



Designation: **F2989 – 13 F2989 – 21**

Standard Specification for Metal Injection Molded Unalloyed Titanium Components for Surgical Implant Applications¹

This standard is issued under the fixed designation F2989; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

1. ~~Scope~~ Scope*

1.1 This specification covers the chemical, mechanical, and metallurgical requirements for three grades of metal injection molded (MIM) unalloyed titanium components in two types to be used in the manufacture of surgical implants.

1.2 The Type 1 MIM components covered by this specification may have been densified beyond their as-sintered density by post-sinter processing.

1.3 Values in either inch-pound or SI are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independent of the other. Combining values from the two systems may result in ~~non-conformance~~ nonconformance with the specification.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate ~~safety~~ safety, health, and health environmental practices and determine the applicability of regulatory limitations prior to use.*

1.5 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- [B243 Terminology of Powder Metallurgy](#)
- [B311 Test Method for Density of Powder Metallurgy \(PM\) Materials Containing Less Than Two Percent Porosity](#)
- [B367 Specification for Titanium and Titanium Alloy Castings](#)
- [B923 Test Method for Metal Powder Skeletal Density by Helium or Nitrogen Pycnometry](#)
- [E3 Guide for Preparation of Metallographic Specimens](#)
- [E8/E8M Test Methods for Tension Testing of Metallic Materials](#)
- [E29 Practice for Using Significant Digits in Test Data to Determine Conformance with Specifications](#)
- [E165 Practice for Liquid Penetrant Testing for General Industry](#)
- [E407 Practice for Microetching Metals and Alloys](#)
- [E539 Test Method for Analysis of Titanium Alloys by Wavelength Dispersive X-Ray Fluorescence Spectrometry](#)

¹ This specification is under the jurisdiction of ASTM Committee F04 on Medical and Surgical Materials and Devices and is the direct responsibility of Subcommittee F04.12 on Metallurgical Materials.

Current edition approved April 1, 2013; Nov. 1, 2021. Published April 2013; November 2021. Originally approved in 2012. Last previous edition approved in 2012 as F2989F2989 – 13, – 12. DOI: 10.1520/F2989-13.10.1520/F2989-21.

² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard

- E1409 Test Method for Determination of Oxygen and Nitrogen in Titanium and Titanium Alloys by Inert Gas Fusion
- E1447 Test Method for Determination of Hydrogen in Titanium and Titanium Alloys by Inert Gas Fusion Thermal Conductivity/Infrared Detection Method
- E1941 Test Method for Determination of Carbon in Refractory and Reactive Metals and Their Alloys by Combustion Analysis
- E2371 Test Method for Analysis of Titanium and Titanium Alloys by Direct Current Plasma and Inductively Coupled Plasma Atomic Emission Spectrometry (Performance-Based Test Methodology)
- E2626 Guide for Spectrometric Analysis of Reactive and Refractory Metals (Withdrawn 2017)³
- E2994 Test Method for Analysis of Titanium and Titanium Alloys by Spark Atomic Emission Spectrometry and Glow Discharge Atomic Emission Spectrometry (Performance-Based Method)
- F67 Specification for Unalloyed Titanium, for Surgical Implant Applications (UNS R50250, UNS R50400, UNS R50550, UNS R50700)
- F601 Practice for Fluorescent Penetrant Inspection of Metallic Surgical Implants
- F629 Practice for Radiography of Cast Metallic Surgical Implants
- ~~IEEE/ASTM SI 10 American National Standard for Use of the International System of Units (SI): The Modern Metric System~~
Metric Practice
- 2.2 *ISO Standards:*⁴
- ISO 5832-3 Implants for Surgery—Metallic Materials—Part 3: Wrought Titanium 6-Aluminum 4-Vanadium Alloy
- ISO 6892 Metallic Materials—Tensile Testing at Ambient Temperature
- ISO 9001 Quality Management Systems—Requirements
- ISO 13485 Medical Devices—Quality Management Systems—Requirements for Regulatory Purpose
- 2.3 *Aerospace Material Specifications:*⁵
- AMS 2249 Chemical Check Analysis Limits, Titanium and Titanium Alloys
- 2.4 *MPIF Standards:*⁶
- Standard 10 Determination of the Tensile Properties of Powder Metallurgy Materials
- Standard 42 Determination of Density of Compacted or Sintered Powder Metallurgy Product
- Standard 50 Preparing and Evaluating Metal Injection Molded Sintered/Heat Treated Tension Specimens
- Standard 63 Density Determinations of MIM Components (Gas Pycnometry)
- Standard 64 Terms Used in Metal Injection Molding

3. Terminology

3.1 Definitions of powder metallurgy and MIM terms can be found in Terminology **B243** and MPIF Standard 64. Additional descriptive information is available in the Related Material Section of Vol. 02.05 of the *Annual Book of ASTM Standards*.

3.2 The materials produced by means of the metal injection molding process are designated by the prefix, “MIM”. prefix “MIM,” followed by the appropriate designation for the alloy grade. The MIM designates that it was made by metal injection molding.

