

Production Order: 500000295351



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		

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3 Kitting Devices  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>XCB1 10:4PM 10JAN24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XCB2 11:30pm 11Jan24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	10JAN24	JAH70
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
	MM0179-01	D <u>Q</u>	PC	500	<u>0000276172</u>	<u>500</u>
					<u>0000272345</u>	<u>40</u>
	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>

Notes: DA2484, 2564

N/A

N/A

Date Printed: 10.01.2024 / 15:37:28

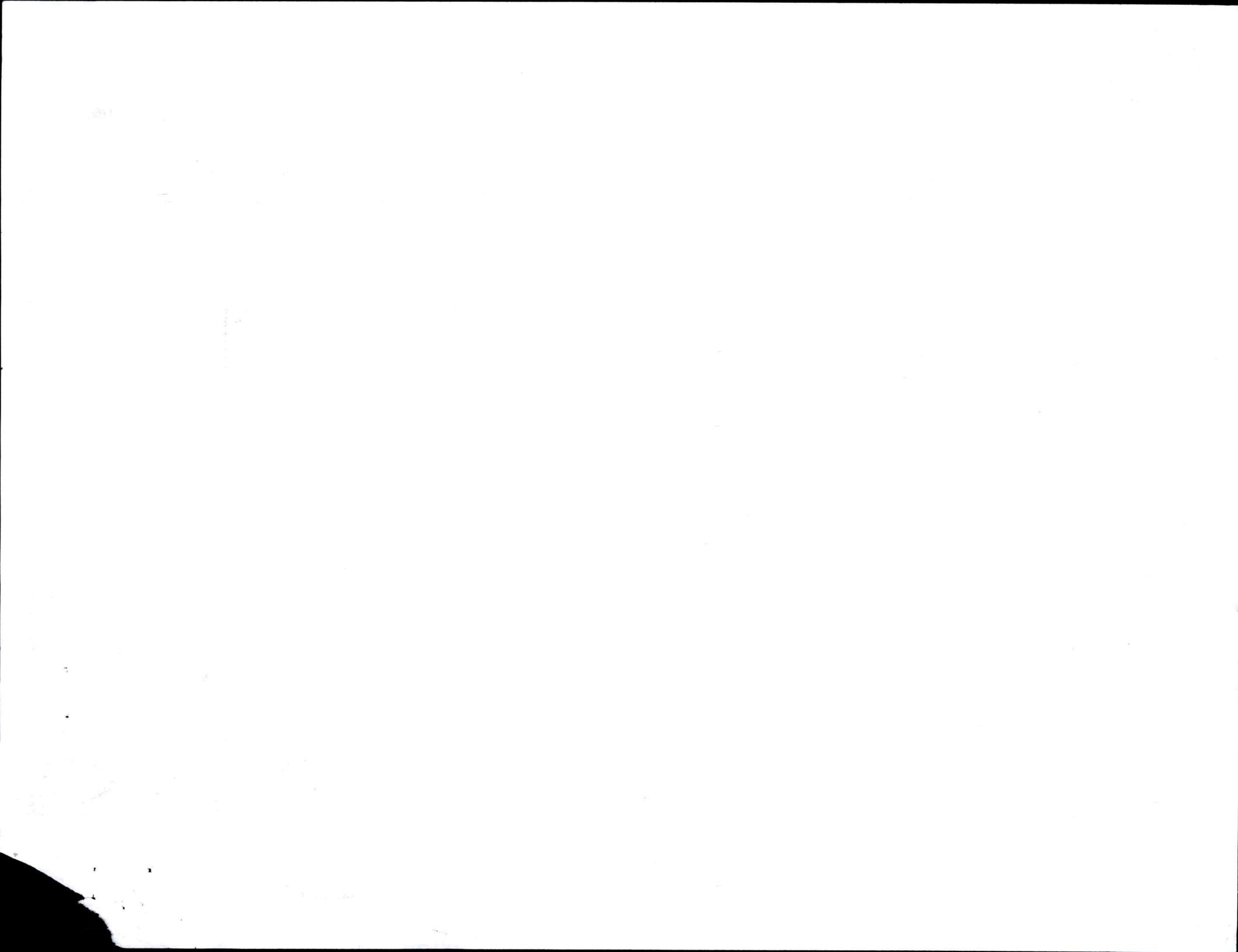
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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>0000263145</u>	<u>40</u>			
							<u>58497</u>	<u>210</u>			
							<u>N/A</u>	<u>N/A</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>87102</u>	<u>200</u>			
							<u>87107</u>	<u>200</u>			
							<u>87221</u>	<u>200</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>400</u>			
							<u>0000278880</u>	<u>100</u>	N/A	N/A	N/A
		MM1537-02	A	<u>A</u>	PC	500	<u>0000276175</u>	<u>500</u>			
							<u>N/A</u>	<u>N/A</u>			
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			

