

Production Order: 500000307850



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 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>G585 8:45AM 15 FEB 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 6:00pm 17 Feb 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	15 Feb 24	OLAS

Component Number	Req'd Rev Rev	UOM	Qty.	Batch No.	Actual Qty Used
MM0179-01	D	PC	500	<u>0000293119</u>	<u>500</u>
MM1536-01	B	PC	500	<u>0000290560</u>	<u>500</u>

Notes: DA2484, 2564

N/A

N/A

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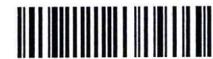


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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	e	PC	200	N/A	N/A			
							SS018	200			
		1000-1153-01	A	a	PC	594	N/A	N/A			
							89093	200			
							88965	200			
							88964	200			
		1000-2053-01	A	A	PC	500	0000257543	500			
							N/A	N/A			
		MM1537-02	A	A	PC	500	0000240571	500	N/A	N/A	N/A
							N/A	N/A			
		TL0167-02	E	E	PC	70	N/A	Bulk			
							N/A	Bulk			
		TL0165-05	J	J	PC	5	N/A	Bulk			
							N/A	Bulk			
		TL0165-03	J	J	PC	5	N/A	Bulk			
							N/A	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	P/A	141967-01	02	02	PC	500	8749D	525			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82865	573			
							N/A	N/A			
		RM7348-01	C	C	PC	500	85677	400			
							N/A	N/A			
		RM4001-01	B	B	PC	125	82819	72			
							88702	100			
		RM0607-01	D	D	PC	56	78849	52	N/A	N/A	N/A
							N/A	N/A			
		RM0498-01	C	C	PC	500	0000275493	456			
							N/A	N/A			
		RM0009-04	I	I	PC	1	88943	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	88943	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	A	PC	500	N/A	Bulk			
							0000302882	500			
		MM1537-01	A	A	PC	1000	N/A	N/A			
							0000294701	1000			
		MM0177-01	C	C	PC	500	N/A	N/A			
							0000294697	500			
		MM0180-01	E	E	PC	500	N/A	N/A			
							0000294374	400			
		MM0178-01	E	E	PC	500	N/A	N/A			
							0000290565	500	N/A	N/A	N/A
		MM0176-01	D	D	PC	500	N/A	N/A			
							0000288413	500			
		MM0074-01	G	G	PC	500	N/A	N/A			
							0000306619	522			
							0000285406	105			
								109			

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
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock Loading Braid Stock Confirmation Reqd(Milestone)	500	0	18Feb24	ST96 PM67 SC10
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	18Feb24	MC17 AD65 CD19

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 Rreqd(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 Rreqd(Milestone)	Insert Cut Hypo Tube	500	0	18 Feb 24	AL42 PL22 TRN BDG4
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	18 Feb 24	AL67 BDG4
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)	.	500	0	18Feb24	CD19 AM47 PL22 TRN SP24
450	CATASY01 Catheter	FEP Removal	500	0	18Feb24	JCG2 AM47
Notes: 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
	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 Confirmation Reqd(Milestone)	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 89093 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	463	EW-LHF IHT IHF IHT IHF IIII OF-IHF III (37)	19Feb24 B160 AK02	
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
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)	455	MATT-JH DL-11 IDB-1 S	19Feb24 PF0	AX82 MH10 FB01 RS23
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	455	O	19Feb24	AX82 LH45 TRN MH10 BG60 TRN PT09 DV39 VA96

Notes:

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OPY46 19 Feb 24



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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 Confirmation Reqd(Milestone)	Loading Heat Shrink	45	0	19 Feb 24	PT09 AX82 VA96
700	CATASY01 Catheter Assembly 1 Tipping	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>0386</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0521</u> Cal Due: <u>31 MAY 24</u>	455	0	19 Feb 24	IC83 STR48 Hv36

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	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> <p>Part #: RM4001-01 Batch #: 82819 Qty: N/A</p> <p>Part #: RM0607-01 Batch #: 78849 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	455	① G 19Feb24	IC83 BI60 STX48 Hv36	
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	455	① 19Feb24	YK40 SN67 SS44	

