

Production Order: 500000307855



Production Order Document
Production Order Qty: 500

PC
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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 Work Center Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																							
50	KITTING3 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>XLOO 5:00PM</u> <u>20Feb24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XLOO 11:00 AM</u> <u>21 Feb 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table border="1"> <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</td> <td>D</td> <td>500</td> <td><u>6000293119</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>N/A</u></td> <td><u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B</td> <td>B</td> <td>500</td> <td><u>6000290560</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	D	500	<u>6000293119</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B	B	500	<u>6000290560</u>	<u>500</u>	N/A	N/A <i>18Feb2024</i>	DK00
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																								
MM0179-01	D	D	500	<u>6000293119</u>	<u>500</u>																								
				<u>N/A</u>	<u>N/A</u>																								
MM1536-01	B	B	500	<u>6000290560</u>	<u>500</u>																								

Notes: DA 2484, 2564

N/A

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		RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u>	<u>N/A</u>	<u>200</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>90426, 90288</u> <u>90434</u> <u>90394</u> <u>90396</u>	<u>100, 100</u> <u>100</u> <u>100</u> <u>100</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>400</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u>	<u>500</u>			
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>			
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>			

Notes:

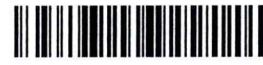
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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		141967-01	02	02	PC	500	86568	503			
		RM7349-02	C	C	PC	543	82864	N/A			
		RM7348-01	C	C	PC	500	86496 000307855	530			
		RM4001-01	B	B	PC	125	82821	600			
		RM0607-01	D	D	PC	56	78845	N/A			
		RM0498-01	C	C	PC	500	000287652 RATO	100	N/A	N/A	N/A
		RM0009-04	I	I	PC	1	88493	200			
		RM0009-04	I	I	PC	1	88493	N/A			

Notes:

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① DK00
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② DK00
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N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		A	<u>A</u>	PC	1000	<u>0000294701</u>	<u>1000</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		C	<u>C</u>	PC	500	<u>0000294697</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		E	<u>E</u>	PC	500	<u>0000294374</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		E	<u>E</u>	PC	500	<u>0000290565</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		D	<u>D</u>	PC	500	<u>0000307855</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		G	<u>G</u>	PC	500	<u>0000288413</u> <u>0000306617</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
						<u>0000305625</u>	<u>519</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>

Notes:

N/A

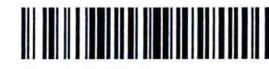
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N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting Line Clearance Confirmation Reqd(Milestone)	500	0	21Feb24	KL95
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	0	21Feb24	NK62 Dm96 V578 Y014 SH23 JY90
Notes:						
N/A						
N/A						
N/A						

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N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	21Feb24	M450 SXII ST96 DX35
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	21Feb24	VPC2 01V39 CP32 AS31

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	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)	N/A	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	21Feb24	W25 D139 SH23 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	21Feb24	CY97 FL34 Ch05 V078

Notes:
N/A
N/A
N/A

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N/A	 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	21Feb24	Ax05 TA36 RM96 SK60 SY47
450	CATASY01 Catheter	FEP Removal	500	0	21Feb24	PM96 SG88 1266 TRWAT39
Notes:						
N/A						
N/A						
N/A						

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	Assembly 1 					
N/A	FEP Removal	N/A	N/A	N/A	N/A	N/A
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-115301 Batch #: 88624 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	488	EW-HH1111 VD-11 DF-1 (12)	21Feb24	L61 CB81 VL91 R66 TD45
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
N/A	N/A	N/A N/A N/A N/A	N/A	N/A	N/A	N/A
Notes:						

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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)	487	DL -1	21 Feb 24	PTH59 RS93 FB01 SV46
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	485	MAH-11 (2)	21 Feb 24	FB01 AK02 ML60 AT39

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	485	0	21 Feb 24 AX82 MM02	
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0386 Cal Due: 31/MAY/24 TMI: 0521 Cal Due: 31/MAY/24 TMI: 2083C Cal Due: 31/MAY/24 TMI: 0936A Cal Due: 31/MAY/24 Tipping	485	0	21 Feb 24 RS23 MM02	
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	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 #: 82821 Qty: 10 Part #: RM0607-01 Batch #: 78845 Qty: 12 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>	485	0	21 Feb 24	HV36 STX48 PP40
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	474	ACD-HH HHI 11	21 Feb 24	SS52 KT26 XL91
Notes:						
N/A						
N/A						
N/A						

