

# Production Order: 500000297266



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: 7988  
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  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>GS85 11:15 AM 22 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 6:30am 23 Jan 24</u> Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table><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>1000-2053-01</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0000278880</u></td><td><u>500</u></td></tr><tr><td>MM1537-02</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0000288401</u></td><td><u>500</u></td></tr></tbody></table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>	MM1537-02	A <u>A</u>	PC	500	<u>0000288401</u>	<u>500</u>		<u>N/A</u>	<u>N/A</u>	<u>22JAN24</u> <u>KL27</u>
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																			
1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>																			
MM1537-02	A <u>A</u>	PC	500	<u>0000288401</u>	<u>500</u>																			

Notes: DA 2564, 2484

N/A

N/A

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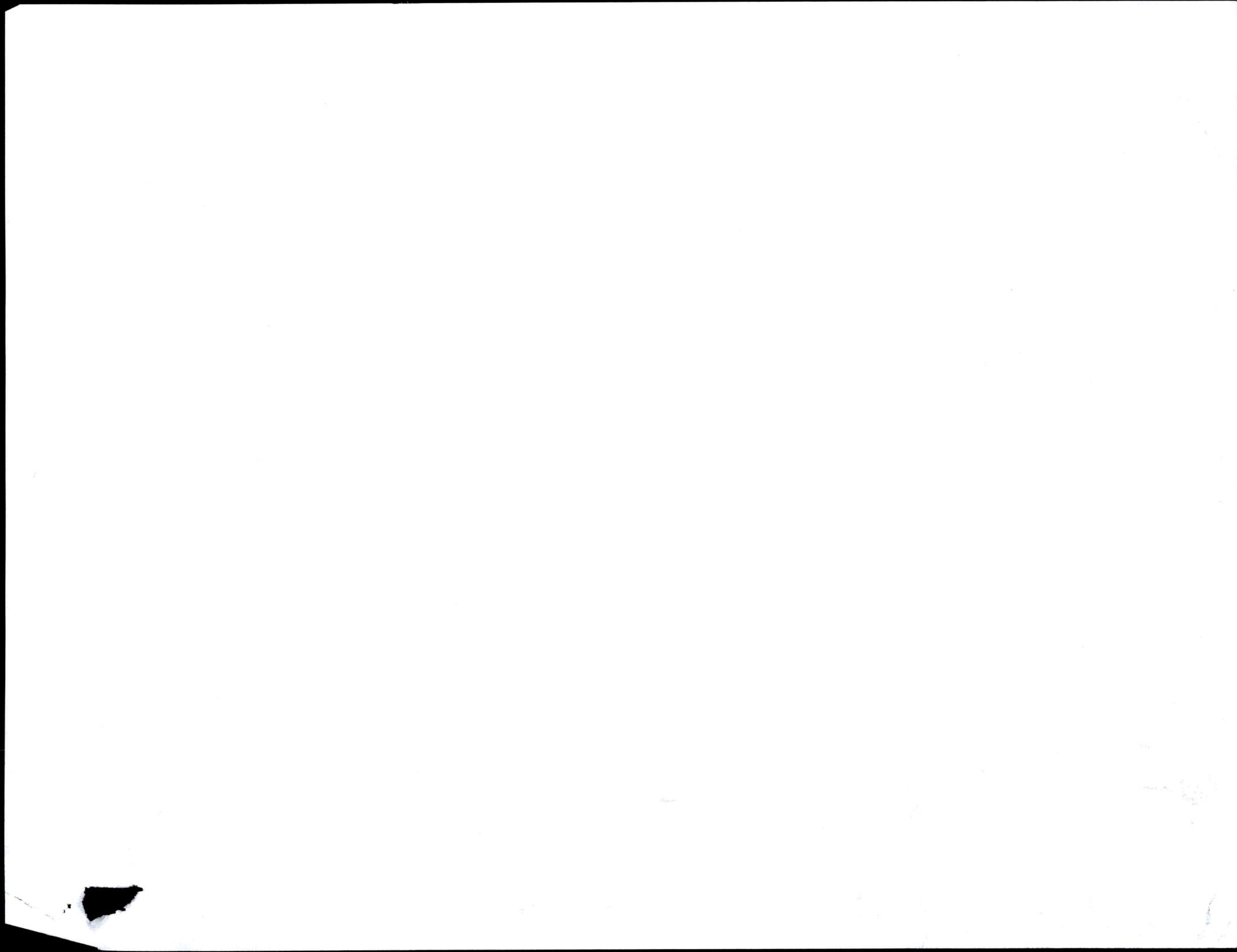
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Op. No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	N/A 58497	N/A 150		
		TL0167-02	E	<u>E</u>	PC	70	N/A	N/A	Bulk	
		TL0165-05	J	<u>J</u>	PC	5	N/A	N/A	Bulk	
		TL0165-03	J	<u>J</u>	PC	5	N/A	N/A	Bulk	
		141967-01	02	<u>D2</u>	PC	500	85561	500	N/A	N/A
		RM7349-02	C	<u>C</u>	PC	543	82733	300		
		RM7348-01	C	<u>C</u>	PC	500	82831 78686 78688 78689	200 150 150 300		

