

# Production Order: 500000302935



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	Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP								
	Kitting Devices		Record Time Extrusions Enter Dryer (Initial/Time/Date):	<u>Alt 1 5:30pm 05Feb24</u>							
			Record Time Extrusions First Exit Dryer (Initial/Time/Date):	<u>Kp02 11:30am 05Feb24</u>							
			Record Dryer Shelf #:	<u>N/A</u>							
			Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used			
		MM0179-01	D <u>D</u>	PC	500		<u>0000293119</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>05Feb24</u>
							<u>0000276172</u>	<u>40</u>			<u>06Feb24</u>
		MM1536-01	B <u>B</u>	PC	500		<u>0000290560</u>	<u>500</u>			<u>ES05</u>

Notes: DA 2564, 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	RM0158-01	E	S	PC	200	N/A	N/A			
						81054	150			
						N/A	N/A			
		A	A	PC	594	87886	200			
						87887	200			
						87889	200			
		A	A	PC	500	0000287543	500			
						N/A	N/A			
N/A	MM1537-02	A	A	PC	500	0000288401	500	N/A	N/A	N/A
						N/A	N/A			
		E	E	PC	70	N/A	Bulk			
						N/A	Bulk			
		J	J	PC	5	N/A	Bulk			
						N/A	Bulk			
		J	J	PC	5	N/A	Bulk			
						N/A	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
N/A	141967-01	02	D2	PC	500	85502 85793 85399 85794 82861	434 19 9 51 500				
	RM7349-02	C	C	PC	543	N/A	N/A				
	RM7348-01	C	C	PC	500	88505 N/A	600 N/A				
	RM4001-01	B	B	PC	125	82460 82461	N/A 100	N/A	N/A	N/A	N/A
	RM0607-01	D	D	PC	56	71864 N/A	60 N/A				
	RM0498-01	C	C	PC	500	0000287645 0000287646	440 50				
	RM0009-04	I	I	PC	1	88992 N/A	Bulk 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
N/A	N/A	MM1538-01	A	A	PC	500	N/A	Bulk		
							0000290562	500		
							N/A	N/A		
		MM1537-01	A	A	PC	1000	0000290561	1,120		① N/A
							N/A	N/A		
		MM0177-01	C	C	PC	500	0000284268	500	N/A	N/A
							N/A	N/A	N/A	N/A
		MM0180-01	E	E	PC	500	0000282490	500		
							N/A	N/A		
		MM0178-01	E	E	PC	500	0000276174	500		
							N/A	N/A		
		MM0176-01	D	D	PC	500	0000283413	500		
							N/A	N/A		
		MM0074-01	G	G	PC	500	0000297638 0000292833 0000300398	413 30 105		

Notes:

N/A

N/A

N/A

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① GS85 06 FEB 24

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Op. 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	05 Feb 24	KLS
	Line Clearance  Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	05 Feb 24	AF34 NK61 PM96 CL30 Y04
	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  Confirmation Reqd(Milestone )	Loading Braid Stock	500	0	05 Feb 24	VPGZ SXII ST96 NY35
250	CATASY01  Catheter Assembly 1    Trim Braid Wire at Proximal End		500	0	05 Feb 24	MY50 AS31 VO78

**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	0	05 Feb 24 WV25 LMU6 C032 G522	
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	05 Feb 24 CY97 SX117B D42C1 C105	
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
400	<b>CATASY01</b> Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone)	Reflow	500	0	05 Feb 24	AF54 NK62 pm96 SY47 SH85
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	05 Feb 24	AF54 pm96 SH85
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	500	0	05Feb24	VLG1 TRN AT39 JY90
	FEP Removal					
	Confirmation Reqd(Milestone )					
500	CATASY01  Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 87886 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	491	WT-11 VD-1 EW-11 DF-11 FM-11  ⑨	05Feb24	LLG1 VC09 TL66 SV46 TD45
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01  Catheter Assembly 1  	Remove Heat Shrink & Mandrel  Remove Heat Shrink & Mandrel  Confirmation Reqd(Milestone )	491	0	05Feb24 (JRN) MMO PP40	VA90 RS23 SV46 Y936 MMO PP40
600	CATASY01  Catheter Assembly 1  	Distal Tip Assembly  Distal Tip Assembly  Confirmation	484	7	05Feb24	FRO PH59 MW78 M260

