

Production Order: 500000304681



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 WorkCenter 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>6085 9:30AM 06 Feb 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 12:15am 08 Feb 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	05 Feb 24	SH70																								
		<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 <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000293119</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>n/a</u></td> <td><u>n/a</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000290560</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>					<u>n/a</u>	<u>n/a</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>				
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>																									
				<u>n/a</u>	<u>n/a</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>																									

Notes: DA 2564, 2484

N/A
N/A

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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>88562</u> <u>89098</u> <u>88563</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>N/A</u> <u>0000288401</u>	<u>N/A</u> <u>500</u>			
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u> <u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		TL0165-05	J	<u>U/J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>N/A</u> <u>Bulk</u>			
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>N/A</u> <u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			

Notes:

N/A

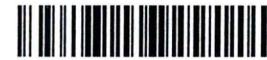
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① AM 68 09 Feb 24

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N/A	N/A	141967-01	02	02	PC	500	85794	500			
		RM7349-02	C	C	PC	543	82869	N/A	N/A		
		RM7348-01	C	C	PC	500	85677	500	N/A		
		RM4001-01	B	B	PC	125	82817	175	N/A		
		RM0607-01	D	D	PC	56	① 78848 N/A	N/A	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	① 0000287643 0000287645	65	37		
		RM0009-04	I	I	PC	1	① 0000287646 ① 0000287644 0000287647	38349	50		
		RM0009-04	I	I	PC	1	88992	Bulk	Bulk		
		RM0009-04	I	I	PC	1	88992	Bulk	Bulk		

Notes:

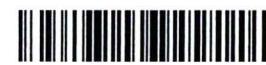
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N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>N/A</u>	Bulk		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>N/A</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>e</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0074-01	G	<u>G</u>	PC	500	<u>0000297039</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</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
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	500	0	08Feb24	V078
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	08Feb24	Sy47 Y014 pm96 0130 Y014

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	08Feb24	AS31 ny35 ST96 Dx35
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	08Feb24	CL05 AS31 V078
Notes:						
N/A						
N/A						
N/A						

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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	08Feb24	ST93 ST96 Ch05 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	08Feb24	DX95 GS22 ny35 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	 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	08Feb24 SY47 SA85	CL30 SH85 PM96
450	CATASY01 Catheter	FEP Removal	500	0	08Feb24 L291 TRV AT39	PM96 L291 TRV 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	Assembly 1 		① 500	① 0	① 08Feb24	JY90
	FEP Removal	N/A	N/A	N/A	N/A	
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-0 Batch #: 88562 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	477	EW-HH II OF- SH VD-II FM-II DL-II 23	LL61 VC09 TA36 CB81 D66 HT72 TD45 VCG1 08Feb24	
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	477	0	08Feb24	RS23 VA96 FR01 Y936 MV78
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly	472	MAH - II DL - II 5	08Feb24	JA96 FB01 PY46 TRN D4L9 MM02 MR60

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 Confirmation Reqd(Milestone)	Loading Heat Shrink	472	0	08Feb24	VAPL FB01 DY29 PP40 ML38
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 0521 Cal Due: 31 May 24	472	0	08Feb24	PH59 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> <p>Part #: <u>Rmc601-01</u> Batch #: <u>82817</u> Qty: <u>10</u></p> <p>Part #: <u>Rmc601-01</u> Batch #: <u>78848</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> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	472	0	08Feb24	Hv36 PH59 SV46
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	466	ACB-HIT 1 6	08Feb24	SS44 SS52 SG88

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	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	1 466	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>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	465	SKV-1	08Feb24 ML65	SS52
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	SH04 MV33 HT72

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	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: 31 May 24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: Rn4001-01 Batch #: 82817 Qty: N/A</p> <p>Part #: 1000-1530 Batch #: 88562 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>	436	<p>Dis-1441</p> <p>DL-1</p> <p>DEL-11</p> <p>WK-11</p> <p>DS-11</p> <p>EW-1</p> <p>ACD-1</p> <p>MAR-144</p> <p>HT-111</p> <p>A1 OS-1</p>	08Feb24	K155 P-146 KL67
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: N/A^① Cal Due: N/A^② 12 APR 24 KL67 08 Feb 24</p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A
N/A
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(1) TMI: 50713B KL67 08Feb24



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NIA	 Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: <u>NIA</u> Cal Due: <u>NIA</u> 30 APR 24 KL67 08 Feb 24 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>	125	DIS-141CSP DIS-111 STR-11	08 Feb 24	CB81 0521 KL67
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>105C</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>	416	Lt-H1 III WD-1	08 Feb 24	SS44 CB81 KL67

Notes:

 NIA
 NIA
 NIA

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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	366	10-SCR(FI) 1-DEL 3-FM 3-EW 5-DIS 2-SKV 2-LD 1-FB 1-MAR 1-KNK 1-BP	09 Feb 24	SV43 XN26 DX52
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>AM 68 09 Feb 24</u>	N/A N/A	N/A N/A	N/A N/A	N/A N/A
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	386	0	09 Feb 24	KX54

Notes:

N/A
N/A
N/A

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Batch Number: 0000304681

By: KX54

Date: 09 Feb 24

Reviewed By:

RB29

Date:

09feb24

Notes:

w/1A

w/1A

w/1A

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Batches To 2024 3228 U/A/23
 Expiry To 19 Feb 2024 3228 11/23
 CREGANNA MEDICAL is part of
 Extend to 2025 3228 11/23
 Due to 2025 3228 11/23



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Extend to 2025 3228 11/23

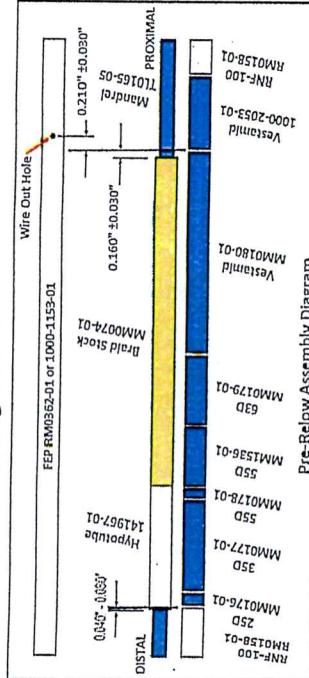
DEVIATION AUTHORIZATION NUMBER: 2484
 * See attached email extension to 2484
 TSIS 24AUG23 230823 5228
 24AUG23 230823 5228

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 FMEAs 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: 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:**

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

CREGANNA MEDICAL
is part of
=TE

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)
① **MM0179-01** **MM1536-01** **Type Connection TS12** **10AUG-23**

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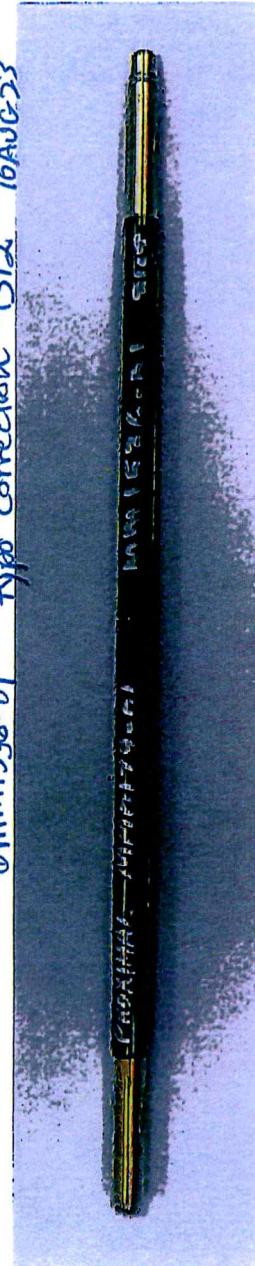


Image- 1

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)

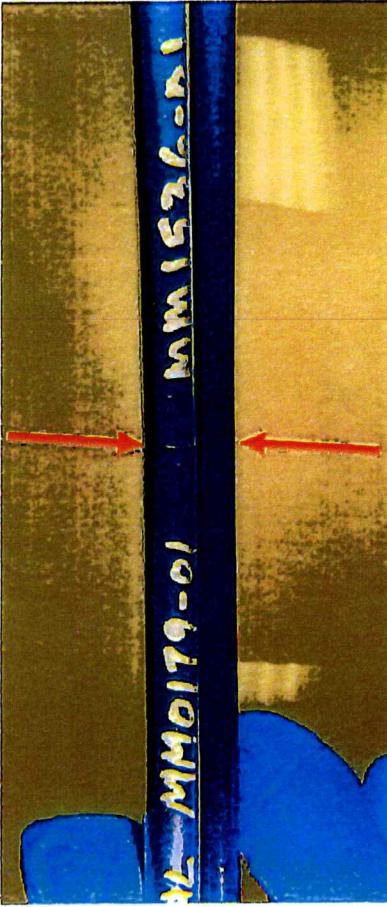


Image- 3

- 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)

