

Production Order: 500000295350



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

Material: SA0155-01 Rev F

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

Order Type: ZSTD

Project Phase:

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>XC31 9:30AM 10JAN24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 7:45am 11 Jan 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>0006276172</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0006281412</u> <u>0000271063</u></td> <td><u>500</u> <u>25</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>0006276172</u>	<u>500</u>	MM1536-01	B <u>B</u>	PC	500	<u>0006281412</u> <u>0000271063</u>	<u>500</u> <u>25</u>	<u>N/A</u>	<u>N/A</u>	<u>KL27</u> <u>10JAN24</u>
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>D</u>	PC	500	<u>0006276172</u>	<u>500</u>																		
MM1536-01	B <u>B</u>	PC	500	<u>0006281412</u> <u>0000271063</u>	<u>500</u> <u>25</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	N/A	141967-01	02	02	PC	500	85500	418		
		RM7349-02	C	C	PC	543	82899 83433 82567 83425 82568 82882 82883	91 50 133 50 345 12 150 050 4150		
		RM7348-01	C	C	PC	500	82566 82882 82883	150		
		RM4001-01	B	B	PC	125	82695	n/a		
		RM0607-01	D	D	PC	56	82101 74662	100 60		
		RM0498-01	C	C	PC	500	0000275489 0000287640	n/a n/a 3723610	n/a n/a n/a	n/a n/a n/a
		RM0009-04	I	I	PC	1	82971 n/a	100 Bulk Bulk		
		RM0009-04	I	I	PC	1	82971	Bulk		

Notes:

N/A
N/A
N/A

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① Am 68 12 Jan 24

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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>58497</u>	<u>N/A</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>87233</u>	<u>N/A</u>		
							<u>87232</u>	<u>200</u>		
							<u>87100</u>	<u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000276175</u>	<u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</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>		
							<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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Opn 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>0000278970</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000281413</u>	<u>1,000</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0180-01	E	<u>E</u>	PC	500	<u>0000252923</u>	<u>30</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000276174</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0074-01	G	<u>G</u>	PC	500	<u>0000281411</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>

Notes:

N/A

N/A

N/A

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Opr. No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	11Jan24	KL95
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	11Jan24	pm96 NK62 AX05 CL30 Y014
	Major and Minor Mandrel Assembly					
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock Loading Braid Stock Confirmation Reqd(Milestone)	500	0	11Jan24 NY35	MV50 CY97 ST96
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	11Jan24	SX11 CY97 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)	Insert Cut Hypo Tube	500	0	11Jun24	VP62 LM46 SH23 AT39
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	11Jan24	VV25 LM46 CP32 AT39

Notes:

N/A

N/A

N/A

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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	11Jan24 pm96 RN27 AF54 SX60 SF85	
450	CATASY01 Catheter	FEP Removal	500	0	11Jan24	pm96
Notes:						
N/A						
N/A						
N/A						

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	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 #: 87109 Qty: 12 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 Part #: N/A Batch #: N/A Qty: N/A	477	EW - HHT HHT-HHT III OF - I SKND-II EH-II (23)	11Jan24	LL61 VC09 CB81 TA36 D66 DX33 MM02 TD415
N/A	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
N/A	N/A	N/A N/A N/A N/A	N/A	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)	477	0	11Jun24	PL34 RS23 SV46
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	448	MAH-III OF- I IBL - I DL-III II DF-II MAS-III HTT III EH-4 (29)	11Jun24	VA96 CL05

