

# Production Order: 500000306362



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
		Component Number	Req'd Rev Rev	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3  Kitting Devices  	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>H02 11:15am 08Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>AL71 7:00am 10Feb24</u> Record Dryer Shelf #: <u>N/A</u>						N/A	N/A	07Feb24	TSAT0
	Kitting Devices	MM0179-01	D D	PC	500	<u>0000293119</u>	<u>500</u>				
		MM1536-01	B B	PC	500	<u>0000290560</u>	<u>500</u>				

Notes: DA2484, DA2564

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	E	<u>E</u>	PC	200	① <u>58497</u> N/A <u>88018</u>	N/A			
		1000-1153-01	A	<u>A</u>	PC	594	<u>58497</u> <u>87895</u> <u>88073</u> <u>88077</u> <u>88080</u>	100 100 100 200 200			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000289401</u>	<u>500</u>	N/A	N/A	N/A
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>	N/A	N/A	N/A
		TL0165-05	J	<u>J</u>	PC	5	<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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N/A	N/A	141967-01	02	02	PC	500	85502	279			
							87455	225			
		RM7349-02*	C	C	PC	543	82860	100			
							82863	100			
							82836	100			
							82857, 82861	100, 100			
		RM7348-01	C	C	PC	500	① 84584	600			
							② 84587 88536				
							③ 85128				
							N/A	N/A			
		RM4001-01	B	B	PC	125	① 82460 N/A	N/A			
							82471 ①	100			
		RM0607-01	D	D	PC	56	71864	33	N/A	N/A	N/A
							N/A	N/A			
		RM0498-01	C	C	PC	500	0000287648	450			
							N/A	N/A			
		RM0009-04	I	I	PC	1	88992	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	88992	Bulk			

Notes: \*82861

N/A

N/A

N/A

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① KF02 12Feb24

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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			
							0000290562	500			
		MM1537-01	A	A	PC	1000	N/A	N/A			
							0000290561	1120			
		MM0177-01	C	C	PC	500	N/A	N/A			
							0000284208	500			
		MM0180-01	E	E	PC	500	N/A	N/A			
							0000287541	500	N/A	N/A	N/A
		MM0178-01	E	e	PC	500	N/A	N/A			
							0000276174	500			
		MM0176-01	D	D	PC	500	N/A	N/A			
							0000288413	500			
		MM0074-01	G	G	PC	500	N/A	S22			
							0000301891	N/A			
							N/A				

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01  Catheter Assembly 1  	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	11Feb24	CB58
	Line Clearance					
	Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	11Feb24	SN47 YK40 AM47 SD34
	Major and Minor Mandrel Assembly					
<b>Notes:</b>						
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  Confirmation Reqd(Milestone )	Loading Braid Stock	500	0	11Feb24 MC17	AIGS
250	CATASY01  Catheter Assembly 1    Trim Braid Wire at Proximal End		500	0	11Feb24 P767	CD19
<b>Notes:</b>						
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
	Trim Braid Wire at Proximal End  N/A 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	11Feb24	RL47 DV34
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	11Feb24	OB3 BD64
Notes:		N/A N/A N/A				

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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	 Load Tubing  Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	<b>CATASY01</b> Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone)	Reflow	500	0	11Feb24	SN67 R16 AL67 AM47
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	11Feb24	AM47 JC92 YK40 SN67
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1  FEP Removal  Confirmation Reqd(Milestone )	N/A	N/A	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 #: 1000-1153-0 Batch #: 88080 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	483	EW-IH-IH HT DF-1 AB-1  17	CB81 AR02 i546 B1G0 VC09  11Feb24	
N/A	N/A	N/A	N/A	N/A	N/A	N/A
<b>Notes:</b>						
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 )	473	MAH-1111 DL-1111 IDB-11  10	11Feb24	MH10 Sc10 SD19 TRN LA45 TRM MH10
600	CATASY01  Catheter Assembly 1  	Distal Tip Assembly  Distal Tip Assembly  Confirmation	473	0	11Feb24	PT09 VA96 IMH10 Scod TRN MH10