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 )	484	0	05Feb24	Ax82 ML36
700	CATASY01 Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24  Tipping	484	0	05Feb24	Hv36 ML36
<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  	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4001-01 Batch #: 82460 Qty: N/A Part #: RM4007-01 Batch #: 71864 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	484	①	05Feb24	STX48 mm02 HT72
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	478	ACD-HH 1 ⑥	05Feb24	SS52 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
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  Confirmation Reqd(Milestone )	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>	478	0	SKV H O 06Feb24 ML65	KL67
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	0	06Feb24 SH04 ML4b	MU33

Notes:

N/A
N/A
N/A

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(1) RUGS 06Feb24



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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
21A	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: 0100-01 Cal Due: 31MAY24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: 1000-1153-01 Batch #: 87886 Qty: N/A</p> <p>Part #: RM4001-01 Batch #: 82461 Qty: N/A</p> <p>Part #: RM0607-01 Batch #: 71864 Qty: N/A</p> <p>Part #: RM0158-01 Batch #: 81054 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	41	ACD-11 DEL-HH1 DIS-LHHHH MAR-HHHHH HHHHH #9-05-11 #10S-111 #60S-LHH HHH #7-05-111 #5-45-1111 WK-1 WK-1 (67) EW-11	06Feb24	KL67 XL91 D429 KT47
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: 50713B Cal Due: 12APR24</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
N/A	 Quality Inspection & Review	<p>TMI: 50311 Cal Due: 31AUG24            Record DIM02 Go/No-Go Gage Information:            TMI: 0691 Cal Due: 30SEP25            TMI: 0692 Cal Due: 30SEP25            Record DIM02 Inspection Results N = 54:            Pass: 54 Fail: 0</p>	373	DIS(SP) HHH DIS - HHH HHH HHH HHH STR - IIII DU - I  (28)	06Feb24	KL67 XL91
1000	 QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone )	<p>Quality Inspection &amp; Review            Leak Test            Record Inspection Data in SAP ROS            Record Leak Tester Information:            TMI: 1056 Cal Due: 31MAY24            Record Length Gage Information:            TMI: 0889 D Cal Due: 30<sup>0</sup> 30SEP24            Record Calibrated Ruler Information:            TMI: 0629 Cal Due: 30SEP24</p>	373	LT-1HH HHH	06Feb24	KL67 XL91 SS4H

Notes:

N/A  
N/A  
N/A

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(1) KL67 05Feb24

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Opri 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    Quality Inspection & Review  Confirmation Reqd(Milestone )	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	350	SCR-101 (TT) FM-11 (T) DEI-III (T) DIS-10111 AB-11 FM-1 PB-1① SKV-1 VD-1 BP-1  23	06 Feb 24	XN26 SV43
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): GS85 06 FEB 24	N/A	N/A	06 Feb 24	GS85
Notes:						
N/A						
N/A						
N/A						