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	RM4001-01	B	<u>B</u>	PC	125	<u>82103</u>	<u>100</u>		
		RM0607-01	D	<u>D</u>	PC	56	<u>82435</u>	<u>25</u>		
		RM0498-01	C	<u>C</u>	PC	500	<u>78322</u>	<u>138</u>		
		RM0362-01	E	<u>E</u>	PC	594	<u>N/A</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>0000275491</u>	<u>52</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>0000287640</u>	<u>74</u>		
		MM1538-01	A	<u>A</u>	PC	500	<u>0000287641</u>	<u>339</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>① 28971 82971 Bulk</u>	<u>90</u>		
							<u>N/A</u>	<u>Bulk</u>	N/A	N/A
							<u>① 28971 82971 Bulk</u>	<u>400</u>		
							<u>N/A</u>	<u>Bulk</u>		
							<u>① 28971 82971 Bulk</u>	<u>90</u>		
							<u>N/A</u>	<u>Bulk</u>		
							<u>500</u>			
							<u>N/A</u>	<u>N/A</u>		
							<u>1000</u>			

Notes:

N/A

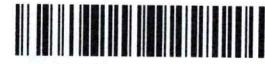
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①CB58 26Jan24

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1536-01	B	<u>B</u>	PC	500	0000281412	N/A		
		MM0180-01	E	<u>E</u>	PC	500	0000282490	N/A		
		MM0179-01	D	<u>D</u>	PC	500	0000276172	N/A		
		MM0178-01	E	<u>E</u>	PC	500	0000276174	N/A	N/A	N/A
		MM0177-01	C	<u>C</u>	PC	500	0000284208	N/A	N/A	N/A
		MM0176-01	D	<u>D</u>	PC	500	0000281411	N/A	N/A	N/A
		MM0074-01	G	<u>G</u>	PC	500	0000295164	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	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	23Jan24	V078
	Line Clearance  Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	23Jan24	NK62 AX05 PM96
	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    Loading Braid Stock  Confirmation Reqd(Milestone )	500	0	23Jan24 AL34 SXII	
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	23Jan24 MUSO LNU6	

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	23Jan24	VPGZ 01/39
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	23Jan24	VU25 C497
Notes:		N/A N/A N/A				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Load Tubing Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone )	Reflow	500	0	23Jan24	N462 RN27 TA36 PM96
450	CATASY01 Catheter	FEP Removal	500	0	23Jan24	0521 PM96

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 #: 1000-1153-0 Batch #: 87656 Qty: 10 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 Part #: N/A Batch #: N/A Qty: N/A	479	OF-H① EW-H① OF-HH 111 EW-HH HH 1 DL-11 (21)	23Jun24	LL61 CB81 VC09
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				
		N/A				

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① LL61 23 Jan 24

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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 )	479	0	23Jan24	DY29 TRN 6155 RS23 FBO1
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Distal Tip Assembly  Confirmation	Distal Tip Assembly	465	DL-4HT11 MAH-4HT11 14	23Jan24	PH59 VA96 AX82 FBO1 CL05

Notes:

N/A  
N/A  
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1  Loading Heat Shrink  Confirmation Reqd(Milestone )	Loading Heat Shrink	465	○	23Jan24	AX82 FB01
700	CATASY01 Catheter Assembly 1  Tipping	Tipping Record Tipping Oven Information: TMI: <u>D386</u> Cal Due: <u>31may24</u> TMI: <u>0521</u> Cal Due: <u>31may24</u> TMI: <u>2083G</u> Cal Due: <u>31May24</u> TMI: <u>0936A</u> Cal Due: <u>31may24</u>	465	○	23Jan24	RS23 STX48 Hv36
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  Confirmation Reqd(Milestone )	Tip Inspection/ Flash Removal Material Consumed: Part #: <u>DN4001-01</u> Batch #: <u>82103</u> Qty: <u>5</u> Part #: <u>DN4007-01</u> Batch #: <u>78322</u> Qty: <u>8</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	465	O  23Jan24	STX48 HV36 MM02 DX35	
800	CATASY01  Catheter Assembly 1    Major Mandrel Removal		458	ACD-HH 11  ⑦	23Jan24 P#96	SS52

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 Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	5 (2) 457	SKV-1  ①	② 23Jan23 23Jun24	SS52 KT4i7 ML65 Y936
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	mL466 MV33 St104 MC65
Notes:						
N/A						
N/A						
N/A						

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① MV33 23Jan24

② XL91 23Jan24

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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 #: RM0158-01 Batch #: 58497 Qty: 5 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 Part #: N/A Batch #: N/A Qty: N/A</p>	424	EW-LXT #5-US-11 DEI-1 #905-11 BP-1 DIS-11 MAR-LH1 #605-111 #705-1 33	23Jan24	PH59 6/155 D429 XL91 KL67
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; 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  
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	<p>TMI: MA Cal Due: MA</p> <p>Record DIM02 Go/No-Go Gage Information:</p> <p>TMI: 060691 Cal Due: 30 Sep 25</p> <p>TMI: 0692 Cal Due: 30 Sep 25</p> <p>Record DIM02 Inspection Results N = 54:</p> <p>Pass: 54 Fail: 0</p> <p>(PY 46 23 Jan 24)</p>	398	 STR - 1111	23 Jan 24	0521
	 Confirmation Reqd(Milestone)			 DECTI 111 DISGP 111 (26)		XL91 KL67
1000	 QUALITY1	<p>Quality Inspection &amp; Review</p> <p>Leak Test</p> <p>Record Inspection Data in SAP ROS</p> <p>Record Leak Tester Information:</p> <p>TMI: 1056 Cal Due: 31 May 24</p> <p>Record Length Gage Information:</p> <p>TMI: 088910 Cal Due: 30 Sep 24</p> <p>Record Calibrated Ruler Information:</p> <p>TMI: 0692 Cal Due: 30 Sep 24</p>	377	 OAL-1 #5/US-11	23 Jan 24	SS44
	 Quality Inspection & Review			(21)		KL67 XL91
	 Confirmation Reqd(Milestone)					

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	<b>QUALITY1</b> 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	360	SCR-11 DIS-111 ORK-111 FB-11 SKV-11 STN-1 VD-1 FL-1 EW-1 GNII-1	24Jan24	XN26 SV43
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02</u> <u>24Jan24</u>	N/A	N/A	24Jan24	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	360	0	24500 mm	

Notes:

N/A

N/A

N/A

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Batch Number: 0000217266

By: MMYT

Date: 26 Jan 24

Reviewed By:

RB29

Date:

26 JAN 24

Notes:

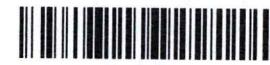
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Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 JUL 2023
Mgr. Manufacturing Engineering	Jake Stanislowski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 JUL 2023

FM0002.RevF

Deviation Authorization

**CONTROLLED COPY**

① UK55, 23JW 2023



CREGANNA  
MEDICAL

DA | 2484  
① 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 MM01536-01 *typo correction TS12 10AUG23*