Notes:

N/A

N/A

N/A

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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	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink  Loading Heat Shrink  Confirmation Reqd(Milestone )	473	0	11Feb24	LH45 PRO9
700	CATASY01  Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: <u>0936A</u> Cal Due: <u>31Mar24</u> TMI: <u>2083L</u> Cal Due: <u>31Mar24</u> TMI: <u>6386</u> Cal Due: <u>31Mar24</u> TMI: <u>6521</u> Cal Due: <u>31Mar24</u>  Tipping	473	0	11Feb24	IC83 BT60

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  	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4061-01 Batch #: 82471 Qty: N/A Part #: RM0607-01 Batch #: 71864 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	464	ETH-JHK 1111 ⑨	11Feb24	JE83 B160
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	464	0	11Feb24	PL07 AL42 TRN YK40
Notes:						
N/A						
N/A						
N/A						

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Major Mandrel Removal  N/A Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	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. <u>Pass</u> 2. <u>Pass</u> 3. <u>Pass</u> 4. <u>Pass</u> 5. <u>Pass</u>	458	SKV-HH1 ⑥	11Feb24	AL42 TRN PL01
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
<b>Notes:</b>						
N/A						
N/A						
N/A						

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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	<b>Quality Inspection &amp; Review</b>  Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0090700-01</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>RM4001-01</u> Batch #: <u>82471</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>71864</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>88018</u> Qty: <u>N/A</u> Part #: <u>1000-1153-01</u> Batch #: <u>88077</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	427	SKV-1HK SP DEL-1HK 1HK TT EU-1HK 11 SKV-111 MEX-1 DS-1 #GOS-1 #GUS-1 #QUS-1 KNK-1 (31)	11Feb24	KX54 PH59 DX52	
950	<b>QUALITY1</b> Quality Inspection & Review  Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:		N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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①CB58 11Feb24

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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	 <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	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 2025</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 2025</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	415	STR-1111 #10S-111 #1US-1 #90S-11 DIS-11  (12)	11Feb24	A67
1000	 <b>Quality Inspection &amp; Review</b>   <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31 MAY 2024</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 Sep 2024</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 2024</u>	389	LT-1H1H 1H1H 1H1  (26)	11Feb24	CB58 BD64
<b>Notes:</b> 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
1050	QUALITY1  Quality Inspection & Review    Quality Inspection & Review  Confirmation Reqd(Milestone )	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	361	SCR - WKT 1 VD - IIII FM - III CRK - II SKV - II DT - II GNII - II Del - I Dis - I ew - I DL - I PBC - I BP - I STN - I  <u>28</u>	12 Feb 24	YK95 SV43
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02</u> <u>12Feb24</u>	N/A	N/A	12 Feb 24 KP02	
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	361	0 13 Feb 24	AP10 Feb 24	AP10

**Notes:**

N/A AP10 13 Feb 24

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**Material: SA0155-01 Rev F**

**Batch Number:** 0000306362

**By:** AP10

**Date:** 13 Feb 24

**Reviewed By:**

RB29

**Date:**

13 Feb 24

**Notes:**

N/A AP10 13 Feb 24

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Betas to 2024 3228 11/16/23  
ExAs to 19 Feb 2024 3228 11/16/23  
**TE**

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**TE**

Extend to 2023 3228 11/16/23

Based to 2023 3228 11/16/23

3228

DEVIATION AUTHORIZATION NUMBER: 2484  
\* See attached email extension to 2484 SEP23  
TSL2