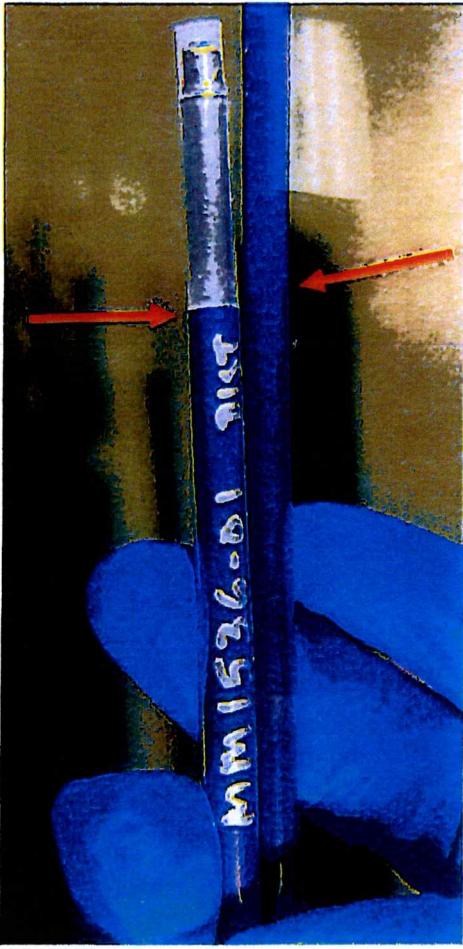


Image- 4

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	MM1536-01
GOOD PART		
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		

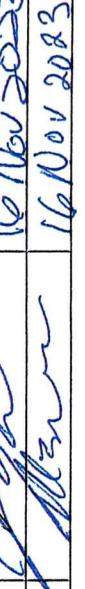
Image - 5

Entered to HINNEN J228 12/16/2023
Entered to 13 FEB 2024 J228 1/5/2024

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CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<p>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.</p>	<p>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.</p>		
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 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#: 500000304681

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	1:30AM	429	SH85	08 Feb 24	1:42AM	415	SH85	08 Feb 24	16
Tm10745	44	5:25AM	430	NK62	08 Feb 24	5:37AM	415	NK62	08 Feb 24	16
Tm10745	44	6:15AM	430	TA36	08 Feb 24	6:27AM	415	TA36	08 Feb 24	16
Tm10745	44	8:00AM	430	PM96	08 Feb 24	8:12AM	415	PM96	08 Feb 24	10
Tm10745	44	8:35AM	429	AX05	08 Feb 24	8:47AM	415	AX05	08 Feb 24	10
Tm10745	44	9:15AM	430	TA36	08 Feb 24	9:27AM	415	TA36	08 Feb 24	15
Tm10745	44	9:48AM	430	OS21	08 Feb 24	10:00AM	415	OS21	08 Feb 24	8
Tm10745	44	10:48AM	430	OS21	08 Feb 24	11:00AM	415	OS21	08 Feb 24	10
Tm10745	44	11:35AM	436	NK62	08 Feb 24	11:47AM	415	NK62	08 Feb 24	13
Tm10745	44	12:30PM	430	OS21	08 Feb 24	12:42PM	415	OS21	08 Feb 24	16
Tm10745	44	1:22 PM	430	PM96	08 Feb 24	1:34 PM	415	PM96	08 Feb 24	10
Tm10745	44	2:08PM	430	TA36	08 Feb 24	2:12PM	415	TA36	08 Feb 24	15



PRODUCTION ORDER# 50000030468

OP 400

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PRODUCTION ORDER#: 500000304681

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	1:47AM	430	CL30	08FEB24	1:59AM	415	CL30	08FEB24	16
Tm10942	44	5:10am	430	TA36	08Feb24	5:22am	415	TA36	08Feb24	16
Tm10942	44	5:55am	430	TA36	08Feb24	6:07am	415	TA36	08Feb24	14
Tm10942	44	7:00AM	430	OS21	08Feb24	7:12AM	415	OS21	08Feb24	13
Tm10942	44	7:45AM	430	PM96	08Feb24	7:57AM	415	PM96	08Feb24	10
Tm10942	44	8:25AM	430	PM96	08Feb24	8:37AM	415	PM96	08Feb24	10
JM10942	44	8:55AM	430	OS21	08Feb24	9:17AM	415	OS21	08Feb24	11
TM10942	44	9:40am	430	AX05	08Feb24	9:52am	415	AX05	08Feb24	12
TM10942	44	11:15AM	430	NK62	08Feb24	11:27A	415	NK62	08Feb24	14
TM10942	44	12:00PM	430	NK62	08Feb24	12:12PM	415	NK62	08Feb24	14
TM10942	44	1:35PM	430	AX05	08Feb24	1:47PM	415	AX05	08Feb24	11
TM10942	44	2:20PM	430	AX05	08Feb24	2:32PM	415	AX05	08Feb24	15



PRODUCTION ORDER# 50000030468

OP 400

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

① V078 08 Feb 24



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000304681OP #: 500 Shift #: 1ST

Total Parts Reworked:

106.