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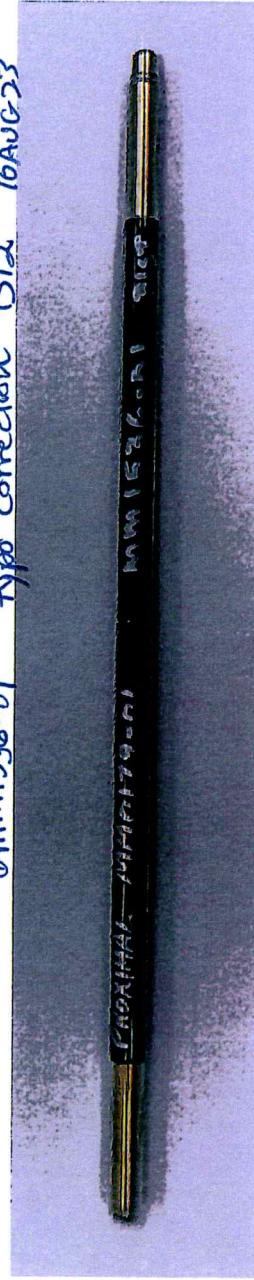


Image- 1

**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)

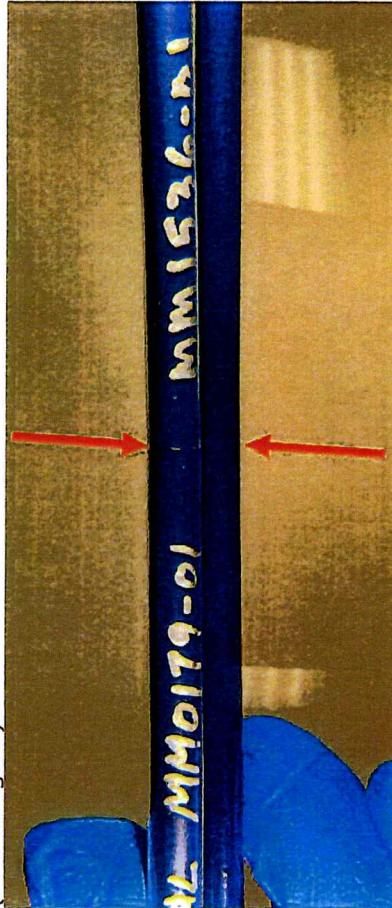


Image- 3

- 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.

**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)

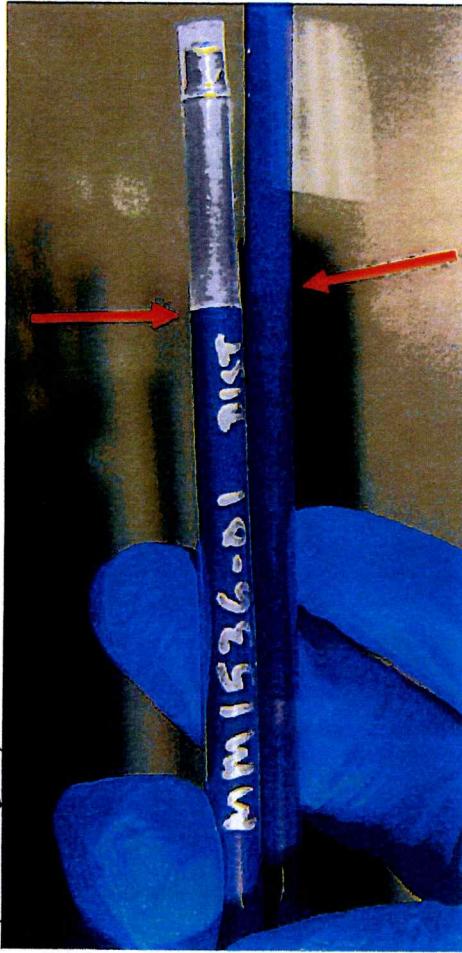


Image- 4

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

Image - 5

Entered to Hansa 3228 12/15/2023  
Entered to 13 Feb 2024 3228 V4/2024

**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: DA2564

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## DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
<b>Deviation From:</b>  Doc # <b>3005206 (Flex Commander MPI0238):</b> <b>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>Deviation To:</b>  Doc # <b>3005206 (Flex Commander MPI0238):</b> <b>OPER850.11:</b> Using a laser micrometer at <b>OPER900 (TMI0700-01)</b> , 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	
<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 FMEAs <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		
<b>If no, explain:</b> 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# 500000297266

