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**Nguyen et al.**

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(54) **ORTHOPEDIC IMPLANTS AND METHODS**

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(52) **U.S. Cl.**

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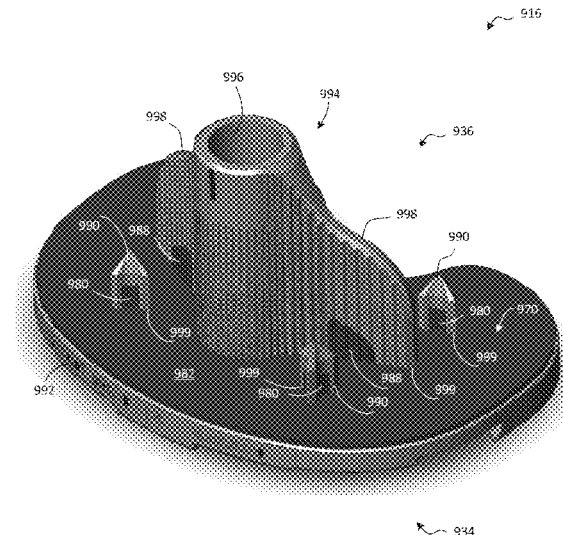
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(57) **ABSTRACT**

A prosthesis for replacing a natural articular surface on a bone may have a joint facing side with an articular surface, a bone anchoring side with a bone engagement surface, and a bone engagement pad secured to at least part of the bone engagement surface. The bone engagement pad may have a transverse portion extending transverse to a length of the bone, and one or more protruding portions extending generally perpendicular to the transverse portion. The transverse portion may have a pad bone-facing surface with a first porosity level, and a pad joint-facing surface on an opposite side of the transverse portion from the pad bone-facing surface, with a second, lower porosity level. The bone engagement surface may be formed via a first manufacturing process selected from the group consisting of forging, milling, and casting. The bone engagement pad may be formed via an additive manufacturing process.

**25 Claims, 10 Drawing Sheets**



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- (52) **U.S. Cl.**  
 CPC ..... *A61F 2/30734* (2013.01); *A61F 2/389* (2013.01); *A61F 2/3859* (2013.01); *A61F 2/4644* (2013.01); *A61F 2002/3092* (2013.01); *A61F 2002/30604* (2013.01); *A61F 2002/30968* (2013.01); *A61F 2310/00023* (2013.01)
- (58) **Field of Classification Search**  
 USPC ..... 623/20.35, 20.36, 22.4, 22.41, 23.11, 623/23.12, 20.29; 606/89  
 See application file for complete search history.

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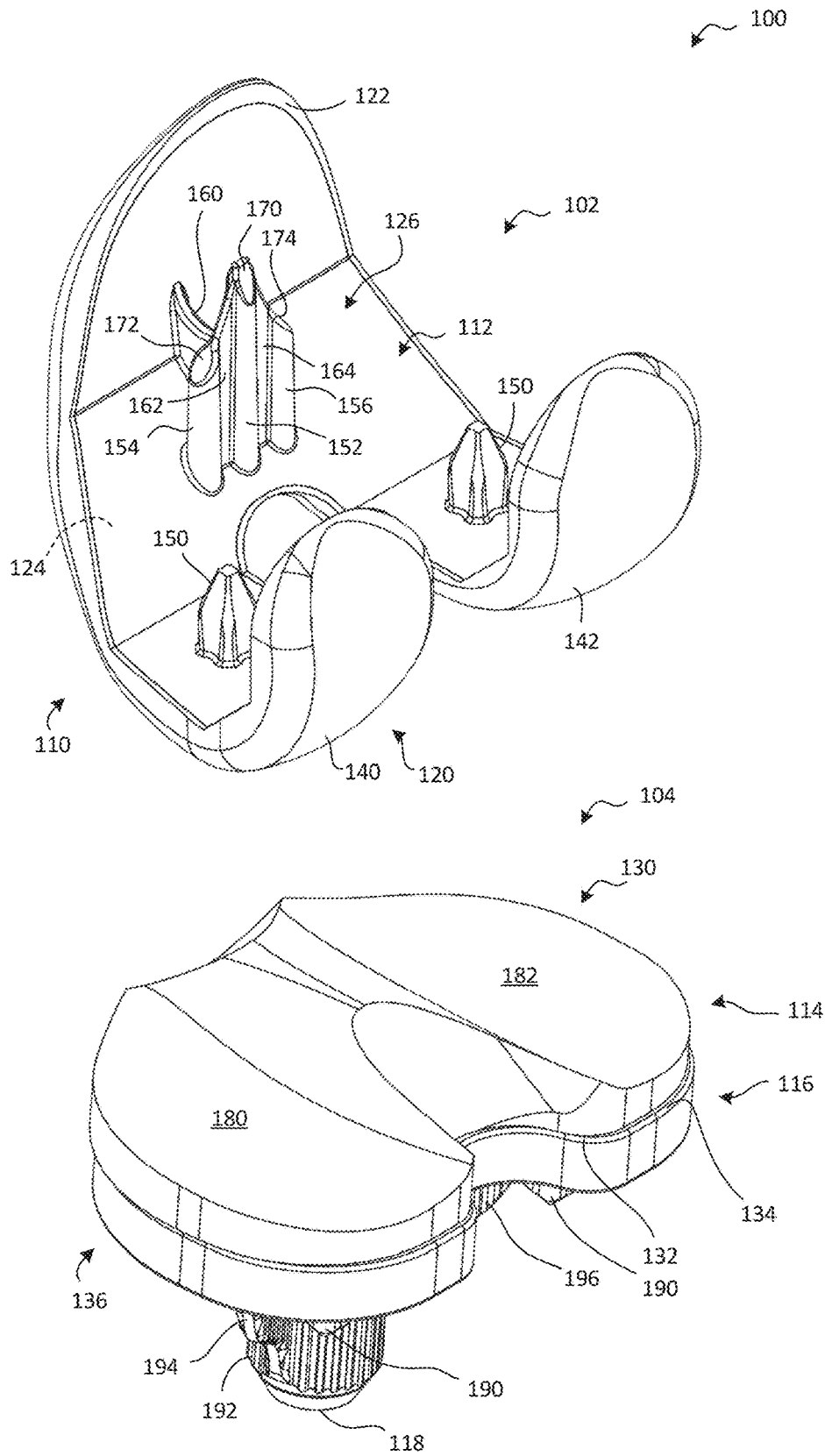
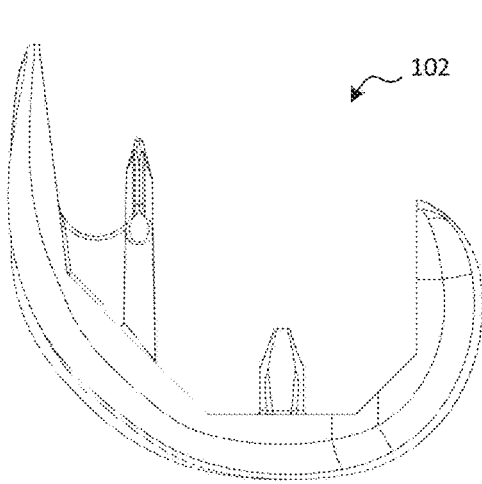
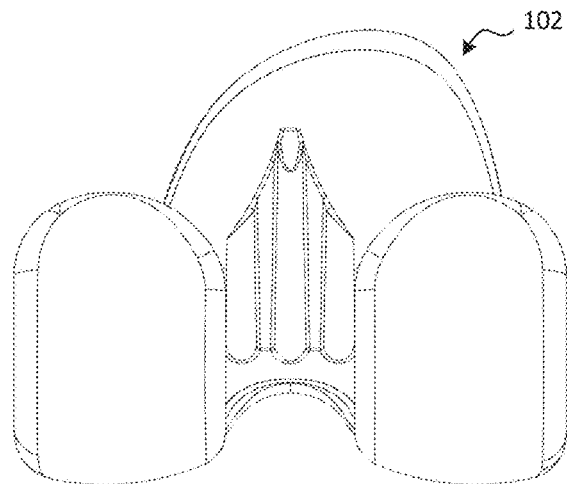


