

Production Order: 500000304682



Production Order Document
Production Order Qty: 500
PC

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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  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>GSB 9:00 AM 07 Feb 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XC31 6:40PM 08 Feb 24</u> Record Dryer Shelf #: <u>N/A</u></p> <table border="1"> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev Used</th> <th>UOM</th> <th>Qty.</th> <th>Batch No.</th> <th>Actual Qty Used</th> </tr> </thead> <tbody> <tr> <td>MM0179-01</td> <td>D <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000294700</u></td> <td><u>500</u> <u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000290560</u></td> <td><u>500</u> <u>N/A</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u> <u>N/A</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u> <u>N/A</u>	N/A	N/A	06 feb 24 N/A
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u> <u>N/A</u>																		
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u> <u>N/A</u>																		

Notes: DA2564, 2484

N/A

N/A

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N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u> <u>81054</u>	<u>N/A</u> <u>167</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>87894,87905</u> <u>878906,88073</u>	<u>N/A</u> <u>200,200</u> <u>100,100</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>00002875413</u>	<u>500</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>N/A</u> <u>0000288401</u>	<u>N/A</u> <u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>06Feb24</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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① 87905 ② KP02 12Feb24

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N/A	N/A	141967-01	02	02	PC	500	85502	511			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82869	500			
							82872	100			
		RM7348-01	C	C	PC	500	85677	500			
							N/A	N/A			
		RM4001-01	B	B	PC	125	82804	100			
							N/A	N/A			
		RM0607-01	D	D	PC	56	6 02/06/2024 N/A	N/A			
							74663	81			
		RM0498-01	C	C	PC	500	0000287647	500			
							N/A	N/A			
		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
N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>N/A</u>	<u>Bulk</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>00002910562</u>	<u>500</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>00002914697</u>	<u>500</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>16 feb 24</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>00002910565</u>	<u>500</u>	<u>N/A</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>	<u>N/A</u>		
		MM0074-01	G	<u>b7</u>	PC	500	<u>0000292833</u>	<u>516</u>	<u>45</u>		
							<u>0000290896</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
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	09Feb24	V078
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	09Feb24	Y014 SH05 SH23 CL30 TRH YK40 SP34
	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	500	0	09Feb24	ST96 DX35 MV50 MC17
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	09Feb24	AS31 V078 CD19 RL97 P467
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)	Insert Cut Hypo Tube	500	0	09Feb24	NY39 GS22 AJ65 PL22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	09Feb24	CL05 AT39 AL67 CD19 BD64
Notes: N/A N/A N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	09Feb24	CL30 Sy47 AV16 SN47
450	CATASY01 Catheter	FEP Removal	500	0	09Feb24	JY90 OS21 AM47
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 FEP Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Confirmation Reqd(Milestone)	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 87894 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	493	EW-1111 DF-111 7	09 Feb 24	V/L91 PP40 T266 TD45 LS46 PH59 AR02
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes: 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	493	0	09Feb24	Y936 SV46 MH10 SC10
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	486	DL-111 MAS-111 7	09Feb24	ML60 MV78 PT09 AB39

Notes:

NA

N/A

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 Loading Heat Shrink Confirmation Reqd(Milestone)	Loading Heat Shrink	484	0	09Feb24	AT39 ML38 LH45 AT39
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0521</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>0936A</u> Cal Due: <u>31 May 24</u>	484	0	09Feb24	ML38 DC83

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 #: RM4001-01 Batch #: 82804 Qty: N/A Part #: RM0607-01 Batch #: 74663 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-111 	09Feb24	Nmo2 1560 SL83
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		478	ACD-111 	09Feb24	SG88 ALUZ TRN BD64