24AUG23 . 3228  
23072023 3228 11/16/23

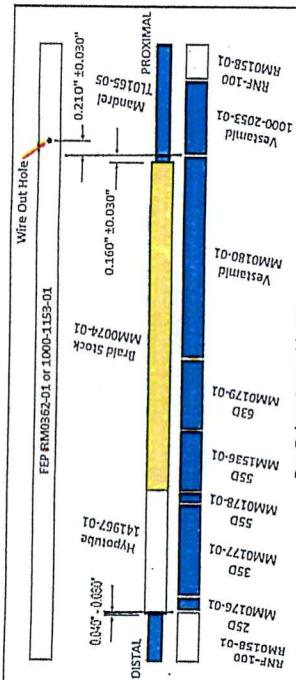
## CONTROLLED COPY

Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

### Deviation From:

QP3107610, 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:**  Yes  No **If no, explain:**

**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

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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 ~~MM1536-02~~ fixture for inspection. (See image 1)  
① **MM1536-01** **type correction TS12** 10AUG23

#### CONTROLLED COPY

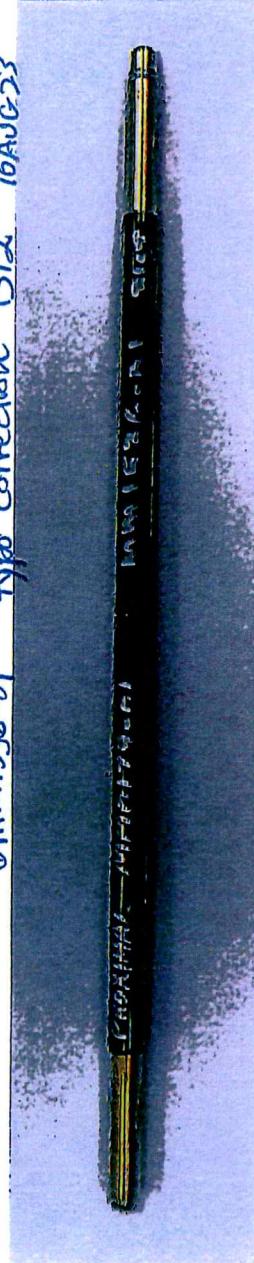


Image- 1

#### 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)

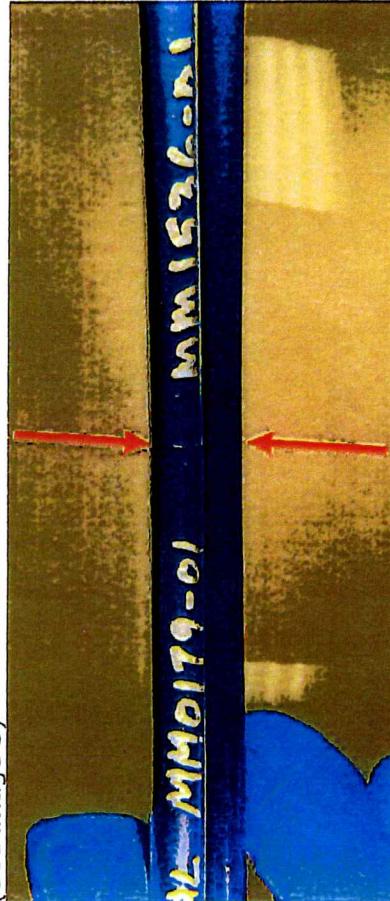


Image- 3

- 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.