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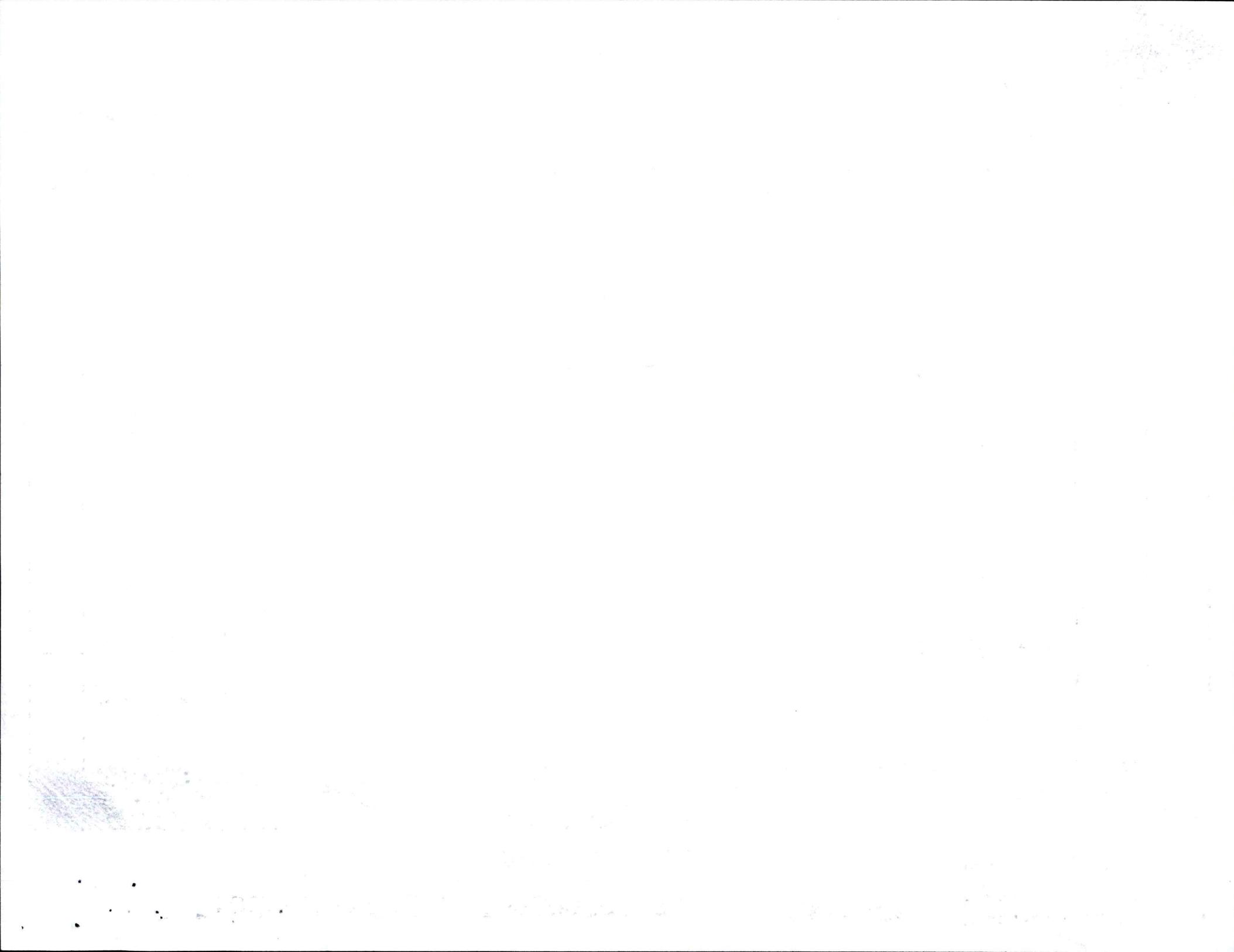
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① SV43 06 Feb 24

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Material: SA0155-01 Rev F

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	350	0	06Feb24	Vmy

Notes:

N/A

N/A

N/A

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Material: SA0155-01 Rev F

Batch Number: 0000302935

By: mmg7

Date: 06 Feb 24

Reviewed By:

RB-29

Date:

06 feb 24

Notes:

N/A

N/A

N/A

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Bills to 10/2024 10/2028 10/2023  
Ex-As to 19 Feb 2024 2028 10/2023  
**=TE**

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Extend to 22 Nov 2023 2028 10/2023  
Bills to 20 Dec 2023 2028 10/2023

10/2023

**=TE**

DEVIATION AUTHORIZATION NUMBER: 2484  
\* See attached email extension to 24 SEP 23  
TS12

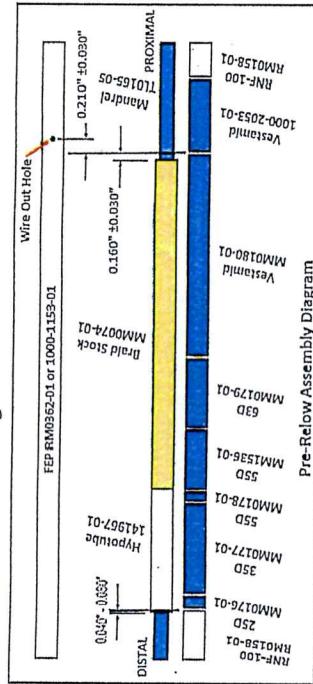
24 AUG 23 2023  
Extend to 23 Oct 2023 2028 10/2023

Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

**Deviation From:**

QIP3107610, Section 8.0 Inspection Requirements  
(Supplemental Visual Inspection) OP 1050;  
Current QIP3107610 does not state to inspect for the  
correct extrusion configuration.



**Deviation To:**

This DA allows addition inspection for correct assembly of  
extrusion material MM0179-01 and MM1536-01 during  
performing QIP3107610, Section 8.0 Inspection  
Requirements (Supplemental Visual Inspection) OP 1050.  
See instructions attached to this DA.

**Justification:** Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-26390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with out of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid incorrect assembly defects.

Part Number Affected	Revision
SA0155-01	H

Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

**Risk Assessment:**

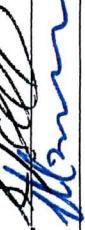
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:  
Control Plans  Yes  No FMEAs  Yes  No Validations  Yes  No Details (if any): N/A

If yes to any of the above, what controls are being put in place to mitigate the risk.

