

Production Order: 500000295352



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: 7987
 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>KIT 1:30pm 11 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 68 11:00am 12 Jan 24</u> Record Dryer Shelf #: <u>N/A</u></p> <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>0000276172</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000281412</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>0000276172</u>	<u>500</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>	N/A	N/A	11JAN24 KL27
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>D</u>	PC	500	<u>0000276172</u>	<u>500</u>																		
MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>																		

Notes: SA 2484, 2.564

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01 1000-1153-01 1000-2053-01 MM1537-02 TL0167-02 TL0165-05 TL0165-03	E B59 A E A E J J	E B59 A E A E J J	PC PC PC PC PC PC	200 594 500 500 70 5 5	N/A N/A-81054① 85882 N/A 0000278880 0000276175 0000271023 N/A N/A N/A N/A N/A N/A	100 N/A 600 N/A 500 500 20 Bulk Bulk Bulk Bulk Bulk Bulk	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

Notes:

N/A

N/A

N/A

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N/A	N/A	141967-01	02	02	PC	500	85500	525		
		RM7349-02	C	C	PC	543	82854 82567, 82727 82729, 82568	514 100, 41 72, 50		
		RM7348-01	C	C	PC	500	78686 82882 82883	150 150 300		
		RM4001-01	B	B	PC	125	① N/A 82103 82434	N/A 58	N/A	N/A
		RM0607-01	D	D	PC	56	74662 N/A	63 N/A		
		RM0498-01	C	C	PC	500	0000287640	500		
		RM0009-04	I	I	PC	1	82971 N/A	Bulk Bulk		
		RM0009-04	I	I	PC	1	82971	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	<u>A</u>	PC	500	<u>0000278970</u>	<u>N/A</u>	<u>Bulk</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000281413</u>	<u>N/A</u>	<u>500</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>N/A</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>N/A</u>	<u>500</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>N/A</u>	<u>40</u>	<u>N/A</u>	<u>N/A</u>
		MM0074-01	G	<u>G</u>	PC	500	<u>0000292835</u>	<u>N/A</u>	<u>514</u>		
							<u>0000286923</u>	<u>52</u>			

Notes:

<u>N/A</u>
<u>N/A</u>

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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	13Jan24	CB58
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	13Jan24	SN67 JC92 SD34 YK40 AM47
	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 Loading Braid Stock Confirmation Reqd(Milestone)	500	0	13Jan24 PL65 PY67 LH45	
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	13Jan24 PL22 TRN SC10 RL45	
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	13Jan24	PL22 AL67 AL42
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	13Jan24	RL47 CX63

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	13Jan24	AM47 TRN RWB
450	CATASY01 Catheter	FEP Removal	500	0	13Jan24	JK92 YK240
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 Material Consumed: Part #: 1000-1153-01 Batch #: 87109 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	482	EW-HTR/11 OF-HM IDB-1 CRK-1 (18)	LS46 AK02 BIG0 CB81 13Jan24	
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
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	476	MAH-1111 OF -1 DL -1 ⑥	13Jan24	VA96 M1410 PT09
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	476	0	13Jan24	PT09

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	476	0	13Jan24	P709 B160
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 09367 Cal Due: 31Mar24 TMI: 20830 Cal Due: 31Mar24 TMI: 0386 Cal Due: 31Mar24 TMI: 6521 Cal Due: 31Mar24 Tipping	476	0	13Jan24	I683
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
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	Tip Inspection/ Flash Removal Material Consumed: Part #: RM400-01 Batch #: 82434 Qty: N/A Part #: RM060701 Batch #: 74662 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	475	EH-1 ①	13Jan24	IL83
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		471	ACD-1111 ④	13Jan24	AL42 KL45 YK40
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
	Major Mandrel Removal N/A 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. <u>Pass</u> 2. <u>Pass</u> 3. <u>Pass</u> 4. <u>Pass</u> 5. <u>Pass</u>	① 471 471	① O O	13Jan24 16Jan24	KL45 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	N/A
Notes:						
N/A						
N/A						

