

# Production Order: 500000303891



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

Material Type:	ZFRT	Description: Edwards Flex Shaft Commander 155885	Order Type: ZSTD
Production Version:	7987		Project Phase:
Plant / Business Unit:	1213 / AC5		

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																								
50	KITTING3  Kitting Devices    Kitting Devices	<p>Kitting Devices</p> <p>Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KP02 5:30AM 05Feb24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 11:45pm 06Feb24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table><thead><tr><th>Component Number</th><th>Req'd Rev Rev Used</th><th>UOM</th><th>Qty.</th><th>Batch No.</th><th>Actual Qty Used</th></tr></thead><tbody><tr><td>MM0179-01</td><td>D <u>D</u></td><td>PC</td><td>500</td><td><u>0000293119</u></td><td><u>500</u></td></tr><tr><td></td><td></td><td></td><td></td><td><u>0000276172</u></td><td><u>40</u></td></tr><tr><td>MM1536-01</td><td>B <u>B</u></td><td>PC</td><td>500</td><td><u>0000290560</u></td><td><u>500</u></td></tr></tbody></table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>					<u>0000276172</u>	<u>40</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>	N/A	N/A	06Feb24	DKW
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>																									
				<u>0000276172</u>	<u>40</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>																									

Notes: DA 2484, 2564

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>0000271063</u>	<u>40</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>81054</u>	<u>100</u>		
							<u>N/A</u>	<u>N/A</u>		
							<u>87897</u>	<u>200</u>		
							<u>87896</u>	<u>200</u>		
							<u>87904</u>	<u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>		
							<u>N/A</u>	<u>N/A</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u>	<u>500</u>		
							<u>N/A</u>	<u>N/A</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>Bulk</u>		
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>Bulk</u>		

## Notes:

N/A

N/A

N/A

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① KPO2 08-Feb-24

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N/A	N/A	141967-01	02	02	PC	500	85794	500		
							N/A	N/A		
		RM7349-02	C	C	PC	543	82861	500		
							N/A	N/A		
		RM7348-01	C	C	PC	500	84587	500		
							N/A	N/A		
		RM4001-01	B	B	PC	125	82803	200		
							N/A	N/A		
N/A	N/A	RM0607-01	D	D	PC	56	71863	60	N/A	N/A
							N/A			
N/A	N/A	RM0498-01	C	C	PC	500	0000287647 0000287646 0000287645	343 18 145		
N/A	N/A	RM0009-04	I	I	PC	1	88992	Bulk		
							N/A	Bulk		
N/A	N/A	RM0009-04	I	I	PC	1	88992	Bulk		

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>N/A</u> <u>0000240562</u>	<u>Bulk</u> <u>500</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000258434</u> <u>0000290561</u>	<u>40</u> <u>1060</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u> <u>0000252923</u>	<u>500</u> <u>40</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282490</u> <u>N/A</u>	<u>500</u> <u>N/A</u>	N/A	N/A	N/A
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u> <u>N/A</u>	<u>500</u> <u>N/A</u>			
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u> <u>N/A</u>	<u>500</u> <u>N/A</u>			
		MM0074-01	G	<u>G</u>	PC	500	<u>0000300895</u> <u>N/A</u>	<u>519</u> <u>N/A</u>			

Notes:

N/A

N/A

N/A

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MIA	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0 07 Feb 24	V078	
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0 07 Feb 24 SY47 PM96	V078	

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1  	Loading Braid Stock	500	0	07Feb24	cp32 Y014
	Loading Braid Stock					
	Confirmation Reqd(Milestone )					
250	CATASY01 Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	07Feb24	CLO5 AS31
<b>Notes:</b>						
N/A						
N/A						
N/A						

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End  Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
300	CATASY01  Catheter Assembly 1  	Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	500	0	07 Feb 24	ST23 DX35
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	07 Feb 24	ST96 GS22
Notes:						
MA						
N/A						
N/A						

