



Designation: **F86—12a F86 – 13**

Standard Practice for Surface Preparation and Marking of Metallic Surgical Implants¹

This standard is issued under the fixed designation F86; 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 reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This practice provides a description of surface characteristics, methods of surface preparation, and methods of marking for metallic surgical implants. Marking nomenclature and neutralization of endotoxin are not specified in this practice (see **X1.3**). Surface requirements and marking methods included in the implant specification shall take precedence over requirements listed in this practice, where appropriate.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *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 and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

[A380 Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems](#)

[A967 Specification for Chemical Passivation Treatments for Stainless Steel Parts](#)

[B600 Guide for Descaling and Cleaning Titanium and Titanium Alloy Surfaces](#)

[F983 Practice for Permanent Marking of Orthopaedic Implant Components](#)

3. Significance and Use

3.1 The surface treatments documented in this practice are intended to improve the corrosion resistance of metallic surgical implants manufactured from iron, cobalt, titanium, and tantalum base materials.

3.2 Iron particles, ceramic media, and other foreign particles may become smeared over or imbedded into the surface of implants during processing operations such as forming, machining, tumbling, bead blasting, and so forth. These particles should be removed to minimize localized rust formation and superficial blemishes.

3.3 The various chemical and electrochemical surface treatments specified in this practice are intended to remove objectionable surface contaminants and to restore maximum corrosion resistance to the passive oxide film.

3.4 The need for an additional implant surface treatment such as secondary passivation in nitric acid should be evaluated for localized implant surfaces that have electrochemical or laser product markings created after the final surface treatment.

4. Description of Acceptable Surface Characteristics

4.1 Metallic implants, when inspected in accordance with this practice, shall be free of surface imperfections such as toolmarks, nicks, scratches, cracks, cavities, burrs, and other defects that would impair the serviceability of the device. The surfaces shall be cleaned to minimize the presence of foreign material.

¹ This practice 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.

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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

4.2 Specific finish requirements such as texture, surface roughness, or additional surface treatments shall be included in the implant production specification.

4.3 The implants shall be given an appropriate final surface treatment according to Section 6.

5. Cleaning

5.1 The surface of the implants shall be cleaned to minimize foreign material.

5.2 The cleaning operations used shall relate to the following as appropriate:

5.2.1 A method such as organic solvent degreasing for the removal of oils, greases, and other loose surface contaminants.

NOTE 1—Anhydrous methanol and other solvents known to cause environmentally assisted cracking of titanium and its alloys should be avoided.

5.2.2 A method such as one of the following for the removal of adherent foreign material, if necessary.

5.2.2.1 Hot alkaline cleaner used as recommended.

5.2.2.2 Alkaline cleaner applied electrochemically as recommended.

NOTE 2—Avoid cathodic cleaning of metals known to be susceptible to hydrogen contamination and anodic cleaning of metals known to be susceptible to pitting. In addition, testing to confirm that acidic cleaning will not affect the mechanical properties of alloys susceptible to hydrogen contamination effects should be considered.

5.2.2.3 Ultrasonically agitated cleaning agent.

5.2.3 An acidic cleaning process may be used. For titanium, titanium alloys, and tantalum, some possible cleaning processes may be found in Guide B600.

NOTE 3—Before an acidic cleaning, degreasing shall be considered where appropriate to make the acidic cleaning effective in a uniform manner.

5.2.3.1 If acidic cleaning methods are used, this shall be stated in the implant production specification.

5.3 A neutralizing treatment shall be carried out where appropriate.

5.4 An adequate rinsing operation shall be carried out.

5.5 An adequate drying cycle shall follow.

6. Final Surface Treatment

6.1 Implants shall be given a final surface treatment before they are packaged. A number of different surface treatments are acceptable, including acid treatment, electropolishing, anodizing, and oxidation. The following surface treatments should not be considered restrictive:

6.2 Final nitric acid surface treatments are as follows:

6.2.1 Immerse in 20 to 45 volume % nitric acid (specific gravity 1.197 to 1.285) at room temperature for a minimum of 30 min. The room temperature passivation treatment is equivalent to the Nitric 2 treatment at a temperature range from 70 to 90°F (21 to 32°C) in Specification A967. For an accelerated process, a 20 to 25 volume % acid solution, heated to at a temperature in the range from 120 to 140°F (49 to 60°C), may be used for a minimum of 20 min. (See Specification A967 and Practice A380).

6.2.1.1 This treatment provides passivation by surface oxidation and is able to dissolve certain foreign material that might be present from previous operations; it is therefore particularly recommended when no other treatments take place that would remove such foreign material.

6.2.2 Use a neutralizing procedure for product designs in which acidic liquid could be trapped.

6.2.3 A thorough water rinsing process and a drying process are essential.

6.3 A final electropolishing procedure can provide passive surface conditions and cleansing from certain foreign material for stainless steel, cobalt, titanium, and tantalum alloys (see Specification A967).

6.4 Electrochemical anodizing processes for titanium and tantalum base materials can provide similar passivating and cleaning effects as the electrochemical polishing procedures have. Alternative oxidation treatments can render passive surfaces as well.

6.5 If acceptable alternative surface treatments for implants are used, these treatments should be specified in the production procedure documentation.

6.6 If marking of implants is performed after the final surface treatment, it must be evaluated whether a secondary passivation treatment is necessary or not.

7. Product Marking

7.1 Markings are applied to the implant surfaces to provide traceability if the size and configuration of the implant are sufficient for such markings. To minimize potential adverse effects, it is necessary to use an appropriate marking procedure and technique and to select a suitable location for the marking of the implant.

7.1.1 Details on marking are found in Practice F983.