

Production Order: 500000301828



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

Material Type:	ZFRT	Description: Edwards Flex Shaft Commander 155885	Order Type: ZSTD
Production Version:	7987		Project Phase:
Plant / Business Unit:	1213 / AC5		

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																								
50	KITTING3 Kitting Devices 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KP02 8:30am 01Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>AM 6:41:00 pm 02 Feb 2024</u> (2) 02Feb24 Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	31 JAN 24	OLX70																								
	Kitting Devices	<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>0000294700</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>0000276172</u></td> <td><u>40</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>0000294700</u>	<u>500</u>					<u>0000276172</u>	<u>40</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>0000294700</u>	<u>500</u>																									
				<u>0000276172</u>	<u>40</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>																									

Notes: DA 2484, 2564

N/A

N/A

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(2) KP02 05 Feb 24 Correction
for AM68

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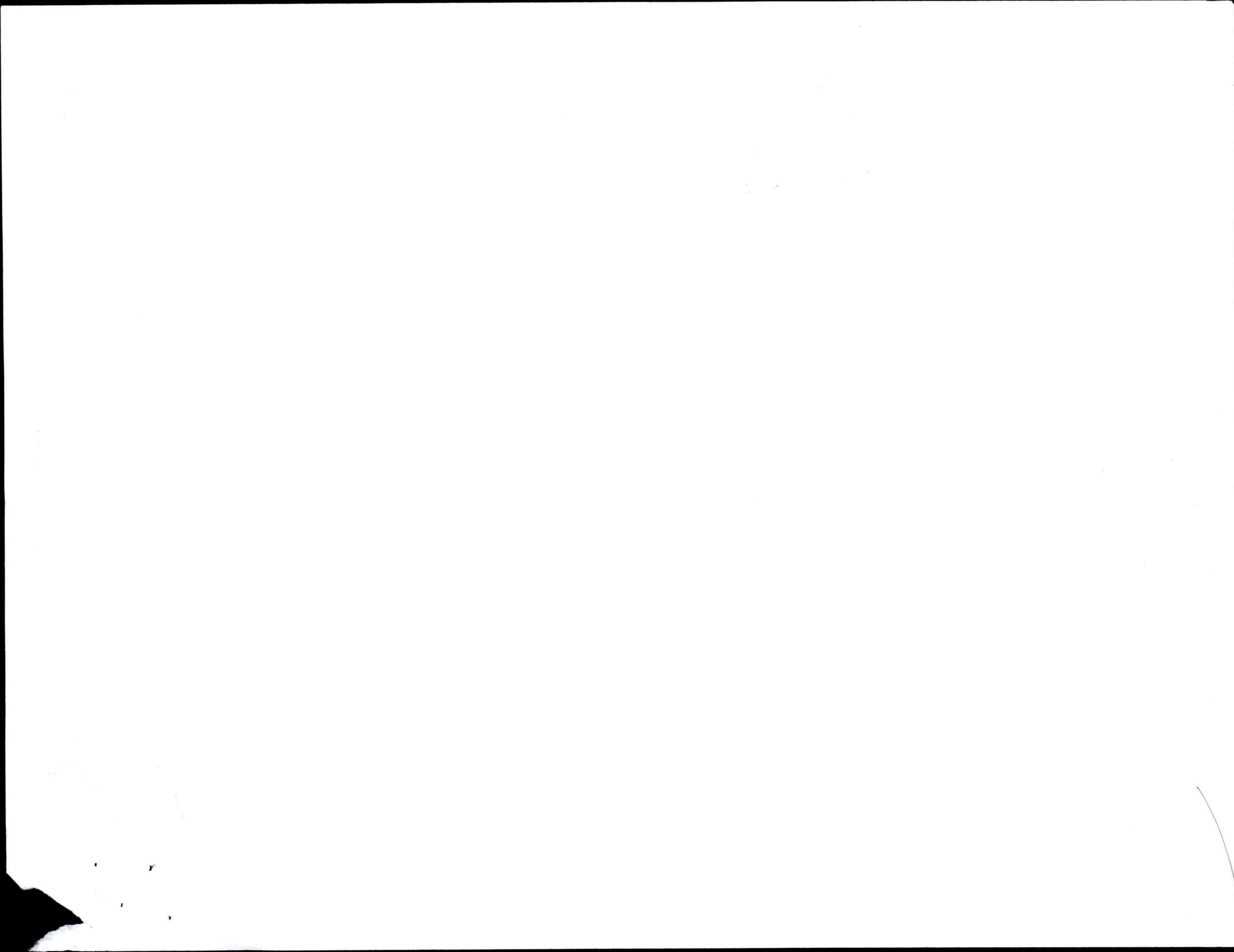
① AM 6:41:00 pm 02 Feb 2024
03 Feb 24



