



E-R Resin Lamination Recommendations

1. You DO NOT need a sealer for a wet cast. DO NOT bother with that step.
2. Pull Sheet PVA over the cast with shiny side out. Dry with heat gun to help make it a little stronger. (it will moisten up when you pull vacuum but it will not bother the finish)
3. Carefully pull your first layer of fabric over your model, being careful not to break the inner PVA sheet.
4. Remember, with a resin the strength of **E-R Resin**, you do not need as many layers of fabric to achieve better results than other resins currently on the market.
5. DO NOT use Spray Adhesives to hold your carbon strips in place. All they do is seal up the fabric and not allow the resin to fully penetrate. We do not typically use carbon tape anymore.
6. Pull your final PVA sleeve over you layup
7. Keep track of the measurements and layups on the projects you do with our handy chart. It will make future laminations more economical by wasting less resin.
8. Mix 100 grams of Resin to 40 Grams of Hardener to get the amount you totally want.
9. Add 2% pigment and stir by hand or speed mixer, your choice. I keep reusing to the same Paint stir stick for quite awhile.
10. Wait 60 seconds for Epoxy Resin to settle and then pour into your PVA bag.
11. Pull full vacuum and DO NOT immediately squeeze bag. Allow the resin a minute or two to be pulled by the vacuum through your distal fabric and whatever attachments you have put in.
12. Gently start applying a little pressure on the PVA bag above the resin to force the resin downward. Apply it in a manner that allows the resin to flow down the project in a pattern that keeps it fairly equal all of the way around.
13. I saturate the entire project with just my hand pressure.
14. Using a parachute cord, I then will string the socket a couple times around to convince myself I've gotten it all soaked into the fabric.
15. I wait until the resin is getting warm in the PVA bag at the top and then squeeze a little more out and string it one last time. This gives me a smooth finish on the outside surface.
16. Twist the PVA bag at the top of your project, eliminating the bulk of the resin from being a part of the socket. This prevents gassing of the resin in the thick part at the distal end.
17. **There are now two ways to go from here:**
 - A. Allow Project to sit and cure for a couple of hours or overnight if you can, **or**
 - B. When projects starts to cool, superheat it with your heat gun to force it to cure quicker. On a normal AK socket, this takes about ten minutes of heating all around.
 - C. Allow the project to cool completely and then remove it and sand as normal.
18. Trim per your normal trim lines.
19. DO not worry if the socket feels a little more flexible at this point than you want it to be. It will continue to cure for 24 hours to its fullest possible strength.
20. The quickest I have done a socket from start to finish was 2 hours, so fast sockets are not a problem.
21. This resin will quite simply produce the lightest, strongest socket in the Prosthetic and Orthotic Industry, saving you quite a bit in what it actually costs to make a socket.

We do not need to drive a truck over the sockets we make. We just need to make them strong enough for our clients to move out of the path of the oncoming truck. Happy Laminating!!!!!!