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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 Confirmation Reqd(Milestone)	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>pass</u> 2. <u>pass</u> 3. <u>pass</u> 4. <u>pass</u> 5. <u>pass</u>	474	0	22 Feb 2024	yp36 552
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	S104 HT72 ML65 MV33

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
	 Quality Inspection & Review Confirmation Reqd(Milestone) <i>N/A</i>	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information:</p> <p>TMI: <u>0100-01</u> Cal Due: <u>31MAY24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>1000-153-01</u> Batch #: <u>90426</u> Qty: <u>N/A</u></p> <p>Part #: <u>Pn4001-01</u> Batch #: <u>52821</u> Qty: <u>17</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	<i>425</i>	#5US-I #6US-II #70S-HHIII #90S-III EW-III WK-III MAR-HH DIS-HHHT HHHT (49)	<i>22 Feb 2024</i> <i>R446</i> <i>k155</i> <i>KT27</i>	<i>KL67</i> <i>XL91</i> <i>P446</i>
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>50713B</u> Cal Due: <u>12APR24</u></p> <p>Record Caliper Information:</p>	<i>N/A</i>	<i>N/A</i>	<i>N/A</i>	<i>N/A</i>

Notes:

*N/A**N/A**N/A*

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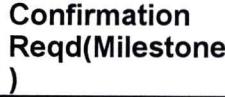


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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>TMI: <u>0735</u> Cal Due: <u>30 APR 24</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 SEP 25</u> TMI: <u>0692</u> Cal Due: <u>30 SEP 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u></p>	412	DIS(SP) HHT DIS-3 ^⑥ DIS-1111 STR-1 WK-11 TD-1 (13)	22 Feb 24	KL67 XL91
1000	 Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31 MAY 24</u> Record Length Gage Information: TMI: <u>0889 D</u> Cal Due: <u>30 SEP 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u></p>	402	(10)	22 Feb 24	KL67 XL91 TRN KT26 SS44

Notes:

N/A

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(1) KL67 21 Feb 24

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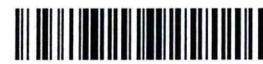


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N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone)	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS		SCE-XM HTT (TT) SKV-XM HTT HTT II BP-HTI DIS-III VD-II WK-II ETT - I FB-1 Mar-1 CRK-1 Del-1 (XU)	22 Feb 24	SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): GS85 22 Feb 24	N/A	N/A	22 Feb 24	GS85
Notes:						
N/A						
N/A						
N/A						

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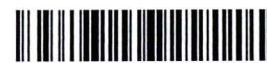
Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	358	0	22 Feb 24	BA71

Notes:

Mr
Mr
Mr

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Batch Number: 0000307855

By: BA71

Date: 22 Feb 24

Reviewed By:

RB29

Date:

23 feb 24

Notes:

H/N

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Beta 4 → 2024 3228 11/16/23
Ex-els → 19 Feb 2024 3228 11/16/23
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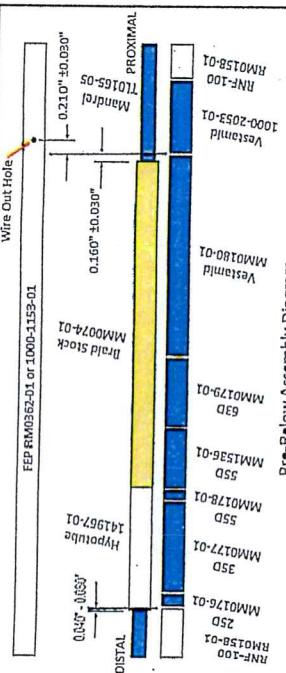
Ex-els to 2024 3228 11/16/23

Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

Deviation From:
QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050:
Current QIP3107610 does not state to inspect for the correct extrusion configuration.

Deviation To:
This DA allows addition inspection for correct assembly of extrusion material MM0179-01 and MM1536-01 during performing QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050.
See instructions attached to this DA.



Justification: Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-26390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with out of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid incorrect assembly defects.

Part Number Affected	Revision
SA0155-01	H

Start Date: 26 Jul 2023 **End Date:** 25 Aug 2023 **Lot Number:** N/A

Risk Assessment:
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:
Control Plans Yes No FMEA's Yes No Validations Yes No
Details (if any): N/A

If yes to any of the above, what controls are being put in place to mitigate the risk.