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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>00002T1063</u>	<u>40</u>			
							<u>58497</u>	<u>200</u>			
							<u>N/A</u>	<u>N/A</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>88374</u>	<u>200</u>			
							<u>88375</u>	<u>200</u>			
							<u>88349</u>	<u>200</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000297543</u>	<u>500</u>			
							<u>N/A</u>	<u>N/A</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</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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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	85794	515			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82852	600			
							N/A	N/A			
		RM7348-01	C	C	PC	500	84587	500			
							N/A	N/A			
		RM4001-01	B	B	PC	125	88746	100			
							N/A	N/A			
		RM0607-01	D	D	PC	56	78849	115			
							N/A	N/A			
		RM0498-01	C	C	PC	500	0000287646	479			
							N/A	N/A			
		RM0009-04	I	I	PC	1	79170	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	79170	Bulk			

Notes:

N/A

N/A

N/A

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N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>500</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>1000</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>500</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>500</u>	N/A	N/A	N/A
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>500</u>			
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>			
		MM0074-01	G	<u>G</u>	PC	500	<u>0000295162</u>	<u>523</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	03Feb24	CB58
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	03Feb24	SD34 YKHO
	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	500	0	03Feb24	SCW PY67
	Loading Braid Stock Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	03Feb24	CD19 SX11
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 Confirmation Reqd(Milestone)	Insert Cut Hypo Tube	500	0	03Feb24	PV16 AIG5
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	03Feb24	CX63 PL22

Notes:

N/A

N/A

N/A

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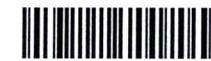


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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)		500	0	03Feb24	RL47 AM47 SN47
450	CATASY01 Catheter FEP Removal		500	0	03Feb24	JCG2
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 					
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 #: 88730 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	480	EH-HH EN-HP111 OF-11 VD-11 DL-11 FM-1 20	03Feb24	LS46 ARD2 MM02 C B-81
N/A	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
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)	474	MAH-WHI ⑥	03Feb24	MH10 VA96 SC10
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly Distal Tip Assembly Confirmation	474	0	03Feb24	PT09 MH10

Notes:

N/A

N/A

N/A

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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	474	O	03Feb24	AT60 JC83 LH45
700	CATASY01 Catheter Assembly 1 Tipping Record Tipping Oven Information: TMI: 04364 Cal Due: 31May24 TMI: 20836 Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 0521 Cal Due: 31May24 Tipping	Tipping Record Tipping Oven Information: TMI: 04364 Cal Due: 31May24 TMI: 20836 Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 0521 Cal Due: 31May24	474	O	03Feb24	JC83

