

# Production Order: 500000307849



Production Order Document  
Production Order Qty: 500  
PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

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

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3  Kitting Devices  	Kitting Devices  Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Am 68 6:20 am 15Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 68 6:15 am 16Feb24</u> Record Dryer Shelf #: <u>N/A</u>						N/A	N/A	15Feb24	OLAS
		MM0179-01	D <u>D</u>	PC	500	<u>000029319</u>	<u>500</u>				
		MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>				

Notes: DA 2584, 2484

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details					Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
<i>N/A</i>	<i>N/A</i>	RM0158-01	E	<u>E</u>	PC	200	<u>88018</u> <u>N/A</u>	<u>N/A</u> <u>100</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>88966</u> <u>88967</u> <u>88972</u>	<u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u> <u>N/A</u>	<u>500</u> <u>N/A</u>	<i>N/A</i>	<i>N/A</i>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u> <u>0000288401</u>	<u>500</u> <u>60</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u> <u>N/A</u>	<u>Bulk</u> <u>Bulk</u>		
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>Bulk</u> <u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>Bulk</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	87490	500	N/A		
		RM7349-02	C	C	PC	543	32871	600	N/A		
		RM7348-01	C	C	PC	500	85677	400	N/A		
		RM4001-01	B	B	PC	125	90127	100	N/A		
		RM0607-01	D	D	PC	56	78848	78	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	0000297650	478	N/A		
		RM0009-04	I	I	PC	1	88942	Bulk			
		RM0009-04	I	I	PC	1	88942	Bulk			

Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details					Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	A	PC	500	<u>0000302882</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>500</u>		
		MM1537-01	A	A	PC	1000	<u>0000294701</u>	<u>N/A</u>	<u>1000</u>	
							<u>N/A</u>	<u>N/A</u>		
		MM0177-01	C	C	PC	500	<u>0000294697</u>	<u>500</u>		
							<u>N/A</u>	<u>N/A</u>		
		MM0180-01	E	E	PC	500	<u>0000294374</u> <u>0000295774</u> <u>0000295574</u>	<u>400</u>		
							(D)	<u>100</u>		
		MM0178-01	E	e	PC	500	<u>0000290565</u>	<u>500</u>	N/A	N/A
							<u>N/A</u>	<u>N/A</u>	N/A	N/A
		MM0176-01	D	D	PC	500	<u>0000288413</u>	<u>500</u>		
							<u>N/A</u>	<u>N/A</u>		
		MM0074-01	G	G	PC	500	<u>0000306618</u>	<u>519</u>		
							<u>N/A</u>	<u>N/A</u>		

Notes:

N/A

N/A

N/A

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(D) KL95 20 Feb 24

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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	18Feb24	CB58
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	18Feb24	Jc92 AM47 GN67 XK40 SD34

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	18Feb24	MC11 SC10 ST96 M450
250	CATASY01  Catheter Assembly 1    Trim Braid Wire at Proximal End		500	0	18Feb24	PL22 CD14 R447 P767 MC17
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
	Trim Braid Wire at Proximal End  N/A Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1  	Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	500	0	18Feb24	PY67 QV10 AZ65 ALL2
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	18Feb24	BD64 AB7
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	<b>CATASY01</b> Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone)		500	0	18Feb24	SNL67 QV16
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	18Feb24	AM47 J292 YK40

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 #: 88972 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	494	OF-III EW-III ⑥	18Feb24	LLGd LS46 CB81 AR02
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone )					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
<b>Notes:</b>						
N/A						
N/A						

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## Material: SA0155-01 Rev F

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 )	487	MAH-1HT IDB-1 DL-1  	18Feb24	SCLU CH45 MH1D AX82
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Confirmation	Distal Tip Assembly	487	0	18Feb24	P TO9 BIGO TRN SCIO CHAS TRN MH1D AX82

Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink	487	0	18Feb24	B160 LH45 PP40 AX82
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01  Catheter Assembly 1  	Tipping  Record Tipping Oven Information: TMI: 0936A Cal Due: 31Mar24 TMI: 2083C Cal Due: 31Mar24 TMI: 0386 Cal Due: 31Mar24 TMI: 0521 Cal Due: 31Mar24  Tipping	487	0	18Feb24	IC83
<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
750	CATASY01  Catheter Assembly 1  	<b>Tip Inspection/ Flash Removal</b> <b>Material Consumed:</b> Part #: RM4001-01 Batch #: 90127 Qty: N/A Part #: RM0607-01 Batch #: 78848 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	483	EH-1111 (4)	18Feb24	MM02 IC83
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	479	ACD-1111 (4)	18Feb24	BD64 SN07 YK40