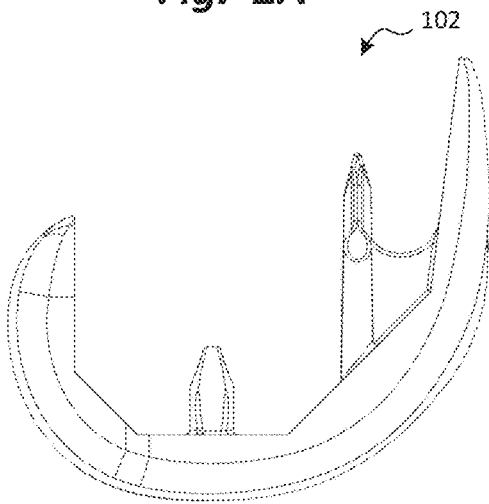
Fig. 1



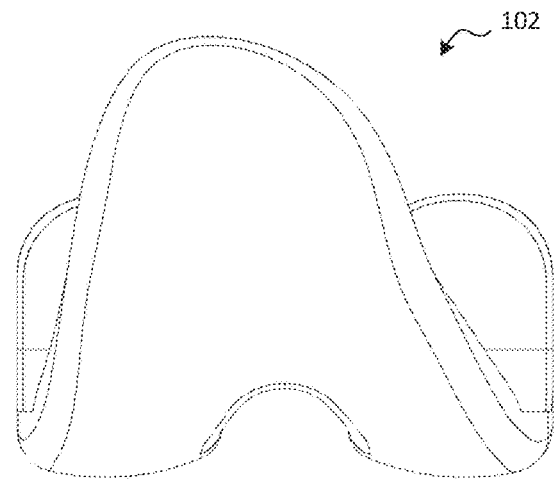
**Fig. 2A**



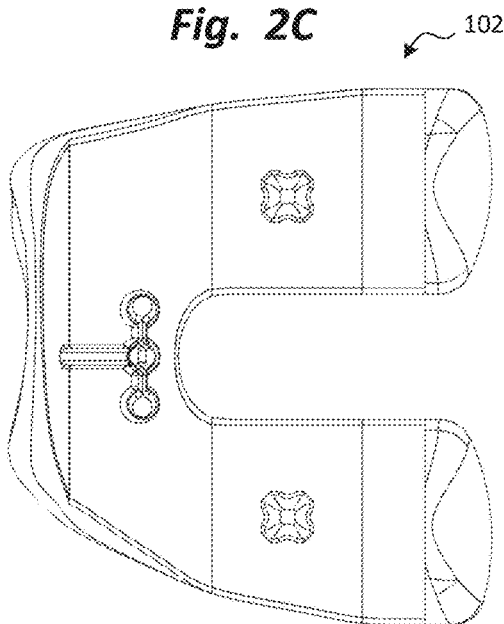
**Fig. 2B**



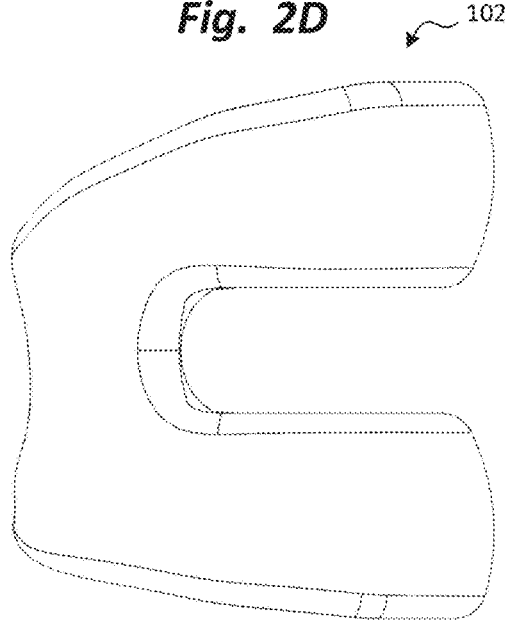
**Fig. 2C**



**Fig. 2D**



**Fig. 2E**



**Fig. 2F**

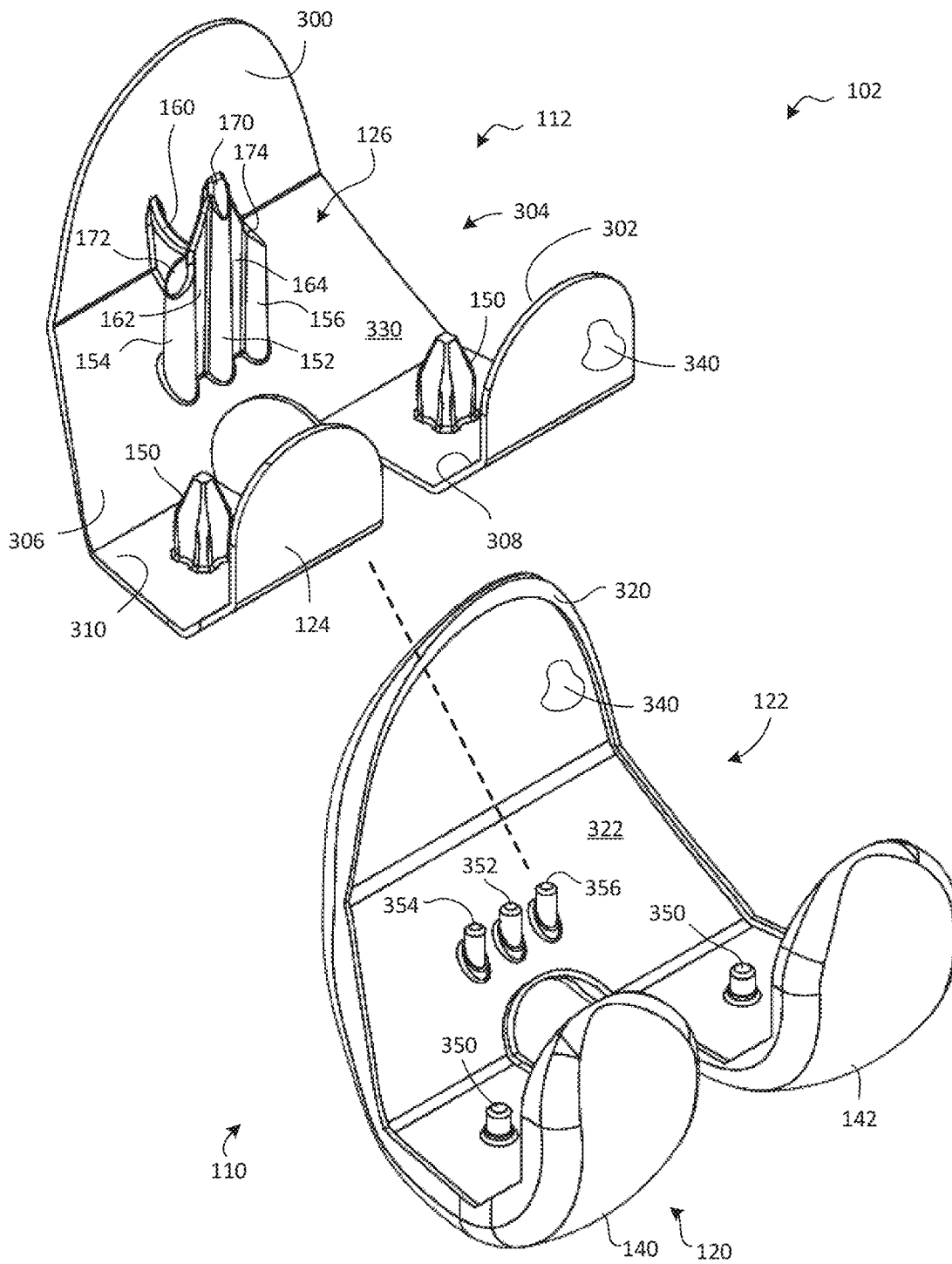


Fig. 3

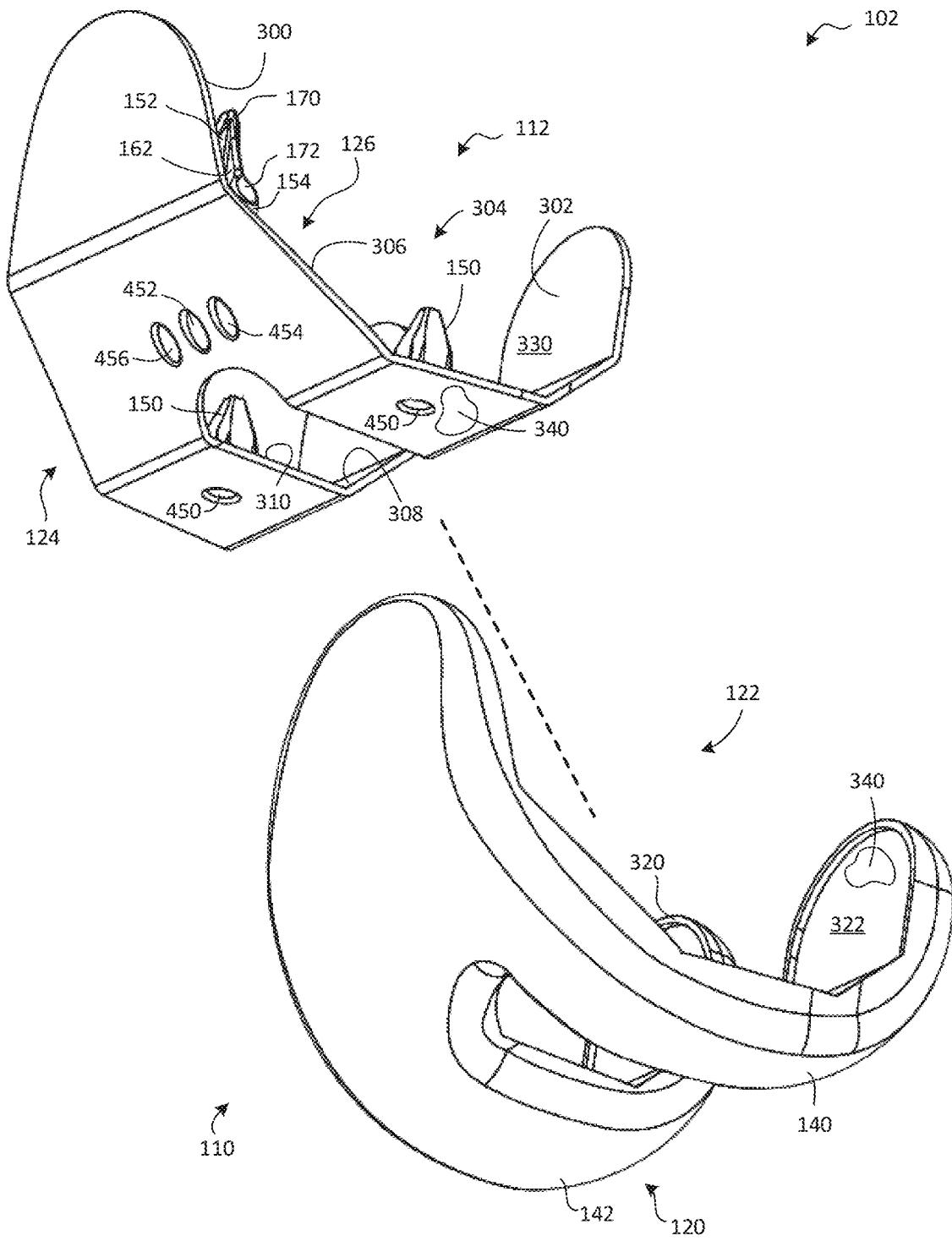
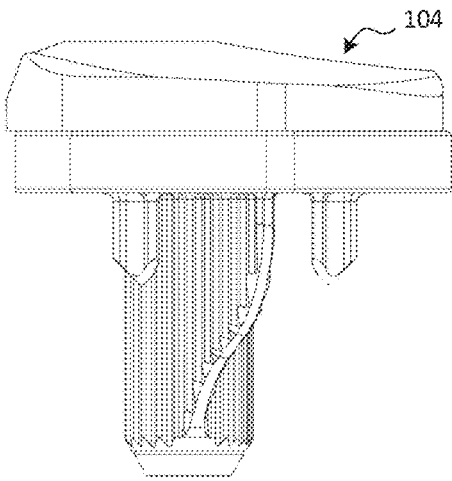
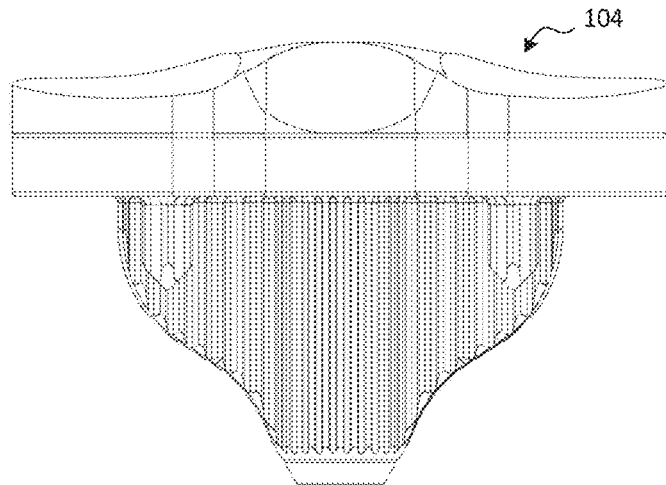


