

# Production Order: 500000306368



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>KP02 3:39pm 11Feb24</u>            Record Time Extrusions First Exit Dryer (Initial/Time/Date):  <u>KP02 2:00pm 13Feb24</u>            Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	08FEB24	BV57

Notes: DA 2484, 2564.

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
<i>N/A</i>	<i>N/A</i>	RM0158-01	E	<u>E</u>	PC	200	<u>88018</u>	<u>N/A</u>	<u>200</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>88566</u>	<u>N/A</u>	<u>200</u>		
							<u>88569</u>		<u>200</u>		
							<u>88571</u>		<u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>N/A</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u>	<u>N/A</u>	<u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	<i>N/A</i>	<i>N/A</i>
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		

Notes:

*N/A*

*N/A*

*N/A*

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N/A	N/A	141967-01	02	02	PC	500	88393 85794 88399	175 122 225			
		RM7349-02	C	C	PC	543	82868 82869	500 57			
		RM7348-01	C	C	PC	500	① 85677 N/A 88523 88536	N/A 350 150			
		RM4001-01	B	B	PC	125	89601 N/A	25 N/A			
		RM0607-01	D	D	PC	56	78845 N/A	65 N/A	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	0000287650 0000287649	500 6			
		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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(D) 09 FEB 23 TRD

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	A	PC	500	N/A	Bulk			
							0000302882	500			
		MM1537-01	A	A	PC	1000	N/A	N/A			
							0000290561	1000			
		MM0177-01	C	C	PC	500	N/A	60			
							0000294701				
		MM0180-01	E	E	PC	500	N/A	N/A			
							0000287541	500			
		MM0178-01	E	E	PC	500	N/A	N/A			
							0000290565	500			
		MM0176-01	D	D	PC	500	N/A	40			
							0000211050				
		MM0074-01	G	G	PC	500	N/A	N/A			
							0000303765	517			
							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	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	13 Feb 24 KL95	
	Line Clearance					
	Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	13 Feb 24 AX05 CL30 V078	
	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 Confirmation Reqd(Milestone )	Loading Braid Stock	500	0	13Feb24	SX11 ST96 NY35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	13Feb24	VP62 AS31

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	13Feb24	MU50 CL05 GS22
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	13Feb24	MU25 CP32
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
NIA	Load Tubing  Confirmation Reqd(Milestone )	NIA	NIA	NIA	NIA	NIA
400	CATASY01  Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone )	Reflow	500	0	13Feb24 SY47 SH85	NK62
450	CATASY01  Catheter	FEP Removal	500	0	13Feb24	JY90 VL91 TR0 AT89
Notes:						
NIA						
NIA						
NIA						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1					
N/A	 FEP Removal Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
500	<b>CATASY01</b> Catheter Assembly 1  In-process Inspection and Rework Confirmation Reqd(Milestone )	In-process Inspection and Rework Material Consumed: Part #: <u>1000-1153-01</u> Batch #: <u>88213</u> Qty: <u>20</u> Part #: <u>2M14001-01</u> Batch #: <u>89601</u> Qty: <u>10</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	489	EW-HT111 DF-111 (11)	14Fes2u R66	V291
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						

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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 )		489	0	14Feb24	PP40 Y936 FBOJ RS23
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Distal Tip Assembly  Confirmation		486	MAH-III	14Feb24	ML60 MM02 VA96 AX62 PH59

Notes:

N/A

N/A

N/A

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Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink	486	0	14Fe524 ML38 AX82	MV78
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01  Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: 0396 Cal Due: 31 May 24 TMI: 0521 Cal Due: 31 May 24 TMI: 20830 Cal Due: 31 May 24 TMI: 09364 Cal Due: 31 May 24  Tipping	486	0	14Fe524	ML38 STX48
<b>Notes:</b>						
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
	Confirmation Reqd(Milestone )	N/A				
750	CATASY01  Catheter Assembly 1  	Tip Inspection/ Flash Removal Material Consumed: Part #: RM40010 Batch #: 89601 Qty: 30 Part #: RM607.0 Batch #: 78845 Qty: 10 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	486	0	14Feb24	SV46 STX48 HV36 PY46 TRN D429
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	481	ACD-HH (5)	14Feb24	SG88 XL91 SS44
Notes:						
N/A						
N/A						
N/A						

