

Production Order: 500000296055



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
Production Version: 7988
Plant / Business Unit: 1213 / AC5

Order Type: ZSTD

Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																		
50	KITTING3 Kitting Devices 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KIT3 5:15AM 17 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XCS1 7:20PM 17 Jan 24</u> 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>1000-2053-01</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0000278880</u></td><td><u>500</u></td></tr><tr><td>MM1537-02</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0000276175</u></td><td><u>N/A</u></td></tr></tbody></table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>	MM1537-02	A <u>A</u>	PC	500	<u>0000276175</u>	<u>N/A</u>	N/A	N/A	16/01/24	TR010
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																			
1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>																			
MM1537-02	A <u>A</u>	PC	500	<u>0000276175</u>	<u>N/A</u>																			

Notes: DA2484, 2564

N/A

N/A

Date Printed: 01/16/2024 / 17:05:40

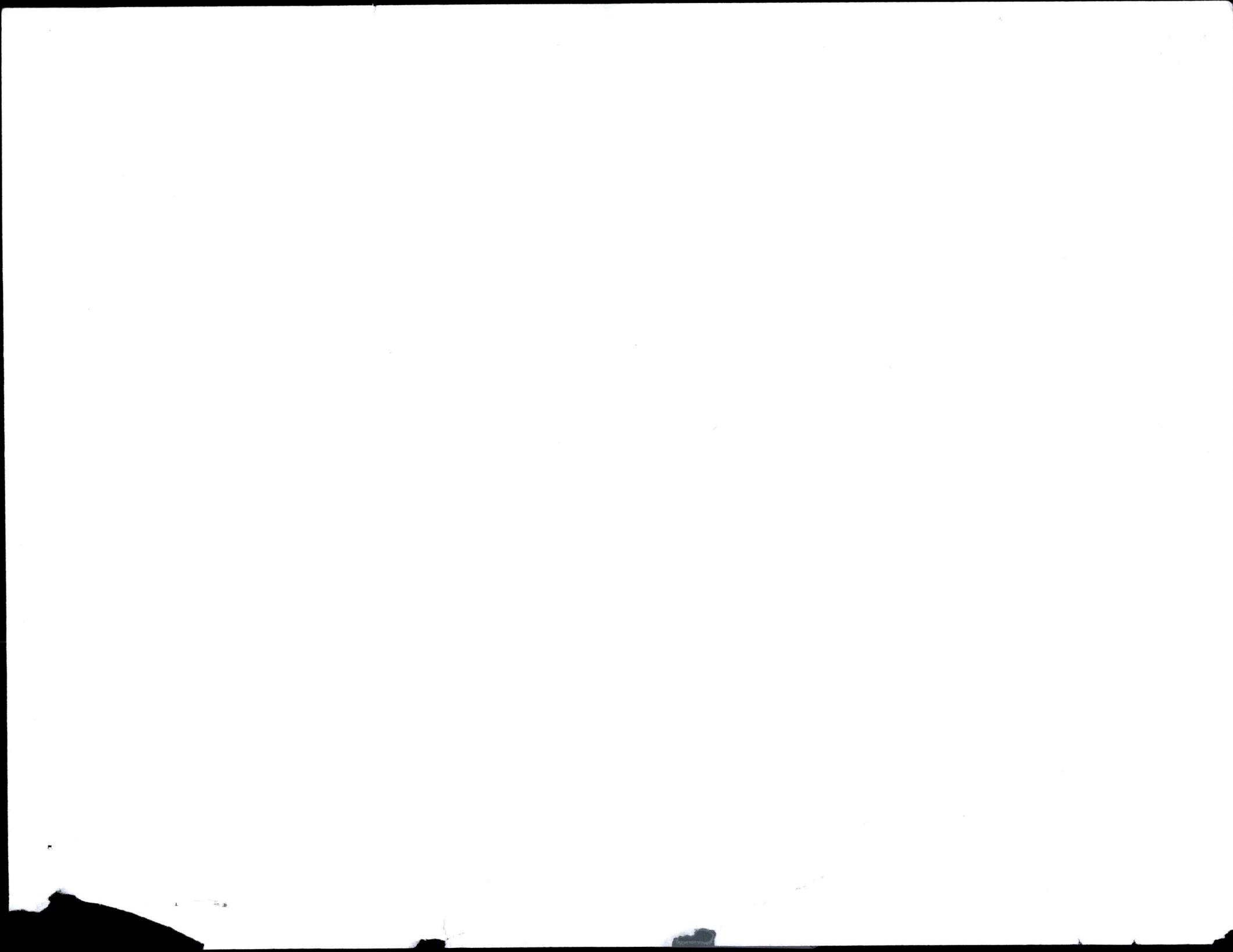
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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	N/A 58497	N/A 150		
		TL0167-02	E	<u>E</u>	PC	70	N/A	N/A	Bulk	
		TL0165-05	J	<u>J</u>	PC	5	N/A	N/A	Bulk	
		TL0165-03	J	<u>J</u>	PC	5	N/A	N/A	Bulk	
		141967-01	02	<u>02</u>	PC	500	85501	501	N/A	N/A
		RM7349-02	C	<u>C</u>	PC	543	82851	500		
		RM7348-01	C	<u>C</u>	PC	500	82854 786089	76 560	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	RM4001-01	B	<u>B</u>	PC	125	<u>82452</u>	<u>200</u>			
						<u>N/A</u>	<u>N/A</u>			
		D	<u>D</u>	PC	56	<u>74602</u>	<u>100</u>			
						<u>N/A</u>	<u>N/A</u>			
		C	<u>C</u>	PC	500	<u>0000275470</u>	<u>473</u>			
						<u>N/A</u>	<u>N/A</u>			
		E	<u>E</u>	PC	594	<u>80240</u>	<u>600</u>			
						<u>N/A</u>	<u>N/A</u>			
N/A	RM0009-04	I	<u>I</u>	PC	1	<u>82971</u>	<u>Bulk</u>			
						<u>N/A</u>	<u>Bulk</u>			
		I	<u>I</u>	PC	1	<u>82971</u>	<u>Bulk</u>			
						<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u>	<u>500</u>			
						<u>N/A</u>	<u>N/A</u>			
N/A	MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u>	<u>1,000</u>			