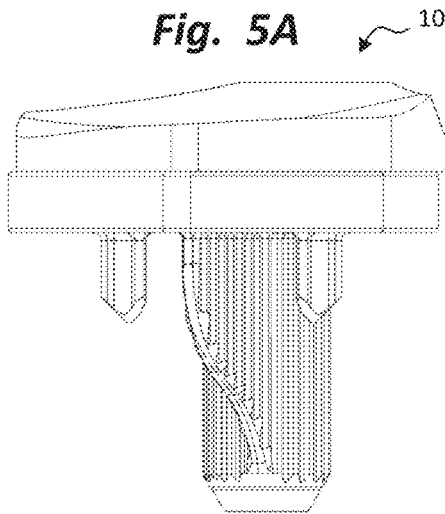
Fig. 4



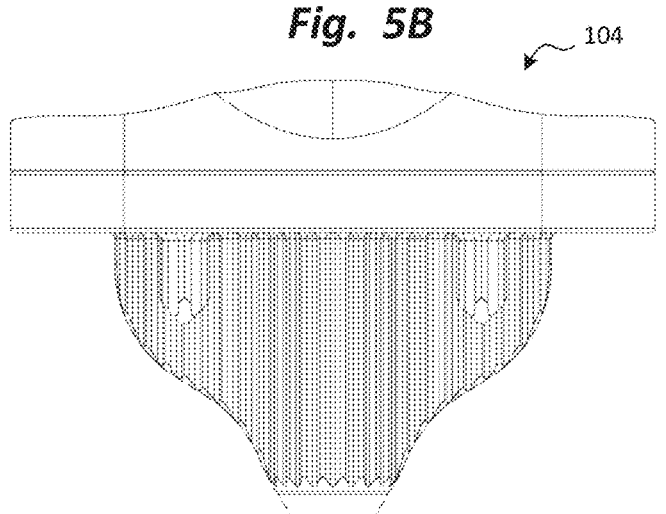
**Fig. 5A**



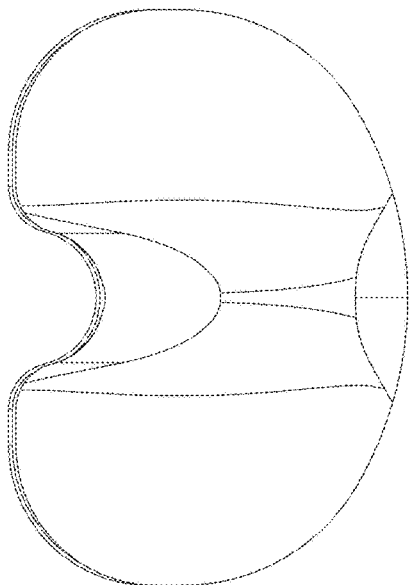
**Fig. 5B**



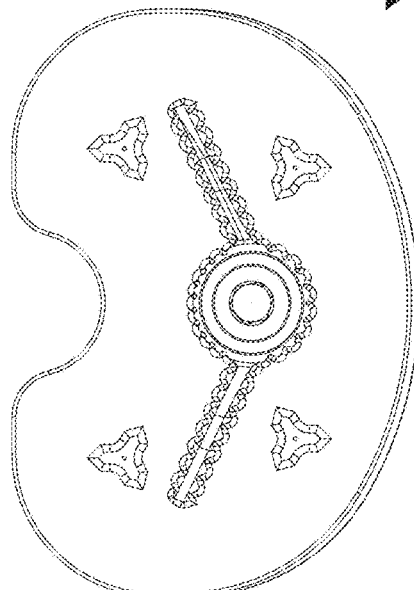
**Fig. 5C**



**Fig. 5D**



**Fig. 5E**



**Fig. 5F**



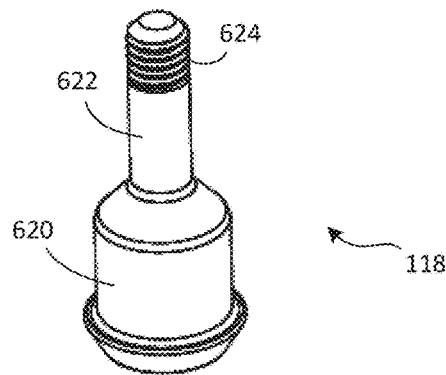
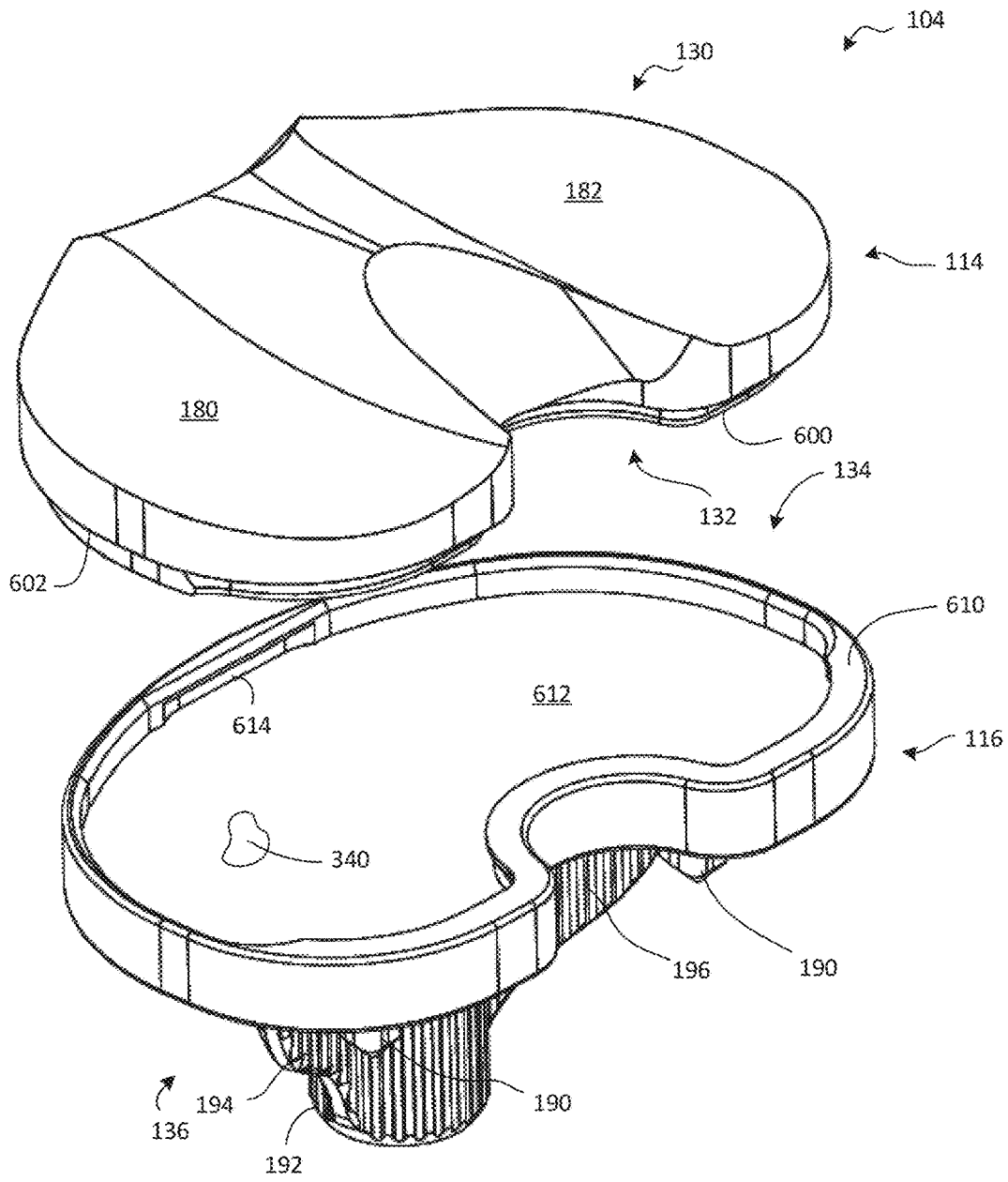