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		24
EW	Exposed Wire		68
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		2
VD	Voids		9
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

VC 09, LL 61, CB 81, 08 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 #: 500000304681

OP #: 500 Shift #: 2

Total Parts Reworked:		<u>20</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>HH HH HH //</u>	<u>19</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>1</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Carter</u>	<u>08 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.

Data Uploaded for Engineering Review (Check):



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000304681OP #: 500 Shift #: 2nd

Total Parts Reworked:		14	
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		8
MP	Micropores	n/a	n/a
SCR	Scratch		3
SKV	Skive Marks	n/a	n/a
VD	Voids		4
n/a	n/a	n/a	n/a

Inspected By (Sign and Date): Vamneet Loh 08 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 #: 500000 304681 OP #: 750 Shift #: 1st

Total Parts Reworked:		56	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		12
DIM07 US / WC	DIM07 Undersized (Window Closed)		15
EH	Exposed Hypotube		11
N/A	Glue , stopper		18
Inspected By (Sign and Date):		PH59 Hv36	08 Feb 24

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

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000304681 OP #: 750 Shift #: 2nd

Total Parts Reworked:		12	
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		2
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV 46 08 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# 500000304681

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	8:25am	190°F	SSH44	08feb24	9:35am	190°F	SSH44	08feb24	42
Tm12036	N/A	9:10am	190°F	SSH44	08feb24	10:20am	190°F	SSH44	08feb24	32
Tm10409	N/A	9:40am	190°F	K155	08Feb 24	10:50am	190°F	K155	08Feb 24	27
Tm10409	N/A	11:20 am	190°F	K155	08Feb 24	12:30 pm	190°F	K155	08Feb 24	33
Tm12036	N/A	12:00 pm	190°F	K155	08Feb 24	1:10 pm	190°F	K155	08Feb 24	21
Tm10409	N/A	12:35PM	190°F	OS21	08Feb 24	1:45PM	190°F	SSH44	08feb24	26
Tm10409	N/A	1:45pm	190°F	SSH44	08feb24	2:55pm	190°F	SSH44	08feb24	33
Tm12036	N/A	2:15pm	190°F	SSH44	08feb24	3:25pm	190°F	SSH44	08feb24	25
Tm10409	N/A	3:57pm	190°F	SG88	08Feb 24	5:07pm	190°F	SG88	08Feb 24	29
Tm12036	N/A	4:51pm	190°F	SG88	08Feb 24	6:01pm	190°F	SA07	08Feb 24	34
Tm12036	N/A	① 5:54pm	190°F	SA07	08Feb 24	7:15pm	190°F	SG88	08Feb 24	24
Tm10409	N/A	6:52pm	190°F	SG88	08Feb 24	8:02PM	190°F	SG88	08Feb 24	34
Tm12036	N/A	7:34pm	190°F	SG88	08Feb 24	8:34pm	190°F	SG88	08Feb 24	34

① 08Feb24 SA07

Page 1 of 1

PRODUCTION ORDER# 5000003D4681

OP 800

① SCF68 08 Feb 24

Page 1 of 1



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 50000304681 OP #: 900 Shift #: 15F

Total Parts Reworked:		57	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		1
EW	Exposed Wire		12
MP	Micropores	N/A	N/A
SCR	Scratch		36
SKV	Skive Marks	N/A	N/A
VD	Voids		5
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		16
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		KT217 P146 K155	08 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 #: 500000304681 OP #: 900 Shift #: 2

Total Parts Reworked:		69	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		3
EW	Exposed Wire		26
MP	Micropores	N/A	N/A
SCR	Scratch		63
SKV	Skive Marks	N/A	N/A
VD	Voids		4
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized	N/A HT72 08Feb24	
DIM09 US	DIM09 OD Undersized	HT72 08Feb24	
Inspected By (Sign and Date):		HT72 08Feb24	

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 #: 500000304681

OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		68	
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		16
MP	Micropores	N/A	0
SCR	Scratch		49
SKV	Skive Marks	N/A	0
VD	Voids		2
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		15
DIM06 OS	DIM06 OD Oversized		2
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Qee H - 07 08 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.

SH04 08 Feb 24

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	34.54	25.6	25.49	33.37	28.98	34.92	25.67	29.77	24.62	27.58	29.054	3.9660902	4.378	11.6904573	8.542	PASS
Seg B	68.62	72.75	81.32	75.65	72.23	79.43	81	70.8	70.11	78.11	75.002	4.7217436	3.981	56.2047389	8.542	PASS
Seg C	85.6	81.26	83.07	89.73	81.25	85.7	90.32	84.61	88.93	86.49	85.696	3.2706309	2.911	76.1751934	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 #: 500000304681

Date: 09FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



09 FEB 2024