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1 	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	478	0	09Feb24	ML65 ALU2 TRN
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 HT72 SH94 DL07
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:</p> <p>TMI: 0700-01 Cal Due: 31MAY24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: 1000-153-01 Batch #: 87894 Qty: N/A</p> <p>Part #: RM4001-01 Batch #: 82804 Qty: N/A</p> <p>Part #: RM0606-N Batch #: N/A Qty: N/A</p> <p>Part #: RM0607-01 Batch #: 74663 Qty: N/A</p> <p>Part #: RM0158-01 Batch #: 81054 Qty: N/A</p>	441	MAR-HHII #105-11 DEL-HFSP SKV-II EW-II DIS-HK HK #90S-1 #5US-1 37	09Feb24	KL67 Y936
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: 50113-B 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: 0733 Cal Due: 30APR24 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>	 439	 STR-11 #10s-1	09Feb24	KL67 Y936 0321
1000	 Quality Inspection & Review	<p>Quality Inspection & 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: 30SEP24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30SEP24</p>	433	 FT-111	09Feb24	KL67 Y936 BD64

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	397	SCR-III (T) FM-III (T) DIS-III (T) SCR-II STN-I DT-I VD-III BP-II FM-II PBC-II CRK-II (36)	09 Feb 24	SV43 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02 12 Feb 24</u>	N/A	N/A	12 Feb 24	KP02

Notes:

N/A
N/A
N/A

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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	397	O 12 Feb 24	AP10 12 Feb 24	AP10

Notes:

N/A AP10 12 Feb 24

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Batch Number: 0000304682

By: AP10

Date: 12 Feb 24

Reviewed By:

RB29

Date:

13 Feb 24

Notes:

N/A AP10 12 Feb 24

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is part of **EXTEND to 20-Nov-2023** **528** **POSTS**

Requestor Name: Udhesh Kapadnis

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DEVIATION FORM B747-2 to 23 OCT 2023 **DEVIATION NUMBER:** 2484
* See attached email extension to 24 SEP 2023
1512
24 AUG 23

DEVIATION AUTHORIZATION NUMBER: 2484
See attached email extension to 2484 SEP 22

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24 AUG 23 524
2304 3223 152

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CONTROLLED COPY

DEVIATION AUTHORIZATION NUMBER: 2484

* See attached email extension to 32

150

24 AUG 23 524
2304 3223 152

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DEVATI A
Date to 2023

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.

Justification: Recently, it has been shown that

Nonconformance. 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

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 FMEA's 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

Comments Action Requests

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 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 **MM0179-01** **MM1536-01** **Type Connection TS12** 10AUG23

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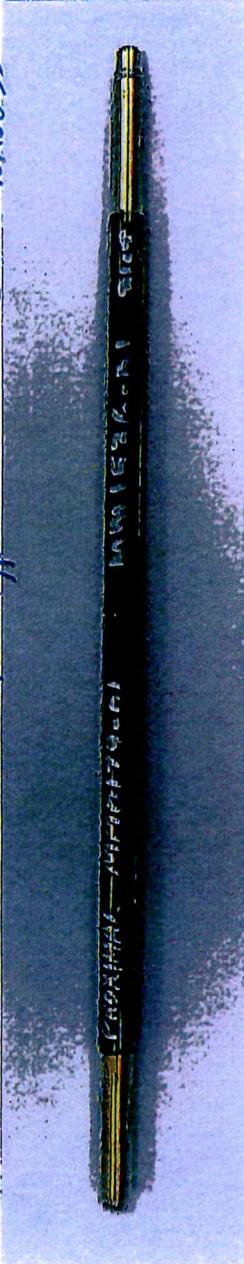


Image- 1

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)

