

Production Order: 500000307853



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>AL71 2:45pm 17Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>GOGG 6:40AM 20 Feb 24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	15 Feb 24	SA70
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
	MM0179-01	D <u>D</u>	PC	500	<u>000029319</u>	<u>500</u>
					<u>NA</u>	<u>NA</u>
	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>

Notes: DA 2484, 2564

Date Printed: 15.02.2024 / 16:54:46

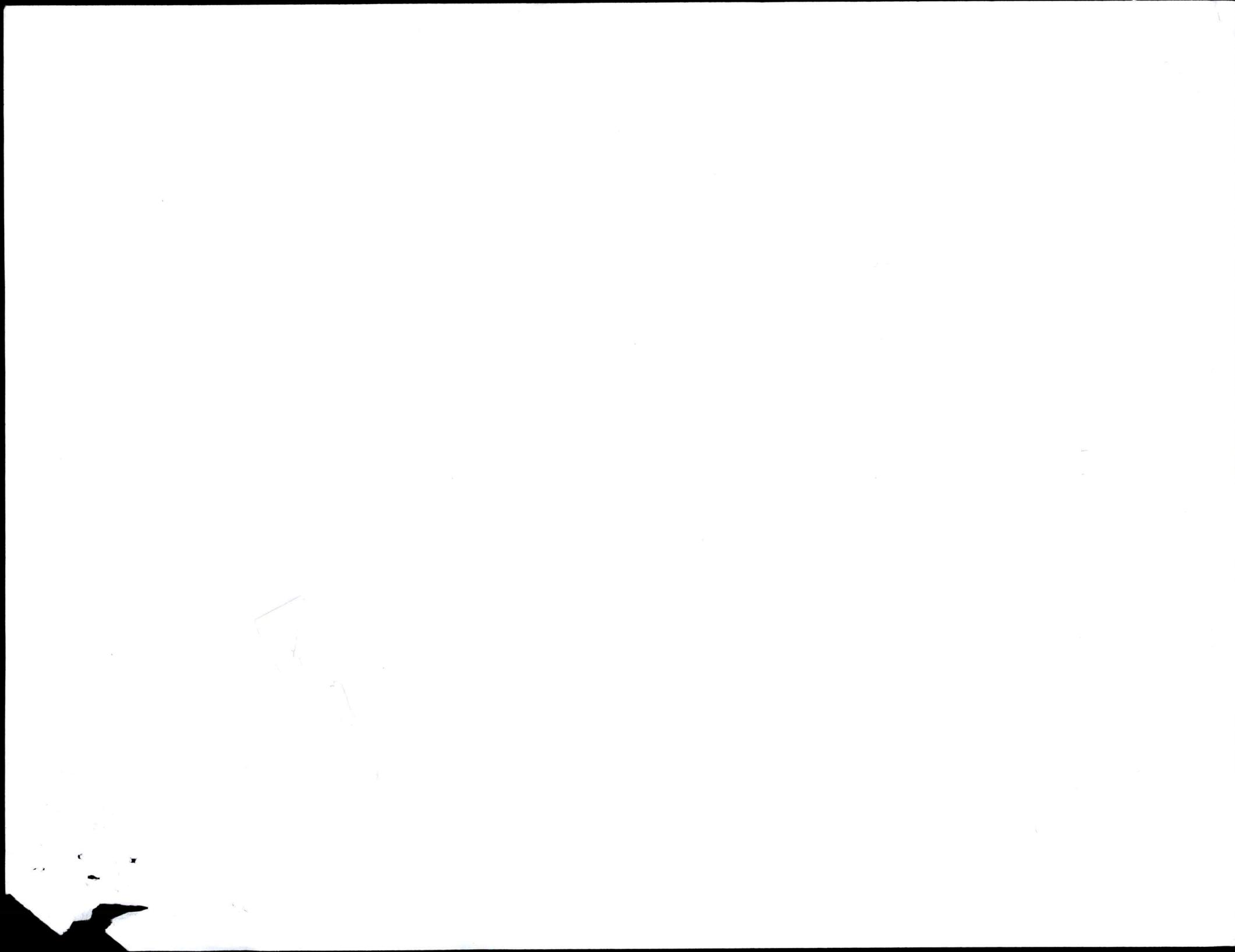
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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>NA</u> <u>88018</u>	<u>NA</u> <u>59</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>NA</u> <u>89300</u> <u>89383</u> <u>89094</u> <u>90166</u>	<u>NA</u> <u>200</u> <u>200</u> <u>200</u> <u>100</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000295775</u> <u>0000287543</u>	<u>400</u> <u>100</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u>	<u>500</u>	NA	NA	21Feb24 9m57
		TL0167-02	E	<u>NA</u>	PC	70	<u>NA</u>	<u>NA</u>			
		TL0165-05	J	<u>NA</u>	PC	5	<u>NA</u>	<u>Bulk</u>			
		TL0165-03	J	<u>NA</u>	PC	5	<u>NA</u>	<u>Bulk</u>			
							<u>NA</u>	<u>Bulk</u>			

