

## Resin Mixture for Laminated Orthoses Using Acrylic Resin

Total Amount Resin Mixture	Flexible Resin (103 e)	Laminating Resin (80 : 20)	Siegelharz	Hardener Spoons (1,5 g)	Hardener in Grams	
					Average	From - To
400 <sub>g</sub>	250 <sub>g</sub>	150 <sub>g</sub>		5,0 <sub>X</sub>	is 7,5g	5,5g - 9,5g
350 <sub>g</sub>	219 <sub>g</sub>	131 <sub>g</sub>		4,4 <sub>X</sub>	is 6,6g	4,8g - 8,3g
300 <sub>g</sub>	188 <sub>g</sub>	113 <sub>g</sub>		3,8 <sub>X</sub>	is 5,6g	4,1g - 7,2g
250 <sub>g</sub>	156 <sub>g</sub>	94 <sub>g</sub>		3,1 <sub>X</sub>	is 4,7g	3,4g - 5,9g
200 <sub>g</sub>	125 <sub>g</sub>	75 <sub>g</sub>		2,5 <sub>X</sub>	is 3,8g	2,8g - 4,8g
150 <sub>g</sub>	94 <sub>g</sub>	56 <sub>g</sub>		1,9 <sub>X</sub>	is 2,8g	2,1g - 3,6g
100 <sub>g</sub>	63 <sub>g</sub>	38 <sub>g</sub>		1,3 <sub>X</sub>	is 1,9g	1,4g - 2,4g
50 <sub>g</sub>	31 <sub>g</sub>	19 <sub>g</sub>		0,6 <sub>X</sub>	is 0,9g	0,7g - 1,2g
			100 <sub>g</sub>	1,3 <sub>X</sub>		2,0g - 3,0g
			50 <sub>g</sub>	0,7 <sub>X</sub>		1,0g - 1,5g

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- **Hardener proportions according to manufacturer's directions:** Flexible resin 1-2 %, Laminating resin and Siegelharz 2-3 %.
- **Attention:** In order to avoid premature hardening of the lamination, we recommend using a minimum amount of hardener in the Siegelharz.
- For fabrication using 5 layers of perlon stockinette (or 4 layers of perlon stockinette and 1 design fabric). Binding of components using fibreglass band.
- Orthosis soles have 2 layers of carbon fibre tubing which are first impregnated with Siegelharz.