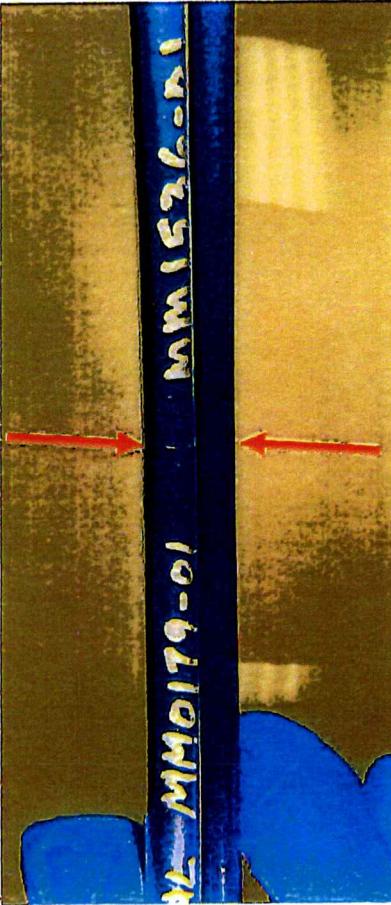


Image- 3

- 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)

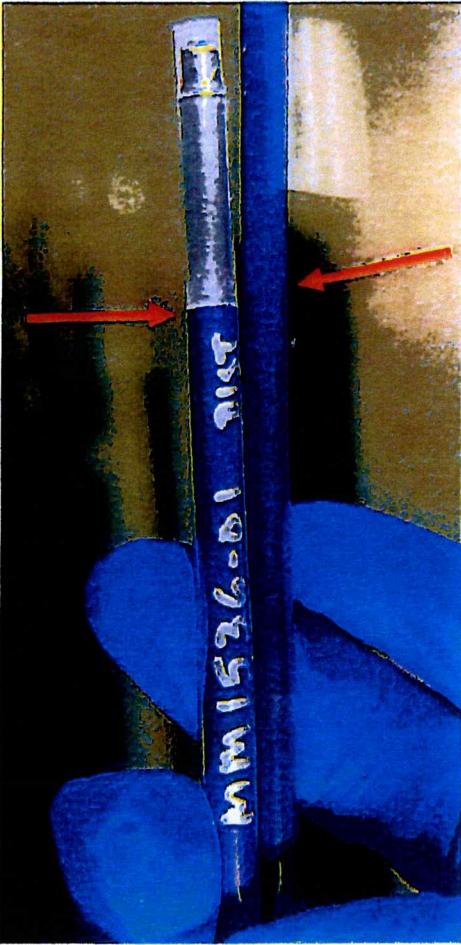


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

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

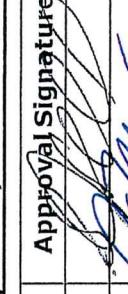
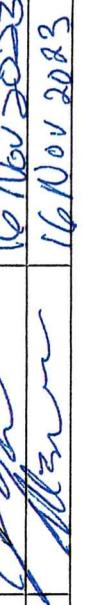
Image - 5

Entered to Hansa 3228 12/16/2023
Entered to 13 Feb 2024 3228 V/A/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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is part of
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DEVIATION AUTHORIZATION FORM

Requestor Name:	Krishna Selvaraj		
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
Doc #3005206 (Flex Commander MPI0238): OPER850.11:	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.			
Justification:	TM10602 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. TM10700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TM10700-01 is already qualified to inspect Dim 6 per ES0647: Laser micrometer equivalency test, there is no additional risk in using TM10700-01 for OPER850 Dim 6 inspection till TM10602 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 checked="" type="checkbox"/> No		
If no, explain: This is a temporary change to use TM10700-01. DA will be removed once the lasermic TM10602 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#: 500000304682