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> <table> <tr> <td>Part #: 1000115367</td> <td>Batch #: 88730</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: RM0607-01</td> <td>Batch #: 78849</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: RM4001-01</td> <td>Batch #: 88746</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #: N/A</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #: N/A</td> <td>Qty: N/A</td> </tr> </table>	Part #: 1000115367	Batch #: 88730	Qty: N/A	Part #: RM0607-01	Batch #: 78849	Qty: N/A	Part #: RM4001-01	Batch #: 88746	Qty: N/A	Part #: N/A	Batch #: N/A	Qty: N/A	Part #: N/A	Batch #: N/A	Qty: N/A	474	0	IC83 03Feb24
Part #: 1000115367	Batch #: 88730	Qty: N/A																		
Part #: RM0607-01	Batch #: 78849	Qty: N/A																		
Part #: RM4001-01	Batch #: 88746	Qty: N/A																		
Part #: N/A	Batch #: N/A	Qty: N/A																		
Part #: N/A	Batch #: N/A	Qty: N/A																		
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	474	0	KL45 AL42 TRN 03Feb24															
Notes:																				
N/A																				
N/A																				
N/A																				

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OCB58 03Feb24

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N/A	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1 	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. Pass 2. Pass 3. Pass 4. Pass 5. Pass	474	O	04Feb24	KL45
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:</p> <p>TMI: <u>0700-01</u> Cal Due: <u>31MAY24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>1000-1153-01</u> Batch #: <u>88730</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM400H01</u> Batch #: <u>88746</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM0607-01</u> Batch #: <u>78849</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM0158-01</u> Batch #: <u>58497</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	453	DEL-4H(SP) FM-111(TT) DL-4H(TT) DIS-111 #5US_1 #90S_1 DS-1 21	04Feb24	DLOT KX524 PP40
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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Cpr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 25</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	450	DIS-11 #10S-1 (3)	04 Feb 24	A67
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>1056</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>	448	LT-11 (2)	04 Feb 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 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS 	4/4	<ul style="list-style-type: none"> • 1-CRK • 5-VD • 8-EW • 3-FM • 6-SCR • 7-DIS • 1-DISC • 1-BP • 1-SKV • 1-MAH 	04 Feb 24	DX52
1100	CATASY01 Catheter Assembly 1 	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): Kp02 05Feb24	N/A	N/A	05 Feb 24	Kp02
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	414	0	05Feb24 mmca7	

Notes:

N/A

N/A

N/A

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Batch Number: 0000301828

By: mm 97

Date: 05Feb24

Reviewed By:

RB29

Date:

06feb24

Notes:

N/A

N/A

N/A

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EE422 + DSC 19Feb2014 2228 8256 11/16/2014 11/15/2014 11/15/2014



CREGANNA MEDICAL

MEDICAL is part of **THE** **23**

Extend to 31 Dec 2023 DEVIATION A
Extend to 31 Dec 2023 J28 ^{11/17/2023}

Requestor Name: Udhesh Kapadnis

DEVIATION AUTHORIZATION NUMBER: 2484
See attached email extension to 24/SEP/22

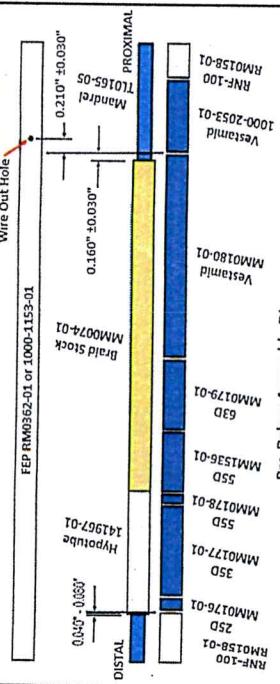
REGISTRATION FORM ~~2nd~~ to ~~23 Oct 2023~~ ~~21 Sept 2023~~

CONTROLLED COPY

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.

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



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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

Part Number Affected	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

Digitized by

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

Please see one of the above contacts.

Communication Activities

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 Requirements: Yes No

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

CONTROLLED COPY

(1) UK55, 23JW 2023



DA DA ①
2484
2468

Description/Objectives of Training:
DA- Inspection at final QC, Op#1050.