Notes:

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N/A

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	MA	MM1536-01	B	<u>B</u>	PC	500	<u>0000281413</u>	<u>60</u>		
		MM0180-01	E	<u>2</u>	PC	500	<u>0000281412</u>	<u>500</u>		
		MM0179-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276172</u>	<u>500</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000276174</u>	<u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>500</u>	N/A	N/A
		MM0074-01	G	<u>G</u>	PC	500	<u>0000271639</u>	<u>515</u>	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	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	18 Jan 24	V078
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	0	18 Jan 24	SY47 SH23 JY90 RN27 AF54
Notes:						
N/A						
N/A						
N/A						

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① 6155 19 Jan 24
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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
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock Loading Braid Stock Confirmation Reqd(Milestone)	500	0	18 Jan 24	CL05 JY35 DX35 AL34 MV50 SX11
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	18 Jan 24	CP22 DS31 CMUB
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)	Insert Cut Hypo Tube	500	0	ST423 GS22 VPC2 DV39 145 Jan 24	ST423 GS22 VPC2 DV39
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	18 Jan 24	ST96 NY35 W25
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	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	18 Jun 2024	V078 CL30 TRNV078 SF85 WK62 AX05 pm96
450	CATASY01 Catheter	FEP Removal	500	0	18 Jun 2024	Y014 TRNV078 PM96
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				
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Confirmation Reqd(Milestone) N/A	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 87655 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 Part #: N/A Batch #: N/A Qty: N/A	486	EW - HTT EH-1 OF - 1111 EW - 1111 (14)	EW - HTT TD45 LLG1 VLC9 CB81	VLC91 PZ66 TD45 LLG1 VLC9 CB81
N/A	N/A	N/A N/A N/A N/A	N/A	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 Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel	486	0	18 Jan 24	AT39 MM02 FB01 VA96 PH59 D429 TKN K155
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	466	MAS-III MAIT-III III DL-III IDB-11 20	18 Jan 24	ML60 FB01 VA96 PH59

Notes:

N/A

N/A

N/A

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N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink Loading Heat Shrink Confirmation Reqd(Milestone)	466	0	18 JUN 24	ML38 FBO1 PH59
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	466	0	18 JUN 24	ML38 STX48 Hv36

Notes:

N/A

N/A

N/A

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N/A	Confirmation Reqd(Milestone)		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 #: 82452 Qty: 11 Part #: RM0007-01 Batch #: 74662 Qty: 4 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>	463	EH-III (1) EH-III (3) (4) (1) 18JUN2024		SV46 STX48 Hv36
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	453	ACD-EH-III (10)	14JUN2024	SG88 SS44

Notes:

N/A

N/A

N/A

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(1) RL95 18 Jan 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
	Major Mandrel Removal N/A Confirmation Reqd(Milestone)		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. pass 2. pass 3. pass 4. pass 5. pass	453	0 18 Jan 24	Y936 SSSC	
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
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
	MA Quality Inspection & Review Confirmation Reqd(Milestone) Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0100-01</u> Cal Due: <u>0315 31 may 24</u> TMI: <u>MA</u> Cal Due: <u>MA</u> TMI: <u>MA</u> Cal Due: <u>MA</u> Material Consumed: Part #: <u>P-4001-01</u> Batch #: <u>82452</u> Qty: <u>18</u> Part #: <u>7000-153-01</u> Batch #: <u>78655</u> Qty: <u>N/A</u> Part #: <u>P-0607-01</u> Batch #: <u>24662</u> Qty: <u>10</u> Part #: <u>MA</u> Batch #: <u>MA</u> Qty: <u>N/A</u> Part #: <u>MA</u> Batch #: <u>MA</u> Qty: <u>N/A</u>	430	EW-11 WK-111 DIS-4HTI SKU-1 #S-US-111 EH-1 FM-11 H6US-1 A109-1 DEL-1 DL-1	MA <i>18 Jun 24</i>		KT27 PHG K155
950	QUALITY1 Quality Inspection & Review Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:		N/A	N/A	N/A	N/A

Notes:

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N/A

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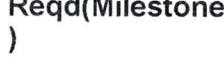
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OP446 18 Jan 24


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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)	TMI: <u>NA</u> Cal Due: <u>NA</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30SEP25</u> TMI: <u>0692</u> Cal Due: <u>30SEP25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	405	Dis- <u>441</u> <u>441</u> (SP) StP- <u>111</u> <u>(25)</u> Del- <u>4411</u> <u>(TT)</u> SCR- <u>11</u> (TD) Fm- <u>11</u> <u>(TD)</u>	<u>18JUN24</u>	K155
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: <u>1056</u> Cal Due: <u>31May24</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30SEP24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30SEP24</u>	394	L+ <u>44</u> <u>441</u> <u>11</u>	<u>18JUN24</u>	SSH4

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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	361	MAR- III SCR- H H IIII FB- IIII DEL- 1 DL- H H VD- III EW- I CRK- I DISC- II SKV- I DNT- I EH- I FM- I <u>33</u>	18 Jan 24	XN26 SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>XC31</u> / <u>18JAN24</u>	N/A	N/A	18JAN24	XC31

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
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	361	0	19 Jun 24	b71

Notes:

N/A

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Batch Number: 0000296055

By: BA71

Date: 19 Jan 24

Reviewed By:

RB29

Date:

19 JAN 24

Notes:

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Document No: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 50000296055

OP #: 750 Shift #: 1st

Total Parts Reworked:		132	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		28
DIM07 US / WC	DIM07 Undersized (Window Closed)		11
EH	Exposed Hypotube		40
N/A	Glue, Stopper		53
Inspected By (Sign and Date):		Hv36 18 Jan 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 #: 50000296055 OP #: 900 Shift #: 1st

Document No: 6102619
Rev: B
Document Type: Manufacturing Form
Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		85	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	1	1
EW	Exposed Wire		9
MP	Micropores	N/A	N/A
SCR	Scratch		49
SKV	Skive Marks		2
VD	Voids		23
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		12
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		K155, KT247	18 Jan 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: 5105589
FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000296055

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	7:54pm	428	SH85	14 Jan 24	8:06pm	415	SH85	17 Jan 24	16
TM10745	44	9:06pm	430	SH85	17 Jan 24	9:18pm	415	SH85	17 Jan 24	16
TM10745	44	9:35pm	428	SH85	17 Jan 24	9:47pm	415	SH85	17 Jan 24	16
TM10745	44	10:22pm	430	CL30	17 Jan 24	10:34pm	415	CL30	17 Jan 24	16
TM10745	44	10:52pm	429	CL30	17 Jan 24	11:04pm	415	V078	17 Jan 24	16
TM10745	44	11:56pm	430	CL30	17 Jan 24	12:08AM	415	V078	18 Jan 24	16
TM10745	44	12:22Am	428	V078	18 Jan 24	12:34AM	415	CL30	18 Jan 24	16
TM10745	44	12:46Am	427	V078	18 Jan 24	12:58AM	415	SH85	18 Jan 24	16
TM10745	44	1:15Am	429	V078	18 Jan 24	1:25AM	415	SH85	18 Jan 24	16
TM10745	44	1:52Am	428	SH85	18 Jan 24	2:04AM	415	V078	18 Jan 24	16
TM10745	44	5:15am	430	AX05	18 Jan 24	5:27am	415	AX05	18 Jan 24	16
TM10745	44	5:45am	430	AX05	18 Jan 24	5:57am	415	AX05	18 Jan 24	16