3.3 *Definitions of Terms Specific to This Standard:*

3.3.1 *absolute density, n*—the value of density used to characterize a powder material with a particular chemical composition as if it were a fully dense material, completely free of porosity.

3.3.1.1 *Discussion—*

For the purposes of this specification, the skeletal density (also referred to as pycnometer density) measured on the raw material powders using the pycnometry method of Test Method **B923** shall be used to represent the absolute density of the particular chemical composition.

3.3.2 *debinding, v*—a step between molding and sintering where the majority of the binder used in molding is extracted by heat, solvent, a catalyst, or other techniques.

3.3.3 *feedstock, n—in metal injection molding*, a moldable mixture of metal powder and binder.

3.3.4 *feedstock batch, n*—a specified quantity of feedstock made up of the same lot of metallic powders and the same lot of binder materials mixed under the same conditions at essentially the same time.

³ The last approved version of this historical standard is referenced on www.astm.org.

⁴ Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>.

⁵ Available from SAE International (SAE), 400 Commonwealth Dr., Warrendale, PA 15096-0001, <http://aerospace.sae.org>.

⁶ Available from Metal Powder Industries Federation (MPIF), 105 College Rd. East, Princeton, NJ 08540, <http://www.mpif.org>.

3.3.5 *lot, n*—a specified quantity of components made up of the same batch of feedstock, debound, sintered, and post-processed under the same conditions at essentially the same time.

3.3.6 *metal injection molded component, n*—product fabricated by a metal injection molding process consisting of mixing metal powders with binders to make a feedstock, introducing this feedstock into a mold by injection or other means, debinding to remove the binders, and sintering.

3.3.7 *near net component, n*—a component that meets dimensional tolerance as built with little post processing.

3.3.8 *net component, n*—a component that meets dimensional tolerance as built with no post processing.

3.3.9 *pre-alloyed powder, n*—powder composed of two or more elements that are alloyed in the powder manufacturing process in which the particles are of the same nominal composition throughout.

3.3.10 *relative density, n*—the density ratio, often expressed as a percentage, of the density of a porous material to the absolute density of the same material, completely free of porosity.

3.3.11 *sintering, v*—the metallurgical bonding of particles in a MIM component resulting from a thermal treatment at a temperature below the melting point of the main constituent.

3.3.12 *Type 1, n*—a MIM component that may have been densified beyond its as-sintered density by post-sinter processing.

3.3.13 *Type 2, n*—a MIM component that shows the as-sintered density and was not densified after sintering.

4. Ordering Information

4.1 Include with inquiries and orders for material under this specification the following information:

4.1.1 Quantity,

4.1.2 ASTM specification and date of issue,

4.1.3 Grade (MIM 1, MIM 2, or MIM 3),

4.1.4 Type (1 or 2),

4.1.5 Units to be certified—SI or Inch-Pounds, inch-pound,

4.1.6 Component configuration (engineering drawing or 3D solid model, or both) and dimensional requirements,

4.1.7 Condition (5.2),

4.1.8 Mechanical properties (if applicable),

4.1.9 Finish (5.2),

4.1.10 Special tests (Sections 9, 10, and 11), if any, and

4.1.11 Other requirements.

5. Materials and Manufacture

5.1 Components conforming to this specification shall be produced by the metal injection molding process using unalloyed metal powders with major elemental composition meeting the chemical requirements of Table 1.

TABLE 1 Chemical Composition

Composition for both Type 1 and Type 2 Composition, % (mass/mass)			
Element	Grade MIM 1	Grade MIM 2	Grade MIM 3
Nitrogen, max	0.03	0.03	0.05
Carbon, max	0.08	0.08	0.08
Hydrogen, max	0.015	0.015	0.015
Iron, max	0.20	0.30	0.30
Oxygen, max	0.18	0.25	0.30
Cobalt ^A	<0.1	<0.1	<0.1
Other Elements Each, ^B max	0.10	0.10	0.10
Other Elements Total, ^B max	0.4	0.4	0.4
Titanium ^C	Balance	Balance	Balance

^A Refer to X1.5.

^B Other elements need not be reported unless the concentration level is greater than 0.1 % each, or 0.4 % total. Other elements may not be added intentionally. Other elements may be present in titanium or titanium alloys in small quantities and are inherent to the manufacturing process. In titanium these elements typically include aluminum, vanadium, tin, chromium, molybdenum, niobium, zirconium, hafnium, bismuth, ruthenium, palladium, yttrium, copper, silicon, tantalum, nickel, boron, manganese, and tungsten.

^C The percentage of titanium is determined by difference and need not be determined or certified.

5.2 Post-sintering operations may be employed to achieve the desired density, shape, size, surface finish, or other component properties. The post-sintering operations shall be agreed upon between the supplier and purchaser.

5.3 The condition and finish of the components shall be agreed upon between the supplier and purchaser.

6. Chemical Requirements

6.1 The components supplied under this specification shall conform to the chemical requirements in **Table 1**. The supplier shall not ship components with chemistry outside the requirements specified in **Table 1**.