Group Training Record

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and MM1536-02 fixture for inspection. (See image 1)
① MM0179-01 type correction TS12 10AUG23

CONTROLLED COPY

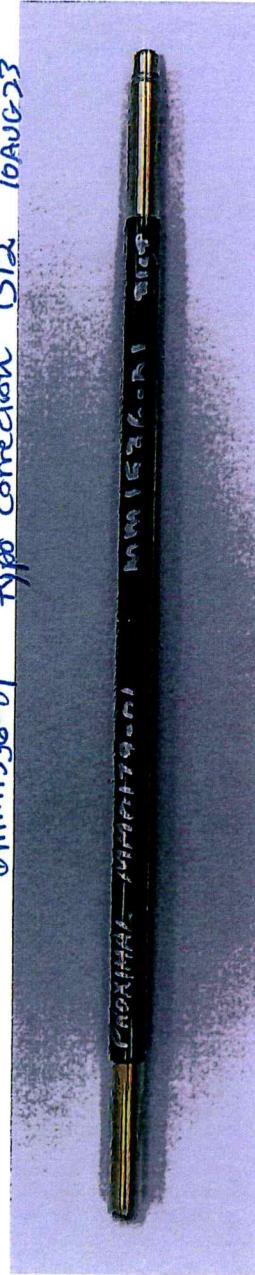


Image- 1

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)

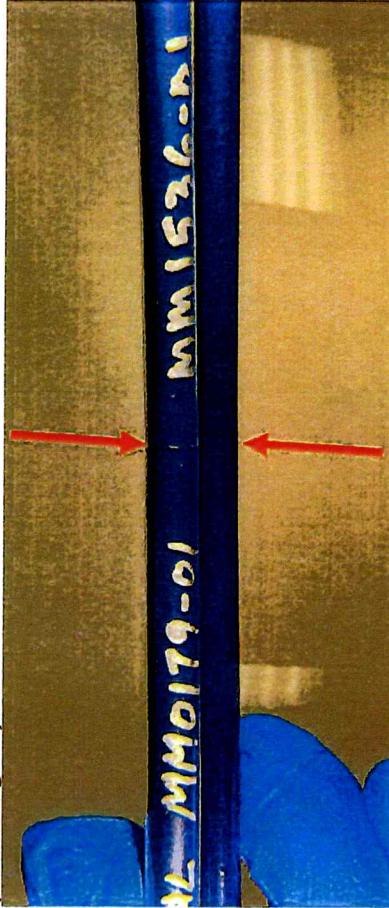


Image- 3

- 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.

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

Entered to Hansa T228 12/16/2023
Entered to Hansa T228 13 Feb 2024 19/02/24

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

CREGANNA MEDICAL
is part of 

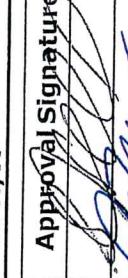
DEVIATION AUTHORIZATION FORM

Requestor Name:	Krishna Selvaraj		
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
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.	Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer at OPER900 (TMI0700-01) , check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.		

Justification:

TMI0602 lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable.

TMI0700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified to inspect Dim 6 per ES0647; Laser micrometer equivalency test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.

Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	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	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# SO0000301828

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	2:00pm	430	OS21	02Feb24	2:12pm	415	OS21	02Feb24	16
TM10745	44	2:25pm	430	CB58	02Feb24	2:37pm	415	CB58	02Feb24	16
TM10745	44	3:00pm	430	OS21	02Feb24	3:12pm	415	OS21	02Feb24	16
TM10745	44	3:30pm	430	CB58	02Feb24	3:42pm	415	CB58	02Feb24	16
TM10745	44	4:30pm	430	RL47	02Feb24	4:42pm	415	RL47	02Feb24	16
TM10745	44	4:54pm	430	SD34	02Feb24	5:06pm	415	SD34	02Feb24	16
TM10745	44	5:24pm	430	SD34	02Feb24	5:36pm	415	SD34	02Feb24	16
TM10745	44	6:24pm	430	SD34	02Feb24	6:36pm	415	SD34	02Feb24	16
TM10745	44	7:40AM	430	CB58	03Feb24	7:52AM	415	CB58	03Feb24	16
TM10745	44	8:00AM	430	CB58	03Feb24	8:12AM	415	CB58	03Feb24	16
TM10745	44	8:26AM	430	CB58	03Feb24	8:38AM	415	CB58	03Feb24	16
TM10745	44	9:20AM	430	CB58	03Feb24	9:32AM	415	CB58	03Feb24	16