Notes: NA

N/A

N/A

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N/A	N/A	141967-01	02	02	PC	500	87490	510			
							NA	NA			
		RM7349-02	C	C	PC	543	82869 82862 82858	526 15 85			
		RM7348-01	C	C	PC	500	85677	485			
							NA	NA			
		RM4001-01	B	B	PC	125	89429 90286	100 52	N/A	N/A	21Feb24 9057
		RM0607-01	D	D	PC	56	78322	100			
							NA	NA			
		RM0498-01	C	C	PC	500	0000275493	500			
							NA	NA			
		RM0009-04	I	I	PC	1	① NA 88993	Bulk			
							NA	Bulk			
		RM0009-04	I	I	PC	1	① NA 88993	Bulk			

Notes:

N/A

N/A

N/A

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①CB58 23 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	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>Bulk</u>			
							<u>NA</u>	<u>500</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000294701</u>	<u>1000</u>			
							<u>NA</u>	<u>NA</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000294697</u>	<u>500</u>			
							<u>NA</u>	<u>NA</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000294374</u>	<u>400</u>	N/A	N/A	21 Feb 24 9M57
							<u>0000295174</u>	<u>100</u>			
		MM0178-01	E	<u>E</u>	PC	500	<u>0000290565</u>	<u>500</u>			
							<u>NA</u>	<u>NA</u>			
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>540</u>			
							<u>NA</u>	<u>NA</u>			
		MM0074-01	G	<u>G</u>	PC	500	<u>0000306621</u>	<u>50-524</u>			
							21 Feb 24				

Notes: NA
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	20Feb24	KL95
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	20Feb24 AS31 SH23 SH185	PM96 TA36
	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 Req'd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Loading Braid Stock Confirmation Req'd(Milestone)	Loading Braid Stock	500	0	20Feb24	MV50 SX11 ST96 11/35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	20Feb24	DV39 CP32 DX35

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	20Feb24	VPC2 C497 SHZ2 GSZ2
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	20Feb24	VV25 CL05 V078

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	 Load Tubing Confirmation Rreqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Rreqd(Milestone)	Reflow	500	0	20Feb24	NK62 PL34 PM96 SX60 SY47
450	CATASY01 Catheter	FEP Removal	500	0	20Feb24	PM96 JY90 PZ66
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	Assembly 1 	N/A	N/A	N/A	N/A	N/A
	FEP Removal					
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-0 Batch #: 89300 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	491	EH - I OF - III EW - II Fm - I DF - II 9	HL61 VC09 CB81 VL91 TD215 20Feb24	
	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 Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel	481	MAH-III EH-III IDB-1 (10)	20Feb24	AX82 F B01 RS93 Y936 SV46
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	468	MAH-III DL - II EH- I IDB- II DF- I (13)	20Feb24	AX82 F B01 MM02 ML60

Notes:

NIA

NIA

NIA

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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)	468	0	20Feb24	Ax82 FB01 PHH9 DY29 PP40
700	CATASY01 Catheter Assembly 1 	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>0521</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0386</u> Cal Due: <u>31 MAY 24</u> Tipping	468	0	20Feb24	STX48 Hv36 PP40

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 #: Rm4001-01</td> <td>Batch #:</td> <td>89429</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: Rm0158-01</td> <td>Batch #:</td> <td>88018</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: Rm0607-01</td> <td>Batch #:</td> <td>78322</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> </table>	Part #: Rm4001-01	Batch #:	89429	Qty:	N/A	Part #: Rm0158-01	Batch #:	88018	Qty:	N/A	Part #: Rm0607-01	Batch #:	78322	Qty:	N/A	Part #: N/A	Batch #:	N/A	Qty:	N/A	Part #: N/A	Batch #:	N/A	Qty:	N/A	463	EH - 1 ACD - 1111 	STX48 Hv36 MU78 20Feb24
Part #: Rm4001-01	Batch #:	89429	Qty:	N/A																										
Part #: Rm0158-01	Batch #:	88018	Qty:	N/A																										
Part #: Rm0607-01	Batch #:	78322	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	457	ACD-1111 	SS52 KT26 20Feb24 XL91																									