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. Pass    2. Pass    3. Pass    4. Pass    5. Pass	479	0	18Feb24	KL45 TRN PLZ
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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## Material: SA0155-01 Rev F

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: <u>0700-01</u> Cal Due: <u>31 MAY 2024</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>1000-1153-01</u> Batch #: <u>88972</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>90127</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>78848</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>88018</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	456	DIS-144 (5) DEL-144 (4) EOU-111 EH-11 SCR-11 SKN-1  23	18 Feb 24	LS46 KX54 MC17 DLG7
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:</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: <u>N/A</u> Cal Due: <u>N/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 2025</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 2025</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	447	STR-1111 DIS-111 #10S-11 <u>9</u>	18Feb24	PZ22 KL45
1000	 Quality Inspection & Review  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 2024</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 Sep 2024</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 2024</u>	438	LT-14K 1111 <u>9</u>	18Feb24	CB58 BD64

Notes:

N/AN/AN/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	<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	400	SCR-111 HHI EW-111 III MEX-111 FB-111 DIS-111 FM-111 EH-111 RDG-111 FL-111 VD-111 TO-111 DT-111 GNM-111 CRK-111 PBC-111  (33)	19 Feb 24	DX52 SV43
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>GS85 19 Feb 24</u> ① GS85 19 Feb 24	N/A	N/A	19 Feb 24	GS85
<b>Notes:</b> N/A N/A N/A						

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① GS85 19 Feb 24

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Opn 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	400	0	11 Feb 24	BH1

Notes:

H  
N  
N

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**Batch Number:** 0000307849

**By:** BATI

**Date:** 19 Feb 24

**Reviewed By:**

CX46

**Date:**

22 Feb 24

**Notes:**

N  
N  
N

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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 | DA | 2484  
2468 | ①

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

### Group Training Record

#### Procedure:

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

① **MM1536-01** **Type connection TS12** 10AUG-23

#### 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)

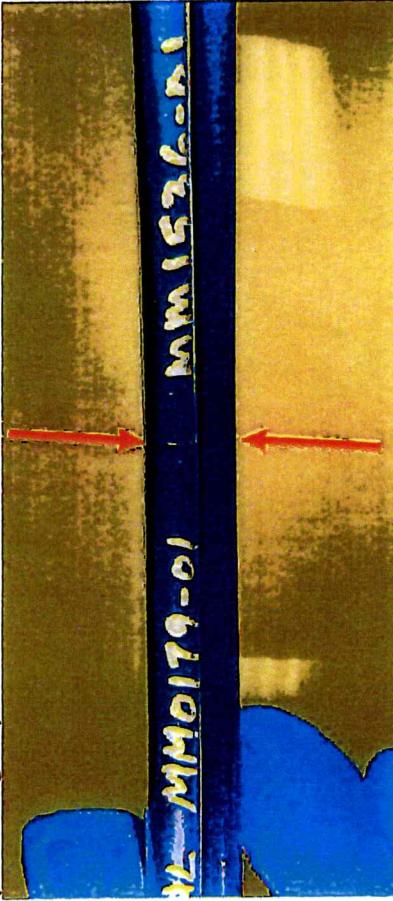


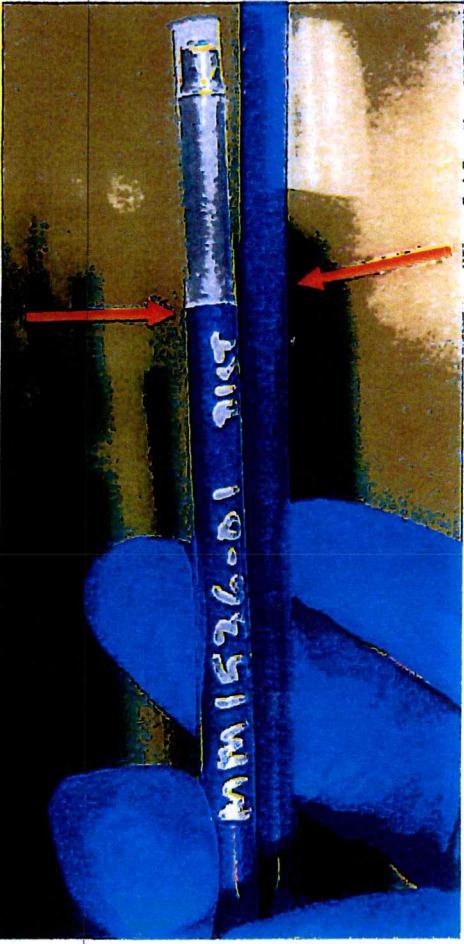
Image- 3

- 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.