**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)

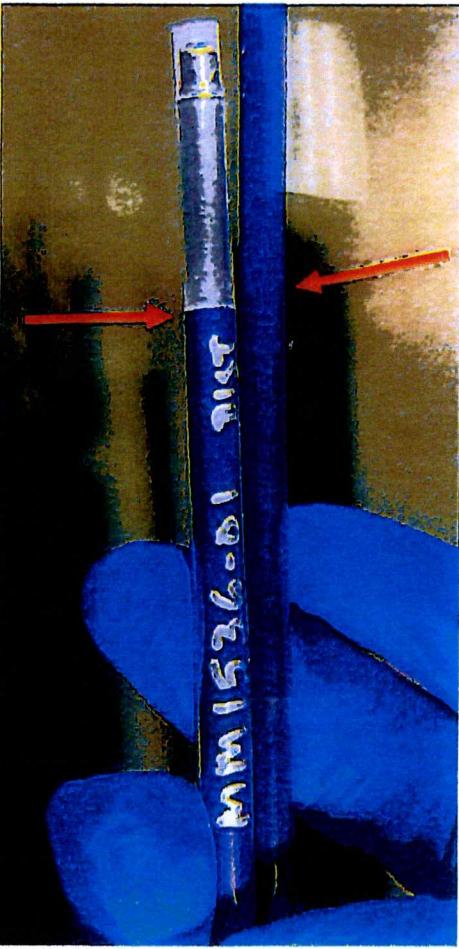


Image- 4

- 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.

<b>1</b>	MM0179-01	MM1536-01
<b>GOOD PART</b>		
<b>2</b>	MM1536-01	MM0179-01
<b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>		
<b>3</b>	MM0179-01	MM0179-01
<b>Two MM0179-01 - BAD PART</b>		
<b>4</b>	MM1536-01	MM1536-01
<b>Two MM1536-01 - BAD PART</b>		

Image - 5

Edits to Handwritten 3228 12/15/2023  
Edits to 13 Feb 2024 3228 1/5/2024

**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: DA2564

**CREGANNA**  
MEDICAL  
is part of



## DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
<b>Deviation From:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b> 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.			
<b>Justification:</b> TMIO602 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. TMIO700-01 Lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMIO700-01 is already qualified to inspect Dim 6 per ES0647; Laser micrometer equivalency test, there is no additional risk in using TMIO700-01 for OPER850 Dim 6 inspection till TMIO602 issue is resolved.			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b> 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			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No <b>If no, explain:</b> This is a temporary change to use TMIO700-01. DA will be removed once the lasermic TMIO602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> 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# 500000306362

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	8:30AM	430	SD34	10Feb24	8:42AM	415	SD34	10Feb24	16
TM10942	44	9:25AM	430	CB58	10Feb24	9:37am	415	CB58	10Feb24	16
TM10942	44	9:53AM	430	SN67	10Feb24	10:05AM	415	SN67	10Feb24	16
TM10942	44	10:30AM	430	SN67	10Feb24	10:42AM	415	SN67	10Feb24	16
TM10942	44	11:01AM	430	YK40	10Feb24	11:13AM	415	YK40	10Feb24	16
TM10942	44	11:33AM	430	PL22	10Feb24	11:45AM	415	PL22	10Feb24	16
TM10942	44	12:07PM	430	PL22	10Feb24	12:19PM	415	PL22	10Feb24	16
TM10942	44	1:30PM	430	SN67	10Feb24	1:42PM	415	SN67	10Feb24	16
TM10942	44	2:00PM	430	SD34	10Feb24	2:18PM	415	SD34	10Feb24	16
TM10942	44	2:35pm	430	CB58	10Feb24	2:47pm	415	CB58	10Feb24	16
TM10942	44	3:21pm	430	SN67	10Feb24	3:33pm	415	SN67	10Feb24	16
TM10942	44	4:31pm	430	SN67	10Feb24	3:43pm	415	SN67	10Feb24	16

⑪ CB58 10Feb24



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#: 500000306362

OP 400

(1) RL47 11 Feb 24



Document No: 5105589

FM15104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000306362

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	8:17AM	430	SD34	10Feb24	8:29AM	415	SD34	10Feb24	16
TM10745	44	8:36AM	430	SD34	10Feb24	8:48AM	415	SD34	10Feb24	16
TM10745	44	9:38AM	430	SN67	10Feb24	9:50AM	415	SN67	10Feb24	16
TM10745	44	10:15AM	430	SN67	10Feb24	10:27AM	415	SN67	10Feb24	16
TM10745	44	10:41AM	430	SN67	10Feb24	10:53AM	415	SN67	10Feb24	16
TM10745	44	11:17AM	430	SN67	10Feb24	11:29AM	415	SN67	10Feb24	16
TM10745	44	11:42AM	430	PL22	10Feb24	11:54AM	415	PL22	10Feb24	16
TM10745	44	12:23PM	430	PL22	10Feb24	12:35PM	415	PL22	10Feb24	16
TM10745	44	1:43pm	430	SN67	10Feb24	1:55pm	415	SN67	10Feb24	16
TM10745	44	2:20pm	430	CB58	10Feb24	2:32pm	415	CB58	10Feb24	16
TM10745	44	2:55pm	430	CB58	10Feb24	3:07pm	415	CB58	10Feb24	16
TM10745	44	4:46pm	430	SD34	10Feb24	4:58pm	415	SD34	10Feb24	16