Notes:

N/A
N/A
N/A

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N/A	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	457	0	20Feb24	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>	457	0	20Feb24	SS52 ML65
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	MV33 SH04 HT72
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
900	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: 0700-C1 Cal Due: 31 May 24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: Pn 41001-01 Batch #: 89429 Qty: N/A</p> <p>Part #: 10010-1153-01 Batch #: 89300 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	414	Dis-1H.III 1H.III #605-11 #605-1111 MAR-1H.III #15US-1 DL-11 #705-1H.II	20 Feb 24	K155 KT217 PY266 XL91 Y936
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: 50713B Cal Due: 12 Apr 24</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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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
950	 Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>TMI: <u>0733</u> Cal Due: <u>30 Apr 24</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></p>	381	<u>ST12-111</u> <u>DIS-HHT HHT</u> <u>HHT</u> <u>DLGTT) HHT HHT</u> <u>DIS(EP)HHT</u>	20 Feb 24	<u>0521</u> <u>XL91</u> <u>Y936</u>
1000	 Quality Inspection & Review  Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>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>08891</u> Cal Due: <u>30 SEP 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u></p>	380	<u>L+1</u>	20 Feb 24	<u>SS44</u> <u>XL91</u> <u>Y936</u> <u>5688</u>

Notes:

N/A

N/A

N/A

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N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS		DIS-III 11 VD-III BP-III DL-III SKV-II SCR-II FB-I MEX-I AB-I 7/6 (24)		XN26 SV43 21Feb24
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>AMS7</u> <u>21Feb24</u>	356	NA	21Feb24	<u>AMS7</u>
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	356	0	21Feb24 AB10	

Notes:

N/A AB10 21Feb24

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Batch Number: 0000307853

By: AF10

Date: 21 Feb 24

Reviewed By:

RB29

Date:

23 Feb 24

Notes:

N/A AF10 21 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

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① UK55, 23JW 2023



is part of

DA | 2484
2468

①

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

Procedure:

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



Image- 1

Step 1:

- Visually locate the MM0180-01 (Vestamid) transition to MM0179-01 on the completed part approximately 9.75" from the distal end using magnification light 2.25X minimum.
- Align the fixture MM0179-01 extrusion proximal end to the Vestamid transition on completed part. (See image 2)



Image- 2

- Visually verify the MM0179-01 distal end of the fixture is approximately at the same location on the completed part. (See image 3)

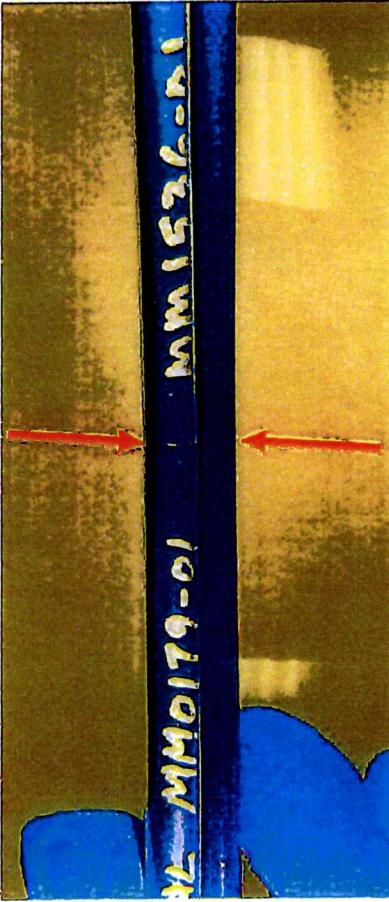


Image- 3

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, move to Step 2.