Notes:

N/A

N/A

N/A

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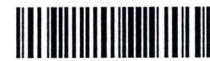


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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials	
N/A	N/A	141967-01	02	02	PC	500	85500	500	N/A			
		RM7349-02	C	C	PC	543	84168	268				
		RM7348-01	C	C	PC	500	84171	300				
		RM4001-01	B	B	PC	125	82884	450				
		RM0607-01	D	D	PC	56	82824	100	N/A	N/A	N/A	
		RM0498-01	C	C	PC	500	82823	100				
		RM0009-04	I	I	PC	56	74663	106	N/A	N/A	N/A	
		RM0009-04	I	I	PC	1	0000287640	500				
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	<u>A</u>	PC	500	<u>0000278970</u>	<u>Bulk</u> <u>N/A</u>	<u>500</u> <u>N/A</u>	
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000281413</u>	<u>N/A</u>	<u>1120</u> <u>N/A</u>	
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>N/A</u>	<u>500</u> <u>N/A</u>	
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>N/A</u>	<u>500</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>500</u> <u>40</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000291411</u>	<u>N/A</u>	<u>500</u> <u>40</u>	
		MM0074-01	G	<u>G</u>	PC	500	<u>0000292832</u>	<u>N/A</u>	<u>516</u> <u>53</u>	
							<u>0000286923</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	12Jan24	V078
	Line Clearance Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	12Jan24	SX60 JY90 SD34 SN47 YK40
	Major and Minor Mandrel Assembly					

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				ep32 y014
	Loading Braid Stock		500	0	12Jan24	
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	12Jan24	CL30 AS31
Notes:						
N/A						
N/A						
N/A						

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Opr. No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1 	Insert Cut Hypo Tube Insert Cut Hypo Tube Confirmation Reqd(Milestone)	500	0	12Jan24	ST93 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	12Jan24	ST96 N35 V078

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 Reflow Confirmation Reqd(Milestone)		500	0	12Jan24	SG85 NY35 V078
450	CATASY01 Catheter	FEP Removal	500	0	12Jan24	SG88
Notes:						
N/A						
N/A						
N/A						

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Op. 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	N/A	N/A	N/A
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 #: 87109 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	489	skv-11 DF-IHT EW-1111 12Jan24 11	P66 DX35 TD245 LS446 G160 PT09	
		N/A N/A N/A N/A	N/A	N/A	N/A	N/A
	Notes:					

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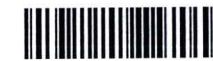


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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	485	MAH-1111 	12Jan24	SV16 MV78 CD19 LH45 TRN MH10 VAG6 PT09
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly Distal Tip Assembly Confirmation	482	DL-111 	12Jan24	CL05 AT39 MH10 BI60

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	482	0	12Jan24	ML38 BIGO
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
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: 6386 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	482	0	12Jan24	ML38 IC83
	Tipping					
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
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
750	CATASY01 Catheter Assembly 1 	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4001-01 Batch #: 82824 Qty: N/A Part #: RM4007-01 Batch #: 74663 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	479	EH-111 (3)	12Jan24	MNC2 JL83
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	473	ACD-WT1 (6)	12Jan24	XL91 AT39 SN67 YK40 AIGS