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	 Load Tubing Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
400	 CATASY01 Catheter Assembly 1   Reflow Confirmation Reqd(Milestone )		500	0	07 Feb 24	CL30 SF85 PM96
450	 CATASY01 Catheter	FEP Removal	500	0	07 Feb 24	PM96 0521 JY96
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1  FEP Removal  Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
500	CATASY01  Catheter Assembly 1  In-process Inspection and Rework  Confirmation Reqd(Milestone )	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 81898 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	484	16 07Feb24	OF-44411 EW-44411 TD45	LL61 VC09 CB81 P266 VL91
		N/A	N/A	N/A	N/A	N/A
	Notes:	N/A N/A N/A				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01  Catheter Assembly 1  	Remove Heat Shrink & Mandrel  Remove Heat Shrink & Mandrel  Confirmation Reqd(Milestone )	484	0	07Feb24	RS23 PH59 DY29 MV78
600	CATASY01  Catheter Assembly 1  	Distal Tip Assembly	473	11	07Feb24	VA96 PH59 ML60 mno2

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	473	0	07Feb24	PH59 DYK9 ML36
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: <u>0936A</u> Cal Due: <u>31 MAY 24</u> TMI: <u>2083C</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0521</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0386</u> Cal Due: <u>31 MAY 24</u> Tipping	473	0	07Feb24	SIX48 HV36 ML36
<b>Notes:</b>						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
750	CATASY01  Catheter Assembly 1  	<p>Tip Inspection/ Flash Removal Material Consumed:</p> <p>Part #: Rm4001-01 Batch #: 52803 Qty: N/A      Part #: Rm067-01 Batch #: 71863 Qty: N/A      Part #: N/A Batch #: N/A Qty: N/A      Part #: N/A Batch #: N/A Qty: N/A      Part #: N/A Batch #: N/A Qty: N/A</p> <p>Tip Inspection/ Flash Removal  Confirmation Reqd(Milestone )</p>	471	EH-11  ②	07Feb24	STX48 Hv36 5552 SV46
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	462	ACP-III III ⑨	07Feb24	5552 SS44 5588

Notes:

N/A

N/A

N/A

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① 5552 07 Jan 24



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N/A	Major Mandrel Removal  Confirmation Reqd(Milestone )	N/A	N/A	N/A N/A N/A		
850	CATASY01  Catheter Assembly 1  	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	4.59	SKU -111	07Feb24	SS52 ML65
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A
<b>Notes:</b>						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Quality Inspection & Review  Confirmation Reqd(Milestone )	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: 0706-01 Cal Due: 31 may 24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: 2n4001-01 Batch #: 82803 Qty: N/A Part #: 1000-1153-01 Batch #: 67897 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A</p>	447  478  ①	DIS-HIT ACD-HL① BP-① EW-1111 DEL-III MAR-1111①	07Feb24  KL67 XL91 HT72	PY46 K155 MU33 SH04 KL67 XL91 HT72
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: 50713B Cal Due: 12APR24 Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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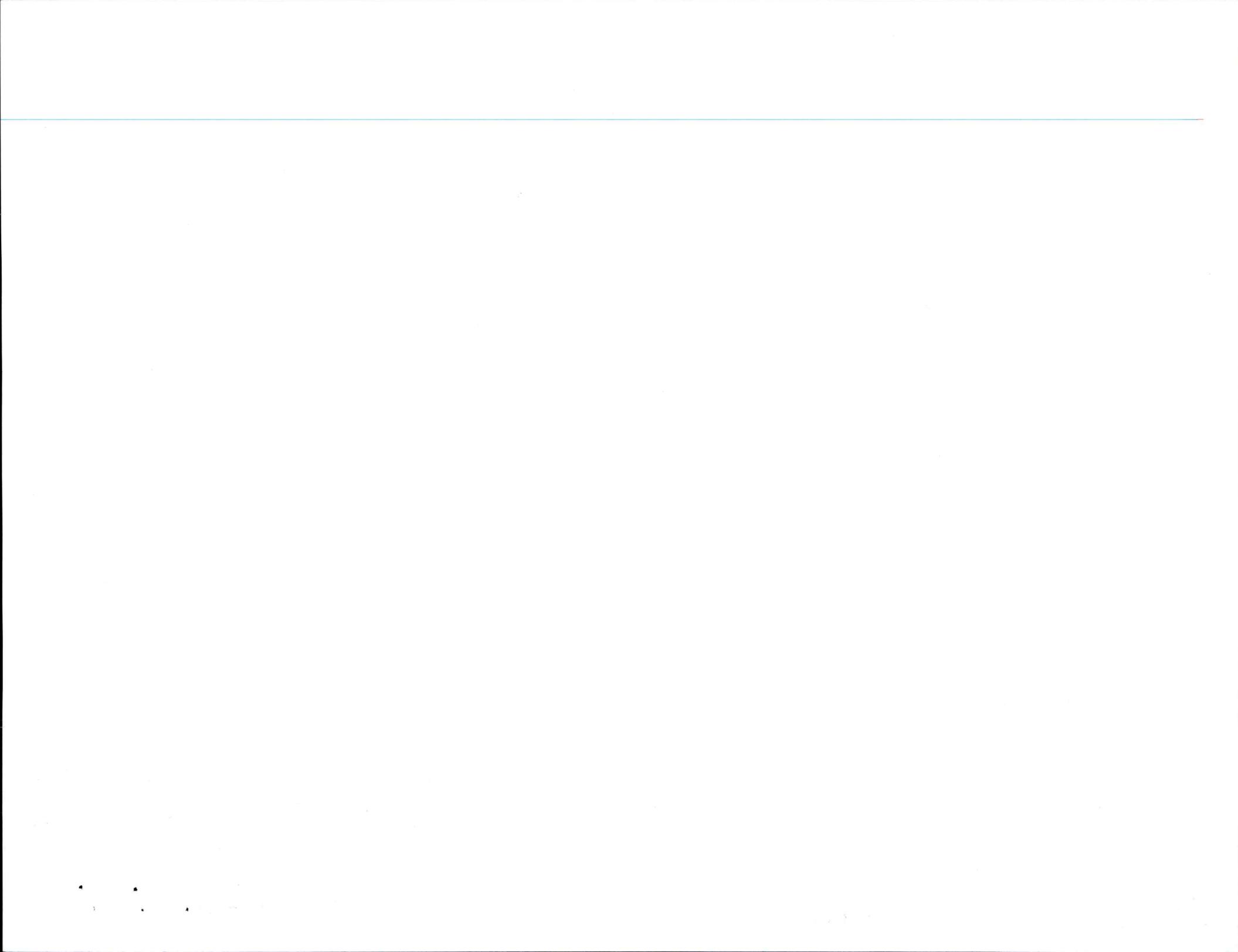
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① XL91 07Feb24





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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: 0733 Cal Due: 30 APR 24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 SEP 25 TMI: 0692 Cal Due: 30 SEP 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	432 408	TD+① ① DIS-1H HHH HHH (SP) STR- IIII WK-1 DIS- HHH HHH	07Feb24	0521 KL67 XL91
1000	 Quality Inspection & Review  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: 1056 Cal Due: 31 MAY 24 Record Length Gage Information: TMI: 08890 Cal Due: 30 SEP 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 SEP 24	① 382 422	24 - HHH HHH HHH HHH HHH HHH	07Feb24	5544 KL67 XL91

Notes:

N/A  
N/A  
N/A

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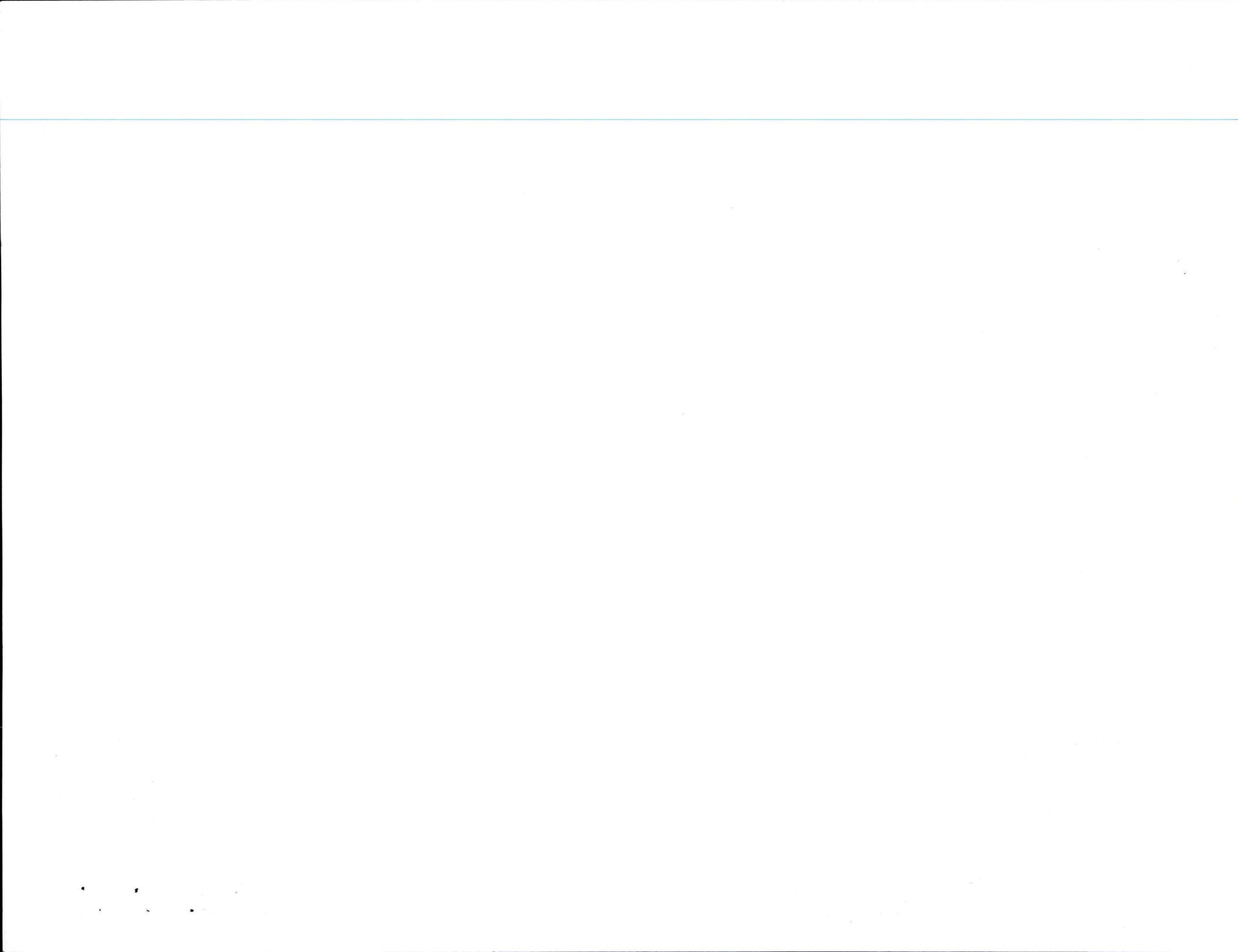
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	<b>QUALITY1</b> Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone )	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	391	SCR-1111 DEL-1 VD-1111 AB-1 DIS-111 BP-111 FB-111 SKV-11 DISC-1 FM-1 (TT) DL-111 (TT) (31)	07 Feb 24 SV43 XN26	
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02</u> <u>08 Feb 24</u>	N/A	N/A	08 Feb 24 KP02	