Fig. 6

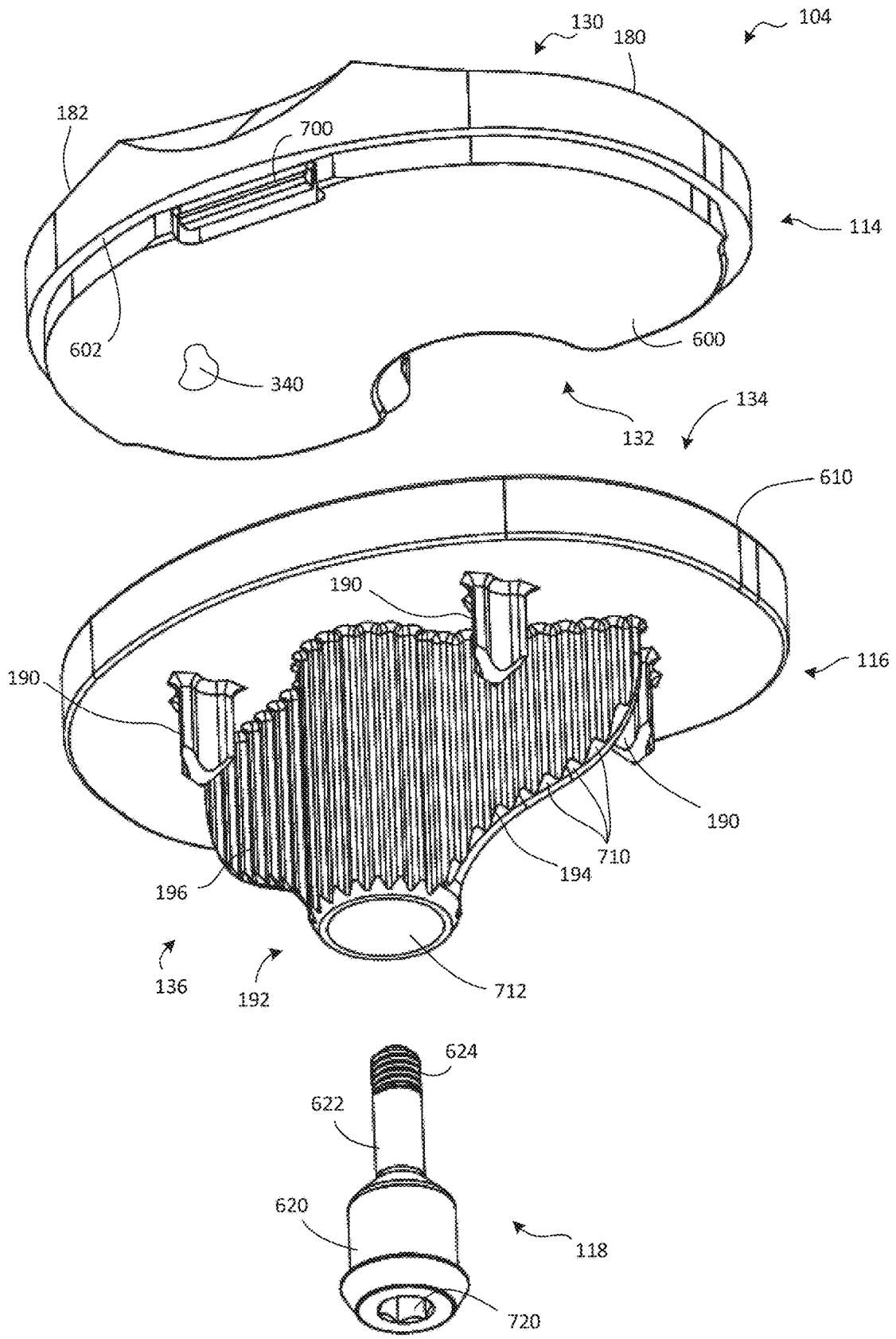


Fig. 7

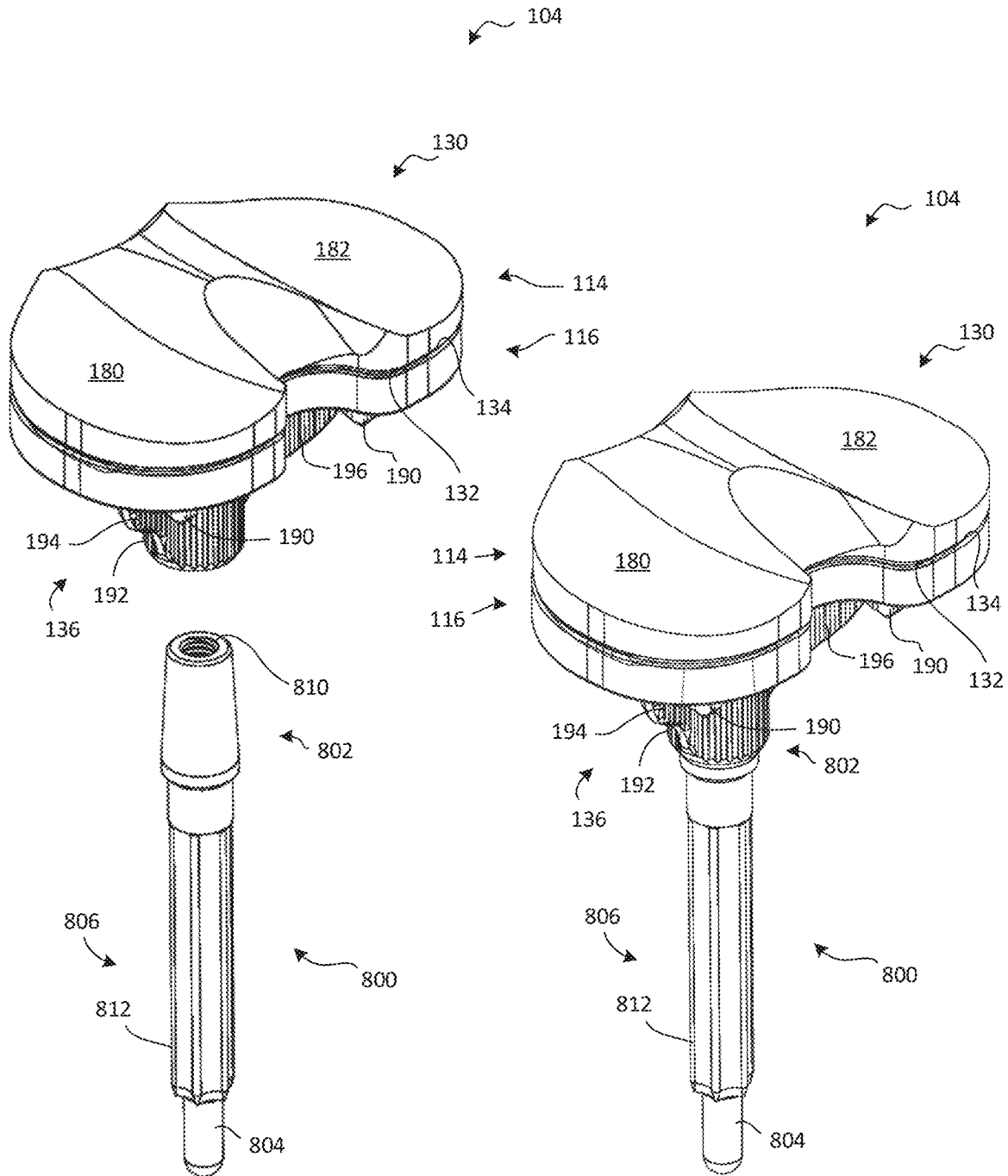


Fig. 8A

Fig. 8B

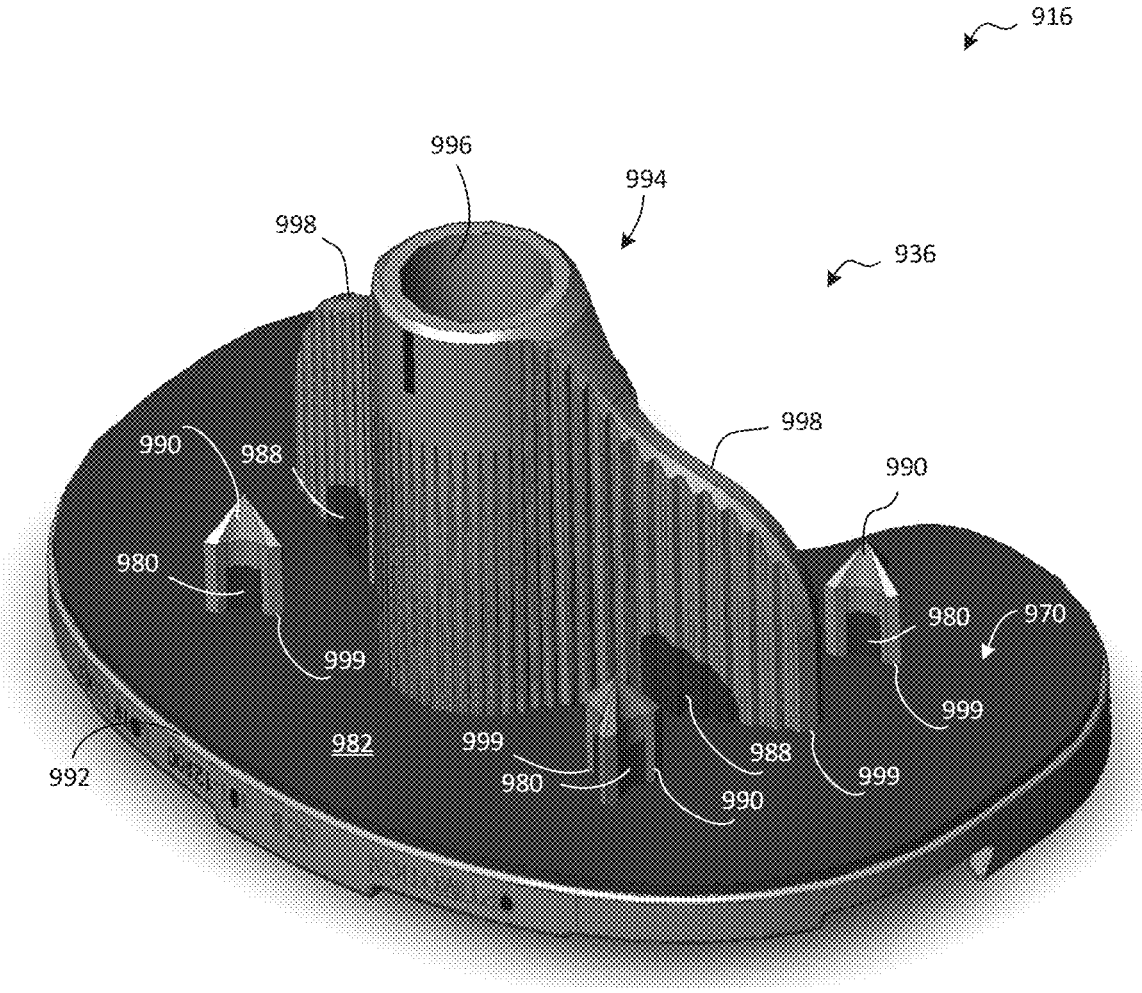


Fig. 9

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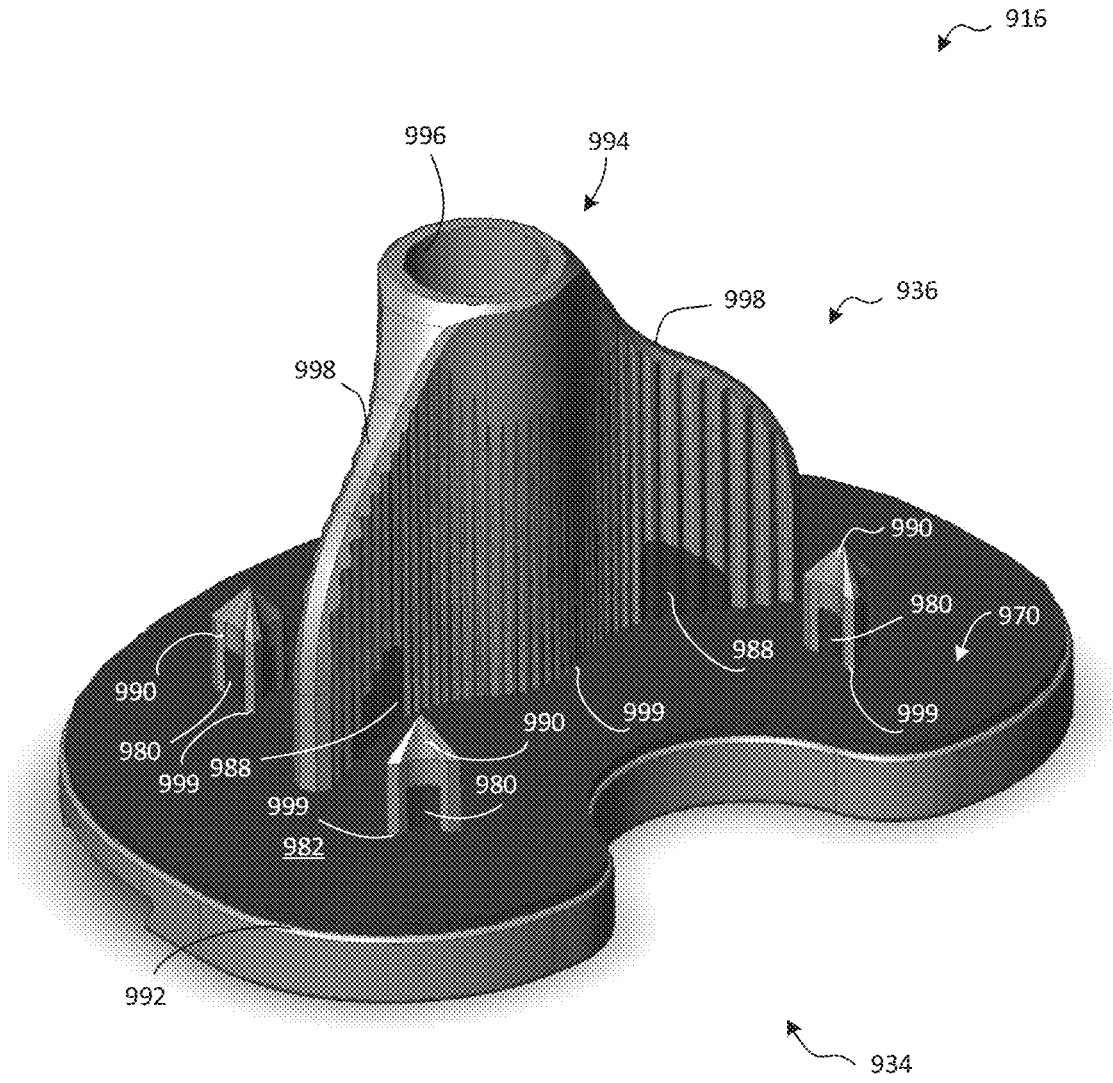


Fig. 10

**ORTHOPEDIC IMPLANTS AND METHODS**

## RELATED APPLICATIONS

The present application claims the benefit of U.S. Provisional Patent Application Ser. No. 62/694,834, filed Jul. 6, 2018 and entitled ORTHOPEDIC IMPLANTS AND METHODS. The present application is also a continuation-in-part of U.S. patent application Ser. No. 15/622,688, filed Jun. 14, 2017, which claims the benefit of U.S. Provisional Patent Application Ser. No. 62/466,249, filed Mar. 2, 2017 and entitled COMPOSITE JOINT ARTHROPLASTY SYSTEMS AND METHODS. All of the foregoing are incorporated by reference as though set forth herein in their entirety.

## TECHNICAL FIELD

The present disclosure relates to surgical systems and methods. More specifically, the present disclosure relates to implants and related methods for joint arthroplasty.

## BACKGROUND

Joint arthroplasty procedures are surgical procedures in which one or more articulating surfaces of a joint are replaced with prosthetic articulating surfaces. Such procedures are becoming increasingly commonplace.

For a successful joint arthroplasty, it is important that the joint implants remain in place and maintain the necessary wear characteristics. Further, it is desirable for the arthroplasty procedure to be carried out quickly and smoothly. Many existing arthroplasty implants and methods are time-consuming to implant, do not form a sufficient attachment to the underlying bone, or leave excessive wear debris.

## SUMMARY

The various systems and methods of the present disclosure have been developed in response to the present state of the art, and in particular, in response to the problems and needs in the art that have not yet been fully solved by currently available arthroplasty systems and methods. The systems and methods of the present disclosure may provide prostheses that enhance bone fixation, manufacturability, and overall outcomes for arthroplasty procedures.

According to one embodiment, a knee implant may be provided, for replacing a natural articular surface on bone. The knee implant may have a joint facing side with an articular surface shaped to replace the natural articular surface, a bone anchoring side comprising a bone engagement surface, and a bone engagement pad secured to at least part of the bone engagement surface. The articular surface may be one of a natural tibial articular surface and a natural femoral articular surface. The bone engagement pad may have a transverse portion extending transverse to a length of the bone. The transverse portion may have a pad bone-facing surface with a first porosity level, and a pad joint-facing surface on an opposite side of the transverse portion from the pad bone-facing surface. The pad joint-facing surface may have a second porosity level lower than the first porosity level. The bone engagement pad may further have one or more protruding portions extending generally perpendicular to the transverse portion. The bone engagement surface may be formed via a first manufacturing process selected from the group consisting of forging, milling, and casting. The bone engagement pad may be formed via a second manufacturing process different from the first manufacturing

process. The second manufacturing process may be an additive manufacturing process.

The bone engagement pad may extend generally transverse to a length of the bone, and may have a thickness, parallel to the length, that is substantially uniform. The thickness may be within the range of 0.5 mm to 1.5 mm.