Notes:

N/A

N/A

N/A

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① P446 19 Feb 24

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Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
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. PASS 2. PASS 3. PASS 4. PASS 5. passed	454	SKV-1 ①	KL45 SS56 SS52 ① SS52	19Feb24
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:						
MA						
N/A						
N/A						

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① 5552 18 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
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: 0700-01 Cal Due: 31MAY24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: RM0158-01 Batch #: 88018 Qty: N/A Part #: 1000-1153-01 Batch #: 89093 Qty: N/A Part #: RM4001-01 Batch #: 82819 Qty: N/A Part #: RM0607-01 Batch #: 78849 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A</p>	① 293 391	DIS-JHT(4H) II EW-LHT MAR-1 WK-4H1 EW-LHT1 III DEL-1 #5US-2H II SRV-11 #70S-HH11 1 (63) FM-1 #10S-151 #6US-HH1	19FEB24	LS46 DL07 KX54 MC17 PY46 D429 K155
950	QUALITY1 Quality Inspection & Review	Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: N/A Cal Due: N/A Record Caliper Information:	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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① PY46 19 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
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: <u>N/A</u> Cal Due: <u>N/A</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>	① 320 37 325	DIS-1 #10S-1 DIS-HH LHT HH HHT HHT HHT HHT HHT HHT 1 STR-HHT HHT ⑥③	19Feb24 MA	AL67 RILB
1000	 QUALITY1  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>105G</u> Cal Due: <u>31 MAY 24</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u>	311	LT-HHT HHT HHT HHT ⑯	19Feb24 MA	CB58 SS44

Notes:

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① P146 19 Feb 24

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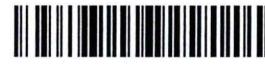
PC
Slide 1 / 61

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① 3y50 19 Feb 24

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Opn 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	286	0	20 Feb 24	BATI

Notes:

Not
Not
Not

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Material: SA0155-01 Rev F

Batch Number: 0000307850

By: BA71

Date: 20 Feb 24

Reviewed By:

RB29

Date:

20 Feb 24

Notes:

H/N

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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	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 MM1536-02 fixture for inspection. (See image 1)
**① MM0179-01
Type Connection 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)

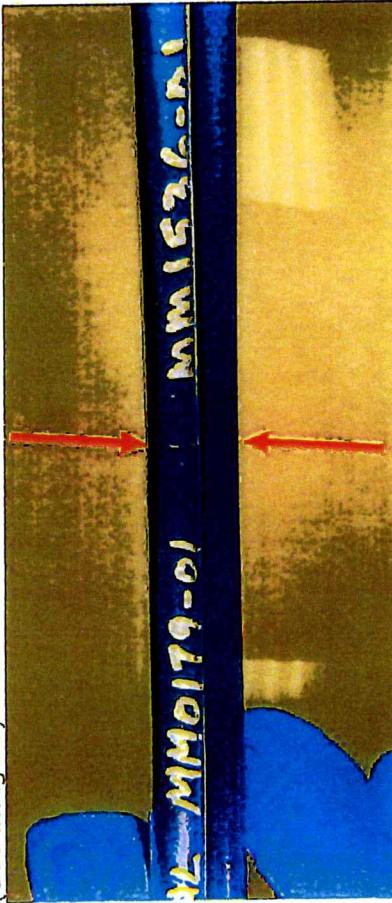


Image- 3

- 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.