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

PRODUCTION ORDER# 500000301828

OP 400



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

PRODUCTION ORDER# 500000 301828

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	2:05pm	430	CB58	02Feb24	2:17pm	415	CB58	02Feb24	16
TM10942	44	2:40pm	430	CB58	02Feb24	2:52pm	415	CB58	02Feb24	16
TM10942	44	3:12pm	430	JC92	02Feb24	3:24pm	415	JC92	02Feb24	① 16
TM10942	44	4:49PM	430	SD34	02Feb24	5:01PM	415	SD34	02Feb24	16
TM10942	44	5:09pm	430	SD34	02Feb24	5:21pm	415	SD34	02Feb24	16
TM10942	44	5:39PM	430	SD34	02Feb24	5:51PM	415	SD34	02Feb24	16
TM10942	44	6:09pm	430	SD34	02Feb24	6:21pm	415	SD34	02Feb24	16
TM10942	44	6:47AM	430	SN67	03Feb24	6:59AM	415	SN67	03Feb24	16
TM10942	44	7:15AM	430	AM47	03 Feb 24	7:27 AM	415	AM47	03 Feb 24	16
TM10942	44	7:48AM	430	CB58	03Feb24	8:00AM	415	CB58	03Feb24	16
TM10942	44	8:14AM	430	CB58	03Feb24	8:20AM	415	CB58	03Feb24	16
TM10942	44	9:29am	430	CB58	03Feb24	9:41am	415	CB58	03Feb24	16

① SN67 03Feb24



PRODUCTION ORDER# 500000301828

OP 400

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



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

PO #: 50000301828 OP #: 500 Shift #: 2nd.

Total Parts Reworked:		33	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		3
EH	Exposed Hypotube		2
EW	Exposed Wire	-	22
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		1
VD	Voids		8
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

MM02

03 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 #: 500000301828

OP #: 500 Shift #: 3rd

Total Parts Reworked:		100	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		25
EW	Exposed Wire	 	86
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		7
VD	Voids		2
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

CB 81 /S4G ARD

03 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 #: 500 000 301 828OP #: 750 Shift #: 3

Total Parts Reworked:		29	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	XXX III	8
DIM07 US / WC	DIM07 Undersized (Window Closed)	XXX II	7
EH	Exposed Hypotube	XXX III	8
GD	Glue Damage	XXI	6
Inspected By (Sign and Date):		IC83	63 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# 500000301828

OP 800

PO #: 500000301828OP #: 900 Shift #: 3

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		235	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		16
EH	Exposed Hypotube		19
EW	Exposed Wire		106
MP	Micropores	N/A	N/A
SCR	Scratch		98
SKV	Skive Marks		6
VD	Voids		51
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		16
DIM06 OS	DIM06 OD Oversized		13
DIM09 US	DIM09 OD Undersized		4
Inspected By (Sign and Date):		DL07, KX54, PP40	03 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	25.63	25.6	25.78	27.01	26.21	26.52	25.59	25.24	25.06	25.76	25.84	0.5879153	4.378	23.2661067	8.542	PASS
Seg B	63.81	60.62	62.75	67.52	57.94	60.68	69.18	61.97	58.41	64.03	62.691	3.6244063	3.981	48.2622385	8.542	PASS
Seg C	81.62	80.87	72.88	77.1	79.09	77.91	78.21	78.36	76.04	78.49	78.057	2.4446043	2.911	70.940757	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 #: 500000301828

Date: 05 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

05 Feb 24