The bone engagement surface may have a bone engagement feature extending through an aperture formed in the transverse portion. The one or more protruding portions may extend from one or more edges of the aperture, alongside one or more surfaces of the bone engagement feature.

According to one embodiment, a prosthesis for replacing a natural articular surface on bone may have a joint facing side with an articular surface, a bone anchoring side with a bone engagement surface, and a bone engagement pad secured to at least part of the bone engagement surface. The bone engagement pad may have a pad bone-facing surface with a first porosity level, and a pad joint-facing surface with a second porosity level lower than the first porosity level.

The bone engagement surface may be formed via a first manufacturing process. The bone engagement pad may be formed via a second manufacturing process different from the first manufacturing process.

The first manufacturing process may be selected from the group consisting of forging, milling, and casting. The second manufacturing process may be an additive manufacturing process.

The bone engagement pad may have a thickness within the range of 0.5 mm to 1.5 mm.

The bone engagement pad may have a transverse portion that extends generally transverse to a length of the bone. The pad bone-facing surface and the pad joint-facing surface may be on opposite sides of the bone engagement pad. The transverse portion may have a thickness, parallel to the length, that is substantially uniform.

The bone engagement pad may have a transverse portion extending transverse to a length of the bone. The pad bone-facing surface and the pad joint-facing surface may be on opposite sides of the transverse portion. The bone engagement pad may further have one or more protruding portions extending generally perpendicular to the transverse portion.

The bone engagement surface may have a bone engagement feature extending through an aperture formed in the transverse portion. The one or more protruding portions may extend from one or more edges of the aperture, alongside one or more surfaces of the bone engagement feature.

The bone engagement pad may have a transverse portion that extends generally transverse to a length of the bone. The pad bone-facing surface and the pad joint-facing surface may be on opposite sides of the bone engagement pad. The transverse portion may have a porosity gradient by which porosity of the transverse portion gradually increases toward the pad bone-facing surface.

The bone engagement pad may have a transverse portion that extends generally transverse to a length of the bone. The pad bone-facing surface and the pad joint-facing surface may be on opposite sides of the bone engagement pad. The transverse portion may have a low-porosity layer proximate the pad joint-facing surface, by which a porosity of the transverse portion abruptly increases toward the pad bone-facing surface.

The prosthesis may be a knee implant. The articular surface may be shaped to replace the natural articular surface. The natural articular surface may be one of a natural tibial surface and a natural femoral articular surface.

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According to one embodiment, a prosthesis for replacing a natural articular surface on bone may have a joint facing side with the articular surface, a bone anchoring side with a bone engagement surface, and a bone engagement pad secured to at least part of the bone engagement surface. The bone engagement pad may have a transverse portion extending transverse to a length of the bone, and one or more protruding portions extending generally perpendicular to the transverse portion.

The bone engagement surface may be formed via a first manufacturing process, and the bone engagement pad may be formed via a second manufacturing process different from the first manufacturing process.

The first manufacturing process may be selected from the group consisting of forging, milling, and casting. The second manufacturing process may be an additive manufacturing process.

The bone engagement pad may have a thickness within the range of 0.5 mm to 1.5 mm.

The transverse portion may extend generally transverse to a length of the bone, and may have a thickness, parallel to the length, that is substantially uniform.

The bone engagement surface may have a bone engagement feature extending through an aperture formed in the transverse portion. The one or more protruding portions may extend from one or more edges of the aperture, alongside one or more surfaces of the bone engagement feature.

The prosthesis may be a knee implant. The articular surface may be shaped to replace the natural articular surface. The natural articular surface may be one of a natural tibial surface and a natural femoral articular surface.

#### BRIEF DESCRIPTION OF THE DRAWINGS

Exemplary embodiments of the disclosure will become more fully apparent from the following description and appended claims, taken in conjunction with the accompanying drawings. Understanding that these drawings depict only exemplary embodiments and are, therefore, not to be considered limiting of the scope of the appended claims, the exemplary embodiments of the present disclosure will be described with additional specificity and detail through use of the accompanying drawings in which:

FIG. 1 is a perspective view of a knee arthroplasty system according to one embodiment.

FIGS. 2A through 2F are left, posterior, right, anterior, cephalad, and caudal views, respectively, of the femoral prosthesis of the knee arthroplasty system of FIG. 1.

FIG. 3 is an exploded, perspective view of the femoral prosthesis of the knee arthroplasty system of FIG. 1.

FIG. 4 is an exploded, perspective view, from a different viewpoint, of the femoral prosthesis of the knee arthroplasty system of FIG. 1.

FIGS. 5A through 5F are left, posterior, right, anterior, cephalad, and caudal views, respectively, of the tibial prosthesis of the knee arthroplasty system of FIG. 1.

FIG. 6 is an exploded, perspective view of the tibial prosthesis of the knee arthroplasty system of FIG. 1.

FIG. 7 is an exploded, perspective view, from a different viewpoint, of the tibial prosthesis of the knee arthroplasty system of FIG. 1.

FIGS. 8A and 8B are exploded and fully-assembled perspective views, respectively, of the tibial prosthesis of FIG. 1, with an optional keel.

FIG. 9 is a perspective view of a tibial bone anchoring component of a tibial prosthesis of a system according to one alternative embodiment.

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FIG. 10 is a perspective view, from a different viewpoint, of the tibial bone anchoring component of FIG. 9.

#### DETAILED DESCRIPTION

Exemplary embodiments of the disclosure will be best understood by reference to the drawings, wherein like parts are designated by like numerals throughout. It will be readily understood that the components of the disclosure, as generally described and illustrated in the Figures herein, could be arranged and designed in a wide variety of different configurations. Thus, the following more detailed description of the embodiments of the apparatus, system, and method, as represented in FIGS. 1 through 10, is not intended to limit the scope of the claims, as claimed, but is merely representative exemplary of exemplary embodiments.

The phrases “connected to,” “coupled to” and “in communication with” refer to any form of interaction between two or more entities, including mechanical, electrical, magnetic, electromagnetic, fluid, and thermal interaction. Two components may be functionally coupled to each other even though they are not in direct contact with each other. The term “abutting” refers to items that are in direct physical contact with each other, although the items may not necessarily be attached together. The phrase “fluid communication” refers to two features that are connected such that a fluid within one feature is able to pass into the other feature.

The word “exemplary” is used herein to mean “serving as an example, instance, or illustration.” Any embodiment described herein as “exemplary” is not necessarily to be construed as preferred or advantageous over other embodiments. While the various aspects of the embodiments are presented in drawings, the drawings are not necessarily drawn to scale unless specifically indicated.

FIG. 1 is a perspective view of a knee arthroplasty system, or system 100, according to one embodiment. The system 100 may be designed to replace the natural articulating surfaces of a knee joint, and may thus have a femoral prosthesis 102 and a tibial prosthesis 104. In some embodiments, the system 100 may be designed to replace only the femoral or tibial articulating surfaces, and may thus include only the femoral prosthesis 102 or the tibial prosthesis 104.

The femoral prosthesis 102 and the tibial prosthesis 104 may each have an articulating component with replacement articulating surfaces, and a bone anchoring component secured to the articulating component to secure the articulating component to the underlying bone. Specifically, the femoral prosthesis 102 may have a femoral articulating component 110 and a femoral bone anchoring component 112. Similarly, the tibial prosthesis 104 may have a tibial articulating component 114 and a tibial bone anchoring component 116. The tibial prosthesis 104 may also have a tibial fastener 118.

Each of the aforementioned articulating components and bone anchoring components may have a joint-facing side and a bone-facing side. Thus, the femoral articulating component 110 may have a joint-facing side 120 and a bone-facing side 122, and the femoral bone anchoring component 112 may have a joint-facing side 124 and a bone-facing side 126. Similarly, the tibial articulating component 114 may have a joint-facing side 130 and a bone-facing side 132, and the tibial bone anchoring component 116 may have a joint-facing side 134 and a bone-facing side 136.

The bone-facing side 122 of the femoral articulating component 110 may have a shape that matches the shape of the joint-facing side 124 of the femoral bone anchoring

component **112**, and may be secured to the joint-facing side **124** of the femoral bone anchoring component **112** in a manner that will be set forth in greater detail subsequently. Similarly, the bone-facing side **132** of the tibial articulating component **114** may have a shape that matches the shape of the joint-facing side **134** of the tibial bone anchoring component **116**, and may be secured to the joint-facing side **134** of the tibial bone anchoring component **116** in a manner that will be set forth in greater detail subsequently.

The joint-facing side **120** of the femoral articulating component **110** may have a first articulating surface **140** and a second articulating surface **142**, which are shaped to mimic the shapes of the natural articulating surfaces on the end of the femur. The shapes depicted in FIG. 1 are merely exemplary; according to alternative embodiments, any articulating surface shape known in the art may be used.

The bone-facing side **126** of the femoral bone anchoring component **112** may have a plurality of features that enhance engagement of the femoral bone anchoring component **112** with the underlying bone. For example, the bone-facing side **126** of the femoral bone anchoring component **112** may have a pair of posts **150**, a first femoral anchoring member **152**, a second femoral anchoring member **154**, and a third femoral anchoring member **156**, which protrude from various surfaces of the bone-facing side **126** of the femoral bone anchoring component **112**, as will be set forth in greater detail subsequently.

The first femoral anchoring member **152**, the second femoral anchoring member **154**, and the third femoral anchoring member **156** may be connected to each other and to the remainder of the bone-facing side **126** by a primary femoral web **160**, a first femoral web **162**, and a second femoral web **164**. Specifically, the second femoral anchoring member **154** may be connected to the first femoral anchoring member **152** with the first femoral web **162**, and the third femoral anchoring member **156** may be connected to the first femoral anchoring member **152** with the second femoral web **164**. The first femoral anchoring member **152** may have a tip **170** with a tapered shape. The first femoral anchoring member **152**, the first femoral web **162**, and the second femoral anchoring member **154** may cooperate to define a first bevel **172**. Similarly, the first femoral anchoring member **152**, the second femoral web **164**, and the third femoral anchoring member **156** may cooperate to define a second bevel **174**.

The joint-facing side **130** of the tibial articulating component **114** may also have a first articulating surface **180** and a second articulating surface **182**. After implantation of the femoral prosthesis **102** and the tibial prosthesis **104**, the first articulating surface **140** may articulate with the first articulating surface **180**, and the second articulating surface **142** may articulate with the second articulating surface **182**. The articulation of the femoral articulating component **110** with the tibial articulating component **114** may be designed to mimic that of the natural knee joint.

The bone-facing side **136** of the tibial bone anchoring component **116** may have a plurality of posts **190** that protrude into the bone from the remainder of the bone-facing side **136**. Further, the bone-facing side **136** of the tibial bone anchoring component **116** may have a central post **192** that also protrudes from the remainder of the bone-facing side **136**. The central post **192** may further be connected to the remainder of the bone-facing side **136** by a first tibial web **194** and a second tibial web **196**.

FIGS. 2A through 2F are left, posterior, right, anterior, cephalad, and caudal views, respectively, of the femoral

prosthesis **102** of the system **100** of FIG. 1. These views further depict the various features described in connection with FIG. 1.

FIG. 3 is an exploded, perspective view of the femoral articulating component **110** and the femoral bone anchoring component **112** that are best suited for the role to be performed.

For example, the femoral articulating component **110** may be designed to endure cyclical loading in friction and compression. Accordingly, high-strength and/or low-wear materials and surface properties may be desired. Accordingly, the femoral articulating component **110** may be made of a relatively hard material such as an alloy of Cobalt Chromium ("Cobalt Chrome,"). Specifically, the femoral articulating component **110** may be made of an alloy of Cobalt Chromium Molybdenum (CoCrMo). A manufacturing process such as casting may be used. In some embodiments, the first articulating surface **140** and the second articulating surface **142** may be specially processed in a manner that increases their hardness and/or wear resistance.