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	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>  Cut to Length  Confirmation Reqd(Milestone )	480	SKV-1  14Feb24	M65 KT27	
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	0	0  14Feb24	MV33 TRN KY86 SH04 HT70	

Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
900	Quality Inspection & Review  Confirmation Reqd(Milestone )	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31 May 24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>RM4001-01</u> Batch #: <u>89601</u> Qty: <u>20</u> Part #: <u>1000-1153-01</u> Batch #: <u>88571</u> Qty: <u>25</u> Part #: <u>RM0602-01</u> Batch #: <u>78845</u> Qty: <u>078845-7</u> Part #: <u>RM0158-01</u> Batch #: <u>98018</u> Qty: <u>4</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	3 ① 438	DIS-1HHHHTT LHHHHHIII EW-11 MAR-111 WK-111 FM-1 #10S-11 #5-US-11 #70S-1 #9US-1 #90S-1 SKU-1 DL-11 (42)	14 Feb 24	R66 KL67 XL91 K155 DY29 P446
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>50713 B</u> Cal Due: <u>12 APR 24</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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① K155 14 Feb 24

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## Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
950	Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: 0733 Cal Due: 30 APR 24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 SEP 25 TMI: 0692 Cal Due: 30 SEP 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	424	DIS - HTT 111 1 STR - 111 DIS - HTT SP 14	14 Feb 24	KL67 XL91
1000	QUALITY1  Quality Inspection & Review  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: 1056 Cal Due: 31 MAY 24 Record Length Gage Information: TMI: 0889 D Cal Due: 30 SEP 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 SEP 24	419	LT - HTT	14 Feb 24	KL67 XL91 SSW4

Notes:

N/A

N/A

N/A

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06155 14 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
N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1  Quality Inspection & Review  	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	388	<ul style="list-style-type: none"> <li>• SCR-HH II (TT)</li> <li>• FM - II (TT)</li> <li>• DL - I (TT)</li> <li>• VD - HH</li> <li>• DIS - HH</li> <li>• TL - II</li> <li>• DEL - II</li> <li>• BP - I</li> <li>• AB - I</li> <li>• EW - I</li> <li>• SKV - I</li> <li>• DISC - I</li> <li>• PBC - II</li> </ul> <p>(31)</p>	14Feb24	SV43 XN26
1100	CATASY01  Catheter Assembly 1  	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KPD 14Feb24	N/A	N/A	14Feb24	KPD
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
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	388	0	15 Feb 24	AB10

**Notes:**

N/A AB10 15 Feb 24

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**Material: SA0155-01 Rev F**

Batch Number: 0000.306368

By: APW

Date: 15 Feb 24

Reviewed By:

RB29

Date:

16 Feb 24

Notes:

N/A APW (15 Feb 24)

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1973-1974  
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2022-2023  
2023-2024



CREGANNA  
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二十一

DEVIATION AU  
2005-2003 2003-2005

Requestor Name: Uddhesh Kanadnis

**DEVIATION AUTHORIZATION NUMBER:** 2484  
\* See attached email extension to 2484 (SEP23)  
1562  
24AUG23  
**DEVIATION FORM Extended to 23OCT2023** 5288  
=1562

DEVIATION AUTHORIZATION NUMBER: 2484  
*(See attached email extension to 2)*

DEVIATION AUTHORIZATION NUMBER: 2484  
See attached email for extension to 24 SEP 2023

CONTROLLED COPY

DEVIATION AUTHORIZATION NUMBER: 2484  
((See attached email extension to 24 SEP 23))

Extend to 22nd 2023 - 2024  
Based to 22nd 2023 DEVIATION AU  
11/17/2023

Requestor Name:	Udhesh Kapadnis
Document Number Affected	3107610
Deviation From:	<p>QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050:</p> <p>Current QIP3107610 does not state to inspect for the correct extrusion configuration.</p>
Deviation To:	<p>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.</p> <p>See instructions attached to this DA.</p>
Revision	L

### Deviation From:

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

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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.

Part Number Affected	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

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**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

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Corrective Action Required:	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No
<b>If no, explain:</b> 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.		