## **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 <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



## DEVIATION AUTHORIZATION FORM

<b>Requestor Name:</b> Krishna Selvaraj			
<b>Document Number Affected</b>	<b>Revision</b>		
Doc #3005206 (MPI0238)	BP		
<b>Deviation From:</b>	<b>Deviation To:</b>		
<b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b>	<b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b>		
<p>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>			

### 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.

<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b>			
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No      FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No      Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A			
If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
<b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> N/A			
<b>Title</b>	<b>Approval Name</b>	<b>Approval Signature</b>	<b>Date</b>
Engineering Manager	Jake Stanislawski		16 Nov 2023
Quality Manager	Jay Zabel		16 Nov 2023
Operations Manager	Matthew Benson		16 Nov 2023



PRODUCTION ORDER# 500000307849

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	6:46 AM	430	AM47	17 Feb 24	6:58 AM	415	AM47	17 Feb 24	16
TM10745	44	7:24 AM	430	AM47	17 Feb 24	7:36 AM	415	AM47	17 Feb 24	16
TM10745	44	7:55 AM	430	AM47	17 Feb 24	8:07 AM	415	AM47	17 Feb 24	16
TM10745	44	8:20 am	430	TA36	17 Feb 24	8:32 am	415	TA36	17 Feb 24	16
TM10745	44	9:28 AM	430	YKH0	17 Feb 24	9:40 AM	415	YKH0	17 Feb 24	16
TM10745	44	10:00 am	430	TA36	17 Feb 24	10:12 am	415	TA36	17 Feb 24	16
TM10745	44	10:25 AM	430	AM47	17 Feb 24	10:37 AM	415	AM47	17 Feb 24	16
TM10745	44	11:11 AM	430	SD34	17 Feb 24	11:23 AM	415	SD34	17 Feb 24	16
TM10745	44	11:50 AM	430	SD34	17 Feb 24	12:02 PM	415	SD34	17 Feb 24	16
TM10745	44	1:21 PM	430	RV16	17 Feb 24	1:33 PM	415	RV16	17 Feb 24	16
TM10745	44	1:56 PM	430	SN47	17 Feb 24	2:08 PM	415	SN47	17 Feb 24	16
TM10745	44	2:27 PM	430	RV16	17 Feb 24	2:39 PM	415	RV16	17 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000307849

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TML0745	44	2:44pm	430	R1b	17Feb24	2:56pm	415	R1b	17Feb24	16
TML0745	44	3:16pm	430	CB58	17Feb24	3:28pm	415	CB58	17Feb24	16
TML0745	44	4:25pm	430	R1b	17Feb24	4:37pm	415	R1b	17Feb24	16
TML0745	44	4:49pm	430	R1b	17Feb24	5:01pm	415	R1b	17Feb24	16

N/A CM 99 17 Feb 24



PRODUCTION ORDER# 500000307849

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	6:22 pm	430	CD19	16 Feb 24	6:34 pm	415	CD19	16 Feb 24	4
TM10942	44	7:10 AM	430	AM47	17 Feb 24	7:22 AM	415	AM47	17 Feb 24	16
TM10942	44	7:35 AM	430	AM47	17 Feb 24	7:42 AM	415	AM47	17 Feb 24	16
TM10942	44	8:05 AM	430	AM47	17 Feb 24	8:17 AM	415	AM47	17 Feb 24	16
TM10942	44	8:35 AM	430	AM47	17 Feb 24	8:47 AM	415	AM47	17 Feb 24	16
TM10942	44	9:42 AM	430	YK40	17 Feb 24	9:54 AM	415	YK40	17 Feb 24	16
TM10942	44	10:10 am	430	TA36	17 Feb 24	10:22 am	415	TA36	17 Feb 24	16
TM10942	44	10:55 am	430	TA36	17 Feb 24	11:07 am	415	TA36	17 Feb 24	16
TM10942	44	11:25 AM	430	SD34	17 Feb 24	11:37 AM	415	SD34	17 Feb 24	16
TM10942	H4	12:11 PM	430	YK40	17 Feb 24	12:23 PM	415	YK40	17 Feb 24	16
TM10942	44	1:42 PM	430	RJ16	17 Feb 24	1:54 PM	415	RJ16	17 Feb 24	16
TM10942	44	2:08 PM	430	SN607	17 Feb 24	2:20 PM	415	SN607	17 Feb 24	16