CONTROLLED COPY

Step 2:

- Visually verify the MM1536-01 distal end of the fixture is approximately at the same location on the completed part. (See image 4)

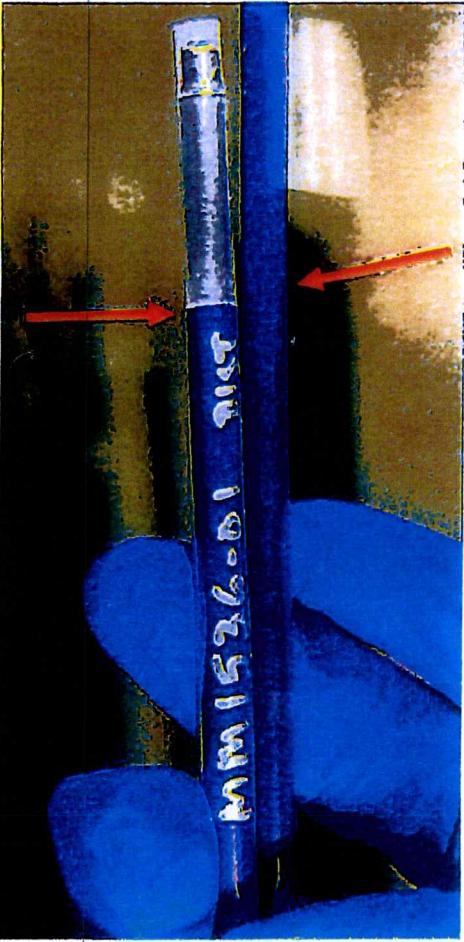


Image- 4

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

1	MM0179-01 GOOD PART	MM1536-01
2	MM1536-01	MM0179-01 MM0179-01 and MM1536-01 Wrong Order - BAD PART
3	MM0179-01	MM0179-01 Two MM0179-01 - BAD PART
4	MM1536-01	MM1536-01 Two MM1536-01 - BAD PART

Image - 5

DEVIATION AUTHORIZATION FORM

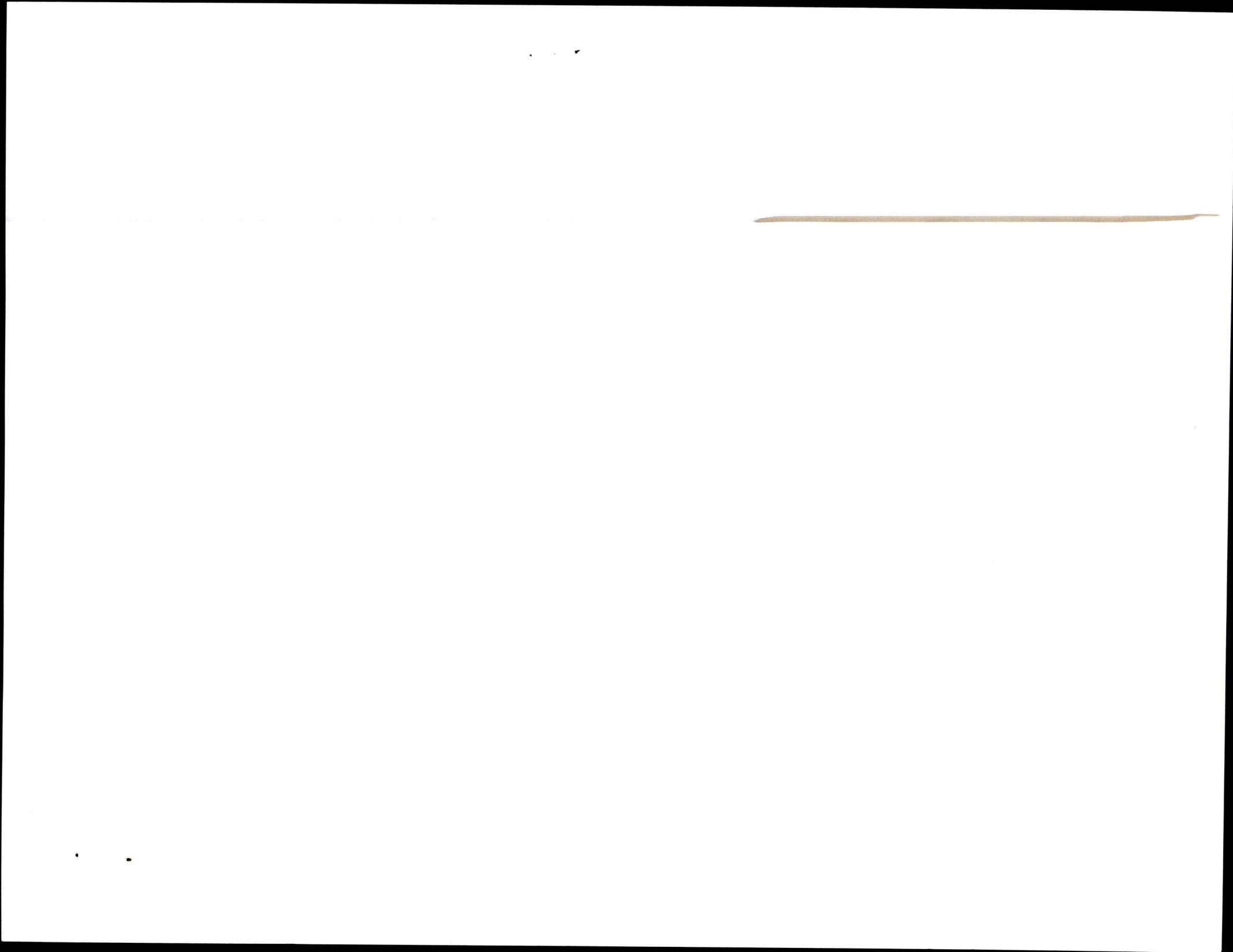
Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	
Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.	
Deviation To:	
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 equivalence 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 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#: 500000 307853