Notes:

N/A  
N/A  
N/A

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1100	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1  Packing assembly    Package Confirmation Reqd(Milestone )	Package Package, Label, and Ship Finished Parts	391	O 09 Feb 24	AP10	AP10

Notes:

N/A AP10 09 Feb 24

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Material: SA0155-01 Rev F

Batch Number: 0000303891

By: AP10

Date: 09 Feb 24

Reviewed By:

RBZ9

Date:

09 Feb 24

Notes:

N/A AP10 09 Feb 24

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Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 Jul 2023
Mgr. Manufacturing Engineering	Jake Stanislowski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF Deviation Authorization

**CONTROLLED COPY**

① UK55, 23JW 2023



Group Training Record

**Description/Objectives of Training:**

DA- Inspection at final QC, Op#1050.

**Procedure:**

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and ~~MM1536-02~~ fixture for inspection. (See image 1)  
① **MM01536-01** *typo correction TS12 10AUG23*

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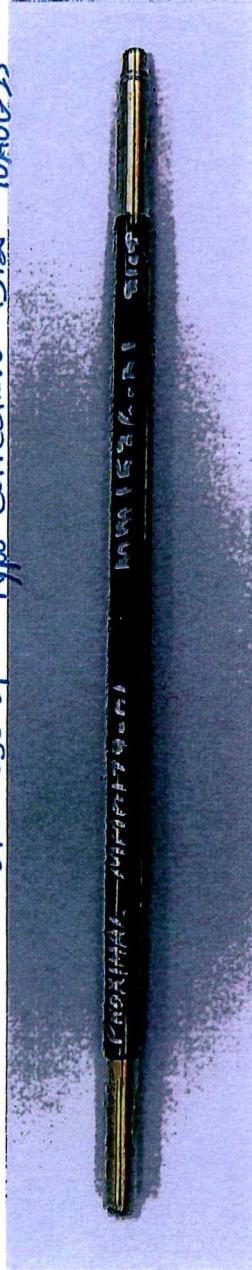


Image- 1

**Step 1:**

- Visually locate the MM0180-01 (Vestamid) transition to MM0179-01 on the completed part approximately 9.75" from the distal end using magnification light 2.25X minimum.
- Align the fixture MM0179-01 extrusion proximal end to the Vestamid transition on completed part. (See image 2)



Image- 2

- Visually verify the MM0179-01 distal end of the fixture is approximately at the same location on the completed part. (See image 3)

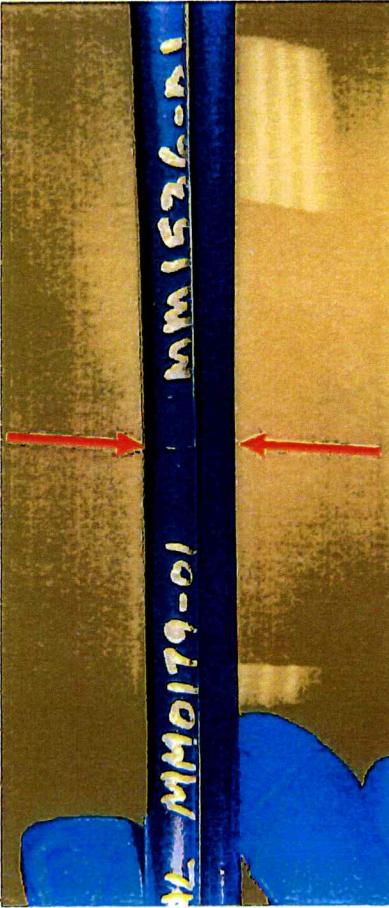


Image- 3

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, move to Step 2.

