

IP#	IP_20-8060-303-00C_REV_C		Part Name R Nom de la pièce			è OFFS	OFFST CUP INSERTER SHAFT		
	umber ro de la pièce	20-8060-303-00		Part revision Révision de la	pièce	С	Protocol revision Révision du protocole	С	

A. SUPPLIER INSPECTION INSTRUCTIONS / INSTRUCTIONS D'INSPECTION FOURNISSEUR

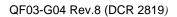
a. Specific Tests / Tests spécifiques

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	СТQ	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	⊕ Ø 0.1 M A D	20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
11. Position of the counter bores hole	⊕ Ø 0.1 C	20-8060-303-01 Sheet 1/1 Area B8	100%	Inspect before assembly
12. Position of the keyway	⊕ 0.1 A	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	⊕ ∅ 0.2 M F	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



Feature	Tolerance	Drawing # and/or Area	Sampling Plan	Comments
16. Position of the inner counter bores	⊕ Ø 0.05 M F	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	⊕ Ø 0.1 M A	20-8060-303-01 Sheet 1/1 Area C7	100%	Inspect before or after assembly
20. Perpendicularity	0.125 A	20-8060-303-01 Sheet 1/1 Area B3	CTQ	Inspect at final inspection
21. Position of the hole for the implant screw	⊕ Ø <u>0</u> .3 A	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	⊕ 0.102 M EM B	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	⊕ 0.051 M EM	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





b. Certificate Verification / Vérification Certificats

Certificates / Certificats	Applicable	Certificates / Certificats	Applicable
General conformity (STD-GEN-01/GEN-02)	×	Titanimum anodizing (STD-FIN-07)	
Electropolish (STD-FIN-01)		Verification of inspection reports (STD-INS-01)	
Glass Bead Blast (STD-FIN-02)		Laser marking (STD-MAR-01)	
Shot peening (STD-FIN-03)		Material / Matériaux (STD-MAT-01)	
Passivation (STD-FIN-04)	×	Heat treatment (STD-TRT-01)	
Polyurethane coating (STD-FIN-05)		Welding / Soudure (STD-WEL-01/WEL-02)	
Low friction chrome coating (STD-FIN-06)		Other:	



B. 7	ZIMMER CAS INSPECTION	INSPECTION INTERNE	(SECTION NOT REQUIRED)
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Lot # (ZCAS / Supplier):		#: N/A	Qty. Received:
☐ FAL ☐ Inspection ☐ Re-inspection* *Re-inspection instructions are provided on the non-conformity reports.		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		Stat	ius
1.	N/A	N/A	N/A	N/A		Pass	Fail
Test results***	N/A			Sample N/A size:		N/A	

1.	N/A	N/A	N/A	N/A			Pass	Fall	
Test results***	N/A			Sample size:	N/A		N/A		
Note 1: always speci	ify the unit of m	neasure for each mea	asurement requi	red.					
*** QF05-10 Inspecti	ion Report is c	ompleted and attache	ed to IP when m	ultiple meas	surem	ents are taker	1		
b. Standard verification	ations / Vérifi	cations standards							
Note: Please refer	Note: Please refer to STD-INS-01 for appropriate procedure Applicable Accepted NC								
Overall visual verific	cation / Vérifica	ation visuelle généra	le				×		
Overall shape verification / Vérifier la forme générale (1 item)							×		
Verification of markings / Verification du marquage ☑							X		
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 □									
c. Inspection Com	ments / Comn	nentaires sur l'insp	ection:						
Qty conform / conforme: Qty. non-conform / non-conforme: NC #:						:			
Performed by / Pa Name & signature						Date: (dd-mmm-yyyy)			
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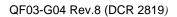


d. <u>Distribution Labeling / Étiquette de distribution</u>

Verification of the labels needed? / Vérification des étiquettes requise?	1 /	Yes	No
If yes, complete section below and attach a copy of the printed labels to the signed Si oui, compléter la section et attacher une copie de chaque étiquette au protocole	\boxtimes		
Label name	Qty printed	Qty sc	rapped
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 LASEL HERE PLACER UNE COPIE DE L'ÉTIQUETTE ICI			
Verified by: Name & signature	Date: (dd-mmm-yyyy)		

Revision History / Historique des révisions

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





С	А	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.
О	В	6-OCT-2022	Updated document template Added LBA and LBB labels to section B.d.
С	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

Approval / Approbation

2:38	EDT
,	2:38

	Printed name and Signature / Nom et signature	Date
Production	Basim Hachem DocuSigned by Basim Hachem 1 have reviewed this document 22-May-2023 10.01.36 EDT	26-Мау-2023 10:01:55 EDT
Design	Jérémie Ménard DocuSigned by Jeremie Menard Jeremie Menard Lapprove this document 28-May-2023 09-44-42 EDT	26-мау-2023 09:44:45 ЕПТ