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

PRODUCTION ORDER# 500000296055

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	8:48PM	430	SH85	17Jan24	9:00PM	415	SH85	17Jan24	16
Tm10942	44	9:22PM	430	SH85	17Jan24	9:34PM	415	SH85	17Jan24	16
Tm10942	44	10:14PM	430	V078	17Jan24	10:26pm	415	V078	17Jan24	16
Tm10942	44	10:35PM	426	CL30	17Jan24	10:47pm	415	V078	17Jan24	16
Tm10942	44	11:12PM	430	V078	17Jan24	11:24pm	415	V078	17Jan24	16
Tm10942	44	11:42PM	428	V078	17Jan24	11:54pm	415	V078	17Jan24	16
Tm10942	44	12:08AM	428	V078	18Jan24	12:20AM	415	CL30	18Jan24	16
Tm10942	44	12:35AM	430	CL30	18Jan24	12:47AM	415	V078	18Jan24	16
Tm10942	44	12:57AM	428	SH85	18Jan24	1:09AM	415	SH85	18Jan24	16
Tm10942	44	1:33AM	430	SH85	18Jan24	1:45AM	415	SH85	18Jan24	16
Tm10942	44	5:30am	430	AX05	18Jan24	5:42am	415	AX05	18Jan24	16
Tm10942	44	6:15AM	430	AX05	18Jan24	6:27AM	415	AX05	18Jan24	16



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

PRODUCTION ORDER# 500000296055

OP 400



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 50000 296055 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>14</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>2</u>
EW	Exposed Wire	<u>HH HH </u>	<u>12</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>Anil</u>	<u>17 Jan 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000296055 OP #: 500 Shift #: 2nd

Total Parts Reworked:		21	
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		5
MP	Micropores	n/a	n/a
SCR	Scratch		3
SKV	Skive Marks	n/a	n/a
VD	Voids		3
n/a	n/a	n/a	n/a

Inspected By (Sign and Date):

Vannmej Lor 17 Jan 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 #: 500000296055 OP #: 500 Shift #: 1st

Total Parts Reworked:		117	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		19
EW	Exposed Wire		64
MP	Micropores	N/A	N/A
SCR	Scratch		9
SKV	Skive Marks		7
VD	Voids		18
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LL61, VC09, BC81 18 Jan 24	

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

Data Uploaded for Engineering Review (Check):

PO #: 500000296055OP #: 750 Shift #: 2nd

Document No: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		15	
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)		1
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV48 17 Jan 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# 500000296055

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	11:56pm	190F	SG88	17 Jan 24	1:06AM	190F	SG88	18 Jan 24	32
Tm10409	N/A	1:12AM	190F	SG88	18 Jan 24	2:22AM	190F	SG88	18 Jan 24	51
Tm10409	N/A	5:30am	190F	K155	18 Jan 24	6:40am	190F	K155	18 Jan 24	43
Tm12036	N/A	6:30 am	190F	K155	18 Jan 24	7:40am	190F	K155	18 Jan 24	52
Tm10409	N/A	6:50 am	190F	K155	18 Jan 24	8:00am	190F	K155	18 Jan 24	31
Tm10409	N/A	8:00 am	190F	K155	18 Jan 24	9:10 am	190F	K155	18 Jan 24	38
Tm12036	N/A	8:30am	190F	K155	18 Jan 24	9:40am	190F	K155	18 Jan 24	45
Tm10409	N/A	9:00am	190F	K155	18 Jan 24	10:10am	190F	K155	18 Jan 24	30
Tm12036	N/A	9:50 am	190F	K155	18 Jan 24	11:00 am	190F	K155	18 Jan 24	50
Tm12036	N/A	11:00am	190F	K155	18 Jan 24	12:10am	190F	K155	18 Jan 24	32
Tm10409	N/A	11:40am	190F	SS44	18 Jan 24	12:50PM	190F	SS44	18 Jan 24	49
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A



Ex-2 to MINDK 5228 11/16/2023
Ex-2 to 13 Feb 2024 5228 Vfay

DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj

Document Number Affected Doc #3005206 (MPI0238)	Revision 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 SA0155-01	Revision H		
Start Date: 16 Nov 23	End Date: 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 FMEAs <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): 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 Engineering Manager Quality Manager Operations Manager	Approval Name Jake Stanislowski Jay Zabel Matthew Benson	Approval Signature 	Date 16 Nov 2023 16 Nov 2023 16 Nov 2023