Corrective Action Required:	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No
If no, explain: No corrective action is required for this event as there are no changes to the current process, consumption of material, or how the product is produced. This added inspection guidelines are to avoid incorrect extrusion assembly defects.		If no, explain:

Training Required: Yes No

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

FM0002.RevF Deviation Authorization

CONTROLLED COPY

① UK55, 23JW 2023



DA DA 2484
2468 ①

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 MM1536-01 fixture for inspection. (See image 1)

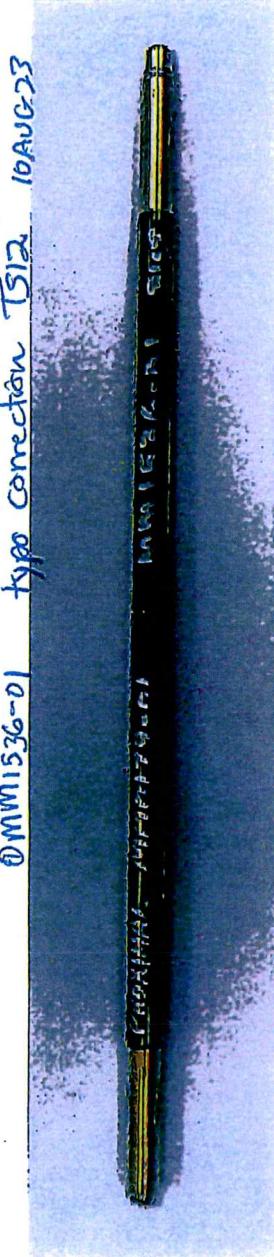


Image- 1

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)

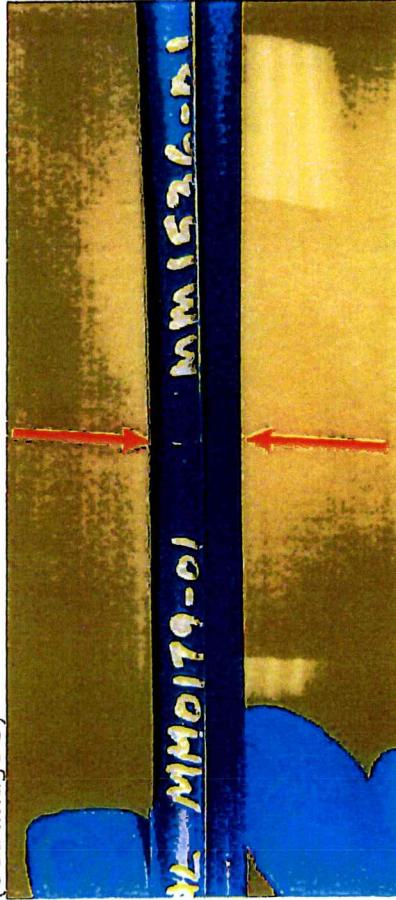


Image- 3

- 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)

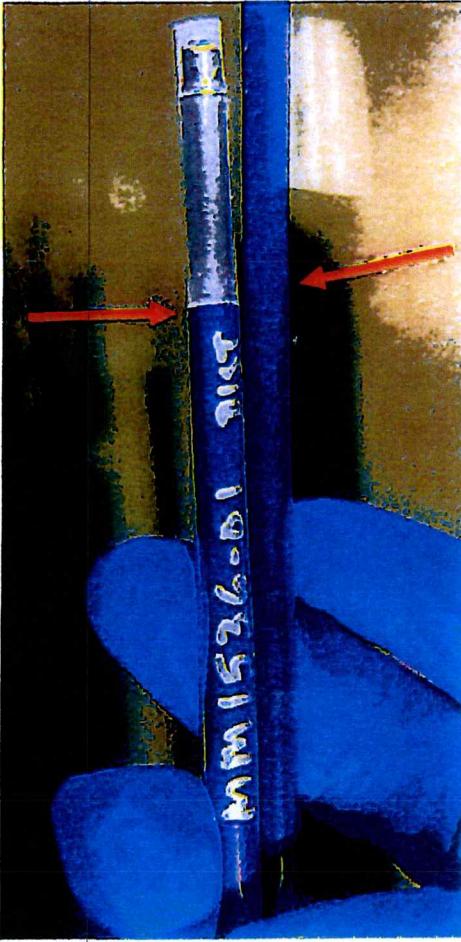


Image- 4

- 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.

1	MM0179-01 GOOD PART	MM1536-01
2	MM1536-01	MM0179-01 MM0179-01 and MM1536-01 Wrong Order - BAD PART
3	MM0179-01	MM0179-01 Two MM0179-01 - BAD PART
4	MM1536-01	MM1536-01 Two MM1536-01 - BAD PART

Image - 5

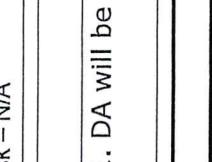
DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	
Doc #3005206 (Flex Commander MPI0238): OPER850.11: 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.	
Deviation To:	
Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer at OPER900 (TMI0700-01) , 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.	

