



# INSPECTION PROTOCOL (IP)

<b>IP #</b>	IP_20-8060-303-00C_REV_C	<b>Part Name</b> <i>Nom de la pièce</i>	ROSA® OFFST CUP INSERTER SHAFT		
<b>Part Number</b> <i>Numéro de la pièce</i>	20-8060-303-00	<b>Part revision</b> <i>Révision de la pièce</i>	C	<b>Protocol revision</b> <i>Révision du protocole</i>	C

## A. SUPPLIER INSPECTION INSTRUCTIONS / INSTRUCTIONS D'INSPECTION FOURNISSEUR

### a. Specific Tests / Tests spécifiques

Sampling plan as per “Zero Acceptance Number Sampling Plans – Fifth Edition” (by Nicholas L. Squeglia) or based on another standard or 100 % inspection. For Critical to Quality (CTQ) sampling plan, AQL level based on capability study, refer to latest version of the SPPA workbook (GBLF06003)

Feature	Tolerance	Drawing # and/or Area	Sampling Plan	Comments
1. 18.25mm	±0.1	20-8060-303-00 Sheet 1/2 Area B4	100%	Inspect at final inspection
2. 5.7mm	±0.1	20-8060-303-00 Sheet 1/2 Area C4	100%	Inspect at final inspection
3. 5mm	±0.1	20-8060-303-00 Sheet 1/2 Area C1	100%	Inspect at final inspection
4. 6.5mm	±0.5	20-8060-303-00 Sheet 1/2 Area C1	100%	Inspect at final inspection
5. Ø23mm e9	-0.040 / -0.092	20-8060-303-00 Sheet 1/2 Area C3-C4	<b>CTQ</b>	Inspect at final inspection; Not Applicable on item 6 & 7 weld zone
6. 233mm	±0.5	20-8060-303-01 Sheet 1/1 Area A4	100%	Inspect before or after assembly
7. 17.7mm	±0.1	20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
8. 22mm	±0.1	20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
9. Ø4.80mm	+0.05 / +0	20-8060-303-01 Sheet 1/1 Area B8	100%	Use a GO-NOGO gage Acceptance criteria: 4.80 +0.006/-0 (GO), 4.85 +0/-0.006 (NOGO) Inspect before assembly
10. Position of the plunger hole		20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
11. Position of the counter bores hole		20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
12. Position of the keyway		20-8060-303-01 Sheet 1/1 Area C7	100%	Inspect before assembly
13. Ø7mm (diameter of the screw hole)	±0.1	20-8060-303-01 Sheet 1/1 Area D8	100%	Use a GO-NOGO gage Acceptance criteria: 6.9 +0.006/-0 (GO), 7.1 +0/-0.006 (NOGO) Inspect before or after assembly
14. Position of the screw hole		20-8060-303-01 Sheet 1/1 Area D8	100%	Inspect before or after assembly
15. Ø19.2mm (diameter of the inner counter bores)	±0.1	20-8060-303-01 Sheet 1/1 Area D7	100%	Inspect before or after assembly