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	8:30am	430	0521	20Feb24	8:42am	415	0521	20Feb24	16
Tm10942	44	9:10am	430	0521	20Feb24	9:22am	415	0521	20Feb24	16
Tm10942	44	9:47am	430	NK62	20Feb24	9:59am	415	NK62	20Feb24	16
Tm10942	44	10:55AM	430	NK62	20Feb24	11:07AM	415	NK62	20Feb24	16
Tm10942	44	11:37am	430	0521	20Feb24	11:49am	415	0521	20Feb24	16
Tm10942	44	12:20pm	430	0521	20Feb24	12:32pm	415	0521	20Feb24	16
Tm10942	44	1:30pm	430	TA36	20Feb24	1:42pm	415	TA36	20Feb24	16
Tm10942	44	2:10pm	430	TA36	20FEB24	2:22pm	415	TA36	20FEB24	16
Tm10942	44	2:45pm	430	TA36	20FEB24	2:57pm	415	TA36	20FEB24	16
Tm10942	44	4:05pm	430	SG88	20Feb24	4:17pm	415	SG88	20Feb24	16
Tm10942	44	4:44pm	430	SX60	20Feb24	4:56pm	415	SX60	20Feb24	16
Tm10942	44	5:20pm	430	SH85	20Feb24	5:32pm	415	SH85	20Feb24	16



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500600307853

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	8:05AM	430	OS 21	20Feb24	8:17am	415	OS 21	20Feb24	16
Tm10745	44	8:48AM	430	OS 21	20 Feb 24	9:00am	415	OS 21	20 Feb 24	16
Tm10745	44	9:25AM	430	OS 21	20Feb24	9:37am	415	OS 21	20Feb24	16
Tm10745	44	11:15 AM	430	PM 96	20 Feb 24	11:57 AM	415	PM 96	20 Feb 24	16
Tm10745	44	11:52 AM	430	PM 96	20 Feb 24	12:04 PM	415	PM 96	20 Feb 24	16
Tm10745	44	12:30PM	430	KL95	20Feb24	12:42PM	415	OS 21	20Feb24	11
Tm10745	44	1:50pm	430	TA 36	20 feb 24	2:02pm	415	TA 36	20 Feb 24	16
Tm10745	44	2:25pm	430	OS 21	20 Feb 24	2:37pm	415	OS 21	20 Feb 24	16
Tm10745	44	2:55pm	430	NK62	20Feb24	3:07PM	415	NK62	20Feb24	13
Tm10745	44	4:22pm	430	SG88	20 Feb 24	4:34 PM	415	SG88	20 Feb 24	16
Tm10745	44	5:05pm	429	SH85	20Feb24	5:17pm	415	SH85	20Feb24	16
Tm10745	44	6:27pm	430	JY90	20Feb24	6:39pm	415	JY90	20Feb24	16



PRODUCTION ORDER# 500000307853

OP 400

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

① SY47 20 Feb 24



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

PRODUCTION ORDER# 50000030785

OP 400



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

PO #: 500000307853

OP #: 500 Shift #: 1ST

Total Parts Reworked:		89	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		10
EW	Exposed Wire		68
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks	N/A	N/A
VD	Voids		9
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

CB 81 , VC 09 , LL 61 20 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 #: 50000301853 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>18</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>N/A</u>	<u>0</u>
EW	Exposed Wire	<u> </u>	<u>16</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>2</u>
VD	Voids	<u> </u>	<u>3</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Andy</u> <u>20 Feb 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: 5106073
Rev: E
Document Type: Manufacturing Form
Title: SA0155-01 Visual Rework Form