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

PRODUCTION ORDER# 500000307849

OP 400



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

**PO #:** 5000000307849

OP #: 500 Shift #: 3rd

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

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

1

CB81.BI60.1546

① ~~17 Feb 24~~

① P446 19 Feb 24

correction for CB81, IB60



500000 307849 ①

PO #: 500000 307850

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

OP #: 500 Shift #: 3

Total Parts Reworked:		57	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		3
EH	Exposed Hypotube		8
EW	Exposed Wire		30
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks		5
VD	Voids		① + 2
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

LS46. 5X21, VCO9, AR02, B160, ① 18 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): 

① LS46 18 Feb 24

PO #: 500000307849OP #: 750 Shift #: 2<sup>nd</sup>

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		55	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		28
DIM07 US / WC	DIM07 Undersized (Window Closed)		2
EH	Exposed Hypotube		25
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MWD	17Feb24

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):



5000000307849  
500 000 307849

PO #: 500 000 307849 OP #: 750 Shift #: 3  
P44619 Feb 24 correction for IC83

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		31	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	III	13
DIM07 US / WC	DIM07 Undersized (Window Closed)		2
EH	Exposed Hypotube		15
GD	Glue Damage		1
Inspected By (Sign and Date):		IC83	18FEB24

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# 500000307849

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm12036	N/A	11:15AM	190°F	BD64	17 Feb 24	12:25PM	190°F	BD64	17 Feb 24	46
Tm10409	N/A	12:05PM	190°F	BD64	17 Feb 24	1:15PM	190°F	BD64	17 Feb 24	55
Tm10409	N/A	1:33PM	190°F	YK40	17 Feb 24	2:43PM	190°F	YK40	17 Feb 24	41
Tm12036	N/A	2:07PM	190°F	YK40	17 Feb 24	3:17PM	190°F	YK40	17 Feb 24	38
Tm10409	N/A	3:24PM	190°F	YK40	17 Feb 24	4:34PM	190°F	YK40	17 Feb 24	53
Tm10409	N/A	4:50pm	190°F	SNL67	17 Feb 24	6:00pm	190°F	SNL67	17 Feb 24	53
Tm12036	N/A	5:05PM	190°F	KL45	17 Feb 24	6:15PM	190°F	KL45	17 Feb 24	70
Tm10409	N/A	7:00AM	190°F	SNL67	18 Feb 24	8:10AM	190°F	SNL67	18 Feb 24	30
Tm12036	N/A	8:10AM	190°F	SNL67	18 Feb 24	9:20AM	190°F	SNL67	18 Feb 24	4445
Tm10409	N/A	9:45AM	190°F	SNL67	18 Feb 24	10:55AM	190°F	SNL67	18 Feb 24	48
					N/A					
					KL45	18 Feb 24				.

① SNL67 18 Feb 24

② P446 19 Feb 24  
 correction for BD 64



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000307849

OP #: 900 Shift #: 3

Total Parts Reworked:		235	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		19
EH	Exposed Hypotube		23
EW	Exposed Wire		99
MP	Micropores	N/A	N/A
SCR	Scratch		92
SKV	Skive Marks		9
VD	Voids		51
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized		8
DIM09 US	DIM09 OD Undersized		6
Inspected By (Sign and Date):		DL071546 MC11/KX524	18Feb24

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	27.81	25.29	32.19	26.28	31.86	30.94	31.92	26.28	28.3	29.44	29.031	2.6097401	4.378	17.6055579	8.542	PASS
Seg B	72.44	70.08	75.78	69.77	69.19	71.86	76.17	68.04	74.21	68.42	71.596	2.985071	3.981	59.7124323	8.542	PASS
Seg C	86.57	90.48	81.24	89.04	87.29	92.02	87.22	92	83.77	87.13	87.676	3.4294062	2.911	77.6929986	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 #: 500000307849

Date: 19FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



# 19 FEB 2024