Justification:

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			
Risk Assessment:			
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			
Corrective Action Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
If no, explain: This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
Training Required: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No If no, explain: N/A			
Title	Approval Name	Approval Signature	Date
Engineering Manager	Jake Stanislawski		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# 500000307855

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	11:20am	430	TA36	21 FEB 24	11:32am	415	TA36	21 FEB 24	16
Tm10942	44	11:48am	430	OS21	21 Feb 24	12:00PM	415	OS21	21 Feb 24	16
Tm10942	44	12:20pm	430	TA36	21 Feb 24	12:32pm	415	TA36	21 Feb 24	16
Tm10942	44	1:30pm	430	TA36	21 FEB 24	1:42pm	415	TA36	21 FEB 24	16
Tm10942	44	2:10PM	430	AX05	21 Feb 24	2:22PM	415	AX05	21 Feb 24	16
Tm10942	44	2:25PM	430	OS21	21 Feb 24	2:37PM	415	OS21	21 Feb 24	16
Tm10942	44	3:00PM	430	KL95	21 Feb 24	3:12PM	415	KL95	21 Feb 24	12
Tm10942	44	4:23PM	430	SG88	21 Feb 24	4:35PM	415	SG88	21 Feb 24	16
Tm10942	44	4:57pm	430	SX60	21 Feb 24	② 5:09pm	415	SX60	21 Feb 24	16
Tm10942	44	5:30PM	428	V078	21 Feb 24	5:42PM	415	AT39	21 Feb 24	16
Tm10942	44	6:25PM	430	Sy47	21 Feb 24	6:37PM	415	Sy47	21 Feb 24	16
Tm10942	44	6:50pm	427	SX60	21 Feb 24	7:02PM	415	Sy47	21 Feb 24	16

① AT39 21 Feb 24
② 5:09pm AT39 21 Feb 24



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

PRODUCTION ORDER#: 500000307855

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	8:00pm	429	SX60	21feb24	8:12pm	① SX1 415	SX60	21Feb24	16
TM10745	44	9:07pm	430	ST85	21 Feb 24	9:19pm	415	ST85	21 Feby	16
TM10745	44	9:35pm	428	SX60	① 21 Feb 24	9:47pm	415	SX60	21Feb24	16
N/A	44 N/A	9:48pm	428 N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A (i)

① SX60 21feb24



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

PRODUCTION ORDER#: 500000307855

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:35am	430	TA 36	21 Feb 24	11:47am	415	TA 36	21 Feb 24	16
Tm10745	44	12:00 pm	430	TA 36	21 Feb 24	12:12pm	415	TA 36	21 Feb 24	16
Tm10745	44	12:30PM	430	OS 21	21 Feb 24	12:42PM	415	OS 21	21 Feb 24	16
Tm10745	44	1:46 PM	430	NK 62	21 Feb 24	1:58PM	415	NK 62	21 Feb 24	16
Tm10745	44	2:20PM	430	OS 21	21 Feb 24	2:32PM	415	OS 21	21 Feb 24	16
Tm10745	44	2:48PM	430	OS 21	21 Feb 24	3:00PM	415	OS 21	21 Feb 24	16
Tm10745	44	4:09PM	430	SG 88	21 Feb 24	4:21PM	415	SG 88	21 Feb 24	16
Tm10745	44	4:39PM	429	SH 85	21 Feb 24	4:51PM	415	SH 85	21 Feb 24	16
Tm10745	44	5:15pm	429	SX 60	21 Feb 24	5:27pm	415	AT 39	21 Feb 24	16
Tm10745	44	6:39PM	430	SG 88	21 Feb 24	6:51PM	415	SG 88	21 Feb 24	16
Tm10745	44	7:02pm	429	SX 60	21 Feb 24	7:14pm	415	SX 60	21 Feb 24	16
Tm10745	44	7:30pm	429	SX 60	21 Feb 24	7:42pm	415	SX 60	21 Feb 24	16

① SX 60 21 Feb 24



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

PO #: 500000307855

OP #: 500 Shift #: 1st

Total Parts Reworked:		31	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		1
EW	Exposed Wire		18
MP	Micropores	N/A	N/A
SCR	Scratch		4
SKV	Skive Marks	N/A	N/A
VD	Voids		6
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB81, LLG1	21 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: 5106073
Rev: E
Document Type: Manufacturing Form
Title: SA0155-01 Visual Rework Form

