

Production Order: 500000306364



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 Order Type: ZSTD
Plant / Business Unit: 1213 / AC5 Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3 Kitting Devices  Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>An 68 7:4um 10 Feb 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 5:00pm 11 Feb 24</u> Record Dryer Shelf #: <u>N/A</u>	N/A	N/A	07 FEB 24	BV57

Notes: DA2564, 2484

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	<u>N/A</u> <u>88018</u>	<u>N/A</u> <u>100</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>89547</u> <u>89543</u> <u>89542</u>	<u>N/A</u> <u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>N/A</u> <u>0000288401</u>	<u>N/A</u> <u>560</u>	<u>N/A</u>	<u>N/A</u>
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>		
		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	88394	503			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82861	300			
							82864	200			
		RM7348-01	C	C	PC	500	85677	400			
							88536	100			
		RM4001-01	B	B	PC	125	89598	100			
							89599	100			
		RM0607-01	D	D	PC	56	78322	100	N/A	N/A	N/A
							N/A	N/A			
		RM0498-01	C	C	PC	500	0000287646	16			
							0000287647	95			
							0000287648	382			
		RM0009-04	I	I	PC	1	88992	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	88992	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
		MM1538-01	A	A	PC	500	① <u>0000290561</u>	<u>500</u>	<u>N/A</u>	<u>Bulk</u>	
		MM1537-01	A	A	PC	1000	<u>0000290561</u>	<u>1000</u>	<u>N/A</u>		
		MM0177-01	C	C	PC	500	<u>0000294697</u>	<u>500</u>	<u>N/A</u>		
		MM0180-01	E	E	PC	500	<u>0000287541</u>	<u>500</u>	<u>N/A</u>		
		MM0178-01	E	E	PC	500	<u>0000290565</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	D	PC	500	<u>0000288413</u>	<u>520</u>	<u>N/A</u>		
		MM0074-01	G	G	PC	500	<u>0000300403</u>	<u>517</u>	<u>N/A</u>		

Notes:

① 07 FEB 24 BU57

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	12Feb24	KL95
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	12Feb24	SN#7 SDZ4 Pm96 AF54 AX05 NKB2 CL30 SH23 Y014
	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 Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	12Feb24	PY67 VP62 ST96 NY35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	12Feb24	SD19 AZ65 MY50 CY97 AS31 AT39

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1 	Insert Cut Hypo Tube Insert Cut Hypo Tube Confirmation Reqd(Milestone)	500	○	12Feb24 VV30 LMub GS22	PL220 TR-TN BD64 RL47
350	CATASY01 Catheter Assembly 1	Load Tubing	500	○	12Feb24	VV25 LMub DX37
Notes:						
N/A N/A N/A						

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① PL22 11 Feb 24 is part of



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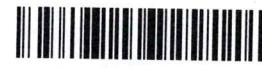
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	12Feb24	AL67 PL22 TRN JC92 PM 96 AF54 NY62 V078
450	CATASY01 Catheter	FEP Removal	500	0	12Feb24	PM 96 AF54 JY90
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	In-process Inspection and Rework Material Consumed: Part #: 1500-1153-01 Batch #: 89542 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	OF-H71 EW=H71 #88 487	① ② ③	TA36 CB81 VL91 P66 TPR15 12Feb24	
	Catheter Assembly 1					
	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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(2) mm02 12Feb24

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OP446 12 Feb 24

signed for TA36, CB81

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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	478	DL-4HT II OF-1 EW-1	12Feb24 ⑨	VAP6 RS23 FB01 AX82 Y936 SV46
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	469	DL-III MAS-4HT SKV-1	12Feb24 ⑨	VAP6 FB01 AX82 PY46 TRN DY29 MV77 ML60