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	7:35pm	430	CL30	08Feb24	7:47pm	415	JY90	08Feb24	16
TM10745	44	7:55pm	428	Sy47	08Feb24	8:07pm	415	AT39	08 Feb24	16
TM10745	44	9:00pm	430	AT39	08 Feb24	9:12pm	415	② AT39 9:12pm	① 08 Feb24 ② 08R	16
TM10745	44	9:20pm	429	Sy47	08Feb24	9:32pm	415	Sy47	08Feb24	16
TM10745	44	9:47pm	429	SH85	08Feb24	9:59pm	415	SH85	08Feb24	16
TM10745	44	10:14pm	429	SH85	08Feb24	10:26pm	415	SH85	08Feb24	16
TM10745	44	10:52pm	430	SH85	08Feb24	11:04pm	415	AT39	08Feb24	16
TM10745	44	11:40pm	430	Sy47	08Feb24	11:52pm	415	Sy47	08Feb24	16
TM10745	44	12:12Am	429	Sy47	09Feb24	12:24AM	415	Sy47	09Feb24	16
TM10745	44	12:40AM	429	Sy47	09Feb24	12:52AM	415	Sy47	09Feb24	16
TM10745	44	1:17AM	430	Sy47	09Feb24	1:29AM	415	Sy47	09Feb24	16
TM10745	44	1:50AM	430	V078	09Feb24	2:02AM	415	V078	09Feb24	16

① SH85 08Feb24
② AT39 08 Feb24



PRODUCTION ORDER#: 560000304682

OP 400

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

① CBS58 09 Feb 24



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

PRODUCTION ORDER# 500000304682

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	7:30pm	430 415①	AT39	08Feb24	7:42PM	415	AT39	08Feb24	16
TM10942	44	8:47pm	430	AT39	08Feb24	8:52PM	415	AT39	08Feb24	16
TM10942	44	9:13pm	430	SH85	08Feb24	9:25pm	415	SH85	08Feb24	16
TM10942	44	9:32pm	427	SH85	08Feb24	9:44pm	415	SH85	08Feb24	16
TM10942	44	9:58pm	428	SH85	08Feb24	10:10pm	415	SH85	08Feb24	16
TM10942	44	10:37pm	430	SH85	08Feb24	10:49pm	415	SH85	08Feb24	16
TM10942	44	11:55pm	430	JY90	08Feb24	12:07AM	415	JY90	09Feb24	16
TM10942	44	12:30AM	430	JY90	09Feb24	12:42AM	415	JY90	09Feb24	16
TM10942	44	1:00AM	429	JY47	09Feb24	1:12AM	415	JY47	09Feb24	16
TM10942	44	1:30 AM	428	JY90	09Feb24	1:42 AM	415	JY90	09Feb24	16
TM10942	44	6:30 am	430	OS21	09Feb24	6:42am	415	OS21	09Feb24	16
TM10942	44	7:10am	430	OS21	09Feb24	7:22am	415	OS21	09Feb24	16

① AT39 08Feb24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000304682

OP 400

① CBS8 09 Feb 24



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000304682OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>19</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>N/A</u>
EH	Exposed Hypotube	<u>N/A</u>	<u>N/A</u>
EW	Exposed Wire	<u> </u>	<u>12</u>
MP	Micropores	<u>N/A</u>	<u>N/A</u>
SCR	Scratch	<u>//</u>	<u>2</u>
SKV	Skive Marks	<u>N/A</u>	<u>N/A</u>
VD	Voids	<u> </u>	<u>7</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
Inspected By (Sign and Date):		<u>Vanneej Lor 08 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 #: 50000304682OP #: 500 Shift #: 2**Total Parts Reworked:**20

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	//	2
EW	Exposed Wire		18
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):

08 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 #: 500000304692 OP #: 500 Shift #: 2nd

Total Parts Reworked:		28	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	/	/
EW	Exposed Wire		21
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids		6
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		PP40 08 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 #: 500000304682

OP #: 500 Shift #: 3

Total Parts Reworked:		74	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		4
EH	Exposed Hypotube	4	① 15 15
EW	Exposed Wire	4 4 4	40
MP	Micropores	N/A	N/A
SCR	Scratch		10
SKV	Skive Marks	N/A	N/A
VD	Voids		5
N/A	N/A	N/A	N/A

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

Data Uploaded for Engineering Review (Check):

① PY 46 12 Feb 24
Signed for LS40



PO #: 500001304682

OP #: 750 Shift #: 2nd

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		39	
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)		7
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Mmo2	08 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 #: 500 000 304682 OP #: 750 Shift #: 3