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Feature	Tolerance	Drawing # and/or Area	Sampling Plan	Comments
16. Position of the inner counter bores		20-8060-303-01 Sheet 1/1 Area D7	100%	Inspect before or after assembly
17. 21.097mm	±0.125	20-8060-303-01 Sheet 1/1 Area D1	100%	Inspect before assembly
18. Ø17mm (inner diameter of shaft)	+0.027 / +0	20-8060-303-01 Sheet 1/1 Area C7	100%	Use a GO-NOGO gage Acceptance criteria: 17 +0.006/-0 (GO), 17.027 +0/-0.006 (NOGO) Inspect before or after assembly
19. Position of the inner diameter		20-8060-303-01 Sheet 1/1 Area C7	100%	Inspect before or after assembly
20. Perpendicularity		20-8060-303-01 Sheet 1/1 Area B3	<b>CTQ</b>	Inspect at final inspection
21. Position of the hole for the implant screw		20-8060-303-01 Sheet 1/1 Area D3	100%	Inspect at final inspection
22. Ø9.525mm (diameter of the hole for the implant screw)	+0.051 / +0	20-8060-303-01 Sheet 1/1 Area C3	100%	Use a GO-NOGO gage pin Acceptance criteria: 9.525 +0.006/-0 (GO), 9.576 +0/-0.006 (NOGO) Inspect before or after assembly
23. 8.890mm	±0.125	20-8060-303-01 Sheet 1/1 Area D3	100%	Inspect before or after assembly
24. Position of the Ø11.906		20-8060-303-01 Sheet 1/1 Area D4	100%	Inspect before or after assembly
25. Ø11.906mm	±0.051	20-8060-303-01 Sheet 1/1 Area D4	100%	Use a GO-NOGO gage pin Acceptance criteria: 11.855 +0.006/-0 (GO), 11.957 +0/-0.006 (NOGO) Inspect before or after assembly
26. 14.975mm	±0.150	20-8060-303-01 Sheet 1/1 Area C2	100%	Inspect before or after assembly
27. Position of the square feature		20-8060-303-01 Sheet 1/1 Area C1	100%	Inspect before or after assembly
28. (2x) 12.522mm	±0.051	20-8060-303-01 Sheet 1/1 Area C1	100%	Inspect before or after assembly
29. Ø4.75mm	±0.025	20-8060-302-03 Sheet 1/1 Area B3	100%	Inspect before assembly
30. 0.75mm	±0.05	20-8060-302-03 Sheet 1/1 Area B3	100%	Inspect before assembly
31. 8.25mm	±0.1	20-8060-302-03 Sheet 1/1 Area B3	100%	Inspect before assembly
32. SR1mm (radius of the sphere)	±0.05	20-8060-302-03 Sheet 1/1 Area C3	100%	Inspect before assembly
33. 7.75mm	±0.10	20-8060-302-03 Sheet 1/1 Area C3	100%	Inspect before assembly



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## **b. Certificate Verification / Vérification Certificats**

<b>Certificates / Certificats</b>	<b>Applicable</b>	<b>Certificates / Certificats</b>	<b>Applicable</b>
General conformity (STD-GEN-01/GEN-02)	<input checked="" type="checkbox"/>	Titanium anodizing (STD-FIN-07)	<input type="checkbox"/>
Electropolish (STD-FIN-01)	<input type="checkbox"/>	Verification of inspection reports (STD-INS-01)	<input checked="" type="checkbox"/>
Glass Bead Blast (STD-FIN-02)	<input checked="" type="checkbox"/>	Laser marking (STD-MAR-01)	<input checked="" type="checkbox"/>
Shot peening (STD-FIN-03)	<input type="checkbox"/>	Material / <i>Matériaux</i> (STD-MAT-01)	<input checked="" type="checkbox"/>
Passivation (STD-FIN-04)	<input checked="" type="checkbox"/>	Heat treatment (STD-TRT-01)	<input checked="" type="checkbox"/>
Polyurethane coating (STD-FIN-05)	<input type="checkbox"/>	Welding / <i>Soudure</i> (STD-WEL-01/WEL-02)	<input checked="" type="checkbox"/>
Low friction chrome coating (STD-FIN-06)	<input type="checkbox"/>	Other :	<input type="checkbox"/>



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## B. ZIMMER CAS INSPECTION / INSPECTION INTERNE (SECTION NOT REQUIRED ☐)

Lot # (ZCAS / Supplier):	Serial #: N/A	Qty. Received:
<input type="checkbox"/> FAL <input checked="" type="checkbox"/> Inspection <input type="checkbox"/> Re-inspection* *Re-inspection instructions are provided on the non-conformity report.		Inspection date: (dd-mmm-yyyy)

### a. Specific tests / Tests spécifiques

Sampling plan as per "Zero Acceptance Number Sampling Plans – Fifth Edition" (by Nicholas L. Squeglia) or based on another standard or 100 % inspection.