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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)

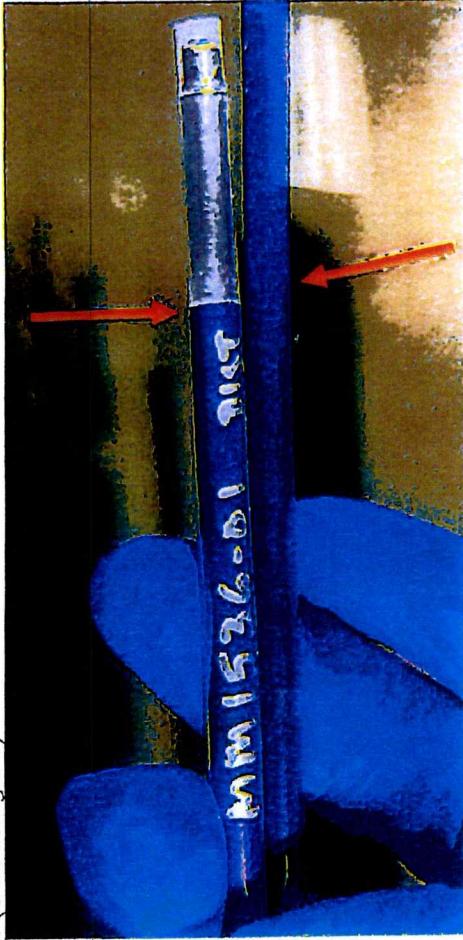


Image- 4

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 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 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			
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 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# 500000307850

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	5:32PM	430	RJLb	17Feb24	5:44PM	415	RJLb	17Feb24	16
TM10745	44	5:53PM	430	RJLb	17Feb24	6:05PM	415	RJLb	17Feb24	16
TM10745	44	6:16PM	430	SNL07	17Feb24	6:28PM	415	SNL07	17Feb24	16
TM10745	44	6:56AM	430	CB58	18Feb24	7:08AM	415	CB58	18Feb24	16
TM10745	44	7:40AM	430	CB58	18Feb24	7:52AM	415	CB58	18Feb24	16
TM10745	44	8:30AM	430	CB58	18Feb24	8:42AM	415	CB58	18Feb24	16
TM10745	44	9:25AM	430	CB58	18Feb24	9:37AM	415	CB58	18Feb24	16
TM10745	44	10:01AM	430	SD34	18Feb24	10:13AM	415	SD34	18Feb24	16
TM10745	44	10:45AM	430	SD34	18Feb24	10:57AM	415	SD34	18Feb24	16
TM10745	44	11:25AM	430	AM47	18Feb24	11:37AM	415	AM47	18Feb24	16
TM10745	44	11:43AM	430	SD34	18Feb24	11:55AM	415	SD34	18Feb24	16
TM10745	44	1:40pm	430	CB58	18Feb24	1:52pm	415	CB58	18Feb24	16



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FM5104665 Rev: C
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Title: SA0155-01 Reflow Log Sheet Form

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PRODUCTION ORDER# 500000 307850

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	5:26PM	430	QJ16	17Feb24	5:38PM	415	QJ16	17Feb24	16
TM10942	44	6:07pm	430	SN167	17 Feb24	6:19pm	415	SN167	17 Feb24	16
TM10942	44	6:20pm	430	SN167	17 Feb24	6:38pm	415	SN167	17 Feb24	10
TM10942	44	6:42AM	430	CB58	18Feb24	6:54AM	415	CB58	18Feb24	16
TM10942	44	7:20AM	430	CB58	18Feb24	7:42AM	415	CB58	18Feb24	16
TM10942	44	7:55AM	430	CB58	18Feb24	8:07AM	415	CB58	18Feb24	16
TM10942	44	8:17AM	430	SD34	18Feb24	8:29AM	415	SD34	18Feb24	10
TM10942	44	9:39AM	430	CB58	18Feb24	9:51AM	415	CB58	18Feb24	16
TM10942	44	10:17AM	430	SD34	18Feb24	10:29AM	415	SD34	18Feb24	16
TM10942	44	11:06AM	430	SD34	18Feb24	11:18AM	415	SD34	18Feb24	16
TM10942	44	12:14PM	430	SD34	18Feb24	12:26PM	415	SD34	18Feb24	10
TM10942	44	1:20pm	430	CB58	18Feb24	1:32pm	① 415	CB58	18Feb24	16