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	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1  Cut to Length Confirmation Reqd(Milestone)	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. Pass 2. Pass 3. Pass 4. Pass 5. Pass	473	0	12Jan24	KLWS
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
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 #: 1000-1153-01 Batch #: 87109 Qty: N/A Part #: RM4001-01 Batch #: 82824 Qty: N/A Part #: RM0607-01 Batch #: 74663 Qty: N/A Part #: RM0158-01 Batch #: S8497 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A</p>	420	53	13Jan24	KT27 PL07 KX54
950	QUALITY1 Quality Inspection & Review	<p>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:</p>	N/A	N/A	N/A	N/A

Notes:

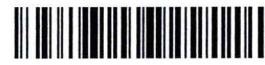
N/A

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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)	TMI: N/A Cal Due: N/A Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 Sep 25 TMI: 0692 Cal Due: 30 Sep 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	412	DIS-LH1 STR-11 ⑧	13 Jan 24	N/A ALG7
1000	 QUALITY1 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: 1056 Cal Due: 31 May 24 Record Length Gage Information: TMI: 0889D Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 Sep 24	394 393	LT-LH1 LH1111 ① ① ① ⑨	13 Jan 24	CB58

Notes:

N/A

N/A

N/A

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① XL91 16 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
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	200	SCR - M1 UMF PPC - M1 VD - M1 SKV - M1 DIS - M1 DL - M1 EW - M1 Del - II PM - I RDG - I ETT - I DISC - I AB - I DNT - I 47	16 Jan 24	YK95 SV43
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KFOZ 16 Jan 24	N/A	N/A	16 Jan 24	KFOZ

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	346	0	19 Jan 24	AP10

Notes:

N/A AP10 19 Jan 24

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Batch Number: 0000295351

By: AP10

Date: 19 Jan 24

Reviewed By:

RB29

Date:

19 JAN 24

Notes:

N/A AP10 19 Jan 24 /

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DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	Deviation To:
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	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
16 Nov 23	15 DEC 23	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
Engineering Manager	Jake Stanislowski	
Quality Manager	Jay Zabel	
Operations Manager	Matthew Benson	

11/15/2020 at 10:45 AM

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CONTROLLED COPY DEVIATION AUTHORIZATION FORM NUMBER: 2484
* See attached email extension to 24 SEP 23
1512
24 AUG 23
23 OCT 2023 1512

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484

APPLICATION FORM Bento to 23 Oct 2023 15:00
24 Aug 23 15:00
See attached email extension to 24 Sep 23
15:00

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.

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:

Are 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): NA

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

Emergency 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

Training Requirements: Yes No **If no answer:**

① UK55, 23JW 2023

2484
2468

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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 ~~MM1536-02~~ fixture for inspection. (See image 1)
① MM0179-01 **10AUG-23** **512** **Type Connection**

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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)

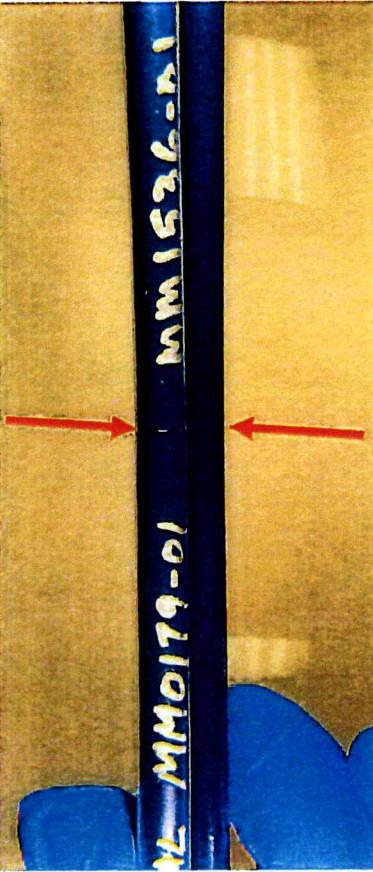


Image- 3

- 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.