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	7:34 AM	430	PM96	23 Jan 24	7:46 AM	415	PM 96	23 Jan 24	16
TM10942	44	7:53 AM	430	PM96	23 Jan 24	8:05 AM	415	PM96	23 Jan 24	16
TM10942	44	8:18 AM	430 ① 428	PM96	23 Jan 24	8:30 AM	415	PM 96	23 Jan 24	16
TM10942	44	8:39 AM	425	PM96	23 Jan 24	8:51 AM	415	PM 96	23 Jan 24	16
TM10942	44	8:57 AM	420	PM96	23 Jan 24	9:11 AM	415	PM96	23 Jan 24	16
TM10942	44	9:28 AM	420	PM 96	23 Jan 24	9:40 AM	415	PM 96	23 Jan 24	16
TM10942	44	9:48 AM	428	PM 96	23 Jan 24	10:00 AM	415	PM 96	23 Jan 24	16
TM10942	44	10:58 AM	430	AX05	23 Jan 24	11:10 AM	415	AX05	23 Jan 24	16
TM10942	44	11:25 AM	430	OS 21	23 Jan 24	11:37 AM	415	OS 21	23 Jan 24	16
TM10942	44	11:55 AM	430	KL95	23 Jan 24	12:07 PM	415	KL95	23 Jan 24	16
TM10942	44	12:15 PM	426	AX05	23 Jan 24	12:27 PM	415	AX05	23 Jan 24	16
TM10942	44	1:15 PM	430	OS 21	23 Jan 24	1:27 PM	415	OS 21	23 Jan 24	16

①PM 96 23 Jan 24



**Document No:** 5105589  
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**PRODUCTION ORDER#** 500000297266

OP 400



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Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000297266

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	7:43 AM	430	PM 96	23 Jan 24	7:55 AM	415	PM 96	23 Jan 24	16
TM10745	44	8:08 AM	430	PM 96	23 Jan 24	8:20 AM	415	PM 96	23 Jan 24	16
TM10745	44	8:25 AM	430	PM 96	23 Jan 24	8:37 AM	415	PM 96	23 Jan 24	16
TM10745	44	8:50 AM	428	PM 96	23 Jan 24	9:02 AM	415	PM 96	23 Jan 24	16
TM10745	44	9:14 AM	428	PM 96	23 Jan 24	9:26 AM	415	PM 96	23 Jan 24	16
TM10745	44	9:36 AM	428	PM 96	23 Jan 24	9:48 AM	415	PM 96	23 Jan 24	16
TM10745	44	10:45 AM	430	AX05	23 Jan 24	10:57 AM	415	AX05	23 Jan 24	16
TM10745	44	11:15 AM	430	AX05	23 Jan 24	11:27 AM	415	AX05	23 Jan 24	16
TM10745	44	11:35 AM	430	AX05	23 Jan 24	11:47 AM	415	AX05	23 Jan 24	16
TM10745	44	11:58 AM	430	KL95	23 Jan 24	12:10 PM	415	KL95	23 Jan 24	16
TM10745	44	12:25 PM	429	KL95	23 Jan 24	12:37 PM	415	KL95	23 Jan 24	16
TM10745	44	1:35 PM	430	AX05	23 Jan 24	1:47 PM	415	AX05	23 Jan 24	16



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

PRODUCTION ORDER# 500000297266

OP 400



**PO #:** 500000297246

OP #: 500

**Shift #:** 151

Document No: 5106073

Rev: E

**Document Type: Manufacturing Form**

**Title: SA0155-01 Visual Rework Form**

Total Parts Reworked:		190	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube		50
EW	Exposed Wire		114
MP	Micropores		4
SCR	Scratch	N/A	N/A
SKV	Skive Marks		2
VD	Voids		19
N/A	N/A	N/A	N/A

**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 #: 50000291266 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>//</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>n/a</u>	<u>0</u>
EH	Exposed Hypotube	<u>/</u>	<u>1</u>
EW	Exposed Wire	<u>    </u>	<u>7</u>
MP	Micropores	<u>n/a</u>	<u>0</u>
SCR	Scratch	<u>n/a</u>	<u>0</u>
SKV	Skive Marks	<u>   </u>	<u>3</u>
VD	Voids	<u>/</u>	<u>1</u>
<u>n/a</u>	<u>n/a</u>	<u>n/a</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Caufi Vangj Lor</u>	<u>23 Jan 24</u>

