

# Production Order: 500000306366



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
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3	Kitting Devices	Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KP02 3:15pm 11Feb24</u>								
	Kitting Devices		Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 11:45pm 12Feb24</u>								
		Kitting Devices	Record Dryer Shelf #: <u>N/A</u>								
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
		MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u>				
						<u>N/A</u>	<u>N/A</u>				
		MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>				

Notes: DA2484, 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>N/A</u> <u>88018</u>	<u>N/A</u> <u>200</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>89537</u> <u>89538</u> <u>89091</u>	<u>N/A</u> <u>200</u> <u>200</u> <u>200</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u> <u>0000288401</u>	<u>500</u> <u>60</u>	N/A	N/A	N/A
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</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>N/A</u>	<u>Bulk</u> <u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			

Notes:

N/A

N/A

N/A

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		141967-01	02	02	PC	500	87435	500			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82862 82872 ② 86872 82873 ② 86873	400 77 70			
		RM7348-01	C	C	PC	500	① 85615 N/A	N/A			
		RM4001-01	B	B	PC	125	88534	500			
		RM0607-01	D	D	PC	56	89419 N/A	200 N/A	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	0000287648 0000287649	210 260			
		RM0009-04	I	I	PC	1	88992 N/A	Bulk Bulk			
		RM0009-04	I	I	PC	1	88992	Bulk			

Notes:

N/A
N/A
N/A

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① 09FEB24 TPO  
② CM99

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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>Bulk</u>			
							<u>0000502882</u>	<u>500</u>			
							<u>0000265874</u>	<u>40</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000240561</u>	<u>1060</u>			
							<u>N/A</u>	<u>N/A</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>500</u>			
							<u>N/A</u>	<u>N/A</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>0000290565</u>	<u>500</u>			
							<u>0000271050</u>	<u>40</u>			
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>			
							<u>N/A</u>	<u>N/A</u>			
		MM0074-01	G	<u>G</u>	PC	500	<u>0000301892</u>	<u>519</u>			
							<u>0000292833</u>	<u>15</u>			

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
NA	NA	NA	NA	NA	NA	NA
100	CATASY01  Catheter Assembly 1  	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	13 Feb 24	V078
150	CATASY01  Catheter Assembly 1    Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	13 Feb 24	Y014 PM96 AX05 NK62 AF54

**Notes:**

MA  
MA  
NA

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## Material: SA0155-01 Rev F

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	① 13 Feb 24	V078 AL34
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	13 Feb 24	CL05 MY50
Notes:		N/A				
		N/A				
		N/A				

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① MM02 13 Feb 24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Trim Braid Wire at Proximal End  NP 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 )	Insert Cut Hypo Tube	500	0	13 feb 24	SH23 VP62 LM46
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	17 feb 24	W25 DK39
<b>Notes:</b>		N/A				
		N/A				
		N/A				

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
118	 Load Tubing Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
400	<b>CATASY01</b> Catheter Assembly 1  Reflow Confirmation Reqd(Milestone )	Reflow	500	0	13 Feb 24	PM96 NK62 TA36 AF54
450	<b>CATASY01</b> Catheter  FEP Removal		500	0	13 Feb 24	PM96 AF54 SY98
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 					
N/A	FEP Removal					
N/A	Confirmation Reqd(Milestone )					
500	CATASY01  Catheter Assembly 1  In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 89091 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	N/A	475	OF - HHT 1111 Fm - 11 EW - HHT HHT VD - 1 SKU - 1 AB - 1	13Feb24	VC09 TA36 DY29 LL61 CB81 VL91 P66
N/A	In-process Inspection and Rework					
N/A	Confirmation Reqd(Milestone )					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
<b>Notes:</b>						
N/A						
N/A						
N/A						
N/A						

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LL61 13 Feb 24

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## Material: SA0155-01 Rev F

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 )	475	0	13Feb24	FB01 VA96 AX82 LG61 PP40 Y936
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Confirmation	Distal Tip Assembly	449	① HHH-HH HHHHHHHH DL HHHH IDB - I MAH - HHH  26	13Feb24	FB01 VA96 AX82 DV39 ML60 Mm02

Notes:

N/A

N/A

N/A

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① P146 14 Feb 24



## Material: SA0155-01 Rev F

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  Confirmation Reqd(Milestone )	Loading Heat Shrink	449	0	13 Feb 24	PKY2 MV18 ML38
700	CATASY01  Catheter Assembly 1    Tipping	Tipping  Record Tipping Oven Information: TMI: 0386 Cal Due: 31may 24 TMI: 0521 Cal Due: 31may 24 TMI: 2083C Cal Due: 31may 24 TMI: 0936A Cal Due: 31may 24	449	0	13 Feb 24	RS23 STX48 ML38

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</p> <p>Material Consumed:</p> <table> <tr> <td>Part #: Rm4001-01</td> <td>Batch #:</td> <td>69419</td> <td>Qty:</td> <td>15</td> </tr> <tr> <td>Part #: RM0601-01</td> <td>Batch #:</td> <td>78849</td> <td>Qty:</td> <td>10</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> </table> <p>Tip Inspection/ Flash Removal</p> <p>Confirmation Reqd(Milestone )</p>	Part #: Rm4001-01	Batch #:	69419	Qty:	15	Part #: RM0601-01	Batch #:	78849	Qty:	10	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	443	EH-HAT 1 13Feb24	PH59 STX48 SV46	
Part #: Rm4001-01	Batch #:	69419	Qty:	15																											
Part #: RM0601-01	Batch #:	78849	Qty:	10																											
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																											
800	CATASY01 Catheter Assembly 1  	Major Mandrel Removal	439	ACD-1111 13Feb24	SS44 SG52 SG88																										

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 Record DIM05 gage result for the first 5 parts at the start of operation: 1. <del>passed</del> 2. <del>passed</del> 3. <del>passed</del> 4. <del>passed</del> 5. <del>passed</del>	437	SKV-11 13Feb24	SS53 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	MV33 TPN KY86 SH04 HT72
<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	<b>Quality Inspection &amp; Review</b>  <b>Confirmation Reqd(Milestone )</b>	Re-Inspect after re-work.  Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31 may 24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u>  Material Consumed: Part # <u>2M4001-01</u> Batch #: <u>59419</u> Qty: <u>N/A</u> Part # <u>1000-1153-01</u> Batch #: <u>59537</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	412	#5US-1 #103-1 DIS-HH1 MAR-HH1 SKV-11 EW-11 BW-1 #6US-1 #605-11 #705-11	PY46 k455 XL91 13Feb24 KLG7	
950	<b>QUALITY1</b>  Quality Inspection & Review	Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>50713B</u> Cal Due: <u>12 APR 24</u> Record Caliper Information:	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
N/A	 <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	<p>TMI: 0733 Cal Due: 30 APR 24</p> <p>Record DIM02 Go/No-Go Gage Information:</p> <p>TMI: 0691 Cal Due: 30 SEP 25</p> <p>TMI: 0692 Cal Due: 30 SEP 25</p> <p>Record DIM02 Inspection Results N = 54:</p> <p>Pass: 54 Fail: 0</p>	393	STR-4H11 DIS-4H11 WK-1	13 Feb 24	0521 XL91 KL67
1000	 <b>QUALITY1</b>  <b>Quality Inspection &amp; Review</b>   <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	<p>Quality Inspection &amp; Review</p> <p>Leak Test</p> <p>Record Inspection Data in SAP ROS</p> <p>Record Leak Tester Information:</p> <p>TMI: 0561056 Cal Due: 31 MAY 24</p> <p>Record Length Gage Information:</p> <p>TMI: 08890 Cal Due: 30 SEP 24</p> <p>Record Calibrated Ruler Information:</p> <p>TMI: 0629 Cal Due: 30 SEP 24</p> <p>(1) PY46 14 Feb 24</p>	390	① LT-### LT-III	13 Feb 24	SS44 XL91 KL67

Notes:

N/A

N/A

N/A

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(1) MM02 13Feb24



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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 Rreqd(Milestone ) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	355	SCR-HH MM(G) VD-1H1 DISC-1H1 EW-1H1 SCR-1H1 DIS-1H1 SKV-1H1 Mar-1 Del-1 FM-1 DL-1 RDG-1 PBC-1	14Feb24	XN26 YK95 SVU3
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>14Feb24</u>	N/A	N/A	14Feb24	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	355	0	14 Feb 24	AP10