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	448	0	11 Jan 24	DV39 ML38
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0936A</u> Cal Due: <u>31 May 24</u> TMI: <u>2083C</u> Cal Due: <u>31 May 24</u> TMI: <u>0521</u> Cal Due: <u>31 May 24</u> TMI: <u>0386</u> Cal Due: <u>31 May 24</u>	448	0	11 Jan 24	KT47 Hv36 ML38
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
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 #: DM4001-01 Batch #: 82095 Qty: 8 Part #: DM4007-01 Batch #: 74662 Qty: 4 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	448	0	11 Jan 24	STX48 Hv36 PP40
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	439	ACD=HTT 111 ⑨	11 Jan 24	SS44 F552 ML65 XL91
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	N/A	N/A	N/A	N/A	N/A
	Confirmation Reqd(Milestone)					
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>	439	N/A	11 Jan 24	SS52 Y936
	Cut to Length					
	Confirmation Reqd(Milestone)					
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	SH04 ML65 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
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: 31 May 24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: RM4001-01 Batch #: 82095 Qty: 5</p> <p>Part #: RM0607-01 Batch #: 74462 Qty: 3</p> <p>Part #: RM0158-01 Batch #: 85497 Qty: 2</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	408	(SP) DIS-4H SCR 1 60S-4H1 #5/US-11. #70S-111 #90S-11 #9US-1 Del-1111 DIS-111 #10S-1 DS-1 MAR-11 (31)	11 Jan 24	XLA1 KL67 PP40
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: N/A Cal Due: N/A</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: <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 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>	378	DIS- #### Str- ####	11 Jan 23 11 Jan 24	XL91 KL67
1000	 QUALITY1 Quality Inspection & Review 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>0889D</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u>		369	LT- ####	11 Jan 24	SS44 XL91 KL67

Notes:

N/A

N/A

N/A

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(1) 11 Jan 24 XL91



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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	331	EH - 2 EW - 16 DL - 16 VD - 1 DIS - 3 DEL - 1(T) SCR - 3(T) DISC - 1 PBC - 1 DL - 6 (38) TT - 4	13Jan24	SV43 XN26 YK95
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>AM 68 12 Jan 24</u>	N/A	N/A	N/A	N/A

Notes:

N/A
N/A
N/A

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① 16 Jan 24 KK83

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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	331	0	16 Jan 24	BA71

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Batch Number: 0000795350

By: BA71

Date: 16 Jan 24

Reviewed By:

RB29

Date:

16 JAHZ4

Notes:

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Beta to 2024 3208 1/1/23



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Extend to 2023 3208 1/1/23
Beta to 2023 3208 1/1/23

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** See added email extension to MSEPs*

TSI2
24 AUG 23 3208
2023

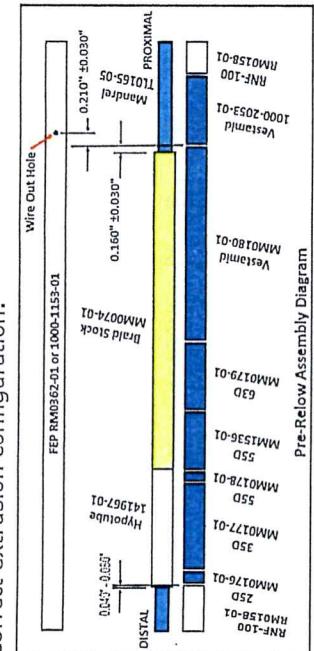
2023

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	End Date:	Revision
SA0155-01	25 Aug 2023	H 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.

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:**

① UK55, 23JW 2023

①	TE	DA	2484 2468
CREGANNA MEDICAL is part of	①		

Group Training Record

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)
①MM0179-01 *10AUG-23* *512* *typo correction*



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)

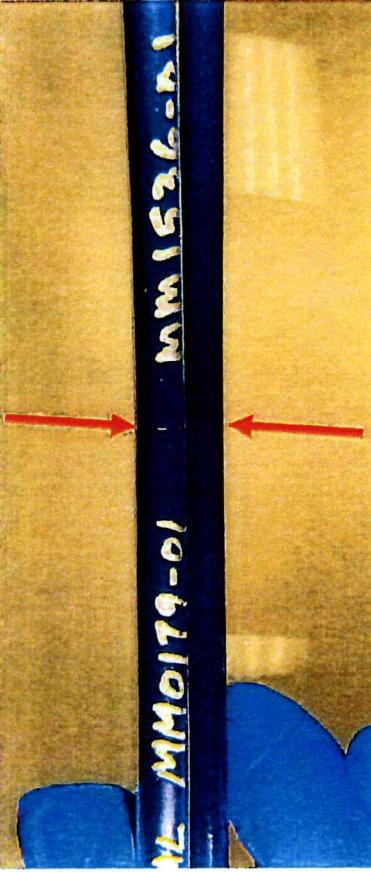


Image- 3

- 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)