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① KL45 13JAN24

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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: <u>0700-01</u> Cal Due: <u>31 MAY 2024</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>RM0158-01</u> Batch #: <u>81054</u> Qty: <u>N/A</u> Part #: <u>1000-1153-01</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>74662</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82434</u> Qty: <u>N/A</u> Part #: <u>RM0362-01</u> Batch #: <u>85882</u> Qty: <u>N/A</u></p>	33	DEL-UHSP DEL-UHAT TT EU-UHUM SKN-11 #545-11 AB-1 EH-1 H905-1 EW-1 DEL-11 WL-1 (38) EM-1	16 Jun 24	DL07 L946 KX54 YK95 OS21 SSHHTR
950	QUALITY1 Quality Inspection & Review	<p>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:</p>	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
	Quality Inspection & Review M ✓ 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>30Sep2025</u> TMI: <u>0692</u> Cal Due: <u>30Sep2025</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	429	(4) DIS-III	16 Jun 24 16 Jun 24	RV16 AUG7
1000	QUALITY1 Quality Inspection & Review M ✓ 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>31May2024</u> Record Length Gage Information: TMI: <u>08891D</u> Cal Due: <u>30Sep2024</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30Sep2024</u>	425	(4) LT-III	16 Jun 24 16 Jun 24	CB58

Notes:

N/A

N/A

N/A

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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	35	SCR - M1 M1 M1 111 VD - M1 M1 M1 SKV - M1 M1 Del - M1 M1 EW - M1 M1 FM - M1 M1 DIS - M1 M1 DL - M1 M1 EH - M1 M1 FB - M1 M1 CRK - M1 M1 PBC - M1 M1 MEX - M1 M1 DNT - M1 M1 AB - M1 M1 (68)	16 Jan 24	K155 SV43
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KPO2 16 Jan 24	N/A	N/A	16 Jan 24	KPO2

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	357	0	19 Jan 24	PA71

Notes:

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N

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Batch Number: 0000295352

By: BA71

Date: 19 Jan 24

Reviewed By:

AF78

Date:

19 Jan 24

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11/16/2028 At 10:00 AM



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is part of **DEVIA**TION A
Extends to 22 Nov 2023 028 Part 23

Requestor Name: Udhesh Kapadnis

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484

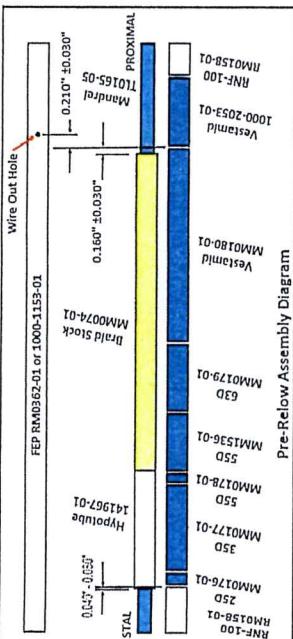
IZATION FORM Began to ~~23 Oct 2023~~ 24 Sep 2023
See attached email extension to 24 SEP 2023
1512
24 AUG 23

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
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:	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> 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.

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, 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 MM01536-01 **10AUG-23** **512**

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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)

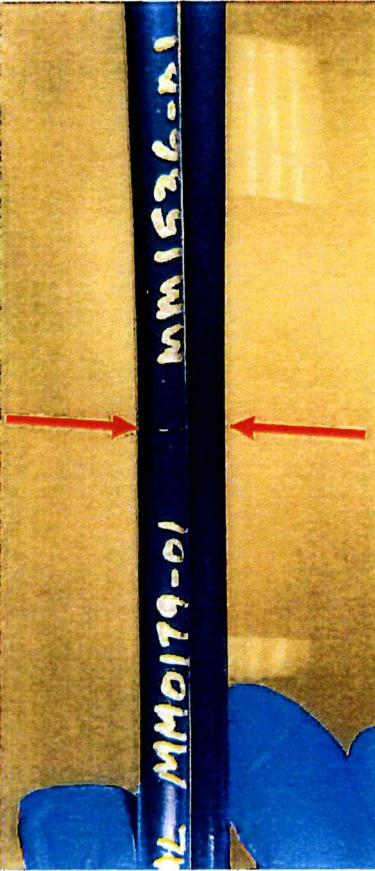


Image- 3

- 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)

