

## SPECIFICATION FOR FEMORAL BALLS

### SPECIFICATION N° MPC/GEN 3

**MATERIAL** Co Cr to BS 7252 Part 4, ASTM F75.

#### TESTING

**FLUORESCENT PENETRANT INSPECTION** Each casting shall be Fluorescent Penetrant Inspected in accordance with **ISO 3452 1994**, and inspected to **ISO 9583 1993 Table A1, Inspection Area B**. All castings will be processed in the 'As Cast' condition.



**MARKING** Please specify your individual requirements. All castings can be marked with the batch number if required.

**FINISH** Castings can be submitted:

1. As Cast - Grit blasted (#60 grit), gates ground flush to **+1 mm**.
2. Fully Finished - Machined and Polished

#### FULLY FINISHED FEMORAL BALLS WILL BE SUPPLIED IN THE FOLLOWING CONDITION

A high lustre, sharp reflection shall be seen on the bearing surface.

Spherical bearing surfaces shall have a diameter with a tolerance **+0/-0.2 mm** unless otherwise requested.

The surface finish of the bearing surface shall have an **Ra** value of not greater than **0.05 µm**

The surface finish of a non-bearing surface shall be grit blasted and have a **Ra** value of not greater than **3.0 µm**.

Sphericity of the ball shall be not greater than **10 µm**, using the method detailed in ISO 7206-2.

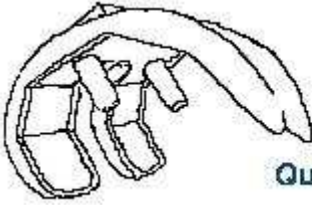
The taper shall be the industry norm of **5° 43' 30"** inclusive, unless otherwise stated.

Available 2 standard sizes: **28 and 32 mm Ø**, and 3 types, short, medium and long neck.

The fully finished components shall be supplied in the non-passivated and non-sterilized condition. This can be provided however, at additional cost.

#### KEY

<b>AQL= ACCEPTED QUALITY LEVELS</b>	<b>CoCr = COBALT CHROME</b>
<b>F/F = FULLY FINISHED</b>	<b>mm = MILLIMETRES</b>
<b>G = GRIT BLASTED</b>	<b>AMIB = AUSTIN MOORE 'I-BEAM'</b>
<b>ST/ST = STAINLESS STEEL</b>	<b>TIR = TOTAL INDICATOR READING</b>



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### CERTIFICATION

Each batch of castings will be supplied with certification, the minimum being a Certificate of Conformity quoting Mechanical Test, Chemical Analysis, Quantity Despatched, Customer Order Number and Customer Part Number. A statement will be included on the Certificate of Conformity to confirm all product supplied has been Fluorescent Penetrant Inspected.

### PACKAGING

‘As Cast’ castings shall be packaged to prevent damage during transit.

‘Fully finished’ casting shall be protected by covering the head with a tubular bandage.

The castings shall be individually sealed in a polythene bag. Each bagged casting shall be placed in a cardboard box separated from each other by bubble pack or equivalent.

Each bag shall be labeled with the following information:

**MPC Batch N°**

**Description**

**Size**

**Material Code "C" (for Cobalt Chrome)**

### LATENT PACKAGING

Up to **3%** latent defects on ‘As Cast’ castings will be accepted by the customer.

A **3 month** liability period applies to all castings from the date of delivery to the customer’s site. This ensures rapid feedback and corrective action of potential problems.

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