**Corrective Action Required:**  Yes  No

**If no, explain:** No corrective action is required for this event as there are no changes to the current process, consumption of material, or how the product is produced. This added inspection guidelines are to avoid incorrect extrusion assembly defects.

**Training Required:**  Yes  No **If no, explain:**

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

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① UK55, 23JW 2023

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**TE**

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)



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)

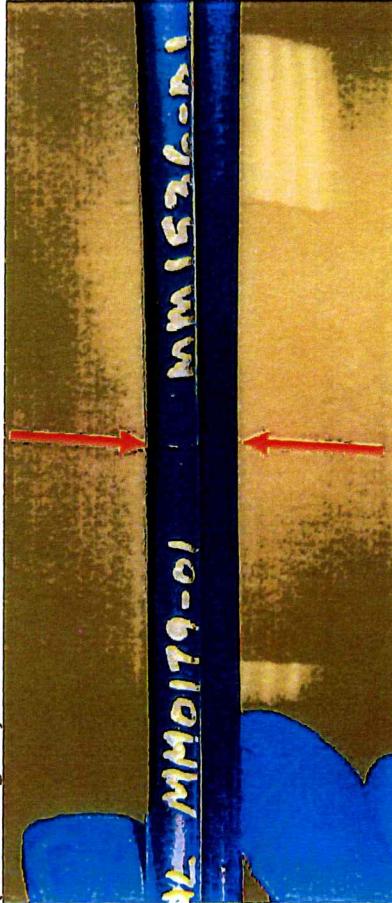


Image- 3

- 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)

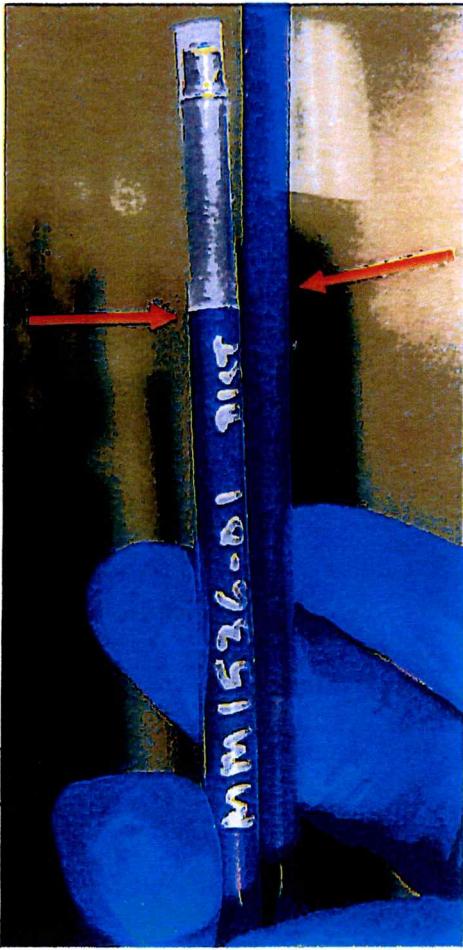


Image- 4

- 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.

<b>1</b>	MM0179-01  GOOD PART	MM1536-01
<b>2</b>	MM1536-01	MM0179-01  <b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>
<b>3</b>	MM0179-01  <b>Two MM0179-01 - BAD PART</b>	MM0179-01
<b>4</b>	MM1536-01  <b>Two MM1536-01 - BAD PART</b>	MM1536-01

Image - 5

Entered to **HMS** 1228 12/16/2023  
Entered to **13 Flex Commander** 1228 12/16/2023

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## DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<b>Doc #3005206 (Flex Commander MPI0238): 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>Doc #3005206 (Flex Commander MPI0238): 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.		
<b>Justification:</b> 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:		
16 Nov 23	15 DEC 23		
Lot Number:	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 checked="" type="checkbox"/> Yes <input 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			
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# 500000302935

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	9:35pm	428	V078	05 Feb 24	9:47pm	415	Sy47	05 Feb 24	16
Tm10745	44	10:15pm	429	V078	05 Feb 24	10:17pm	415	SA07	05 Feb 24	16
Tm10745	44	10:52pm	430	V078	05 Feb 24	11:04pm	415	V078	05 Feb 24	16