Conversely, the femoral bone anchoring component **112** may be designed to provide high-strength fixation of the femoral articulating component **110** to the underlying bone. It may be desirable for the femoral bone anchoring component **112** to have a porous structure that encourages bone in-growth. Accordingly, the femoral bone anchoring component **112** may be formed of a metal such as Titanium, or specifically, direct metal laser sintered ("DMLS") Titanium. The femoral bone anchoring component **112** may be formed via an additive manufacturing method such as 3D printing. Such manufacturing methods may facilitate the creation of a porous structure, particularly on the bone-facing side **126** of the femoral bone anchoring component **112**.

In some embodiments, the femoral bone anchoring component **112** may be made such that the porosity varies in a gradient through the thickness of the femoral bone anchoring component **112**. Thus, the bone-facing side **126** of the femoral bone anchoring component **112** may be made more porous to facilitate bone in-growth, while the joint-facing side **124** of the femoral bone anchoring component **112** may be made less porous to enhance attachment of the joint-facing side **124** to the bone-facing side **122** of the femoral articulating component **110**. In some embodiments, the joint-facing side **124** may be made substantially solid (i.e., nonporous) to enhance adhesion to the bone-facing side **122** of the femoral articulating component **110**, while the bone-facing side **126** may be highly porous.

As shown, the bone-facing side **122** of the femoral articulating component **110** may have an anterior portion **300**, a posterior portion **302**, and a distal portion **304**. Upon implantation of the femoral articulating component **110**, the anterior portion **300** may be located on the anterior side of the knee, the posterior portion **302** may be located on the posterior side of the knee, and the distal portion **304** may be located at the distal end of the femur. The distal portion **304** may be divided into three faces: an anterior-distal face **306**, a posterior-distal face **308**, and a distal face **310**. The anterior-distal face **306** may reside between the anterior



portion **300** and the distal face **310**, and the posterior-distal face **308** may be reside between the posterior portion **302** and the distal face **310**.

As shown, the posts **150** may protrude from the distal face **310**. The first femoral anchoring member **152**, the second femoral anchoring member **154**, and the third femoral anchoring member **156** may protrude from the posterior-distal face **308**. The primary femoral web **160** may connect the first femoral anchoring member **152** to the anterior portion **300**. The first femoral web **162** may connect the first femoral anchoring member **152** to the second femoral anchoring member **154** and to the anterior-distal face **306**. Similarly, the second femoral web **164** may connect the first femoral anchoring member **152** to the third femoral anchoring member **156** and the anterior-distal face **306**.

The first femoral anchoring member **152**, the second femoral anchoring member **154**, the third femoral anchoring member **156**, the primary femoral web **160**, the first femoral web **162**, and the second femoral web **164** may cooperate to enhance engagement of the bone-facing side **126** of the femoral bone anchoring component **112** with the underlying bone. Specifically, these features may add to the surface area of the bone-facing side **126** in contact with the bone, providing a stronger bond with the bone via bone in-growth and/or application of bone cement. The position of these features on the anterior-distal face **306**, proximate the anterior portion **300** may enable them to penetrate a relatively dense, sturdy bone mass proximate the distal end of the femur. Specifically, the bone that underlies the natural femoral articular surfaces to be replaced may, due to mechanical loading, have a denser structure and/or a thicker layer of cortical bone. Accordingly, the first femoral anchoring member **152**, the second femoral anchoring member **154**, the third femoral anchoring member **156**, the primary femoral web **160**, the first femoral web **162**, and the second femoral web **164** may be optimally positioned for anchorage in strong, relatively dense bone that is likely to provide solid anchorage for the femoral bone anchoring component **112**.

The posts **150**, the first femoral anchoring member **152**, the second femoral anchoring member **154**, the third femoral anchoring member **156**, the primary femoral web **160**, the first femoral web **162**, and the second femoral web **164** may all protrude in a cephalad direction so that these features can penetrate the bone, helping to anchor the femoral articulating component **110** on the distal end of the femur (not shown). These features may also be shaped to facilitate entry into and/or compaction of the bone.

Specifically, the tip **170**, the first bevel **172**, and the second bevel **174** may help to spread bone out of the path of the first femoral anchoring member **152**, the second femoral anchoring member **154**, the third femoral anchoring member **156**, the first femoral web **162**, and the second femoral web **164** as these features are pressed into the bone, thereby easing placement of the femoral prosthesis **102** on the distal end of the femur. Further, due to the presence of the tip **170**, the first bevel **172**, and/or the second bevel **174**, the bone surrounding these features in their implanted state may be compacted and/or strengthened.

As also shown in FIG. 3, the bone-facing side **122** of the femoral articulating component **110** may have a peripheral ridge **320** that defines an interior recess **322**. The shape of the interior recess **322** may closely match that of the joint-facing side **124** of the femoral bone anchoring component **112** so that the joint-facing side **124** of the femoral bone anchoring component **112** can be secured to the interior recess **322**. When the femoral bone anchoring component **112** and the femoral articulating component **110** are

assembled together, the bone-facing side **126** of the femoral bone anchoring component **112** may lie substantially flush with the peripheral ridge **320** of the bone-facing side **122** of the femoral articulating component **110**.

In some embodiments, the bone-facing side **126** of the femoral bone anchoring component **112** may be treated to enhance porosity and/or bone in-growth. In some examples, the bone-facing side **126** of the femoral bone anchoring component **112** may be processed via a process such as anodizing to form Titanium Dioxide nanotubes on the bone-facing side **126**. Specifically, the bone-facing side **126** may be anodized in a Fluoride electrolyte, as set forth in U.S. application Ser. No. 11/913,062, filed Jun. 10, 2008 and entitled "Compositions Comprising Nanostructures for Cell, Tissue and Artificial Organ Growth, and Methods for Making and Using Same, now U.S. Pat. No. 8,414,908, which is incorporated by reference as though set forth herein in its entirety. The result may be the formation of a surface layer **330** of Titanium Dioxide nanotubes on the bone-facing side **126**.

The femoral articulating component **110** and the femoral bone anchoring component **112** may be secured together in a variety of ways. Such ways may include, but are not limited to, welding, brazing, press fitting, and the like. According to some embodiments, a substance **340** may be applied to one or both of the surfaces to be secured together via chemical and/or adhesive bonding. Any of the methods mentioned above may be used to secure the tibial articulating component **114** to the tibial bone anchoring component **116**.

In addition to or in the alternative to the foregoing attachment methods, the methods disclosed in U.S. application Ser. No. 10/455,846, filed Jun. 6, 2003 and entitled "METHOD FOR ATTACHING A POROUS METAL LAYER TO A METAL SUBSTRATE," now U.S. Pat. No. 6,945,448, may be used. This application is incorporated as though set forth herein in its entirety.

Optionally, the surfaces to be bonded together may have features that facilitate and/or enhance the results of the bonding process. For example, the bone-facing side **122** of the femoral articulating component **110** may have features that cooperate with corresponding features (shown in FIG. 4) on the joint-facing side **124** of the femoral bone anchoring component **112** to help align the femoral articulating component **110** with the femoral bone anchoring component **112** and/or add mechanical fastening to the bonding described above. These features of the bone-facing side **122** may include a pair of post bosses **350**, a first femoral anchoring member boss **352**, a second femoral anchoring member boss **354**, and a third femoral anchoring member boss **356**.

FIG. 4 is an exploded, perspective view, from a different viewpoint, of the femoral prosthesis **102** of the system **100** of FIG. 1. The joint-facing side **124** of the femoral bone anchoring component **112** and the joint-facing side **120** of the femoral articulating component **110** are more clearly visible.

As shown, the joint-facing side **124** of the femoral bone anchoring component **112** may have features that cooperate with the post bosses **350**, the first femoral anchoring member boss **352**, the second femoral anchoring member boss **354**, and the third femoral anchoring member boss **356** of the bone-facing side **122** of the femoral articulating component **110** depicted in FIG. 3. These features may include post bores **450**, a first femoral anchoring member bore **452**, a second femoral anchoring member bore **454**, and a third femoral anchoring member bore **456**. Each of the post bores **450** may reside in the interior of one of the posts **150**.

Similarly, the first femoral anchoring member bore **452**, the second femoral anchoring member bore **454**, and the third femoral anchoring member bore **456** may reside in the interiors of the first femoral anchoring member **152**, the second femoral anchoring member **154**, and the third femoral anchoring member **156**, respectively.

The post bores **450** may be shaped to receive the post bosses **350**. Similarly, the first femoral anchoring member bore **452**, the second femoral anchoring member bore **454**, and the third femoral anchoring member bore **456** may be shaped to receive the first femoral anchoring member boss **352**, the second femoral anchoring member boss **354**, and the third femoral anchoring member boss **356**, respectively. If desired, the post bosses **350**, the first femoral anchoring member boss **352**, the second femoral anchoring member boss **354**, and/or the third femoral anchoring member boss **356** may each be tapered to facilitate insertion into the post bores **450**, the first femoral anchoring member bore **452**, the second femoral anchoring member bore **454**, and/or the third femoral anchoring member bore **456**, respectively.

The features of the bone-facing side **122** may be received by these features of the joint-facing side **124** with some interference, which may cooperate with the bond described above to enhance attachment of the bone-facing side **122** to the joint-facing side **124**. When the femoral articulating component **110** and the femoral bone anchoring component **112** are compressed together, as set forth above, the compression may be sufficient to urge the post bosses **350**, the first femoral anchoring member boss **352**, the second femoral anchoring member boss **354**, and the third femoral anchoring member boss **356** into the post bores **450**, the first femoral anchoring member bore **452**, the second femoral anchoring member bore **454**, and the third femoral anchoring member bore **456**, respectively.

Additionally or alternatively, heat applied to the femoral articulating component **110** and/or the femoral bone anchoring component **112** may cause thermal expansion that eases insertion of the post bosses **350**, the first femoral anchoring member boss **352**, the second femoral anchoring member boss **354**, and the third femoral anchoring member boss **356** into the post bores **450**, the first femoral anchoring member bore **452**, the second femoral anchoring member bore **454**, and the third femoral anchoring member bore **456**, respectively. The femoral articulating component **110** may be made such that the femoral articulating component **110** has higher thermal expansion than the femoral bone anchoring component **112**. Thus, after insertion of the bosses into the bores, the femoral articulating component **110** and the femoral bone anchoring component **112** may be cooled, allowing the bores to tighten around the bosses.

In alternative embodiments, other positive and/or negative features may be used. Further, if desired, the positive features may be on the joint-facing side **124** of the femoral bone anchoring component **112**, and the negative features may be on the bone-facing side **122** of the femoral articulating component **110**.

FIGS. **5A** through **5F** are left, posterior, right, anterior, cephalad, and caudal views, respectively, of the tibial prosthesis **104** of the system **100** of FIG. **1**. These views further depict the various features described in connection with FIG. **1**.

FIG. **6** is an exploded, perspective view of the tibial prosthesis **104** of the system **100** of FIG. **1**. As with the femoral prosthesis **102**, the tibial articulating component **114** and the tibial bone anchoring component **116** may optionally be manufactured separately from each other. Accordingly, different manufacturing processes may be used to form the

tibial articulating component **114** and the tibial bone anchoring component **116**. For example, the tibial articulating component **114** may be formed via casting, and the tibial bone anchoring component **116** may be formed via additive manufacturing such as 3D printing.

Like the femoral articulating component **110**, the tibial articulating component **114** may be made of Cobalt Chromium, or Cobalt Chromium Molybdenum. Similarly, like the femoral bone anchoring component **112**, the tibial bone anchoring component **116** may be made of DMLS Titanium. A gradient of porosities may be present in the tibial bone anchoring component **116**, with greater porosity on the bone-facing side **136**, and lesser porosity on the joint-facing side **134**. If desired, the joint-facing side **134** may be made substantially nonporous to enhance adhesion to the tibial articulating component **114**, and the bone-facing side **136** may have a high level of porosity to promote bone ingrowth.