**Step 2:**

- Visually verify the MM1536-01 distal end of the fixture is approximately at the same location on the completed part. (See image 4)

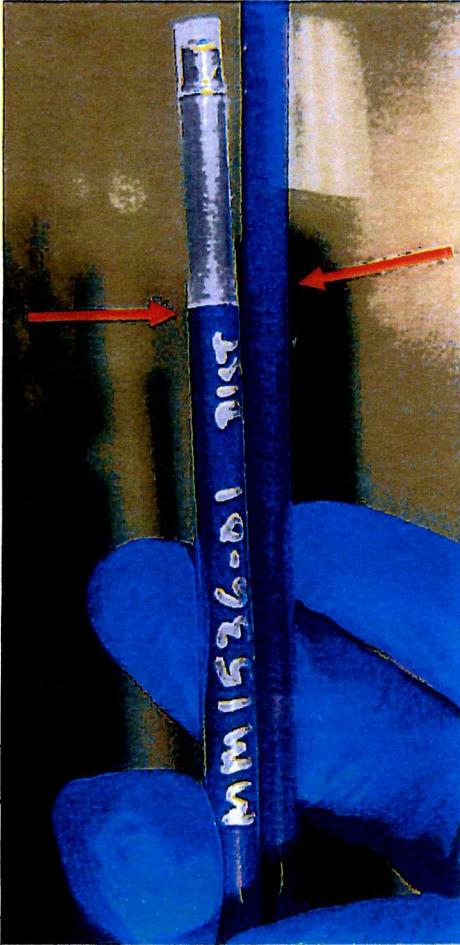


Image- 4

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

<b>1</b>	MM0179-01 <b>GOOD PART</b>	MM1536-01
<b>2</b>	MM1536-01	MM0179-01 <b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>
<b>3</b>	MM0179-01	MM0179-01 <b>Two MM0179-01 - BAD PART</b>
<b>4</b>	MM1536-01	MM1536-01 <b>Two MM1536-01 - BAD PART</b>

Image - 5

Entered to MANDRIN 3228 12/15/2023

Entered to 13 Feb 2024 3228 1/9/2024

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## DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc # 3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<p>Doc #<b>3005206</b> (Flex Commander MPI0238): <b>OPER850.11:</b> Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.</p>	<p>Doc #<b>3005206</b> (Flex Commander MPI0238): <b>OPER850.11:</b> Using a laser micrometer at <b>OPER900 (TMI0700-01)</b>, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.</p>		
<b>Justification:</b> TMI0602 lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable. TMI0700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified to inspect Dim 6 per ES0647; Laser micrometer equivalency test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:		
16 Nov 23	15 DEC 23		
Lot Number:			
N/A			
<b>Risk Assessment:</b> Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
<b>Corrective Action Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No			
<b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> N/A			
Title	Approval Name	Approval Signature	Date
Engineering Manager	Jake Stanislowski		16 Nov 2023
Quality Manager	Jay Zabel		16 Nov 2023
Operations Manager	Matthew Benson		16 Nov 2023



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000303891

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0942	44	12:37AM	429	SH85	07 Feb 24	12:49AM	415	SH85	07 Feb 24	16
TMI0942	44	1:13 AM	430	SH85	07 Feb 24	1:25 AM	415	SH85	07 Feb 24	16
TMI0942	44	1:45 AM	430	SH85	07 Feb 24	1:57 AM	415	SH85	07 Feb 24	16
TMI0942	44	5:35 am	430	AX05	07 Feb 24	5:47 am	415	AX05	07 Feb 24	16
TMI0942	44	6:15 am	430	TA36	07 Feb 24	6:27 am	415	TA36	07 Feb 24	16
TMI0942	44	6:38 am	427	AX05	07 Feb 24	6:50 am	415	AX05	07 Feb 24	16
TMI0942	44	7:35 am	430	OS21	07 Feb 24	7:47 am	415	OS21	07 Feb 24	16
TMI0942	44	8:15 am	430	OS21	07 Feb 24	8:27 am	415	OS21	07 Feb 24	16
TMI0942	44	8:30 AM	430	PM96	07 Feb 24	8:42 AM	415	PM96	07 Feb 24	16
TMI0942	44	9:00 AM	427	NK62	07 Feb 24	9:12 AM	415	NK62	07 Feb 24	16
TMI0942	44	10:00AM	430	OS21	07 Feb 24	10:12AM	415	OS21	07 Feb 24	16
TMI0942	44	11:15AM	430	AX05	07 Feb 24	11:27AM	415	AX05	07 Feb 24	16