NIA  
V078 05 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000302935

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
JM10745	44	12:05pm	430	OS21	05Feb24	12:17pm	415	OS21	05Feb24	16
JM10745	44	1:30PM	430	OS21	05Feb24	1:42PM	415	OS21	05Feb24	16
JM10745	44	2:00PM	430	OS21	05Feb24	2:12PM	415	OS21	05Feb24	16
JM10745	44	2:25 PM	430	OS21	05Feb24	2:37PM	415	OS21	05Feb24	16
JM10745	44	3:05 PM	430	OS21	05Feb24	3:17PM	415	OS21	05Feb24	16
JM10745	44	4:15 PM	430	SY47	05Feb24	4:27PM	415	SY47	05Feb24	16
JM10745	44	4:30pm	429	SY90	05Feb24	4:52PM	415	SH85	05Feb24	16
JM10745	44	6:17pm	430	SH85	05Feb24	6:29pm	415	SH85	05Feb24	16
JM10745	44	6:49pm	430	CL30	05Feb24	7:01pm	415	SH85	05Feb24	16
JM10745	44	7:17 pm	430	CL30	05Feb24	7:29pm	415	CL30	05Feb24	16
JM10745	44	7:45pm	428	SH85	05Feb24	7:57pm	415	SH85	05Feb24	16
JM10745	44	9:12pm	430	V078	05Feb24	9:24pm	415	V078	05Feb24	16

(1)V078 05Feb24



PRODUCTION ORDER# 500000302935

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	9:00pm	430	V078	05 Feb 24	9:12pm	415	V078	05 Feb 24	16
Tm10942	44	9:23pm	428	Sy47	05 Feb 24	9:35pm	415	Sy47	05 Feb 24	16
Tm10942	44	9:50pm	428	Sy47	05 Feb 24	10:02pm	415	Sy47	05 Feb 24	16
Tm10942	44	10:30pm	430	Sy47	05 Feb 24	10:42pm	415	Sy47	05 Feb 24	16
Tm10942	44	10:56pm	426	V078	05 Feb 24	11:08pm	415	V078	05 Feb 24	4
				NIA	05 Feb 24					
				V078						



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000302935

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	12:25pm	430	0521	05Feb24	12:37pm	415	0521	05Feb24	16
Tm10942	44	1:45 pm	430	KL95	05Feb24	1:57pm	415	KL95	05Feb24	16
Tm10942	44	2:10 pm	430	KL95	05Feb24	2:22pm	415	KL95	05Feb24	16
Tm10942	44	2:45PM	430	0521	05Feb24	2:57PM	415	0521	05Feb24	16
Tm10942	44	4:08PM	430	SH85	05Feb24	4:15pm	415	SH85	05Feb24	16
Tm10942	44	4:31PM	428	SH85	05Feb24	4:43pm	415	SH85	05Feb24	16
Tm10942	44	4:45PM	429	SY47	05Feb24	4:57pm	415	SY47	05Feb24	16
Tm10942	44	5:08PM	430	SH85	05Feb24	5:20PM	415	SH85	05Feb24	16
Tm10942	44	6:30PM	430	SH85	05Feb24	6:42PM	415	SH85	05Feb24	16
Tm10942	44	7:05 PM	430	SH85	05Feb24	7:17PM	415	SH85	05Feb24	16
Tm10942	44	7:31PM	427	SH85	05Feb24	7:48PM	415	SH85	05Feb24	16
Tm10942	44	7:58PM	427	SH85	05Feb24	8:10PM	415	V078	05Feb24	16



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

PO #: 500000302935 OP #: 500 Shift #: 2nd

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	1	1
EH	Exposed Hypotube	N/A	N/A
EW	Exposed Wire		22
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	1	1
VD	Voids	1	1
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 05 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 #: 500000302935OP #: 500 Shift #: 2nd

Total Parts Reworked:		38	
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		23
MP	Micropores	n/a	n/a
SCR	Scratch		2
SKV	Skive Marks		4
VD	Voids		12
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Vannej Lor 05 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 #: 50000302935OP #: 500 Shift #: 2**Total Parts Reworked:**30

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	//	<u>2</u>
EH	Exposed Hypotube	////	<u>4</u>
EW	Exposed Wire	HH HHH HHH HHH HHH III	<u>28</u>
MP	Micropores	N/A	<u>0</u>
SCR	Scratch	N/A	<u>0</u>
SKV	Skive Marks	N/A	<u>0</u>
VD	Voids	N/A	<u>0</u>
N/A	N/A	N/A	<u>0</u>

