

Quality Without Compromise...

SPECIFICATION FOR BI-POLAR CUPS

SPECIFICATION N° MPC/GEN 6

MATERIAL

Co Cr to BS 7252 Part 4, ASTM F75.

HEAT TREATMENT

Castings can be supplied in either:

1. 'As Cast' condition.
2. HIP Condition - Castings shall be heat treated at **1200°C ± 10°C** for **4 hours**, in a pressurized atmosphere of **103 MPa ± 5 MPa**.
3. Heat treated in a vacuum atmosphere at **1200°C** for 4 hours and rapid gas quenched in Nitrogen.

Supply condition is determined by the customer.

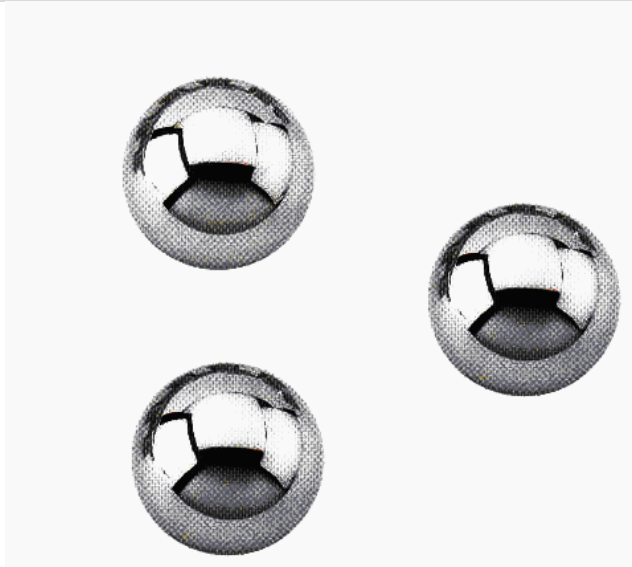
TESTING

RADIOGRAPHY

Castings shall be x-rayed on an AQL 2.5% Level II or **100%** basis. The castings shall have 1 plan shot, and be assessed against **ASTM E192 Plate 2**.

FLUORESCENT PENETRANT INSPECTION

Castings 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 Each x-rayed casting can be identified with a unique number to maintain traceability. All castings can be marked with the batch number if required.

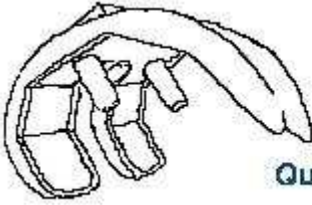
FINISH

Castings can be supplied either:

1. 'As Cast' - Grit blast finish, gates ground flush to plus **0.5 mm**.
2. 'Fully Finished' - To customer requirements.

KEY

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



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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, X-ray Certificate Numbers, 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

All as cast castings shall be packaged to prevent damage during transit.

Each fully finished castings shall be protected by covering the head with a tubular Bandage.

Each casting shall be sealed separately in a polythene bag.

Each bag shall be placed in a cardboard box, separated by bubble pack or equivalent.

Each bag shall be labeled with the following information:

MPC Batch N° and Unique X-Ray Identification.

Description.

Size.

Material Code 'C' (for Cobalt Chrome).

LATENT DEFECTS

Up to 3% latent defects will be accepted by the customer on as cast product only.

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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