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 Loading Heat Shrink Confirmation Reqd(Milestone)	469	○	12Feb24 HX 82 ML38	VAG6 0V39 FBO1
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0936A</u> Cal Due: <u>31 MAY 24</u> TMI: <u>2083C</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0386</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0521</u> Cal Due: <u>31 MAY 24</u>	469	○	12Feb24	STX48 HV 36 ML38
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 #: <u>Pn4601-01</u> Batch #: <u>89598</u> Qty: <u>N/A</u> Part #: <u>Pn66701</u> Batch #: <u>78322</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> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	458	EH-HH HH W0-1 11	12 Feb 24	STX48 Hv36 PP40 mm02
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	448	ACD-HH HH 10	12 Feb 24	SS52 SS44 SG88
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
NA	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> Cut to Length Confirmation Reqd(Milestone)	448	0	12Feb24	SS52 M165 Y93G AT39
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	SH04 MV33 TRN KY86
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Quality Inspection & Review Confirmation Reqd(Milestone)	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: 0700-01 Cal Due: 31 May 24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: N/A Batch #: N/A Qty: N/A Part #: Pn4000-01 Batch #: 89598 Qty: N/A Part #: 070-153-01 Batch #: 89547 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A</p>	390	BW-III FM-II DS-I Dis-LH1 LH1H1H1 DL-II #60S-III WL-LH1 #90S-II MAD-III DE2-1 ① WL-H1 #9US-1 EW-1 #70S-III #6US-1	12Feb24 Y936	DY29 L155 XL91 HT72
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: 5073B Cal Due: 12 APR 24 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  Confirmation Reqd(Milestone)	TMI: 0733 Cal Due: 30 APR 24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 SEP 25 TMI: 0692 Cal Due: 30 SEP 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	369	STR-HH Dis-HH 1111 WK-1 DEL-1 DIS(SP) HTT	12 Feb 24	P14L XL91 Y936
1000	 QUALITY1 Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: 1056 Cal Due: 31 May 24 Record Length Gage Information: TMI: 068910 Cal Due: 30 SEP 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 SEP 24	355	Lt-HH HH 1111	12 Feb 24	P14L XL91 Y936

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
1050	QUALITY1 Quality Inspection & Review 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS Quality Inspection & Review Confirmation Reqd(Milestone)	338	SCR-UN (T) FM-UN (T) FB-1 AB-1 DL-1 TD-1 PBC-1 UD-1 CRK-1 ⑦	13 Feb 24	XN26 SN43
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KP02 13Feb24	N/A	N/A	13 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	338	O	13Feb24 AP10	

Notes:

WT APR10 13 Feb 24 /

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Batch Number: 0000306364

By: AP10

Date: 13 Feb 24

Reviewed By:

RB29

Date:

13 Feb 24

Notes:

N/A AP10 13 Feb 24

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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

CONTROLLED COPY

① UK55, 23JW 2023



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 MM1536-01 fixture for inspection. (See image 1)
①MM1536-01 type connection TS12 10AUG23

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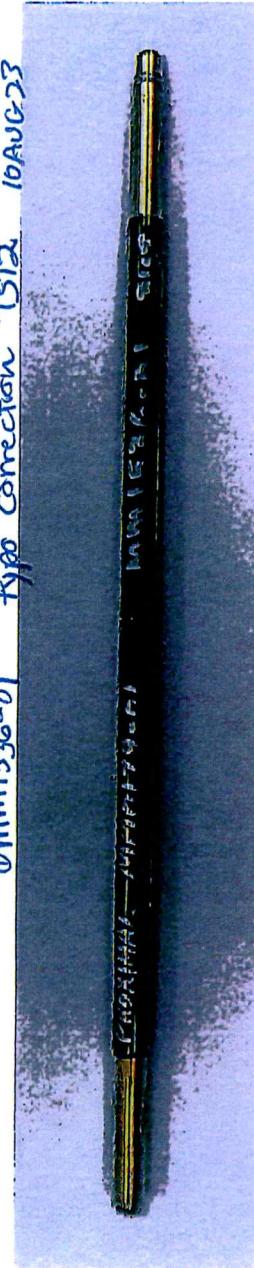


Image- 1

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)

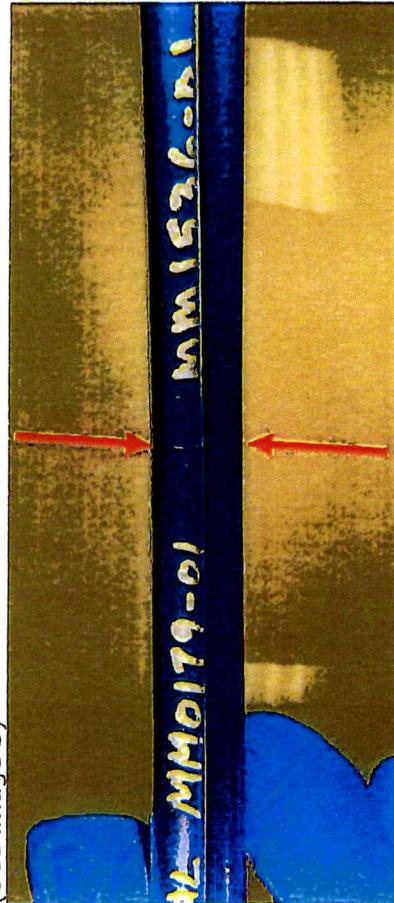


Image- 3

- 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)