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 50000297266 OP #: 750 Shift #: 2nd

Total Parts Reworked:		25	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		22
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	0
EH	Exposed Hypotube		3
N/A	N/A	N/A	0
Inspected By (Sign and Date):		ML60	DX35 23 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):



PO #: 500000297266

OP #: 750 Shift #: 2<sup>nd</sup>

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		98	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		68
DIM07 US / WC	DIM07 Undersized (Window Closed)		15
EH	Exposed Hypotube		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	23 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):



PO #: 500000297266

OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		78	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		16
DIM07 US / WC	DIM07 Undersized (Window Closed)		10
EH	Exposed Hypotube		15
N/A	Glue , stopper		37
Inspected By (Sign and Date):		Hv36 23 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#** 500000297266

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	11:10 AM	190°F	PM96	23Jan24	12:20 PM	190°F	PM96	23Jan24	77
TM12036	N/A	12:00 PM	190°F	PM96	23 Jan 24	1:10 PM	190°F	PM96	23 Jan 24	39
TM10409	N/A	12:25 PM	190°F	PM96	23 Jan 24	1:35 PM	190°F	PM96	23 Jan 24	43
TM10409	N/A	1:45 PM	190°F	KT47	23 Jan 24	2:55 PM	190°F	KT47	23 Jan 24	37
TM12036	N/A	2:15 PM	190°F	KT47	23 Jan 24	3:25 PM	190°F	KT47	23 Jan 24	35
TM10409	N/A	4:01 PM	190°F	SG88	23 Jan 24	5:11 PM	190°F	SG88	23 Jan 24	40
TM12036	N/A	4:40 PM	190°F	SG88	23 Jan 24	5:50 PM	190°F	SG88	23 Jan 24	35
TM10409	N/A	5:23 PM	190°F	SG88	23 Jan 24	6:33 PM	190°F	SG88	23 Jan 24	51
TM10409	N/A	6:51 PM	190°F	SG88	23 Jan 24	8:01 PM	190°F	SG88	23 Jan 24	43
TM12036	N/A	7:48 PM	190°F	SG88	23 Jan 24	8:58 PM	190°F	SG88	23 Jan 24	58
				MN02	23Jan24					



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

PO #: 500000297266 OP #: 900 Shift #: 2nd

Total Parts Reworked:		56	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	NA
EH	Exposed Hypotube	NA	NA
EW	Exposed Wire		3
MP	Micropores	NA	NA
SCR	Scratch		33
SKV	Skive Marks		3
VD	Voids		15
DIM01 US	DIM01 OD Undersized	NA	NA
DIM06 US	DIM06 OD Undersized		12
DIM06 OS	DIM06 OD Oversized	NA	NA
DIM09 US	DIM09 OD Undersized	NA	NA
Inspected By (Sign and Date):		Menon	23 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):



PO #: 500000297266 OP #: 900 Shift #: 2

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

Total Parts Reworked:		49	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		5
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks	N/A	N/A
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		2
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		 23Jan24, HT72	

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

Data Uploaded for Engineering Review (Check):

PO #: 500000297266OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		46	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube		5
EW	Exposed Wire		3
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks	N/A	0
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized	/	1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 23 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):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000299266 OP #: 900 Shift #: 1st

Total Parts Reworked:		35	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	1	1
EW	Exposed Wire		5
MP	Micropores	N/A	N/A
SCR	Scratch		5
SKV	Skive Marks		2
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		k155 PH59 D429 24 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):

EDW Commander Flex - Bend and Tensile Strength Testing

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	23.98	25.83	23.61	27.39	26.94	24.51	28.46	26.18	23.52	26.25	25.667	1.7011503	4.378	18.2193641	8.542	PASS
Seg B	63.22	61.32	65.24	65.54	59.89	66.72	67	63.03	67.81	67.47	64.724	2.7334683	3.981	53.8420627	8.542	PASS
Seg C	75.37	77.75	76.42	75.42	78.7	76.36	74.23	77.45	76.17	74.36	76.223	1.4471585	2.911	72.0103216	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.

 24 Jan 24