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

PRODUCTION ORDER# 500000306362

OP 400



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

PO #: 500000306362 OP #: 500 Shift #: 3rd

**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):

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CB81, LS46

10 Feb 24

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① CB81 12 Fe b 24



PO #: 500000306362      OP #: 500      Shift #: 3rd

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.

PY4612 Feb 24

### Data Uploaded for Engineering Review (Check):

5

PO #: 500000306362OP #: 750 Shift #: 3

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		43	
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)	NA	NA
EH	Exposed Hypotube		5
GD/AB	Glue damage / Air Bubbles		11
Inspected By (Sign and Date):		B160 10 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):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500 000 306 362OP #: 750 Shift #: 3

Total Parts Reworked:		43	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		15
DIM07 US / WC	DIM07 Undersized (Window Closed)		8
EH	Exposed Hypotube		12
GD	Glue Damage		8
Inspected By (Sign and Date):		IC83 11 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# 500000306362

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0409	N/A	1:20PM	190F	BD64	10Feb24	2:30PM	190F	BD64	10Feb24	32
TMI0409	N/A	3:05PM	190F	AL42	10Feb24	4:15 PM	190F	AL42	10Feb24	90
TM12036	N/A	4:10 PM	190F	AL42	10Feb24	5:20 PM	190F	AL42	10Feb24	34
TMI0409	N/A	5:10PM	190F	AL42	10Feb24	6:20PM	190F	AL42	10Feb24	38
TM12036	N/A	6:20 AM	190F	AL42	11Feb24	7:30AM	190F	AL42	11Feb24	30
TMI0409	N/A	7:08 AM	190F	AL42	11Feb24	8:18AM	190F	AL42	11 Feb 24	26
TM12036	N/A	8:00AM	190F	AL42	11 FEB 24	9:10AM	190F	AL42	11 FEB 24	32
TMI0409	N/A	8:37 AM	190F	AL42	11Feb24	9:47AM	190F	AL42	11Feb24	20
TM12036	N/A	10:55AM	190F	AL42	11Feb24	12:05PM	190F	AL42	11Feb24	55
TMI0409	N/A	11:15AM	190F	AL42	11Feb24	12:25PM	190F	AL42	11Feb24	40
TM12036	N/A	12:17PM	190F	YK40	11Feb24	1:27PM	190F	YK40	11Feb24	67
	N/A	XK40								
			11Feb24							

① AL42 11Feb24



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306362OP #: 900 Shift #: 3

Total Parts Reworked:		169	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		16
EH	Exposed Hypotube		19
EW	Exposed Wire		96
MP	Micropores	N/A	N/A
SCR	Scratch		89
SKV	Skive Marks		6
VD	Voids		47
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized		9
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		DL07 KX54 MC17	11 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	28.45	24.4	24.64	28.48	37	24.23	26.54	23.88	23.85	24.35	26.582	4.0748437	4.378	8.74233432	8.542	PASS
Seg B	81.21	71.83	69.04	77.8	70.61	76.8	71.37	78.71	74.57	70.45	74.239	4.1703169	3.981	57.6369683	8.542	PASS
Seg C	83.49	85.77	86.36	81.88	82.71	90.21	85.75	88.23	89.61	87.8	86.181	2.8477104	2.911	77.8913151	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 #: 500000306362

Date: 12FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



SR.  
12 FEB 2024