As shown, the bone-facing side **132** of the tibial articulating component **114** may have a central plateau **600** that extends toward the tibial bone anchoring component **116**, and a peripheral recess **602** that encircles the central plateau **600** and is recessed from the tibial bone anchoring component **116**. The joint-facing side **134** of the tibial bone anchoring component **116** may have a shape that is complementary to that of the bone-facing side **132** of the tibial articulating component **114**. Specifically, the joint-facing side **134** may have a peripheral ridge **610** that encircles an interior recess **612**. An alcove **614** may extend into the peripheral ridge **610**, from the space above the interior recess **612**. When the tibial articulating component **114** and the tibial bone anchoring component **116** are assembled together, the central plateau **600** may be received within the interior recess **612**, and the peripheral ridge **610** may engage the central plateau **600**.

In some embodiments, the tibial articulating component **114** and the tibial bone anchoring component **116** may be secured together by the same bonding process described above in connection with the femoral articulating component **110** and the femoral bone anchoring component **112** of the femoral prosthesis **102**, or with a modified version of such a bonding process. Thus, FIG. **6** depicts the exemplary application of the substance **340**, which may be a paste or the like, to the interior recess **612** of the joint-facing side **134** of the tibial bone anchoring component **116**.

FIG. **6** also depicts the tibial fastener **118** in greater detail. The tibial fastener **118** may have an enlarged head **620** and a shank **622** with threads **624** thereon that enable the tibial fastener **118** to threadably engage the tibial bone anchoring component **116**, as will be discussed in greater detail subsequently.

FIG. **7** is an exploded, perspective view, from a different viewpoint, of the tibial prosthesis **104** of the system **100** of FIG. **1**. As shown, the central plateau **600** of the bone-facing side **132** of the tibial articulating component **114** may have a lip **700** that protrudes anteriorly. When the tibial articulating component **114** and the tibial bone anchoring component **116** are assembled, the lip **700** may protrude into the alcove **614** depicted in FIG. **6**. Engagement of the lip **700** and the alcove **614** may further help to hold the anterior portions of the tibial articulating component **114** and the tibial bone anchoring component **116** together.

FIG. **7** also depicts the bone-facing side **136** of the tibial bone anchoring component **116** in greater detail. Four of the posts **190** may be present on the bone-facing side **136**, and may help enhance the level of engagement of the bone-facing side **136** with the underlying bone, and in particular,

with the cortical bone at the proximal end of the tibia. The central post **192**, the first tibial web **194**, and the second tibial web **196** may each extend distally from the remainder of the bone-facing side **136**, and may cooperate to provide a greater surface area in engagement with the underlying bone. Thus, the central post **192**, the first tibial web **194**, and the second tibial web **196** may

As shown, the central post **192**, the first tibial web **194**, and the second tibial web **196** may each have a crenellated shape, with crenellations **710** shown in FIG. 7. The crenellations **710** may further increase the surface area of the bone-facing side **136** in contact with the bone of the tibia, thereby further enhancing the potential for bone cement bonding and/or bone in-growth between the tibia and the bone-facing side **136**. Further, if desired, the tibial bone anchoring component **116** may be processed as described above in the description of the femoral bone anchoring component **112**, such that the tibial bone anchoring component **116** has a surface layer **330** formed of Titanium Dioxide nanotubes. Such a surface layer **330** may further enhance bone in-growth to further secure the bone-facing side **136** to the bone of the tibia.

As mentioned previously, the tibial articulating component **114** and the tibial bone anchoring component **116** may be secured together through the use of any of a variety of methods. Some of these are mentioned above in the description of assembly of the femoral articulating component **110** and the femoral bone anchoring component **112**. Again, a substance **340** may optionally be applied to the bone-facing side **132** of the tibial articulating component **114** and/or to the joint-facing side **134** of the tibial bone anchoring component **116** to facilitate attachment via chemical and/or adhesive bonding.

As further shown in FIG. 7, the central post **192** may have a bore **712** that receives the tibial fastener **118**. The bore **712** may have interior threads (not shown) that receive the threads **624** of the shank **622** of the tibial fastener **118**. The tibial fastener **118** may serve to seal the bore **712** and reduce the chance of having toxins or microbes enter the bore **712** during implantation. The enlarged head **620** of the tibial fastener **118** may have a socket **720** with a hexagonal or other shape that can receive the shaped distal end of a removal tool (not shown), such as a hex key, to facilitate rotation of the tibial fastener **118** to remove the tibial fastener **118** from the bore **712**.

FIGS. 8A and 8B are exploded and fully-assembled perspective views, respectively, of the tibial prosthesis **104** of FIG. 1, with an optional anchoring member in the form of a keel **800**. The keel **800** may have a proximal end **802** and a distal end **804**, with a shank **806** extending between the proximal end **802** and the distal end **804**. The proximal end **802** may be shaped to be inserted into the bore **712** of the central post **192** of the tibial bone anchoring component **116** of the tibial prosthesis **104**, as shown in FIG. 8B.

Specifically, the proximal end **802** may have a generally frustoconical shape. The walls of the bore **712** may define a similar, complementary shape. If desired, the proximal end **802** may be press-fitted into the bore **712**. Additionally or alternatively, the proximal end **802** may have threads **810**, which may engage corresponding threads (not shown) within the bore **712**. In the alternative, the threads **810** may be used to receive another fastener (not shown), which may, in turn, be secured within the bore **712**.

The tibial prosthesis **104** may be provided to the surgeon with the tibial fastener **118** in place within the bore **712**. The surgeon may remove the tibial fastener **118** from the bore **712**, and may insert and secure the proximal end **802** of the

keel **800** within the bore **712**. The intramedullary space of the tibia may be reamed and/or otherwise prepared to receive the keel **800** prior to attachment of the tibial prosthesis **104**, with the keel **800**, to the tibia.

The keel **800** may help provide additional bone engagement and/or rotational stability for the tibial prosthesis **104**. Thus, the shank **806** may optionally have a plurality of splines **812** that protrude outward from the axis of the shank **806** to engage the surrounding bone. The splines **812** may increase the surface area of the keel **800** in contact with the bone to increase bone engagement, and may further resist rotation of the keel **800** within the bone. If desired, some or all of the keel **800** may have a porous structure that facilitates bone in-growth and/or bone cement engagement. Additionally or alternatively, the keel **800** may be anodized to form a surface layer **330**, as set forth in connection with the femoral bone anchoring component **112** and the tibial bone anchoring component **116**.

FIG. 9 is a perspective view of a tibial bone anchoring component **916** of a tibial prosthesis of a system according to one alternative embodiment. The tibial bone anchoring component **916** may have a joint-facing side **134** and a bone-facing side **936**. The joint-facing side **934** may be identical or similar to the joint-facing side **134** of the tibial bone anchoring component **116** of FIGS. 1 through 5. Like the tibial bone anchoring component **116** of FIGS. 1 through 5, the tibial bone anchoring component **916** of FIG. 9 may be designed to be secured to an articulating component like the tibial articulating component **114** of FIGS. 1 through 5. In the alternative, the tibial bone anchoring component **916** may be designed as a standalone tibial implant, with bone apposition surfaces and articulating surfaces, such as the first articulating surface **180** and the second articulating surface **182** of the tibial articulating component **114**, which may be formed directly on the superior surface (not shown) of the tibial bone anchoring component **916**, if desired.

Like the bone-facing side **136** of the tibial bone anchoring component **116**, the bone-facing side **936** of the tibial bone anchoring component **916** may have a plurality of posts **990** that protrude into the bone from a transverse surface **992** oriented generally transverse to the tibia. Optionally, other bone anchoring features, as known in the art, may be used in addition to or in the alternative to the posts **990**.

For example, in addition to the posts **990**, the bone-facing side **936** of the tibial bone anchoring component **916** may also have stem receiver **994** positioned proximate the center of the bone-facing side **936**. The stem receiver **994** may have an aperture **996** that can receive an anchoring element such as an intramedullary stem (not shown). Such an intramedullary stem may have a proximal end that can be inserted into and secured within the aperture **996**, and a distal end that can be inserted into the intramedullary canal of the tibia to provide supplemental fixation of the tibial bone anchoring component **916** relative to the tibia. The stem receiver **994** may have a generally tubular shape oriented generally parallel to the tibia, and perpendicular to the transverse surface **992**.

The tibial bone anchoring component **916** may further have flanges **998** that connect the side walls of the stem receiver **994** to the transverse surface **992**. The flanges **998** may have crenellated shapes as shown, that present greater surface area to the interior of the tibia, thereby enhancing fixation of the tibial bone anchoring component to the tibia.

In some embodiments, the tibial bone anchoring component **916** may not, in its entirety, be made via additive manufacturing. Rather, the majority of the tibial bone anchoring component **916** may be generally made via more

traditional methods such as casting, milling, and forging. The tibial bone anchoring component **916** may have a bone engagement pad **970** that is made separately from the remainder of the tibial bone anchoring component **916**, and has a highly textured and/or porous shape that facilitate bone in-growth. In some embodiments, the bone engagement pad **970** may have nano-textured surfaces with features such as titanium nanotubes that provide enhanced bone engagement.

As shown, the bone engagement pad **970** may be secured to certain bone-facing surfaces of the main body of the tibial bone anchoring component **916**. For example, the bone engagement pad **970** may include a transverse portion **982** that covers substantially the entirety of the transverse surface **992**, post portions **980** that cover the proximal portions of the posts **990**, and flange portions **988** that cover the proximal portions of the flanges **998**. The posts **990**, stem receiver **994**, and flanges **998** may extend through apertures **999** formed in the transverse portion **982**. The post portions **980** and the flange portions **988** may protrude from the transverse portion **982** and may connect to the transverse portion **982** at the peripheries of the apertures **999** through which the posts **990** and flanges **998** pass, respectively.

The post portions **980** and the flange portions **988** may be called “protruding portions,” because they protrude from the transverse portion **982**, and thence, from the underlying transverse surface **992**. The protruding portions may also extend generally perpendicular to the transverse portion **982**. “Generally perpendicular” means that the protruding portions extend along the adjacent surfaces (i.e., surfaces that are adjacent to the transverse surface) of typical bone engagement features (such as spikes, posts, keels, teeth, and/or the like) that protrude away from the transverse surface of the implant. Many such bone engagement features will have adjacent surfaces that extend perpendicular to the transverse surface, just as the posts **990**, the stem receiver **994**, and the flanges **998** extend perpendicular to the transverse surface **992**. However, some such bone engagement features may have adjacent surfaces that are not precisely perpendicular to the transverse surface. For example, a bone anchoring feature may have a tapered (for example, conical or pyramidal) shape that causes its adjacent surface(s) extend from the transverse surface at an angle of less than 90°. A bone engagement pad may have a “protruding portion” that extends along such a surface, even though it is not precisely perpendicular to the transverse portion **982**.

The bone engagement pad **970** may be made via additive manufacturing through the use of any of the methods mentioned previously. In the alternative, different methods may be used to manufacture the bone engagement pad **970** with the desired porous and/or textured shape.

In some embodiments, the bone engagement pad **970** may be relatively thin compared to the main body of the tibial bone anchoring component **916**. For example, the bone engagement pad **970** may have a thickness within the range of 0.1 mm to 5 mm. More precisely, the bone engagement pad **970** may have a thickness within the range of 0.2 mm to 2 mm. Yet more precisely, the bone engagement pad **970** may have a thickness within the range of 0.5 mm to 1.5 mm. Still more precisely, the bone engagement pad **970** may have a thickness within the range of 0.8 mm to 1.2 mm. Yet more precisely, the bone engagement pad **970** may have a thickness of about 1 mm.