**Notes:**

N/A AP10 14 Feb 24

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**Batch Number:** 0000306366

**By:** AP10

**Date:** 14 Feb 24

**Reviewed By:**

RB29

**Date:**

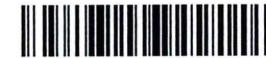
16 Feb 24

**Notes:**

N/A AP10 14 Feb 24

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

FM0002.RevF

Deviation Authorization

**CONTROLLED COPY**

①. UK55, 23JU 2023



DA DA  
2484,  
2468  
①

**Description/Objectives of Training:**  
DA- Inspection at final QC, Op#1050.

### Group Training Record

#### 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)  
**①MM1536-01 type connection TS12 10AUG23**

#### CONTROLLED COPY

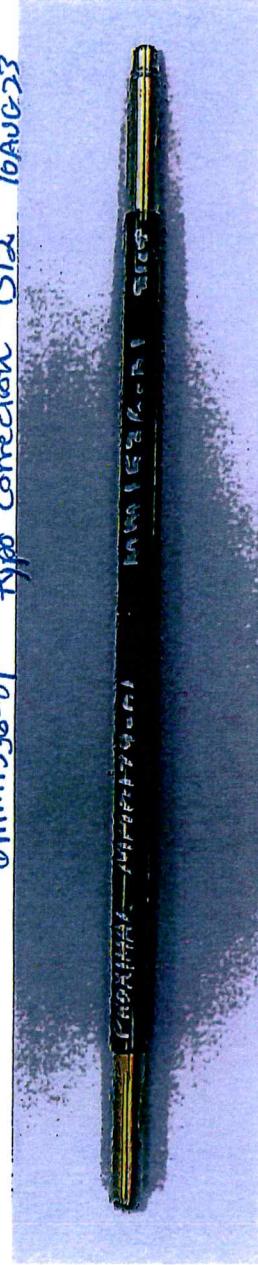


Image- 1

#### 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)

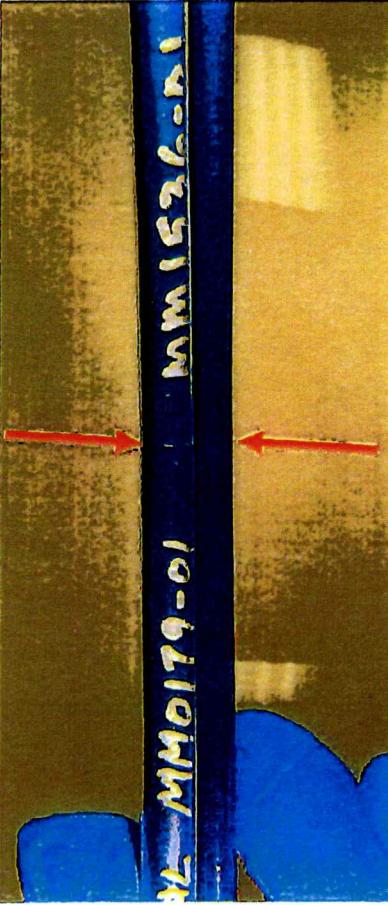


Image- 3

- 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	MM1536-01	<b>GOOD PART</b>
<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

Edits to Item 12B 11/10/03  
Edits to Item 13 Feb 2024 12/28 1/9/2024

CREGANNA  
MEDICAL  
is part of  


**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: DA2564

## 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.

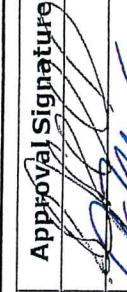
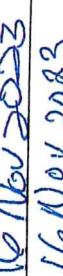
**Justification:**  
TMI0602 Lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable.  
TMI0700-01 Lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified 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	End Date:	Lot Number:	Revision
SA0155-01	15 DEC 23	N/A	H
Start Date:	16 Nov 23		

**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 – N/A

**Corrective Action Required:**  Yes  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:**  Yes  No **If no, explain:** 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#: 500000306366