<https://standards.iteh.ai/catalog/standards/sist/d808150e-0ff3-46c6-98e0-bda82ece8609/astm-f2989-21>

6.2 Chemical analysis of the finished component or a representative sample shall be used for reporting all chemical requirements. Any representative sample shall be produced from the same feedstock batch, debound, sintered, and post processed concurrently with the finished components that it represents.

6.2.1 Requirements for the major and minor elemental constituents are listed in **Table 1**. Also listed are important residual elements. The percentage of titanium is determined by difference and need not be determined or certified.

6.2.2 All commercial metals contain small amounts of elements other than those which are specified. It is neither practical nor necessary to specify limits for unspecified elements, whether residual elements or trace elements, that can be present. The producer is permitted to analyze for unspecified elements and is permitted to report such analyses. The presence of an unspecified element and the reporting of an analysis for that element shall not be a basis for rejection.

6.2.3 Intentional elemental additions other than those specified in **Table 1** are not permitted.

6.2.4 Analysis for elements not listed in **Table 1** is not required to verify compliance with this specification.

6.3 *Product (Check) Analysis:*

6.3.1 ~~Product analysis tolerances do not broaden the specified heat analysis requirements but cover~~ The product (check) analysis tolerances shall conform to the product tolerances in **Table 2** variations in the measurement of per AMS 2249 and Specification **B367** chemical content between laboratories. The product analysis tolerances shall conform to the product tolerances in. Product analysis tolerances do not broaden the specified heat (ladle or ingot) analysis requirements **Table 2**.but cover variations between laboratories in the measurement of chemical content.

TABLE 2 Product (Check) Analysis Tolerance^A

Element	Limit or Maximum of Specified Range %, (mass/mass)	Tolerance Under the Minimum or Over the Maximum Limit ^B
Nitrogen	up to 0.05	0.02
Carbon	0.10	0.02
Hydrogen	up to 0.015	0.002
Iron	up to 0.25	0.10
Iron	over 0.25	0.15
Oxygen	up to 0.20	0.02
Oxygen	over 0.20	0.03
Cobalt ^C	0.10	0.02
Other (each)	0.10	0.02

^A See AMS 2249.

^B Under the minimum limit is not applicable for elements where only a maximum percentage is indicated.

^C See Specification B367.

6.3.2 Product (check) analysis limits are not for supplier's/producer's use at supplier's/producer's acceptance testing. Product analysis limits are not permitted to be applied to ladle or ingot analysis. The supplier/producer shall not ship material that is outside the limits specified in [Table 1](#).

6.3.3 ~~The~~ product analysis is (check) analysis is one performed by the purchaser or supplier of the metal after it has been worked into semi-finished or finished forms or fabricated into parts, and is either for the purpose of verifying the composition of the manufacturing lot or to determine variations in the composition within the lot. ~~Acceptance or rejection of the manufacturing lot of components may be made by the purchaser on the basis of this product analyses.~~ ~~manufacturing lot.~~ In the analysis of finished parts, these values do not apply to elements whose percentage can be varied by fabricating techniques employed (for example oxygen, nitrogen, and hydrogen) unless the sample is sufficiently large to produce a reliable result.

6.3.4 Acceptance or rejection of a heat or manufacturing lot of components may be made by the purchaser on the basis of this product (check) analysis. Product (check) analysis outside the tolerance limits allowed in [Table 2](#) is cause for rejection of the product. A referee analysis may be used if agreed upon by the supplier and purchaser.

6.3.5 Samples for ~~chemical~~ product (check) analysis shall be representative of the component being tested. The utmost care shall be used in sampling titanium for chemical analysis because of its affinity for ability to react with elements such as oxygen, nitrogen, and hydrogen. ~~In~~ Therefore, when cutting samples for analysis, therefore, the operation should be carried out insofar as possible in a dust-free atmosphere. Cutting tools should be clean and sharp. Samples for analysis should be stored in suitable containers.

6.3.4 Product analysis outside the tolerance limits allowed in [Table 2](#) is cause for rejection of the product. A referee analysis may be used if agreed upon by the supplier and purchaser.

6.3.6 For referee purposes, use Test Methods [E539](#), [E1409](#), [E1447](#), [E1941](#), [E2994](#), and [E2371](#) and Guide [E2626](#) or other analytical methods agreed upon between the purchaser and the supplier.

7. Mechanical Requirements

7.1 Tensile Properties:

7.1.1 The components supplied under this specification shall conform to the mechanical property requirements in [Table 3](#).

7.1.2 Test specimens shall be taken from a MIM component if possible, or from a representative sample or molded tensile specimen. A representative sample or molded tensile specimen may only be used only if the component configuration is such that a tensile specimen cannot be obtained from the component.

7.1.3 The number of tensile tests should be agreed upon between the supplier and the purchaser.

7.2 Representative samples or molded tensile specimens shall be produced from the same feedstock batch, debound, sintered, and post processed concurrently with the finished components that they represent.