CONTROLLED COPY

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)

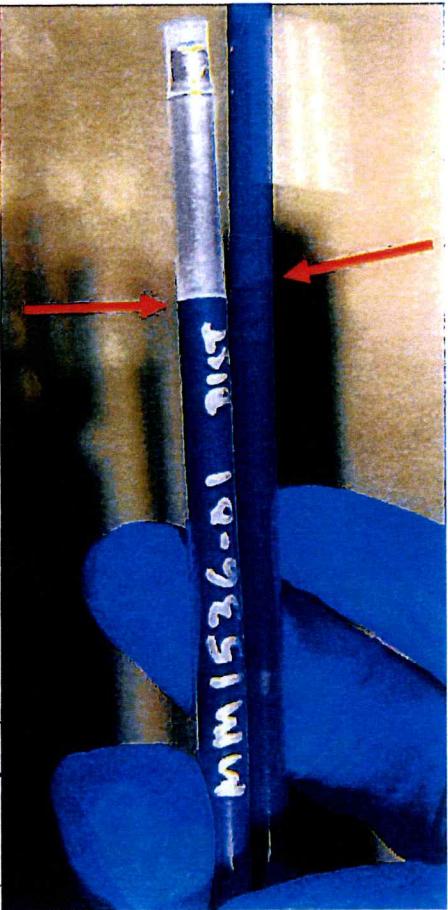


Image- 4

- 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

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

FM0002.RevF

Deviation Authorization

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

PRODUCTION ORDER# 500000295351

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	9:10pm	430	SH85	11Jan24 11Jan24	9:22pm	415	SH85	11Jan24	16
Tm10745	44	9:42pm	428	SH85	11Jan24	9:54pm	415	SH85	11Jan24	16
Tm10745	44	10:20pm	430	V078	11Jan24	10:32pm	415	SH85	11Jan24	16
Tm10745	44	10:52pm	430	V078	11Jan24	11:04pm	415	V078	11Jan24	16
Tm10745	44	12:12AM	430	V078	12Jan24	12:24AM	415	V078	12Jan24	16
Tm10745	44	12:41AM	428	V078	12Jan24	12:53AM	415	V078	12Jan24	16
Tm10745	44	1:12AM	430	V078	12Jan24	1:24AM	415	V078	12Jan24	16
Tm10745	44	1:43AM	428	V078	12Jan24	1:55AM	415	SH85	12Jan24	16
Tm10745	44	6:46AM	430	Jc92	12Jan24	6:58AM	415	Jc92	12Jan24	16
① Tm10742	44	7:42am	430	Cm99	12Jan24	7:54am	415	Cm99	12Jan24	16
Tm10745	44	8:00AM	430	CB58	12Jan24	8:12am	415	CB58	12Jan24	16
Tm10745	44	8:10AM	430	CB58	12Jan24	8:22AM	415	CB58	12Jan24	16

① SH85 11Jan24 ✓



Document No: 5105589
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Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000295351

OP 400

OCB58 12Jan24



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

PRODUCTION ORDER# 500000295351

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	9:24pm	428	SH85	11 Jan 24	9:38pm	415	SH85	11 Jan 24	16
Tm10942	44	9:57pm	429	SH85	11 Jan 24	10:09pm	415	SH85	11 Jan 24	16
Tm10942	44	10:38pm	430	SH85	11 Jan 24	10:48pm	415	SH85	11 Jan 24	16
Tm10942	44	11:05pm	426	V078	11 Jan 24	11:17pm	415	V078	11 Jan 24	16
Tm10942	44	11:50pm	430	SH85	11 Jan 24	12:02AM	415	SH85	12 Jan 24	16
Tm10942	44	12:29AM	430	SC88	12 Jan 24	12:41AM	415	SC88	12 Jan 24	16
Tm10942	44	12:59AM	428	V078	12 Jan 24	1:11AM	415	V078	12 Jan 24	16
Tm10942	44	1:32AM	428	V078	12 Jan 24	1:44AM	415	SH85	12 Jan 24	16
Tm10942	44	1:55AM	428	SH85	12 Jan 24	2:07AM	415	AT39	12 Jan 24	16
Tm10942	44	7:05AM	428	JC92	12 Jan 24	7:17AM	415	JC92	12 Jan 24	16
Tm10942	44	7:20AM	428	JC92	12 Jan 24	7:32AM	415	JC92	12 Jan 24	16
Tm10942	44	8:45am	430	TA36	12 Jan 24	8:57am	415	TA36	12 Jan 24	16