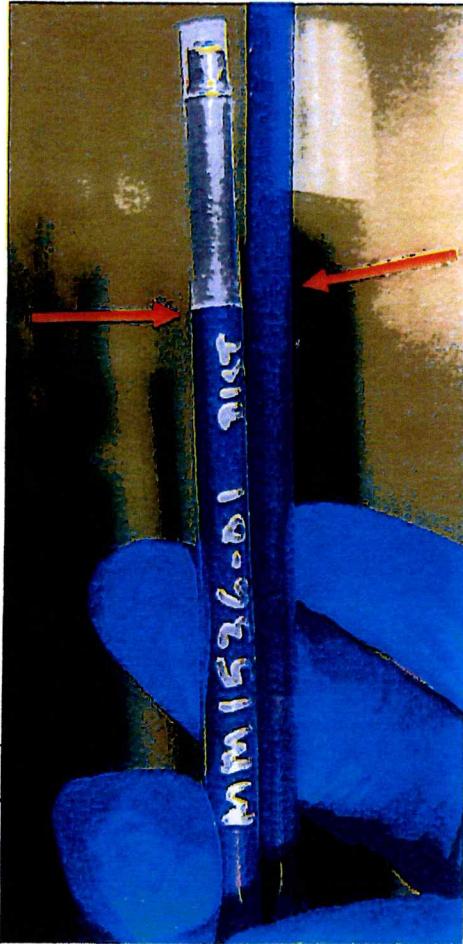


Image- 4

- 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 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 Hennepin J228 11/15/2023
Entered to 13 Feb 2024 3228 1/9/2024

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		
Deviation From:			
<p>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.</p>			
Deviation To:			
<p>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.</p>			
Justification:			
<p>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 equivalence test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.</p>			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:		
16 Nov 23	15 DEC 23		
Lot Number:			
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 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			
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
FM15104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#: 500000306364

OP 400



Document No: 5105589
FM15104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000 306364

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	5:15 AM	430	PM96	12 Feb 24	5:37 AM	415	PM96	12 Feb 24	16
TM10942	44	5:51 AM	430	DM96	12 Feb 24	6:01 AM	415	DM96	12 Feb 24	16
TM10942	44	6:15 AM	427	AX05	12 Feb 24	6:27 AM	415	AX05	12 Feb 24	16
TM10942	44	7:00 AM	430	AF54	12 Feb 24	7:12 AM	415	AF54	12 Feb 24	16
TM10942	44	7:35 AM	430	OS21	12 Feb 24	7:47 AM	415	OS21	12 Feb 24	16
TM10942	44	8:00 AM	430	OS21	12 Feb 24	8:12 AM	415	OS21	12 Feb 24	16
TM10942	44	8:44 AM	430	NK62	12 Feb 24	8:56 AM	415	NK62	12 Feb 24	16
TM10942	44	9:20 AM	430	OS21	12 Feb 24	9:32 AM	415	OS21	12 Feb 24	16
TM10942	44	9:45 AM	427	NK62	12 Feb 24	9:57 AM	415	NK62	12 Feb 24	16
TM10942	44	10:50 AM	430	AX05	12 Feb 24	11:02 AM	415	AX05	12 Feb 24	16
TM10942	44	11:30 AM	430	AX05	12 Feb 24	11:42 AM	415	AX05	12 Feb 24	16
TM10942	44	12:15 PM	430	AX05	12 Feb 24	12:27 PM	415	AX05	12 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#: 500000306364

OP 400



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306364

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	5:16pm	430	SN47	11 Feb 24	5:28pm	415	SN47	11 Feb 24	16
TM10745	44	5:51PM	430	PL22	11 Feb 24	6:03PM	415	PL22	11 Feb 24	16
TM10745	44	6:13PM	430	RL47	11 Feb 24	6:25PM	415	RL47	11 Feb 24	16
TM10745	44	5:31AM	430	PM96	12 Feb 24	5:43AM	415	PM96	12 Feb 24	16
TM10745	44	6:30am	430	Ax05	12 Feb 24	6:42am	415	Ax05	12 Feb 24	16
TM10745	44	7:20am	430	NK62	12 Feb 24	7:32am	415	NK62	12 Feb 24	16
TM10745	44	7:48am	430	OS21	12 Feb 24	8:00am	415	OS21	12 Feb 24	16
TM10745	44	8:22am	430	NK62	12 Feb 24	8:35am	415	NK62	12 Feb 24	16
TM10745	44	9:00am	430	OS21	12 Feb 24	9:12am	415	OS21	12 Feb 24	16
TM10745	44	10:00am	430	OS21	12 Feb 24	10:12am	415	OS21	12 Feb 24	16
TM10745	44	11:10am	430	Ax05	12 Feb 24	11:22am	415	Ax05	12 Feb 24	16
TM10745	44	11:55am	430	Ax05	12 Feb 24	12:07pm	415	Ax05	12 Feb 24	16