Total Parts Reworked:		27	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		7
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		10
GD	Glue Damage		5
Inspected By (Sign and Date):		IC83	09 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 #: 500000304682

OP #: 750 Shift #: 3

Total Parts Reworked:		31	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		5
DIM07 US / WC	DIM07 Undersized (Window Closed)		1
EH	Exposed Hypotube		3
GD / AB	glue damage/ air bubbles		18
Inspected By (Sign and Date):		BIGO	09 FEB 2024

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# 500000304682

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	10:06PM	190F	SG88	08Feb24	11:16PM	190F	SG88	08Feb24	36
TM10409	N/A	11:21PM	190F	SG88	08Feb24	12:31AM	190F	SG88	09Feb24	32
TM12036	N/A	11:53PM	190F	SG88	08Feb24	1:03AM	190F	SG88	09Feb24	35
TM10409	N/A	12:36AM	190F	SG88	09Feb24	1:46AM	190F	SG88	09Feb24	45
TM10409	N/A	06:15AM	190F	AL42	09FEB24	07:25AM	190F	AL42	09FEB24	72
TM12036	N/A	07:00AM	190F	AL42	09FEB24	08:10AM	190F	AL42	09FEB24	24
TM10409	N/A	7:28 AM	190F	AL42	09FEB24	8:38 AM	190F	AL42	09FEB24	26
TM12036	N/A	8:45 AM	190F	AL42	09FEB24	9:55 AM	190F	AL42	09FEB24	47
TM10409	N/A	9:40AM	190F	BD64	09Feb24	10:50AM	190F	BD64	09Feb24	32
TM12036	N/A	10:00AM	190F	AL42	09Feb24	11:10 AM	190F	AL42	09Feb24	32
TM10409	N/A	10:51AM	190F	AT39	09Feb24	12:01PM	190F	AT39	09Feb24	40
TM12036	N/A	11:15 AM	190F	AL42	09Feb24	12:25 PM	190F	AL42	09Feb24	22
TM10409	N/A	12:03 PM	190F	AL42	09Feb24	1:12 PM	190F	SS44	09Feb24	35



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

PO #: 500000304682 OP #: 900 Shift #: 2nd

Total Parts Reworked:			
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	1	1
EW	Exposed Wire	1	1
MP	Micropores	N/A	0
SCR	Scratch		13
SKV	Skive Marks	1	1
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	N/A	0
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Joe H 08 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 #: 500000304682 OP #: 900 Shift #: 2

Total Parts Reworked:		17	
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		7
MP	Micropores	N/A	N/A
SCR	Scratch		19
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized	N/A 08Feb24	
DIM06 OS	DIM06 OD Oversized	HT12	
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT12 08Feb24	

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 #: 500000304682

OP #: 900 Shift #: 3

Total Parts Reworked:		124	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		6
EH	Exposed Hypotube		14
EW	Exposed Wire		53
MP	Micropores	N/A	N/A
SCR	Scratch		84
SKV	Skive Marks		9
VD	Voids		27
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		9
DIM06 OS	DIM06 OD Oversized		5
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		DL07, MV33	09Feb24

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	31.33	26.41	25.96	24.24	32.17	28.04	31.15	22.47	27.27	28.64	27.768	3.1660413	4.378	13.907071	8.542	PASS
Seg B	67.68	76.12	75.1	76.01	65.82	72.59	70.76	71.6	71.98	72.19	71.985	3.3598818	3.981	58.6093106	8.542	PASS
Seg C	77.43	89.97	87.07	88.83	71.78	81.05	88.8	88.69	89.97	88.55	85.214	6.2913701	2.911	66.8998216	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

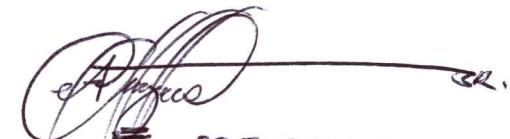
LOT #: 500000304682

Date: 09FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



09 FEB 2024