**Inspected By (Sign and Date):**Con 05 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):

PO #: 500000302935OP #: 750 Shift #: 2

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		44	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		21
DIM07 US / WC	DIM07 Undersized (Window Closed)		13
EH	Exposed Hypotube		10
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 05 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 #: 50000302935OP #: 750 Shift #: 2<sup>nd</sup>.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		68	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		25
DIM07 US / WC	DIM07 Undersized (Window Closed)		8
EH	Exposed Hypotube		35
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	05 Feb 23

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# 500000302935

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	4:19pm	190F	SG88	05 Feb 24	5:29pm	190F	SG88	05 Feb 24	44
TM12036	N/A	5:18pm	190F	SG88	05 Feb 24	6:28pm	190F	SG88	05 Feb 24	40
TM10409	N/A	6:47pm	190F	SG88	05 Feb 24	7:57pm	190F	SG88	05 Feb 24	48
TM12036	N/A	7:24pm	190F	SG88	05 Feb 24	8:34pm	190F	SG88	05 Feb 24	45
TM10409	N/A	7:54pm	190F	SG88	05 Feb 24	9:04pm	190F	SG88	05 Feb 24	40
TM10409	N/A	9:21pm	190F	SG88	05 Feb 24	10:31pm	190F	SG88	05 Feb 24	48
TM12036	N/A	9:48pm	190F	SG88	05 Feb 24	10:58pm	190F	SG88	05 Feb 24	52
TM10409	N/A	10:38pm	190F	SG88	05 Feb 24	11:48pm	190F	SG88	05 Feb 24	51
TM12036	N/A	11:37pm	190F	SG88	05 Feb 24	12:47pm	190F	SG88	06 Feb 24	39
TM10409	N/A	12:15 AM	190F	SG88	06 Feb 24	1:25AM	190F	SG88	06 Feb 24	34
TM12036	N/A	12:46AM	190F	SG88	06 Feb 24	1:56AM	190F	SG88	06 Feb 24	35
				N/A						
				SG88	06 Feb 24					



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

PO #: 500000302935 OP #: 900 Shift #: 2

Total Parts Reworked:		32	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	11	2
EW	Exposed Wire	HT 111	8
MP	Micropores	N/A	N/A
SCR	Scratch	HT HT HT HT HT 1111	29
SKV	Skive Marks	N/A	N/A
VD	Voids	11	2
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	HT 72	
Inspected By (Sign and Date):		HT 72 05 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 #: 500000302935 OP #: 900 Shift #: 2nd

Total Parts Reworked:		80	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	0
EH	Exposed Hypotube	NA	0
EW	Exposed Wire		14
MP	Micropores	NA	0
SCR	Scratch		80
SKV	Skive Marks		6
VD	Voids		2
DIM01 US	DIM01 OD Undersized	NA	0
DIM06 US	DIM06 OD Undersized		1
DIM06 OS	DIM06 OD Oversized	NA	0
DIM09 US	DIM09 OD Undersized	NA	0
Inspected By (Sign and Date):		Mario	05 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 #: 500000302935

OP #: 900 Shift #: 2nd

Total Parts Reworked:		52	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		1
EW	Exposed Wire		12
MP	Micropores	N/A	0
SCR	Scratch		28
SKV	Skive Marks		1
VD	Voids		1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		19
DIM06 OS	DIM06 OD Oversized		2
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 05 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 #: 500000302935 OP #: 900 Shift #: 1ST

Total Parts Reworked:		36	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube		1
EW	Exposed Wire		10
MP	Micropores		N/A
SCR	Scratch		15
SKV	Skive Marks		N/A N/A
VD	Voids		3
DIM01 US	DIM01 OD Undersized		N/A N/A
DIM06 US	DIM06 OD Undersized		4
DIM06 OS	DIM06 OD Oversized		N/A N/A
DIM09 US	DIM09 OD Undersized		N/A N/A
Inspected By (Sign and Date):		K155 D429 K147 P446 06 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	24.7	28	25.3	25.58	26.16	26.45	24.79	26.38	26.21	27.17	26.074	1.030169	4.378	21.5639186	8.542	PASS
Seg B	65.01	66.26	65.02	64.23	69.29	63.95	67.43	65.3	65.58	60.93	65.3	2.203124	3.981	56.5293632	8.542	PASS
Seg C	84.89	85.74	80.85	86.09	74.66	84.89	84.17	83.49	84.56	86.02	83.536	3.474799	2.911	73.4208607	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 #: 500000302935

Date: 06 Feb 24

Inspector Name: Javier Olivares

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

J001 06 feb 24