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

PO #: 500000306364

OP #: 500 Shift #: 1

Total Parts Reworked:		142	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		24
EW	Exposed Wire		109
MP	Micropores	N/A	N/A
SCR	Scratch		14
SKV	Skive Marks		5
VD	Voids		13
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SX , CB81, TA36	12 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 #: 500000306364 OP #: 500 Shift #: 2nd

Total Parts Reworked:		14	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		8
MP	Micropores	n/a	n/a
SCR	Scratch		2
SKV	Skive Marks	n/a	n/a
VD	Voids		3
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Vammeej Lor 12 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 #: 500000306364

OP #: 500 Shift #: 2

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		10
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids		2
N/A	N/A	N/A	0
Inspected By (Sign and Date):		<u>Gang</u> 12 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 #: 500000306364

OP #: 750 Shift #: 1st

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		20
DIM07 US / WC	DIM07 Undersized (Window Closed)		10
EH	Exposed Hypotube		7
N/A	Glue, stopper		36
Inspected By (Sign and Date):		Hv36 12 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):

PO #: 500000306304OP #: 750 Shift #: 2nd.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		26	
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)	/	13
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MMO 2	12Feb24

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# 500000306364

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm12036	N/A	9:30 am	190°F	K155	12 Feb 24	10:40 am	190°F	K155	12 Feb 24	39
Tm10409	N/A	10:30 am	190°F	K155	12 Feb 24	11:40 am	190°F	K155	12 Feb 24	34
Tm12036	N/A	11:30 am	190°F	SS44	12 Feb 24	12:40 pm	190°F	SS44	12 Feb 24	40
Tm10409	N/A	12:15 pm	190°F	SS44	12 Feb 24	1:25 pm	190°F	SS44	12 Feb 24	54
Tm10409	N/A	2:00 am	190°F	SS44	12 Feb 24	3:10 pm	190°F	SS44	12 Feb 24	60
Tm12036	N/A	2:50 pm	190°F	SS44	12 Feb 24	4:00 pm	190°F	SS44	12 Feb 24	61
Tm10409	N/A	4:30 pm	190°F	SG88	12 Feb 24	5:40 pm	190°F	SG88	12 Feb 24	40
Tm12036	N/A	5:30 pm	190°F	SG88	12 Feb 24	6:40 pm	190°F	SG88	12 Feb 24	40
Tm10409	N/A	6:44 pm	190°F	SG88	12 Feb 24	7:54 pm	190°F	SG88	12 Feb 24	45
Tm12036	N/A	7:13 pm	190°F	SG88	12 Feb 24	8:23 pm	190°F	SG88	12 Feb 24	35
				N/A						
				SG88	12 FEB 24					



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306364 OP #: 900 Shift #: 15f

Total Parts Reworked:		33	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire		5
MP	Micropores	N/A	N/A
SCR	Scratch		5
SKV	Skive Marks		2
VD	Voids		4
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		4
DIM06 OS	DIM06 OD Oversized		N/A
DIM09 US	DIM09 OD Undersized		N/A
Inspected By (Sign and Date):		61558446	12 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):



PO #: 500000306364 **OP #:** 900 **Shift #:** 2

OP #: 900 Shift #:

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/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. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306364

OP #: 900 Shift #: 2

Total Parts Reworked:		72	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube		4
EW	Exposed Wire		21
MP	Micropores	n/a	n/a
SCR	Scratch		83
SKV	Skive Marks	n/a	n/a
VD	Voids		3
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	HT72 n/a 12 Feb 24	
Inspected By (Sign and Date):		HT72 12 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):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306364 OP #: 900 Shift #: 2nd

Total Parts Reworked:		60	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		6
MP	Micropores	N/A	0
SCR	Scratch		39
SKV	Skive Marks	N/A	0
VD	Voids		4
DIM01 US	DIM01 OD Undersized	N/A ①	0
DIM06 US	DIM06 OD Undersized		37
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Osee H 12 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):

① SH04 12 Feb 24

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	28.61	26.09	28.79	27.25	34.71	27.55	29.8	29.58	36.54	23.02	29.194	3.9390557	4.378	11.948814	8.542	PASS
Seg B	74.24	70.38	76.91	68.28	78.65	68.63	73.69	69.96	79.9	74.05	73.469	4.1260486	3.981	57.0432007	8.542	PASS
Seg C	90.19	91.41	83.69	89.59	85.24	85.66	84.31	77.84	82.76	85.34	85.603	4.0074987	2.911	73.9371714	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 #: 500000306364

Date: 13FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



SK.
13 FEB 2024