Bonus to DPPM 5228 11/1/23

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is part of



CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484
** See attached email extension to 24/SER/23*

Extend to 22 Nov 2023 5228 10/23

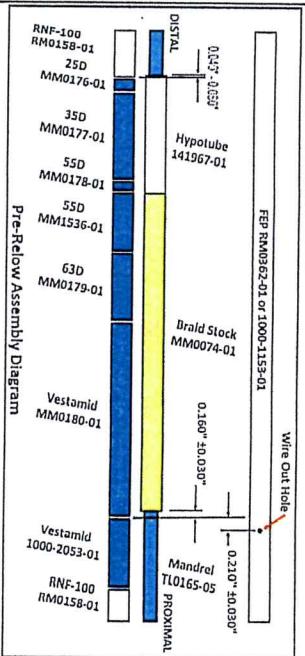
24 AUG 23 1512 5228 11/23

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:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	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

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

Corrective Action Required: Yes 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.

Training Required: Yes No **If no, explain:**

① UK55, 23 JUL 2023

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DA 2484
2468

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)

① MM0179-01 type connection TS12

10 AUG 23



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)

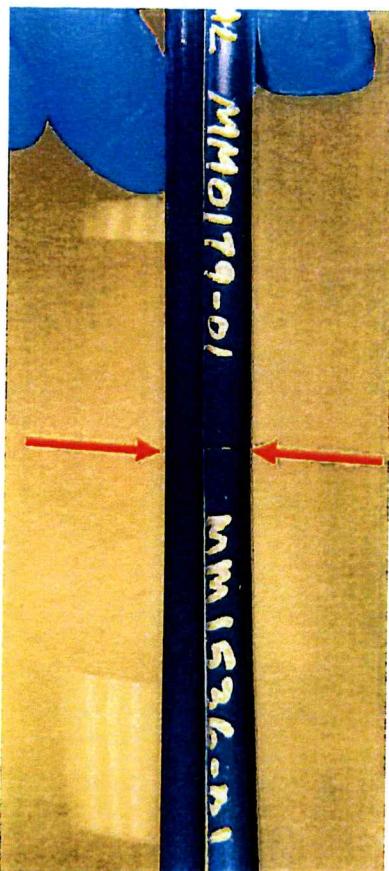


Image-3

- 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.

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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)

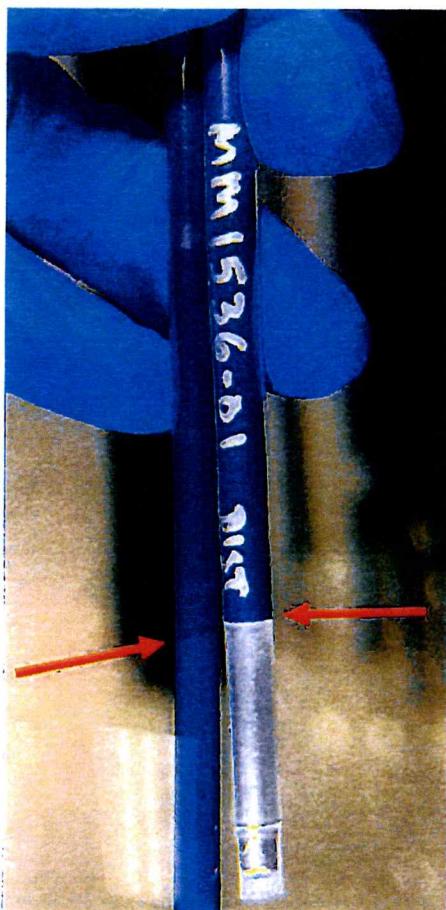


Image-4

- 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	MM1536-01
GOOD PART		
2	MM1536-01	MM1536-01
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

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

FM002.RevF

Deviation Authorization

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Maximum Force Reached During Tensile Test											
Sample #	1	2	3	4	5	6	7	8	9	10	Avg
	Calculated	K	ST Dev	Sigma	Lower bound	Upper bound	MIN	SPEC	PASS / FAIL		
Seg A	23.68	26.11	28.15	26.14	26.2	25.03	24.9	26.2	24.14	23.92	25.47
Seg B	65.27	65.34	63.81	60.62	61.1	58.2	58.72	60.88	23.92	62.06	57.992
Seg C	77.7	79.56	78.67	78.98	76.11	77	77.98	75.05	79.04	77.43	77.752

(10 samples accepted from final inspection for each lot shall be selected and tensile tested)

All Force Values are recorded in Pound-Force and Distance is in inches
Specification for lower bound is 3BN was converted to 8.54LBf
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.

197ma24