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	5:20am	430	TA36	13 Feb 24	5:32am	415	TA36	13 Feb 24	16
Tm10942	44	5:45am	430	TA36	13 Feb 24	5:57am	415	TA36	13 Feb 24	16
Tm10942	44	6:09AM	429	NK62	13 Feb 24	6:21AM	415	NK62	13 Feb 24	16
Tm10942	44	6:30AM	428	OS21	13 Feb 24	6:42AM	415	OS21	13 Feb 24	16
Tm10942	44	7:00am	430	TA36	13 Feb 24	7:12am	415	TA36	13 Feb 24	16
Tm10942	44	7:50AM	430	OS21	13 Feb 24	8:02AM	415	OS21	13 Feb 24	16
Tm10942	44	8:15AM	428	OS21	13 Feb 24	8:27AM	415	OS21	13 Feb 24	16
Tm10942	44	8:55AM	430	OS21	13 Feb 24	9:17AM	415	OS21	13 Feb 24	16
Tm10942	44	9:25AM	430	NK62	13 Feb 24	9:37AM	415	NK62	13 Feb 24	16
Tm10942	44	10:00AM	430	OS21	13 Feb 24	10:12AM	415	OS21	13 Feb 24	13
Tm10942	44	11:05AM	430	OS21	13 Feb 24	11:17AM	415	OS21	13 Feb 24	16
Tm10942	44	11:30am	430	TA36	13 Feb 24	11:42am	415	TA36	13 Feb 24	16



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

PRODUCTION ORDER#500000306366

OP 400



PRODUCTION ORDER# 500000306366

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0745	44	5:10AM	430	NK6Z	13Feb24	5:22AM	415	NK6Z	13Feb24	16
TMI0745	44	5:35AM	430	TA36	13Feb24	5:47AM	415	TA36	13Feb24	16
TMI0745	44	6:00am	430	OS21	13Feb24	6:12am	415	OS21	13Feb24	16
TMI0745	44	6:20am	430	OS21	13Feb24	6:32am	415	OS21	13Feb24	16
TMI0745	44	7:30AM	430	OS21	13Feb24	7:42AM	415	OS21	13Feb24	16
TMI0745	44	8:00AM	430	OS21	13Feb24	8:12AM	415	OS21	13Feb24	16
TMI0745	44	8:35AM	430	NK6Z	13Feb24	8:47AM	415	NK6Z	13Feb24	16
TMI0745	44	9:10AM	430	OS21	13Feb24	9:22AM	415	OS21	13Feb24	16
TMI0745	44	9:30AM	430	NK6Z	13Feb24	10:02AM	415	NK6Z	13Feb24	16
TMI0745	44	10:55AM	430	AX05	13Feb24	11:07AM	415	AX05	13Feb24	16
TMI0745	44	11:20AM	430	AX05	13Feb24	11:32AM	415	AX05	13Feb24	16
TMI0745	44	11:45AM	430	TA36	13Feb24	11:57AM	415	TA36	13Feb24	16



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

PRODUCTION ORDER#: 50000306366

OP 400



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

PO #: 500000306366

OP #: 500 Shift #: 1st

Total Parts Reworked:		200	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		46
EW	Exposed Wire		94
MP	Micropores	N/A	N/A
SCR	Scratch		42
SKV	Skive Marks		4
VD	Voids		22
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB81, LL61, VC09, TA36, My28 13 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 #: 50000306366 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>11</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>0</u>
EH	Exposed Hypotube	<u>///</u>	<u>3</u>
EW	Exposed Wire	<u>    </u>	<u>6</u>
MP	Micropores	<u>N/A</u>	<u>0</u>
SCR	Scratch	<u>N/A</u>	<u>0</u>
SKV	Skive Marks	<u>N/A</u>	<u>0</u>
VD	Voids	<u>//</u>	<u>2</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Guyl</u> 13 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 #: 500000306366OP #: 750 Shift #: 1st

Total Parts Reworked:		62	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		10
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		26
N/A	Glue, stopper		21
Inspected By (Sign and Date):		Hv 36	13 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):