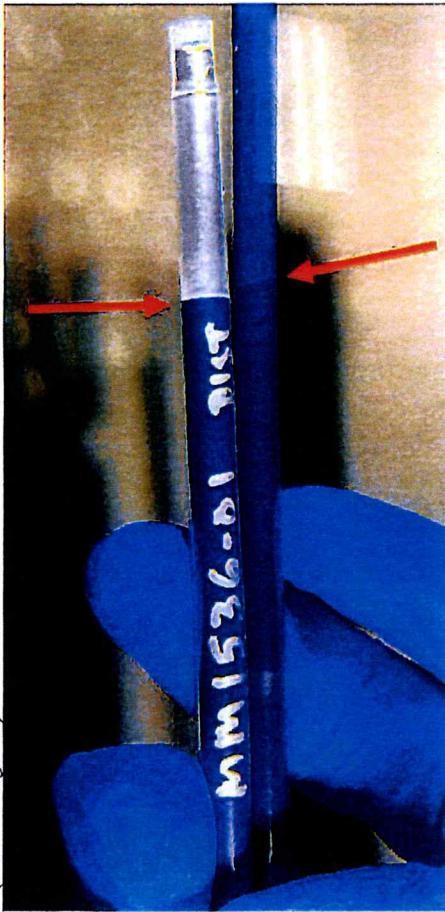


Image- 4

- 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 Two MM0179-01 - BAD PART	MM0179-01
4	MM1536-01 Two MM1536-01 - BAD PART	MM1536-01

Image - 5

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)

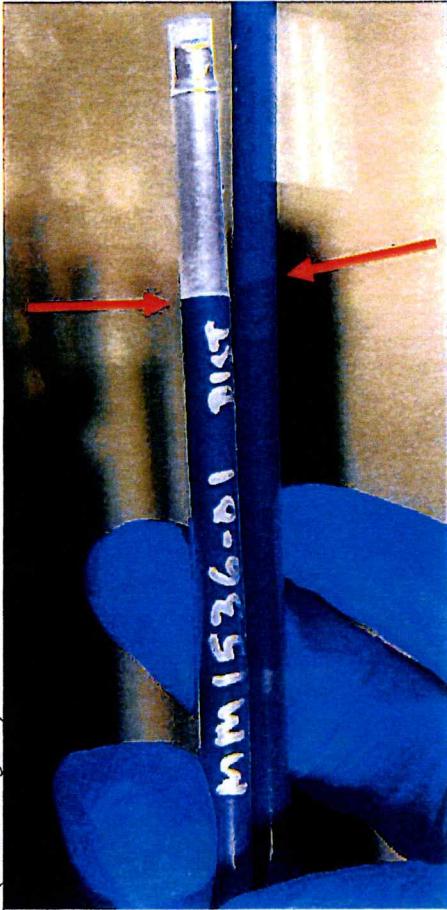


Image- 4

- 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

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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Entered to Hanush 3228 12/12/2023

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MEDICAL
is part of
TE
Technology

DEVIATION AUTHORIZATION NUMBER: DA2564

CONTROLLED COPY

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:
<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:

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:
16 Nov 23	15 DEC 23
Lot Number: N/A	

Risk Assessment:

Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:
 Control Plans 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 – N/A

Corrective Action Required:

Yes 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:

Yes 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# 50000295350

OP 400



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

PRODUCTION ORDER# 500000295350

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	8:55am	430	AF54	11Jan24	9:07am	415	AF54	11Jan24	16
Tm10942	44	9:30am	430	AF54	11Jan24	9:42am	415	AF54	11Jan24	16
Tm10942	44	10:00am	430	OS21	11Jan24	10:12am	415	OS21	11Jan24	16
Tm10942	44	10:59am	430	AX05	11Jan24	11:11am	415	AX05	11Jan24	16
Tm10942	44	11:40am	430	AX05	11Jan24	11:52am	415	AX05	11Jan24	16
Tm10942	44	12:30pm	430	AX05	11Jan24	12:42pm	415	AX05	11Jan24	14
Tm10942	44	1:35pm	430	AX05	11Jan24	1:47pm	415	AX05	11Jan24	16
Tm10942	44	2:20pm	430	AX05	11Jan24	2:32pm	415	AX05	11Jan24	16
Tm10942	44	4:27pm	430	SH85	11Jan24	4:39pm	415	SH85	11Jan24	16
Tm10942	44	4:58pm	429	SH85	11Jan24	5:10pm	415	SH85	11Jan24	16
Tm10942	44	5:30pm	428	V078	11Jan24	5:42pm	415	SH85	11Jan24	16
Tm10942	44	6:20pm	430	SH85	11Jan24	6:32pm	415	SH85	11Jan24	16



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OP 400



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Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#: 500000295350

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	8:40am	430	AF54	11Jan24	8:52am	415	AF54	11Jan24	16
Tm10745	44	8:45am	430	OS21	11Jan24	9:32am	415	OS21	11Jan24	16
Tm10745	44	9:42am	430	AF54	11Jan24	9:53am	415	AF54	11Jan24	16
Tm10745	44	10:20am	430	OS21	11Jan24	10:32am	415	OS21	11Jan24	10
Tm10745	44	11:20am	430	AX05	11Jan24	11:32am	415	AX05	11Jan24	16
Tm10745	44	11:55am	430	AX05	11Jan24	12:07PM	415	AX05	11Jan24	16
Tm10745	44	12:20PM	428	AX05	11Jan24	12:32PM	415	AX05	11Jan24	16
Tm10745	44	1:45PM	430	NK62	11Jan24	1:57PM	415	NK62	11Jan24	16
Tm10745	44	2:00PM	428	AX05	11Jan24	2:12PM	415	NK62	11Jan24	16
Tm10745	44	2:40PM	430	AX05	11Jan24	2:52PM	415	AX05	11Jan24	16
Tm10745	44	3:00PM	430	AF54	11Jan24	3:12PM	415	AF54	11Jan24	16
Tm10745	44	4:06pm	430	SX60	11Jan24	4:18pm	415	SHT85	11Jan24	16

① AF54 11 Jan 24



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

PO #: 500000295350

OP #: 500 Shift #: 1st

Total Parts Reworked:		70	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		7
EW	Exposed Wire		① 58 68
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		1
VD	Voids		12
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB81, LL61, VC09	11 Jan 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 CB81 11 Jan 24



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

PO #: 500000295350

OP #: 500 Shift #: 2nd

Total Parts Reworked:		5	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	PP40 11 Jan 24	N/A
EH	Exposed Hypotube		
EW	Exposed Wire	HH	5
MP	Micropores		
SCR	Scratch		
SKV	Skive Marks	N/A PP40 11 Jan 24	
VD	Voids	PP40 11 Jan 24	
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		PP40 11 Jan 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 #: 50000295350 OP #: 500 Shift #: 2nd.