PO #: 50000307855

OP #: 500 Shift #: 2

Total Parts Reworked:		36	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		9
EW	Exposed Wire		28
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks		4
VD	Voids	/	1
N/A	N/A	N/A	0
Inspected By (Sign and Date):		 21 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: 5106073
Rev: E
Document Type: Manufacturing Form
Title: SA0155-01 Visual Rework Form

PO #: 500000307855 OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>45</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	///	<u>3</u>
EH	Exposed Hypotube	N/A	N/A
EW	Exposed Wire		<u>27</u>
MP	Micropores	N/A	N/A
SCR	Scratch	///	<u>3</u>
SKV	Skive Marks	///	<u>3</u>
VD	Voids		<u>12</u>
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

Vammej Lor 21 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):

PO #: 500000307855OP #: 750 Shift #: 2nd

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		59	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		18
DIM07 US / WC	DIM07 Undersized (Window Closed)		23
EH	Exposed Hypotube		18
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46	21Feb24

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: FM5104661

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Annealing Log Sheet Form

PRODUCTION ORDER# 500000307855

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	2:55pm	190°F	HV36	21Feb24	4:05pm	190°F	HV36	21Feb24	20
TM10409	N/A	4:23pm	190°F	KT26	21Feb24	5:33pm	190°F	KT26	21Feb24	33
TM12036	N/A	4:51pm	190°F	KT26	21Feb24	6:01pm	190°F	KT26	21Feb24	30
TM10409	N/A	5:54pm	190°F	KT26	21Feb24	6:45pm	190°F	KT26	21Feb24	34
TM10409	N/A	6:46pm	190°F	KT26	21Feb24	7:56pm	190°F	KT26	21Feb24	35
TM12036	N/A	6:54pm	190°F	KT26	21Feb24	8:04pm	190°F	KT26	21Feb24	25
TM10409③	N/A	7:57pm	190°F	KT26	21Feb24	9:07pm	190°F	KT26	21Feb24	31
TM12036	N/A	8:05pm	190°F	KT26	21Feb24	9:15pm	190°F	KT26	21Feb24	24
TM10409	N/A	9:14pm	190°F	SG88	21Feb24	10:24pm	190°F	SG88	21Feb24	43
TM12036	N/A	9:50pm	190°F	SG88	21Feb24	11:02pm	190°F	SG88	21Feb24	37
TM10409	N/A	10:27pm	190°F	SG88	21Feb24	11:39pm	190°F	SG88	21Feb24	35
TM12036	N/A	11:05 PM	190°F	XL91	21Feb24	12:15 AM	190°F	KT26	22Feb24	44
TM10409	N/A	11:41 pm	190°F	KT26	21Feb24	12:51am	190°F	KT26	22Feb24	30

③ AT39 21 Feb 24 TM10409

① KT26 21Feb24
② KT26 21Feb24

PRODUCTION ORDER# 500000307855

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
JM12036	IV/A	12:15 AM	190°F	KT26	22 Feb 24	1:25 AM	190°F	KT26	22 Feb 24	37
JM10409	N/A	12:52 AM	190°F	KT26	22 Feb 24	2:02 AM	190°F	KT26	22 Feb 24	16

PLA
ATB 9 22 Feb 24



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000307855 OP #: 900 Shift #: 2

Total Parts Reworked:		56	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire		23
MP	Micropores	N/A	N/A
SCR	Scratch		57
SKV	Skive Marks	N/A	N/A
VD	Voids		5
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	HT72 21Feb24	
Inspected By (Sign and Date):		HT72 21Feb24	

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):



PO #: 500000307855

OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		50	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		5
EW	Exposed Wire		10
MP	Micropores	N/A	0
SCR	Scratch		20
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		19
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Deek	21 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 #: 50000307855

OP #: 900 Shift #: 2

Total Parts Reworked:		55	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		15
MP	Micropores	N/A	0
SCR	Scratch		50
SKV	Skive Marks	N/A	0
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	N/A	0
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Liu. 22Feb24	

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	33.67	30.88	27.82	28.56	31.13	27.16	30.17	31.71	23.64	27.91	29.265	2.8437114	4.378	16.8152316	8.542	PASS
Seg B	77.81	74.49	78	80.68	68.96	80.7	82.58	70.66	72.63	76.07	76.258	4.5413943	3.981	58.1787093	8.542	PASS
Seg C	85.28	83.38	77.99	85.59	78.02	87.83	87.57	84.47	77.97	77.78	82.588	4.2055249	2.911	70.3457169	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 #: 500000307855

Date: 24FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



22 FEB 2024