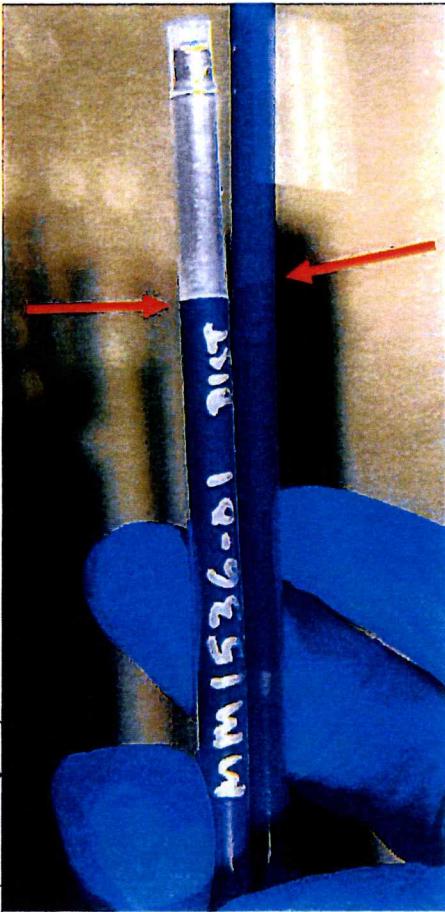


Image- 4

- 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 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

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

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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:	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:

TM10602 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.
 TM10700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TM10700-01 is already qualified to inspect Dim 6 per ES0647: Laser micrometer equivalency test, there is no additional risk in using TM10700-01 for OPER850 Dim 6 inspection till TM10602 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 TM10700-01. DA will be removed once the lasermic TM10602 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# 500000295352

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	12:00pm	430	TA36	12 Jan 24	12:12pm	415	TA36	12 Jan 24	16
TM10745	44	1:55pm	430	CB58	12 Jan 24	2:07pm	415	CB58	12 Jan 24	16
TM10745	44	2:03pm	430	SD34	12 Jan 24	2:15pm	415	SD34	12 Jan 24	16
Tm10745	44	2:30pm	430	SN67	12 Jan 24	2:42pm	415	SN67	12 Jan 24	16
Tm10745	44	2:51pm	430	RV16	12 Jan 24	3:03pm	415	RV16	12 Jan 24	16
Tm10745	44	4:15pm	430	SN67	12 Jan 24	4:27pm	415	SN67	12 Jan 24	16
Tm10745	44	4:45pm	430	cm99	12 Jan 24	4:57pm	415	cm99	12 Jan 24	16
Tm10745	44	5:17pm	430	cm99	12 Jan 24	5:29pm	415	cm99	12 Jan 24	16
Tm10745	44	5:53pm	430	SN67	12 Jan 24	6:05pm	415	SN67	12 Jan 24	16
TM10745	44	6:25PM	430	AL67	12 Jan 24	6:37PM	415	AL67	12 Jan 24	16
TM10745	44	7:15AM	430	RV16	13 Jan 24	7:27AM	415	RV16	13 Jan 24	16
Tm10745	44	8:02am	430	cm99	13 Jan 24	8:14am	415	cm99	13 Jan 24	16



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

PRODUCTION ORDER# 500000295352

OP 400

① cmq9 13 Jan 24



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

PRODUCTION ORDER# 500000295352

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:23pm	430	cm99	12Jan24	12:35pm	415	cm99	12Jan24	16
TM10942	44	1:25pm	430	Jc92	12Jan24	1:37pm	415	Jc92	12Jan24	16
TM10942	44	1:45pm	430	CB58	12Jan24	1:57pm	415	CB58	12Jan24	16
TM10942	44	2:15pm	430	SN167	12Jan24	2:27pm	415	SN167	12Jan24	16
TM10942	44	3:13pm	430	PV16	12Jan24	3:25pm	415	PV16	12Jan24	16
TM10942	44	4:32pm	430	cm99	12Jan24	4:44pm	415	cm99	12Jan24	16
TM10942	44	4:59pm	430	cm99	12Jan24	5:11pm	415	cm99	12Jan24	16
TM10942	44	5:34pm	430	SD34	12Jan24	5:46pm	415	SD34	12Jan24	16
TM10942	44	6:11PM	430	A267	12Jan24	6:23PM	415	AL67	12 Jan 24	16
TM10942	44	6:45 AM	430	PV16	13Jan24	6:57 AM	415	PV16	13 Jan 24	16
TM10942	44	7:38AM	430	SN167	13Jan24	7:50AM	415	SN167	13Jan24	16
TM10942	44	8:16am	430	cm99	13Jan24	8:28am	415	cm99	13Jan24	16