**PRODUCTION ORDER#** 500000303891

OP 400

**Document No:** 5105589  
**FM5104665 Rev:** C  
**Document Type:** Manufacturing Form  
**Title:** SA0155-01 Reflow Log Sheet Form



Document No: 5105589  
FM5104665 Rev: C  
Document Type: Manufacturing Form  
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000303891

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	12:58AM	430	CL 30	07 Feb 24	1:10 AM	415	SH85	07 Feb 24	16
TM10745	44	1:30AM	430	CL 30	07 Feb 24	1:42 AM	415	CL 30	07 Feb 24	16
TM10745	44	1:58AM	428	SH85	07 Feb 24	2:10 AM	415	V078	07 Feb 24	11
TM10745	44	5:20AM	430	AX05	07 Feb 24	5:32AM	415	AX05	07 Feb 24	16
TM10745	44	5:45AM	430	AX05	07 Feb 24	5:57AM	415	AX05	07 Feb 24	16
TM10745	44	6:48AM	430	AX05	07 Feb 24	7:00AM	415	AX05	07 Feb 24	16
TM10745	44	8:00AM	430	OS 21	07 Feb 24	8:12AM	415	OS 21	07 Feb 24	16
TM10745	44	8:45AM	430	PM 96	07 Feb 24	8:57AM	415	PM 96	07 Feb 24	16
TM10745	44	9:20AM	430	AX05	07 Feb 24	9:32AM	415	AX05	07 Feb 24	16
TM10745	44	9:40AM	426	AX05	07 Feb 24	9:52AM	415	AX05	07 Feb 24	16
TM10745	44	10:55AM	430	OS 21	07 Feb 24	11:17AM	415	OS 21	07 Feb 24	16
TM10745	44	11:40AM	430	AX05	07 Feb 24	11:52AM	415	AX05	07 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000303891

OP 400



PO #: 500000303891

OP #500

Shift #: 15

Document No: 5106073

Rev: E

**Document Type:** Manufacturing Form

**Title: SA0155-01 Visual Rework Form**

Total Parts Reworked:		170	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		37
EW	Exposed Wire		98
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		1
VD	Voids		30
N/A	N/A	N/A	N/A

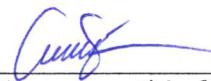
**Note:** Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

**Data Uploaded for Engineering Review (Check):**



Document No: 5106073  
Rev: E  
Document Type: Manufacturing Form  
Title: SA0155-01 Visual Rework Form

PO #: 50000303891 OP #: 500 Shift #: 2

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire	HH 11	7
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	///	4
N/A	N/A	N/A	0
Inspected By (Sign and Date):		 07 Feb 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000303891 OP #: 750 Shift #: 1st

Total Parts Reworked:		53	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		21
DIM07 US / WC	DIM07 Undersized (Window Closed)		7
EH	Exposed Hypotube		15
N/A	Glue , stopper		10
Inspected By (Sign and Date):		Hv36 07 Feb 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 50000303891OP #: 750 Shift #: 2nd

Total Parts Reworked:		14	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		5
DIM07 US / WC	DIM07 Undersized (Window Closed)		2
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SVH6 07 Feb 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