Nominal	Tolerance	Drawing # and/or Drawing Area	Sampling Plan	Measuring tool type & ID	Status	
1.	N/A	N/A	N/A	N/A	Pass	Fail
Test results***	N/A			Sample size: N/A	N/A	

Note 1: always specify the unit of measure for each measurement required.

\*\*\* **QF05-10** Inspection Report is completed and attached to IP when multiple measurements are taken

### b. Standard verifications / Vérifications standards

**Note: Please refer to STD-INS-01 for appropriate procedure**

Overall visual verification / *Vérification visuelle générale*

Overall shape verification / *Vérifier la forme générale* (1 item)

Verification of markings / *Vérification du marquage*

Verification of welds / *Vérification des soudures*

Verification of paint / *Vérification de la peinture*

Verification of threads & threaded inserts / *Vérification des inserts filetés et des filets*

Applicable	Accepted	NC
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

### c. Inspection Comments / Commentaires sur l'inspection:


Qty conform / conforme:	Qty. non-conform / non-conforme:	NC #:
Performed by / Par: Name & signature		Date: (dd-mmm-yyyy)



# INSPECTION PROTOCOL (IP)

## d. Distribution Labeling / Étiquette de distribution

Verification of the labels needed? / Vérification des étiquettes requise?		Yes	No
If yes, complete section below and attach a copy of the printed labels to the signed protocol / Si oui, compléter la section et attacher une copie de chaque étiquette au protocole signé		<input checked="" type="checkbox"/>	<input type="checkbox"/>
Label name	Qty printed	Qty scrapped	
LBA-20-8060-303-00			
PLACE A COPY OF THE LABEL HERE PLACER UNE COPIE DE L'ÉTIQUETTE ICI			
LBA-20-8060-303-00			
PLACE A COPY OF THE LABEL HERE PLACER UNE COPIE DE L'ÉTIQUETTE ICI			
Verified by: Name & signature	Date: (dd-mmm-yyyy)		

## Revision History / Historique des révisions

Part Revision <i>Révision pièce</i>	IP Revision <i>Révision PI</i>	Date (dd-mmm-yyyy )	Description
A	A	28-OCT-2020	Initial Production Unit release.
B	A	19-JAN-2021	Updated tolerance for specifications: Supplier section A.a: IV, V, VIII & XXV
B	B	27-MAY-2021	Added clarification about features that can be inspected before or after assembly in section A.a.



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C	A	16-JUN-2021	Updated inspection protocol form Updated part revision Updated specific test # 5, 10 and 11 in section A.a. Updated test in Zimmer CAS section B.b.
C	B	6-OCT-2022	Updated document template Added LBA and LBB labels to section B.d.
C	B- C	25-MAY-2023	Updated form to reflect new template In table a. (Specific Tests / Tests spécifiques) corrected typo in Specific Test #10 by adding missing MMC symbol 

typo correction: corrected from rev ''B''  
to rev ''C'' in the revision table

**Approval / Approbation**

DocuSigned by Basim Hachem  
Btk | I have reviewed this document  
02-Jun-2023 | 11:52:19 EDT

02-Jun-2023 | 11:52:38 EDT

	Printed name and Signature / Nom et signature	Date
Production	Basim Hachem  <small>DocuSigned by Basim Hachem</small> <small>I have reviewed this document</small> <small>26-May-2023   10:01:38 EDT</small> <small>FA2E079121B842E0A5D3D4D85EFD7311</small>	26-May-2023   10:01:55 EDT
Design	Jérémie Ménard  <small>DocuSigned by Jeremie Menard</small> <small>I approve this document</small> <small>26-May-2023   09:44:42 EDT</small> <small>C21ECF2EEA534D349F848D5559871E33</small>	26-May-2023   09:44:45 EDT