Total Parts Reworked:		27	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube		2
EW	Exposed Wire		5
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks	N/A	N/A
VD	Voids		4
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		m02	11 Jan 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 #: 50000295350 OP #: 500 Shift #: 2

Total Parts Reworked:		44	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	0
EH	Exposed Hypotube	///	3
EW	Exposed Wire		43
MP	Micropores	/	0
SCR	Scratch	/	0
SKV	Skive Marks	/	0
VD	Voids	/	1
N/A	N/A	/	0
Inspected By (Sign and Date):		CJL	11 Jan 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 #: 500000295350

OP #: 500 Shift #: 2

Total Parts Reworked:		22	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube		3
EW	Exposed Wire		16
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): DX35 11 Jan 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 #: 500000295350

OP #: 750 Shift #: 1st

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		4
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		6
N/A	Glue, Stopper		10
Inspected By (Sign and Date):		Hv36 11 Jan 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 #: 500000295350OP #: 750 Shift #: 2nd

Document No: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		27	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		12
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	11Jan24

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 #: 500000295350

OP #: 750 Shift #: 2

Total Parts Reworked:		28	
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		22
N/A	N/A	N/A	0
Inspected By (Sign and Date):		DX35 11 Jan 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):

PRODUCTION ORDER# 500000295350

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	1:40pm	190F	SS44	11Jan24	2:50pm	190F	SS44	11Jan24	20
TM12036	N/A	2:10pm	190F	SS44	11Jan24	3:20pm	190F	SS44	11Jan24	30
TM10409	N/A	3:01pm	190F	SS52	11Jan24	4:11pm	190F	SG88	11Jan24	36
TM10409	N/A	4:30pm	190F	SG88	11Jan24	5:40pm	190F	SG88	11Jan24	37
TM12036	N/A	5:03pm	190F	SG88	11Jan24	6:13pm	190F	SG88	11Jan24	32
TM10409	N/A	6:17pm	190F	SG88	11Jan24	7:27pm	190F	SG88	11Jan24	32
① TM12036 TM10409	N/A	6:54pm	190F	SG88	11Jan24	8:04pm	190F	SG88	11Jan24	33
TM10409	N/A	7:30pm	190F	SG88	11Jan24	8:40pm	190F	AT39	11Jan24	30
TM10409	N/A	8:41pm	190F	AT39	11Jan24	9:51pm	190F	AT39	11Jan24	25
TM10409	N/A	9:52pm	190F	AT39	11Jan24	11:02pm	190F	AT39	11Jan24	31
TM12036	N/A	10:05pm	190F	AT39	11Jan24	11:15pm	190F	AT39	11Jan24	43
TM10409	N/A	10:40pm	190F	AT39	11Jan24	11:50pm	190F	AT39	11Jan24	36
TM12036	N/A	11:14pm	190F	AT39	11Jan24	12:26AM	190F	AT39	12Jan24	33

① SG88 11 Jan 24

② CBS8 12 Jan 24

PRODUCTION ORDER# 500000295350

OP 800



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000295350 OP #: 900 Shift #: 2nd

Total Parts Reworked:		90	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		6
EW	Exposed Wire		10
MP	Micropores	N/A	0
SCR	Scratch		77
SKV	Skive Marks	N/A	0
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized		9
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		PP40, See H 11 Jan 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 #: 500000295350 OP #: 900 Shift #: 2

Total Parts Reworked:		68	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire		16
MP	Micropores	N/A	N/A
SCR	Scratch		64
SKV	Skive Marks	N/A	N/A
VD	Voids		10
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		1
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		HT72 11 Jan 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):

4

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	28.49	27.75	28.18	25.25	24.93	30.06	28.45	30.01	27.1	27.68	27.79	1.7088007	4.378	20.3088703	8.542	PASS
Seg B	60.56	61.92	57.4	59.36	61.12	63.27	63.08	63.18	67.99	61.26	61.914	2.8187751	3.981	50.6924561	8.542	PASS
Seg C	78.96	78.72	78.89	78.1	76.94	79.78	77.04	80.68	78.06	79.21	78.638	1.1564005	2.911	75.271718	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 #: 500000295350

Date: 16JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI03118

Cal Due Date: 27 OCT 24

 16 Jan 24