(1)V078 12 Jan 24



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

PRODUCTION ORDER# 50000295351

OP 400

① C B 58 12 Jan 24



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

PO #: 500000 295351

OP #: 500 Shift #: 2

Total Parts Reworked:		18	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		2
EW	Exposed Wire		19
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	/	1
N/A	N/A	N/A	0
Inspected By (Sign and Date):		Candy 11 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):



500000295351

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

PO #: 5000002953

OP #: 500 Shift #: 2

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	1	1
EW	Exposed Wire		20
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids		2
N/A	N/A	N/A	0
Inspected By (Sign and Date):		DX35 11 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):

DX35 11 Jan 24



PO #: 500000295351

OP #: 500 Shift #: 300

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

Data Uploaded for Engineering Review (Check):

0:



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

PO #: 500000295351 OP #: 500 Shift #: 3

Total Parts Reworked:		48	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire		37
MP	Micropores	N/A	N/A
SCR	Scratch	/	/
SKV	Skive Marks	/	/
VD	Voids		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		B160 PTO9 12 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000295351 OP #: 750 Shift #: 2nd

Total Parts Reworked:		10	
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)	N/A	N/A
EH	Exposed Hypotube	///	5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	11Jan24

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 #: 500 000 295 351 OP #: 750 Shift #: 3

Total Parts Reworked:		42	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	XXXX//	12
DIM07 US / WC	DIM07 Undersized (Window Closed)	XXX//	7
EH	Exposed Hypotube	XXX XXX	15
GD	Glue Damage	XXX///	8
Inspected By (Sign and Date):		IC83	12 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# 500000295351

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	1:15AM	190° F	XL91	12Jan24	2:25AM	190° F	XL91	12Jan24	63
TM10409	N/A	5:00AM	190° F	KL4S	12JAN24	6:10AM	190° F	KL4S	12JAN24	38
TM10409	N/A	6:55AM	190° F	SN67	12Jan24	8:05AM	190° F	SN67	12Jan24	26
TM12036	N/A	7:25AM	190° F	SN67	12 Jan24	8:35AM	190° F	SN67	12 Jan24	21
TM10409	N/A	8:15AM	190° F	SN67	12Jan24	9:25AM	190° F	SN67	12Jan24	37
TM12036	N/A	9:23AM	190° F	YK40	12Jan24	10:33AM	190° F	YK40	12Jan24	28
TM10409	N/A	9:57AM	190° F	YK40	12Jan24	11:07AM	190° F	YK40	12Jan24	29
TM12036	N/A	10:38AM	190° F	YK40	12 Jan24	11:48AM	190° F	YK40	12 Jan24	31
TM10409	N/A	11:14AM	190° F	YK40	12 Jan24	12:24 PM 12:24 AM	190° F	YK40	12 Jan24	D341
TM12036	N/A	12:21PM	190° F	YK40	12 Jan24	1:31 PM	190° F	YK40	12 Jan24	48
TM10409	N/A	1:40PM	190° F	AIG5	12Jan24	2:50PM	190° F	AIG5	12Jan24	28
TM12036	N/A	2:25PM	190° F	AIG5	12Jan24	3:35PM	190° F	AIG5	12Jan24	32
TM10409	N/A	3:00PM	190° F	AIG5	12Jan24	4:10PM	190° F	AIG5	12Jan24	51

YK40 12Jan24

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Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000295351

OP #: 900 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. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

1

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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	29.29	34.18	31.62	25.61	35.9	32.6	30.56	27.64	24.54	30.25	30.219	3.601245	4.378	14.4527494	8.542	PASS
Seg B	69.35	69.51	66.69	67.16	82.25	71.44	69.17	75.41	67.85	65.89	70.472	4.9560755	3.981	50.7418634	8.542	PASS
Seg C	91.41	77.28	89	85.47	87.56	77.73	77.05	90.74	90.3	87.62	85.416	5.827977	2.911	68.450759	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

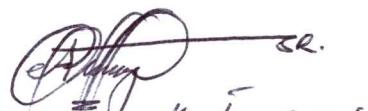
LOT #: 500000295351

Date: 16JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



16 Jan 2024