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000295352

OP 400

① C019 13 Jan 24



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

PO #: 500000295352 OP #: 500 Shift #: 3

Total Parts Reworked:		34	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	NA
EH	Exposed Hypotube		13
EW	Exposed Wire		15
MP	Micropores	NA	NA
SCR	Scratch		1
SKV	Skive Marks		2
VD	Voids		3
NA	NA	NA	NA

Inspected By (Sign and Date):

B160 12 Jan 2023

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 #: 500000 295352 OP #: 500 Shift #: 3

Total Parts Reworked:		80	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	///	5
EH	Exposed Hypotube		20
EW	Exposed Wire		45
MP	Micropores	N/A	N/A
SCR	Scratch	///	5
SKV	Skive Marks		2
VD	Voids	///	3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LS461 AR02	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: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500006295352 OP #: 500 Shift #: 3

Total Parts Reworked:		130	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	NA
EH	Exposed Hypotube		36
EW	Exposed Wire		74
MP	Micropores	NA	NA
SCR	Scratch		5
SKV	Skive Marks		① 39 29
VD	Voids		18
NA	NA	NA	NA

Inspected By (Sign and Date):

BI60 13 Jan 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.

Data Uploaded for Engineering Review (Check):

① BI60 13 Jan 24



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

PO #: 500000295352

OP #: 500 Shift #: 3rd

Total Parts Reworked:		45	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		10
EW	Exposed Wire	+	25
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		10
VD	Voids		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB 81	13 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 #: 560 000295352 OP #: 750 Shift #: 3

Total Parts Reworked:		13	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		6
DIM07 US / WC	DIM07 Undersized (Window Closed)		2
EH	Exposed Hypotube		3
GD	Glue Damage		2
Inspected By (Sign and Date):		IC83	13 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# 500000295352

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	5:20 PM	190°F	KL4S	12JAN24	6:30PM	190°F	KL4S	12JAN24	50
TM10409	N/A	5:00 AM	190°F	KL4S	13JAN24	6:10 AM	190°F	KL4S	13JAN24	34
TM10409	N/A	6:50AM	190°F	SN67	13JAN24	8:00AM	190°F	SN67	13JAN24	27
TM12036	N/A	7:17AM	190°F	KL4S	13JAN24	8:27AM	190°F	KL4S	13JAN24	23
TM10409	N/A	8:23 AM	190°F	KL4S	13JAN24	9:33AM	190°F	KL4S	13JAN24	28
TM12036	N/A	9:22 AM	190°F	KL4S	13JAN24	10:33 AM	190°F	KL4S	13JAN24	39
TM10409	N/A	10:13 AM	190°F	KL4S	13JAN24	11:23 AM	190°F	KL4S	13JAN24	34
TM12036	N/A	11:07 AM	190°F	KL4S	13JAN24	12:17PM	190°F	KL4S	13JAN24	44
TM10409	N/A	12:10PM	190°F	KL4S	13JAN24	1:20PM	190°F	KL4S	13JAN24	41
TM10409	N/A	1:35PM	190°F	KL4S	13JAN24	2:45PM	190°F	KL4S	13JAN24	30
TM12036	N/A	2:13PM	190°F	YK4O	13Jan24	3:23PM	190°F	YK4O	13Jan24	21
TM10409	N/A	3:27pm	190°F	YK4O	13Jan24	4:37pm	190°F	YK4O	13Jan24	39
TM12036	N/A	4:35pm	190°F	YK4O	13Jan24	5:45pm	190°F	YK4O	13Jan24	① 30 ^{CO1}

① YK4O 13Jan24

Page 1 of 1



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000295352

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):

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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	25.33	25.64	26.87	26.42	27.49	27.56	27	27.19	26.8	27.09	26.739	0.7415067	4.378	23.4926836	8.542	PASS
Seg B	65.54	61.67	61.32	65.53	58.5	77.18	62.61	62.5	56.51	59.91	63.127	5.6830666	3.981	40.502712	8.542	PASS
Seg C	78.88	77.15	80.32	72.96	77.87	74.46	74.46	75.12	80.34	75.18	76.674	2.6140781	2.911	69.0644186	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 #: 500000295352

Date: 16JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24


16Jan24