① CB58 18Feb24



PRODUCTION ORDER#: 500000307850

OP 400

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



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

PO #: 500000307850 OP #: 500 Shift #: 1st

Total Parts Reworked:		47	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	1	1
EH	Exposed Hypotube	1111	4
EW	Exposed Wire	1	31
MP	Micropores	N/A	N/A
SCR	Scratch	111	3
SKV	Skive Marks	1	1
VD	Voids	111	5
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

CB81, VC09, LL61 ① 18 Feb 24 19 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):

① LL61 19 Feb 24



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

PO #: 500000307850 **OP #:** 500 **Shift #:** 3

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): ① CBS8 18 Feb 24 ^② Late entry PY46 20 Feb 24



PO #: 500000307850

OP #: 750 Shift #: 3

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

Total Parts Reworked:		45	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	NA	NA
DIM07 US / WC	DIM07 Undersized (Window Closed)		13
EH	Exposed Hypotube		9
GID / AB	glue damage/ air bubbles		23
Inspected By (Sign and Date):		BT60 18 FEB 2024	

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): X



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

PO #: 500000307850 OP #: 750 Shift #: 1st

Total Parts Reworked:		22	
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)		3
EH	Exposed Hypotube		2
N/A	Glue - stopper		5
Inspected By (Sign and Date):		Hv36 19 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# 500000307850

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm12036	N/A	10:30AM	190°F	SN67	18 Feb 24	11:40AM	190°F	SN67	18 Feb 24	36
Tm10409	N/A	11:15AM	190°F	SN67	18 Feb 24	12:25pm	190°F	SN67	18 Feb 24	28
Tm12036	N/A	12:07pm	190°F	SN67	18 Feb 24	1:17pm	190°F	SN67	18 Feb 24	56
Tm10409	N/A	1:30pm	190°F	YK40	18 Feb 24	2:40pm	190°F	YK40	18 Feb 24	47
Tm10409	N/A	3:24pm	190°F	YK40	18 Feb 24	4:34pm	190°F	YK40	18 Feb 24	63
Tm10409	N/A	4:30am	190°F	K155	19 Feb 24	5:40am	190°F	K155	19 Feb 24	44
Tm12036	N/A	5:30am	190°F	SS44	19 Feb 24	6:40am	190°F	SS44	19 Feb 24	43
Tm10409	N/A	6:05am	190°F	SS44	19 Feb 24	7:15am	190°F	SS44	19 Feb 24	40
Tm10409	N/A	7:40Am	190°F	HV36	19 Feb 24	8:50am	190°F	HV36	19 Feb 24	37
Tm10409	N/A	8:55am	190°F	SS44	19 Feb 24	10:05am	190°F	SS44	19 Feb 24	4661
	NA	19 Feb 24	SS44							

① K155 19 Feb 24

② SS44 19 Feb 24



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

PO #: 500000307850 OP #: 900 Shift #: 3

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		9
EH	Exposed Hypotube		12
EW	Exposed Wire		37
MP	Micropores	N/A	N/A
SCR	Scratch		53
SKV	Skive Marks		3
VD	Voids		14
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		6
DIM06 OS	DIM06 OD Oversized	/	1
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		DLO7, KX52, MC17	18 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 #: 500000307850 OP #: 900 Shift #: 1st

Total Parts Reworked:		175	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		6
EW	Exposed Wire		46
MP	Micropores	N/A	N/A
SCR	Scratch	 	104
SKV	Skive Marks		2
VD	Voids		21
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		27
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		P-146 SKII D429	19 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	30.25	25.72	25.38	25.09	25.68	24.48	24.76	28.22	25.35	26.22	26.115	1.7817236	4.378	18.3146142	8.542	PASS
Seg B	64.74	63.57	62.2	54.22	65.28	59.7	56.43	57.33	66.97	65.34	61.578	4.3906309	3.981	44.0988983	8.542	PASS
Seg C	76.12	81.54	82.09	81.44	78.47	83.09	79.46	79.38	77.72	80.16	79.947	2.1506746	2.911	73.6863863	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 #: 500000307850

Date: 19 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24

19 Feb 24

