

# 3190T EZ Lock Check Socket Instructions

The 3190T EZ lock is a very low-profile pin lock system that can easily be incorporated into a check socket for preliminary fitting.

**NOTICE: The check socket will provide an integral pin guide.**



## Mold and Dummy Prep for Lamination

**Important: Be sure to double check that the pin alignment is satisfactory so as not to introduce a binding alignment situation!**



### 1. Mold Prep:

The mold should be checked to verify that the pin will have an acceptable alignment (Figures to the Left). The distal aspect of the mold needs to have the quadrants aligned so that the A/P M/L alignment can be set, and the area flattened for the dummy (Figures to the Right) Finish cast prior to applying the dummy



### 2. Dummy Preparation:

Apply some tape so the bolt is more centered in the socket adapter lamination dummy hole. (Fig.1)  
 Drill a hole centered on the quadrant marks with a 9mm or 3/8" drill bit so bolt will easily fit inside and not interfere with centering the dummy and verify depth so dummy is flat on the cast. (Fig.2, 3)  
 Nail dummy onto cast centered on the quadrant marks with included brads. (Fig. 4)  
 Apply a foam plug to completely cover end of dummy to aid in sanding plastic flush. (Fig. 5)



Fig. 1



Fig. 2



Fig. 3



Fig. 4



Fig. 5



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### 3. Pulling plastic:

Heat up the check socket plastic so droop is about half the length of the socket, then sprinkle powder on the inside of the plastic and slowly work the plastic (stretch the area to correspond to the distal area where the adapter will be so that the plastic on the very bottom of the socket will end up no thicker than 3mm or 1/8"). The 3-prong socket adapter will take the stress, so the side wall area where the prongs attach need to be thicker than 3mm or 1/8".

**We recommend the use of a rotatable 3 prong socket adapter as there is more surface area to bond to the check socket.**



Fig. 6



Fig. 7



Fig. 8



Fig. 9

At the time the plastic is pulled over the mold and dummy with foam, ensure that the plastic is contacting the dummy and mold so there are no voids/space/gapping.

While plastic is still hot and pliable, hand shape it to mold and dummy on the distal end. (fig. 6)

After the plastic sufficiently cools, roughly trim and remove from vacuum platen and sand down plastic over the dummy so foam can be removed. This will allow you to assess how accurate the distal end is before removing from the mold. (fig. 7-9)

If needed, reheat the plastic on the distal end and remold to ensure total contact and exact shape.

**Note: After reheating, apply nylon hose over the plastic so that the plastic bag used to apply the vacuum does not stick or melt, and will provide an air wick.**

After the distal end is satisfactory, sand down the flat surface of the end of the socket flush to the end of the molding dummy.

Roughen up the plastic where the 3 prongs will be bonded to the socket.





Fig. 10



Fig. 11



Fig. 12



Fig. 13

Assemble the socket adapter with lamination dummy and bolt to the pin guide dummy and check socket – checking for clearance (fig. 10) and where the adapter will need to be contoured (fig. 11). Tape up the pinch bolt area so it can move (fig. 12). Bond the adapter to the socket filling in the voids, covering the adapter (fig. 13).

#### 4. Finishing the socket:



Fig. 14



Fig. 15



Fig. 16

When the adhesive has hardened, remove the bolt from the assembly, and proceed to remove the socket from the mold (fig. 14). After the dummy is removed, ensure that there is no adhesive on the sanded plastic (Fig. 15). Remove the tape from the socket adapter pinch clamp area (fig. 16). Thread the 3190T lock assembly into the socket adapter, and ensure that there is no binding as this will gall the threads. Ensure that the lock is flush with the plastic (fig. 17).



Fig. 17