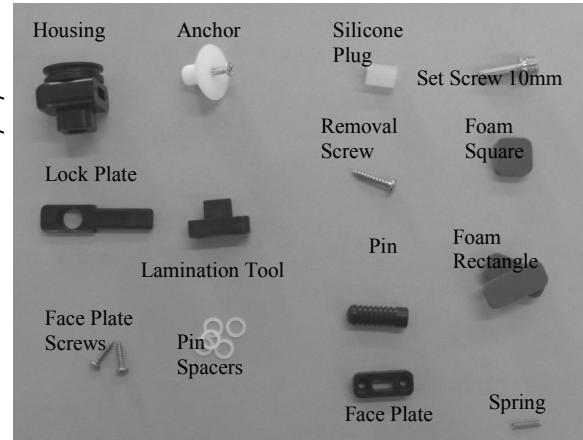
Quick Adhesive is not required for the fabrication of the Grommet, but works very well in this application. Work quickly when using. Quick Adhesive is sold separately.

CD4120 20cc cartridge
CD4180 180cc cartridge

* CD4180 required dispensing gun and mix tips

Thermoforming Grommet™ Lock with Pediatric Fast Four Connector

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Connectors Are Sold Separately



**CD103PFF
Pediatric Fast Four
Connector**

Used in test sockets and definitive sockets when alignment is not an issue



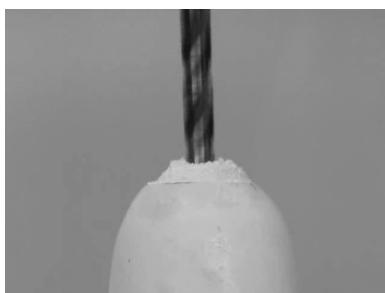
**CD103PAF
Pediatric Alignable
Four Connector**

Used in definitive sockets when customer is needing to offset the alignment.



Remove Lock components from housing. Place housing on mold and trace its location.

Flatten mold where outlined to desired depth.



Drill a hole in the center of the flattened area to seat the anchor.



Fill hole with Quick Adhesive or epoxy and smear a small amount on flattened area



Place anchor screw into hole securing anchor to mold. Fill in any gap with plaster and smooth transition.



Install lamination tool using face plate screws.



**Fit pediatric connector to Grommet™
Place foam rectangle on lamination tool, foam circles on connector posts, and foam square on bottom of lock.**



Place Grommet™ on anchor to mark location of release button. Remove Grommet™. Pull nylon over anchor and mold.



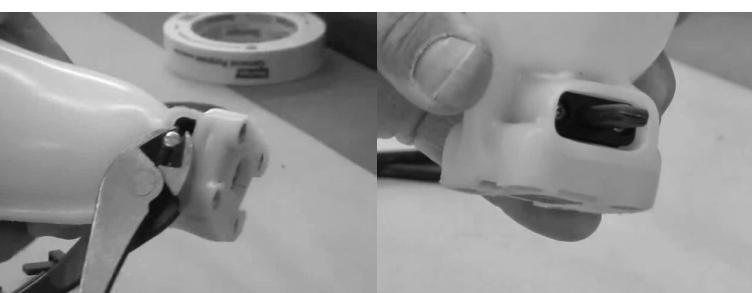
Glue lock to anchor with small amount of glue. Place on anchor. Make sure to align lamination tool with release button location.



Vacuum form as usual. Press plastic into bottom of connector to reinforce it.



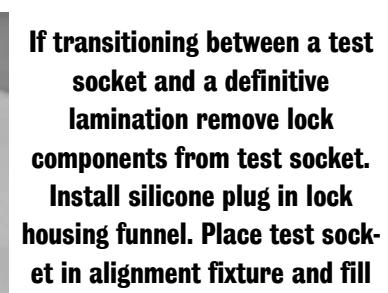
**Carefully sand socket to expose foam placed on lamination tool, connector posts, and bottom of lock.
Remove foam.**



Install removal screw into lamination tool. Remove Lamination tool



Reinstall lock components.



If transitioning between a test socket and a definitive lamination remove lock components from test socket. Install silicone plug in lock housing funnel. Place test socket in alignment fixture and fill as usual. Remove mold. Begin lamination process.

Laminating Grommet™ Lock with Aligned Four Connector

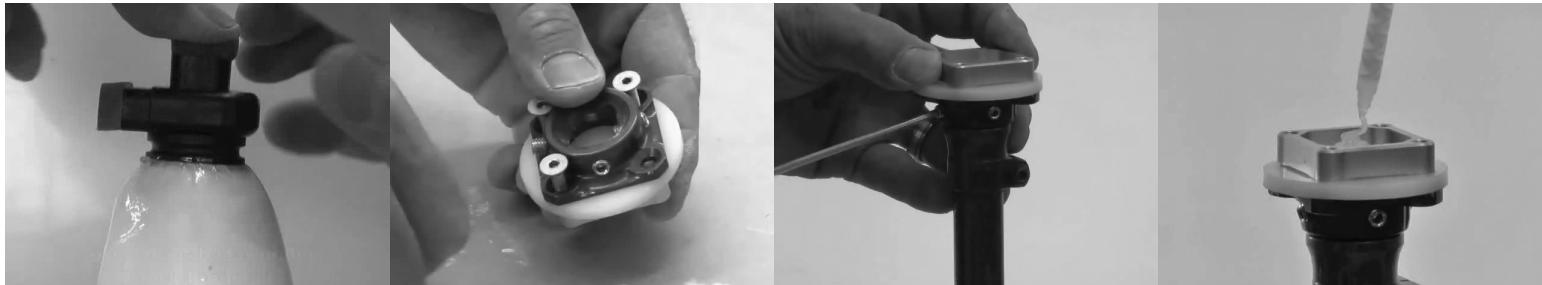
As shown in thermoforming fabrication drill hole large enough for anchor screw. Flatten mold to receive anchor. Seal cast in preferred manner. Install Lamination tool using face plate screws. Place foam rectangle on lamination tool and foam square on bottom of lock.



Glue anchor to cast. Fill in any gap with plaster and smooth transition. Mark location of release button.

Pull PVA bag over cast. Use heat to help ensure PVA fits under lock funnel.

Apply a bead of glue to housing funnel and glue to anchor with lamination tool aligned with release button location mark.



Ensure PVA bag is under lock funnel

Place glue plate on connector. Install pyramid to connector. Do not over tighten screws.

Attach pyramid to endo components. All components should be at neutral. Return mold and lock to alignment fixture.

Check height measurement to ensure height is identical to test socket. Fill connector with glue.



Lower mold and lock onto connector. Allow glue to set.

Remove mold (with lock and connector) from fixture.

Remove screws from connector.

Carefully remove glue plate and begin layup.



Fold carbon and other layup materials between connector posts. As layup material is added, ensure the connector posts remain exposed.

Lube attachment screws. Install Eight Hole Plate. Do not over tighten screws. Install red silicone caps onto screws. Finish Layup

Pull outer PVA bag over mold. Laminate in customary fashion.

Carefully sand to expose the red silicone caps. Expose the foam rectangle over the lamination tool.



Remove foam rectangle and red silicone caps. Install removal screw in lamination tool. Remove lamination tool

Remove Eight Hole Plate. Finish socket as usual.

Slide lock plate into face plate and install spring.

Tighten faceplate screws.

Torque connector screws to 144in lbs.

During attachment of components, make sure screws go entire length of the connector plate.

Use Locktite® 242 on adaptor screw, set screw, pin and connector screws after all adjustments have been made.