The bone engagement pad **970** may be formed as a single piece, such that the post portions **980**, the transverse portion **982**, and the flange portions **988** are all formed as a single piece with each other. In the alternative, the post portions **980**, the transverse portion **982**, and the flange portions **988**

may be formed separately and secured together and/or simply secured to the main body of the tibial bone anchoring component **916**.

The bone engagement pad **970** may be formed separately from the main body of the tibial bone anchoring component **916**. Alternatively, the bone engagement pad **970** may be formed directly on the corresponding surfaces (i.e., the transverse surface **992**, the posts **990**, and the flanges **998**) of the tibial bone anchoring component **916**. In either case, the bone engagement pad **970** may be secured to the corresponding bone engagement surfaces of the tibial bone anchoring component **916** via various methods, such as diffusion bonding and/or through the use of a substance, such as the substance **340** referenced previously, which may be applied to one or both of the surfaces to be secured together to facilitate chemical and/or adhesive bonding. In some embodiments, a paste including a metallic powder, such as Titanium nanoparticles, may be used to facilitate diffusion bonding, melting together of the surfaces to be attached, and/or other attachment mechanisms. Alternatively or additionally, various welding techniques such as laser welding, friction welding, and/or the like may be used.

In some embodiments, the bone engagement pad **970** may have a non-uniform structure that presents different surface properties to the bone and the corresponding bone engagement surfaces of the tibial bone anchoring component **916** to which it is attached. For example, the bone engagement pad **970** may have a bone-facing surface with a high level of porosity and/or surface texturing to provide secure bone engagement and/or in-growth. The bone engagement pad **970** may further have a joint-facing surface secured to the corresponding bone engagement surfaces of the tibial bone anchoring component **916**, with a lower level of porosity and/or surface texturing to facilitate secure attachment of the bone engagement pad **970** to the corresponding bone engagement surfaces of the tibial bone anchoring component **916**.

In some embodiments, the porosity of the bone engagement pad **970** may have a gradient through the thickness of the bone engagement pad **970**, from a highly-porous state at the bone-facing surface of the bone engagement pad **970**, to a much less porous state at the joint-facing surface. In alternative embodiments, the change in porosity may be less gradual (i.e., “stepped.”). For example, additional material may be added to the joint-facing surface of the bone engagement pad **970** and melted, fused, and/or otherwise used to fill the pores in the joint-facing surface so that a layer exists on the joint-facing side in which the porosity is much lower than in the remainder of the bone engagement pad **970**. In either case, the result may be that the joint-facing surface of the bone engagement pad **970** is much smoother than the bone engagement surface of the bone engagement pad **970**, allowing the joint-facing surface to more readily and securely attach to the corresponding bone engagement surfaces of the tibial bone anchoring component **916**, while retaining the enhanced bone in-growth of a porous structure in the bone engagement surface of the bone engagement pad **970**.

FIG. **10** is a perspective view, from a different viewpoint, of the tibial bone anchoring component **916** of FIG. **9**. FIG. **10** depicts the positioning of flange portions **988** on both sides of the flanges **998** of the tibial bone anchoring component **916**. Of course, this is merely exemplary. Those of skill in the art will recognize that the bone engagement pad **970** may be reconfigured in a wide variety of alternative configurations.

For example, in some configurations, the post portions **980** may extend to cover more or less of the posts **990**, or may be omitted altogether. Similarly, the flange portions **988** may extend to cover more or less of the flanges **998**, or may be omitted altogether. One or more stem receiver portions (not shown) may be added to cover some portion(s) of the exterior-facing surfaces of the stem receiver **994**, adjacent to the transverse portion **982**. Yet further, in other alternative embodiments, the bone engagement pad **970** may include a stem portion (not shown) that covers some or all of the stem (not shown). Such protruding portions may have thicknesses that are greater than, less than, and/or equal to the thickness of the transverse portion **982**. Further, the transverse portion **982** may extend to cover more or less of the transverse surface **992**, or may be omitted altogether.

Further, those of skill in the art will recognize that the same principles may be applied to a femoral component. Specifically, a femoral component (not shown) according to an alternative embodiment may include a bone engagement pad that covers one or more bone-facing surfaces, including planar surfaces, post surfaces, and/or other bone-engaging surfaces.

Yet further, those of skill in the art will recognize that the same principles may be applied to any implant for which secure bone engagement is desired. A bone engagement pad, consisting of one or more portions that may be separately formed or formed as a single piece with each other, may be secured to one or more bone-facing surfaces of an implant for arthroplasty, fusion, or modification of any joint, or for replacement of hard tissue such as a tooth or jaw.

Any methods disclosed herein comprise one or more steps or actions for performing the described method. The method steps and/or actions may be interchanged with one another. In other words, unless a specific order of steps or actions is required for proper operation of the embodiment, the order and/or use of specific steps and/or actions may be modified.

Reference throughout this specification to “an embodiment” or “the embodiment” means that a particular feature, structure or characteristic described in connection with that embodiment is included in at least one embodiment. Thus, the quoted phrases, or variations thereof, as recited throughout this specification are not necessarily all referring to the same embodiment.

Similarly, it should be appreciated that in the above description of embodiments, various features are sometimes grouped together in a single embodiment, Figure, or description thereof for the purpose of streamlining the disclosure. This method of disclosure, however, is not to be interpreted as reflecting an intention that any claim require more features than those expressly recited in that claim. Rather, as the following claims reflect, inventive aspects lie in a combination of fewer than all features of any single foregoing disclosed embodiment. Thus, the claims following this Detailed Description are hereby expressly incorporated into this Detailed Description, with each claim standing on its own as a separate embodiment. This disclosure includes all permutations of the independent claims with their dependent claims.

Recitation in the claims of the term “first” with respect to a feature or element does not necessarily imply the existence of a second or additional such feature or element. Elements recited in means-plus-function format are intended to be construed in accordance with 35 U.S.C. § 112 Para. 6. Elements not so recited are not intended to be so construed. It will be apparent to those having skill in the art that

changes may be made to the details of the above-described embodiments without departing from the underlying principles set forth herein.

While specific embodiments and applications of the present disclosure have been illustrated and described, it is to be understood that the scope of the appended claims is not limited to the precise configuration and components disclosed herein. Various modifications, changes, and variations which will be apparent to those skilled in the art may be made in the arrangement, operation, and details of the methods and systems disclosed herein.

What is claimed is:

1. A prosthesis for replacing a natural articular surface on bone, the prosthesis comprising:

a joint facing side comprising an articular surface;  
a bone anchoring side comprising a bone engagement surface; and

a bone engagement pad secured to at least part of the bone engagement surface, the bone engagement pad comprising:

a pad bone-facing surface comprising a first porosity level; and

a pad joint-facing surface comprising a second porosity level lower than the first porosity level;

wherein the bone engagement surface is formed via a first manufacturing process; and the bone engagement pad is formed via a second manufacturing process different from the first manufacturing process, and wherein the first and second porosity levels of the bone engagement pad are formed during the second manufacturing process;

wherein the bone engagement pad comprises a transverse portion configured to extend transverse to a length of the bone, the pad bone-facing surface and the pad joint-facing surface are on opposite sides of the bone engagement pad, and the transverse portion comprises a porosity gradient by which porosity of the transverse portion gradually increases toward the pad bone-facing surface.

2. The prosthesis of claim 1, wherein: the first manufacturing process is selected from the group consisting of forging, milling, and casting; and the second manufacturing process is an additive manufacturing process.

3. The prosthesis of claim 2, wherein: the second manufacturing process is 3D printing.

4. The prosthesis of claim 1, wherein the bone engagement pad has a thickness within the range of 0.5 mm to 1.5 mm.

5. The prosthesis of claim 1, wherein the transverse portion has a thickness, parallel to the length, that is uniform.

6. The prosthesis of claim 1, wherein the bone engagement pad comprises:

one or more protruding portions extending perpendicular to the transverse portion.

7. The prosthesis of claim 6, wherein: the bone engagement surface comprises a bone engagement feature extending through an aperture formed in the transverse portion; and the one or more protruding portions extend from one or more edges of the aperture, alongside one or more surfaces of the bone engagement feature.

8. The prosthesis of claim 1, wherein: the prosthesis comprises a knee implant;

the articular surface is configured to a shape to replace the natural articular surface; and

the natural articular surface is one of a natural tibial surface and a natural femoral articular surface.

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9. The prosthesis of claim 1, wherein: the bone engagement surface comprises a bone engagement feature extending through an aperture formed in the bone engagement pad.

10. A prosthesis for replacing a natural articular surface on bone, the prosthesis comprising:

- a joint facing side comprising an articular surface;
- a bone anchoring side comprising a bone engagement surface; and

a bone engagement pad secured to at least part of the bone engagement surface, the bone engagement pad comprising:

- a transverse portion configured to extend transverse to a length of the bone; and
- wherein the bone engagement pad has a thickness within the range of 0.5 mm to 1.5 mm;

wherein the bone engagement pad comprises a pad bone-facing surface and a pad joint-facing surface on opposite sides of the bone engagement pad, and the transverse portion comprises a porosity gradient by which porosity of the transverse portion gradually increases toward the pad bone-facing surface.

11. The prosthesis of claim 10, wherein: the bone engagement surface is formed via a first manufacturing process; and the bone engagement pad is formed via a second manufacturing process different from the first manufacturing process.

12. The prosthesis of claim 11, wherein: the first manufacturing process is selected from the group consisting of forging, milling, and casting; and the second manufacturing process is an additive manufacturing process.

13. The prosthesis of claim 10, wherein the thickness is parallel to the length and is uniform.

14. The prosthesis of claim 10, wherein: the prosthesis comprises a knee implant;

- the articular surface is configured to a shape to replace the natural articular surface; and
- the natural articular surface is one of a natural tibial surface and a natural femoral articular surface.

15. The prosthesis of claim 10, wherein: the transverse portion has a thickness, parallel to the length, that is uniform.

16. The prosthesis of claim 10, wherein: the bone engagement pad further comprises one or more protruding portions extending generally perpendicular to the transverse portion.

17. The prosthesis of claim 16, wherein: the bone engagement surface comprises a bone engagement feature extending through an aperture formed in the transverse portion; and the one or more protruding portions extend from one or more edges of the aperture, alongside one or more surfaces of the bone engagement feature.

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18. The prosthesis of claim 10, wherein: the prosthesis comprises a knee implant and the articular surface is configured to replace the natural articular surface.

19. A prosthesis for replacing a natural articular surface on bone, the prosthesis comprising:

- a joint facing side comprising an articular surface;
- a bone anchoring side comprising a bone engagement surface; and

a bone engagement pad secured to at least part of the bone engagement surface, the bone engagement pad comprising:

- a transverse portion configured to extend transverse to a length of the bone, a pad bone-facing surface and a pad joint-facing surface are on opposite sides of the bone engagement pad, and the transverse portion comprises a porosity gradient by which porosity of the transverse portion gradually increases toward the pad bone-facing surface;

wherein: the bone engagement surface comprises one or more bone engagement features extending through one or more corresponding apertures formed in the transverse portion.

20. The prosthesis of claim 19, wherein: the transverse portion comprises one or more protruding portions corresponding to the one or more bone engagement features.

21. The prosthesis of claim 20, wherein: the one or more protruding portions extend from one or more edges of the one or more corresponding apertures, alongside one or more surfaces of the one or more bone engagement features.

22. The prosthesis of claim 19, wherein the bone engagement pad has a thickness within the range of 0.5 mm to 1.5 mm.

23. The prosthesis of claim 19, wherein the bone engagement surface is formed via a first manufacturing process; and the bone engagement pad is formed via a second manufacturing process different from the first manufacturing process.

24. The prosthesis of claim 23, wherein the transverse portion comprises:

- the pad bone-facing surface comprising a first porosity level; and

- the pad joint-facing surface comprising a second porosity level lower than the first porosity level;

and wherein the first and second porosity levels of the transverse portion are formed during the second manufacturing process.

25. The prosthesis of claim 24, wherein: the second manufacturing process is 3D printing.