PO #: 50000307853

OP #: 500 Shift #: 2nd

Total Parts Reworked:		25	
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		16
MP	Micropores	n/a	n/a
SCR	Scratch	///	4
SKV	Skive Marks	n/a	n/a
VD	Voids		8
n/a	n/a	n/a	n/a

Inspected By (Sign and Date): Vammeg. Lor 20 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 #: 500000307853 OP #: 750 Shift #: 1st

Total Parts Reworked:		29	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		3
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		8
N/A	Glue - stopper		15
Inspected By (Sign and Date):		Hv36 20 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000307853

OP #: 750 Shift #: 2

Total Parts Reworked:		35	
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)		11
EH	Exposed Hypotube		5
① N/A MA	① N/A GD		4
Inspected By (Sign and Date):		MV78 20 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 MV78 20 Feb 24

PRODUCTION ORDER# 500000307853

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	11:30am	190°F	K155	20Feb24	12:40pm	190°F	K155	20Feb24	32
Tm12036	N/A	12:00 PM	190°F	K155	20Feb24	1:10 PM	190°F	K155	20Feb24	22
Tm10409	N/A	12:40pm	190°F	KL95	20Feb24	1:50 PM	190°F	K155	20Feb24	27
Tm10409	N/A	1:55PM	190°F	KL95	20Feb24	3:05PM	190°F	KL95	20Feb24	43
Tm12036	N/A	2:00 PM	190°F	K155	20Feb24	3:10 PM	190°F	K155	20Feb24	20
Tm10409	N/A	3:44PM	190°F	KT26	20Feb24	4:54PM	190°F	KT26	20Feb24	36
Tm12036	N/A	4:33PM	190°F	KT26	20Feb24	5:43PM	190°F	KT26	20Feb24	25
Tm10409	N/A	5:07PM	190°F	KT26	20Feb24	6:17PM	190°F	KT26	20Feb24	27
Tm10409	N/A	6:18PM	190°F	KT26	20Feb24	7:28PM	190°F	KT26	20Feb24	27
Tm12036	N/A	6:59PM	190°F	KT26	20Feb24	8:09PM	190°F	KT26	20Feb24	32
Tm10409	N/A	7:31PM	190°F	KT26	20Feb24	8:41PM	190°F	KT26	20Feb24	28
Tm12036	N/A	8:11PM	190°F	XL91	20Feb24	9:21PM	190°F	KT26	20Feb24	17
Tm10409	N/A	9:01PM	190°F	KT26	20Feb24	10:11PM	190°F	KT26	20Feb24	28

PRODUCTION ORDER# 500000307853

OP 800



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000307853 OP #: 900 Shift #: 15T

Total Parts Reworked:		25	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NIA	NIA
EH	Exposed Hypotube	NIA	NIA
EW	Exposed Wire		7
MP	Micropores	NIA	NIA
SCR	Scratch		17
SKV	Skive Marks	NIA	NIA
VD	Voids	NIA	NIA
DIM01 US	DIM01 OD Undersized	NIA	NIA
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized	NIA	NIA
DIM09 US	DIM09 OD Undersized	NIA	NIA
Inspected By (Sign and Date):		K155, KT47	20 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 #: 500000307853 OP #: 900 Shift #: 2nd

Total Parts Reworked:		47	
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		15
SKV	Skive Marks		1
VD	Voids		2
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		24
DIM06 OS	DIM06 OD Oversized		4
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Deeth	20 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 #: 50000307853 OP #: 900 Shift #: 2

Total Parts Reworked:		63	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube		2
EW	Exposed Wire		18
MP	Micropores	n/a	n/a
SCR	Scratch		69
SKV	Skive Marks		1
VD	Voids		4
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT72	20 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	28.84	29.18	23.37	27.53	34.5	27.51	27.47	33.2	33.8	29.58	29.498	3.4522643	4.378	14.3839868	8.542	PASS
Seg B	62.63	72.06	76.36	72.38	71	69.1	76.11	70.32	69.69	79.67	71.932	4.7163753	3.981	53.1561101	8.542	PASS
Seg C	88.03	87.6	77.7	88.42	83.17	77.61	84.6	83.46	79.91	88.93	83.943	4.3665447	2.911	71.2319885	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 #: 500000307853

Date: 21FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



21 FEB 2024