PRODUCTION ORDER# 500000303891

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	7:25am	190°F	SSHH	07 Feb 24	8:35am	190°F	SSHH	07 Feb 24	36
Tm12036	N/A	8:00am	190°F	K155	07 Feb 24	9:10 am	190°F	K155	07 Feb 24	32
Tm12036	N/A	8:40am	190°F	SSHH	07 Feb 24	9:50am	190°F	SSHH	07 Feb 24	36
Tm10409	N/A	10:05am	190°F	OS21	07 Feb 24	11:15am	190°F	KT47	07 Feb 24	34
Tm10409	N/A	11:20am	190°F	KT47	07 Feb 24	12:30pm	190°F	KT47	07 Feb 24	36
Tm12036	N/A	11:50am	190°F	KT47	07 Feb 24	1:00 pm	190°F	KT47	07 Feb 24	31
Tm10409	N/A	12:35pm	190°F	OS21	07 Feb 24	1:45pm	190°F	SSHH	07 Feb 24	28
Tm10409	N/A	1:50pm	190°F	SSHH	07 Feb 24	3:00pm	190°F	SSHH	07 Feb 24	30
Tm12036	N/A	2:30pm	190°F	K155	07 Feb 24	3:40pm	190°F	K155	07 Feb 24	43
Tm10409	N/A	4:00 pm	190°F	SG88	07 Feb 24	5:10pm	190°F	SG88	07 Feb 24	32
Tm12036	N/A	4:44pm	190°F	SG88	07 Feb 24	5:45pm	190°F	SG88	07 Feb 24	45
Tm10409	N/A	5:24pm	190°F	SG88	07 Feb 24	6:34 pm	190°F	SG88	07 Feb 24	37
Tm10409	N/A	6:47pm	190°F	SG88	07 Feb 24	7:57pm	190°F	SG88	07 Feb 24	42



**Document No: 6102619**

Rev: B

## **Document Type: Manufacturing Form**

## **Title: SA0155-01 Dimensional/Visual Rework Form**

**PO #:** 50000030389

**OP #: 900 Shift #: 1st**

Total Parts Reworked:		65	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	N/A	N/A
EW	Exposed Wire		11
MP	Micropores	N/A	N/A
SCR	Scratch		78
SKV	Skive Marks	N/A	N/A
VD	Voids		7
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		6
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

**Data Uploaded for Engineering Review (Check):**

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000303891

OP #: 900 Shift #: 2

61

Total Parts Reworked:			
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		3
EH	Exposed Hypotube	N/A	N/A
EW	Exposed Wire		34
MP	Micropores	N/A	N/A
SCR	Scratch		51
SKV	Skive Marks	N/A	N/A
VD	Voids		6
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT 72 07 Feb 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000303891 OP #: 900 Shift #: 2nd

Total Parts Reworked:		26	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		1
EW	Exposed Wire		3
MP	Micropores	N/A	0
SCR	Scratch		14
SKV	Skive Marks	N/A	0
VD	Voids		2
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		20
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 07 Feb 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be selected and tensile tested)																
Sample # -->	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	25.37	24.27	24.5	27.7	24.11	24.44	27.77	26.16	25.83	24.75	25.49	1.361551	4.378	19.529128	8.542	PASS
Seg B	57.73	56.58	55.72	57.75	57.73	59.74	63.17	59.57	64.68	58.35	59.102	2.833242	3.981	47.8228622	8.542	PASS
Seg C	79.82	81.3	79.37	77.48	80.2	78.04	79.17	82.61	80.17	79.32	79.748	1.479811	2.911	75.4402708	8.542	PASS

All Force Values are recorded in Pound-Force and Distance is in Inches  
Specification for lower bound is 38N was converted to 8.542Lbf  
First Peak Force was collected during test and has been included in the raw data file ( this information will not be captured / summarized in the DA due to it is not required to used for DA acceptance.

### EDW Commander Flex - Bend and Tensile Strength Testing

LOT #: 500000303891

Date: 08 Feb 24

Inspector Name: Javier Olivares

Equipment ID: TMII0311B

Cal Due Date: 27 OCT 24

J001 08 feb 24