PO #: 50000304366 OP #: 750 Shift #: 2<sup>nd</sup>.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:			
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		
DIM07 US / WC	DIM07 Undersized (Window Closed)		
EH	Exposed Hypotube	N/A SV 16 13 Feb 24	N/A SV 16 13 Feb 24
N/A	N/A		
Inspected By (Sign and Date):		SV 46 13 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# 500000 306366

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	10:15AM	190°F	0521	13 Feb 24	11:25am	190°F	0521	13 Feb 24	50
TM12036	N/A	11:15am	190°F	SS44	13 Feb 24	12:25pm	190°F	SS44	13 Feb 24	70
TM10409	N/A	11:40am	190°F	6155	13 Feb 24	12:50pm	190°F	6155	13 Feb 24	32
TM12036	N/A	12:30 pm	190°F	6155	13 Feb 24 1:40 PM	1:40 pm	190°F	6155	13 Feb 24	49
TM10409	N/A	1:30PM	190°F	SS44	13 Feb 24	2:40 pm	190°F	SS44	13 Feb 24	36
TM12036	N/A	1:55PM	190°F	SS44	13 Feb 24	3:05pm	190°F	SS44	13 Feb 24	23
TM10409	N/A	2:40PM	190°F	SS52	13 Feb 24	3:50pm	190°F	6155	13 Feb 24	48
TM10409	N/A	4:15PM	190°F	SG88	13 Feb 24	5:25pm	190°F	AT39	13 Feb 24	40
TM12036	N/A	4:57pm	190°F	SG88	13 Feb 24	6:07pm	190°F	SG88	13 Feb 24	40
TM10409	N/A	5:35PM	190°F	AT39	13 Feb 24	6:45pm	190°F	SG88	13 Feb 24	32
TM12036	N/A	6:24pm	190°F	SG88	13 Feb 24	7:34pm	190°F	SG88	13 Feb 24	② + 19
			N/A							
			SG88	13 Feb 24						

① K155 13 Feb 24

② 146 14 Feb 24

② ~~corr~~ correction for SG88



**PO #:** 50000306366

**OP #:** 900    **Shift #:** 1st

Document No: 6102619

Rev: B

**Document Type: Manufacturing Form**

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

Total Parts Reworked:		45	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		N/A
EW	Exposed Wire		5
MP	Micropores		N/A
SCR	Scratch	+       +       +	28
SKV	Skive Marks		N/A
VD	Voids		8
DIM01 US	DIM01 OD Undersized		N/A
DIM06 US	DIM06 OD Undersized		11
DIM06 OS	DIM06 OD Oversized		N/A
DIM09 US	DIM09 OD Undersized		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):**

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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 #: 50000306366OP #: 900 Shift #: 2

Total Parts Reworked:		<u>16</u>	
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		5
MP	Micropores	N/A	0
SCR	Scratch		11
SKV	Skive Marks	N/A	0
VD	Voids		4
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):		<u>Andy</u> <u>13 Feb 24</u>	

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 #: 500000306366

OP #: 900 Shift #: 2nd

Total Parts Reworked:		51	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		7
MP	Micropores	N/A	0
SCR	Scratch		38
SKV	Skive Marks	/	1
VD	Voids		2
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		15
DIM06 OS	DIM06 OD Oversized		6
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Joe H - 13 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):



500000306366

PO #: 500000306336 OP #: 900 Shift #: 2

P14614 Feb 24 correction for HT72

Document No: 6102619

Rev: B

**Document Type: Manufacturing Form**

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

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):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023

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	28.33	27.69	29.31	24.37	29.22	29.72	29	24.72	29.97	29.13	28.146	2.0068726	4.378	19.3599116	8.542	PASS
Seg B	69.56	76.21	73.54	69.7	74.75	75.93	67.89	72.95	76.76	71.44	72.873	3.1178912	3.981	60.4606751	8.542	PASS
Seg C	90.22	83.83	82.46	91.5	83.19	87.03	86.09	87.22	83.15	86.77	86.146	3.0596775	2.911	77.2392787	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

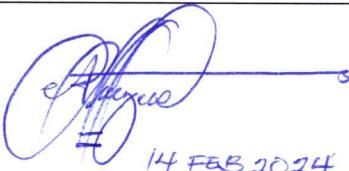
LOT #: 500000306366

Date: 14FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



SR.  
14 FEB 2024