**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.

### **Training Required:**

Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 Jul 2023
Mgr. Manufacturing Engineering	Jake Stanislawski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF Deviation Authorization

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① UK55, 23JW 2023



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DA | 2484  
DA | 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 type connection TS2 10AUG23**

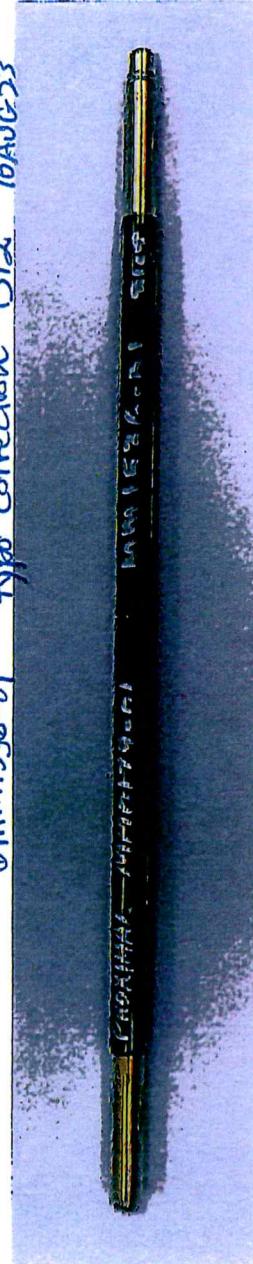


Image- 1

#### 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)

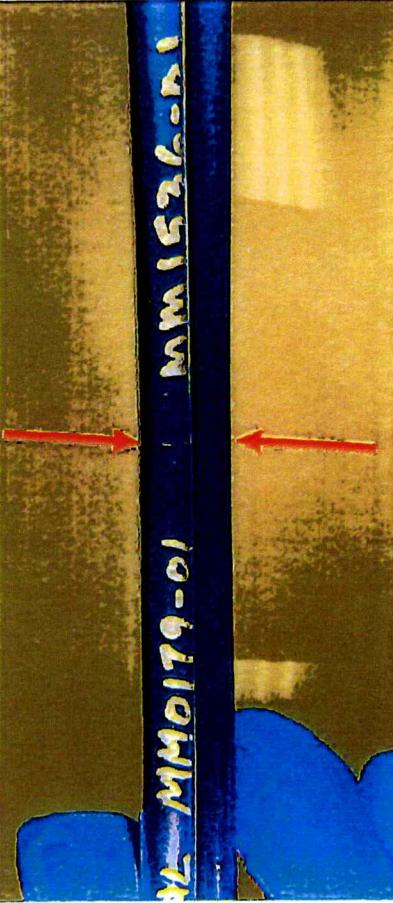


Image- 3

- 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)

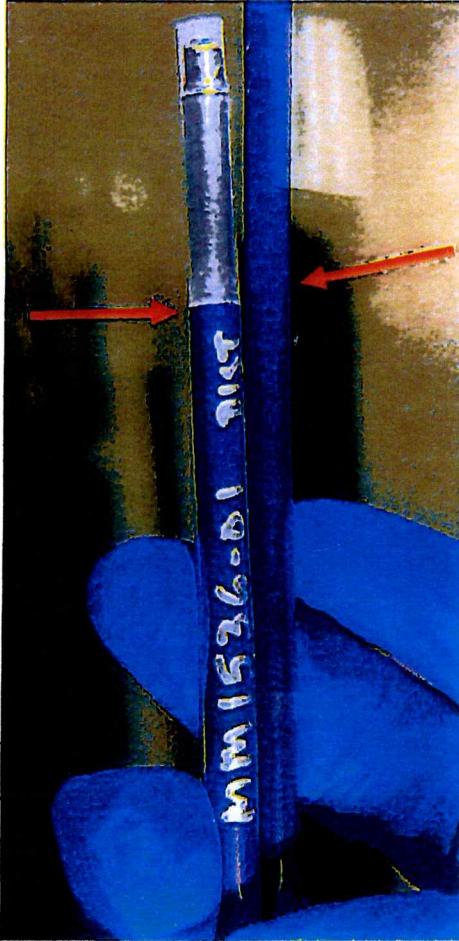


Image- 4  
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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  <b>GOOD PART</b>	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	MM0179-01  <b>Two MM0179-01 - BAD PART</b>
<b>4</b>	MM1536-01	MM1536-01  <b>Two MM1536-01 - BAD PART</b>

Image - 5

Edits to 14 Nov 2023 12/12/2023  
Edits to 13 Feb 2024 12/12/2024

**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: DA2564

**CREGANNA**  
MEDICAL  
is part of  
**TE**

## 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 OPER900 ( <b>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:	Lot Number:	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b> Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No <b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No   <b>If no, explain:</b> N/A			
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



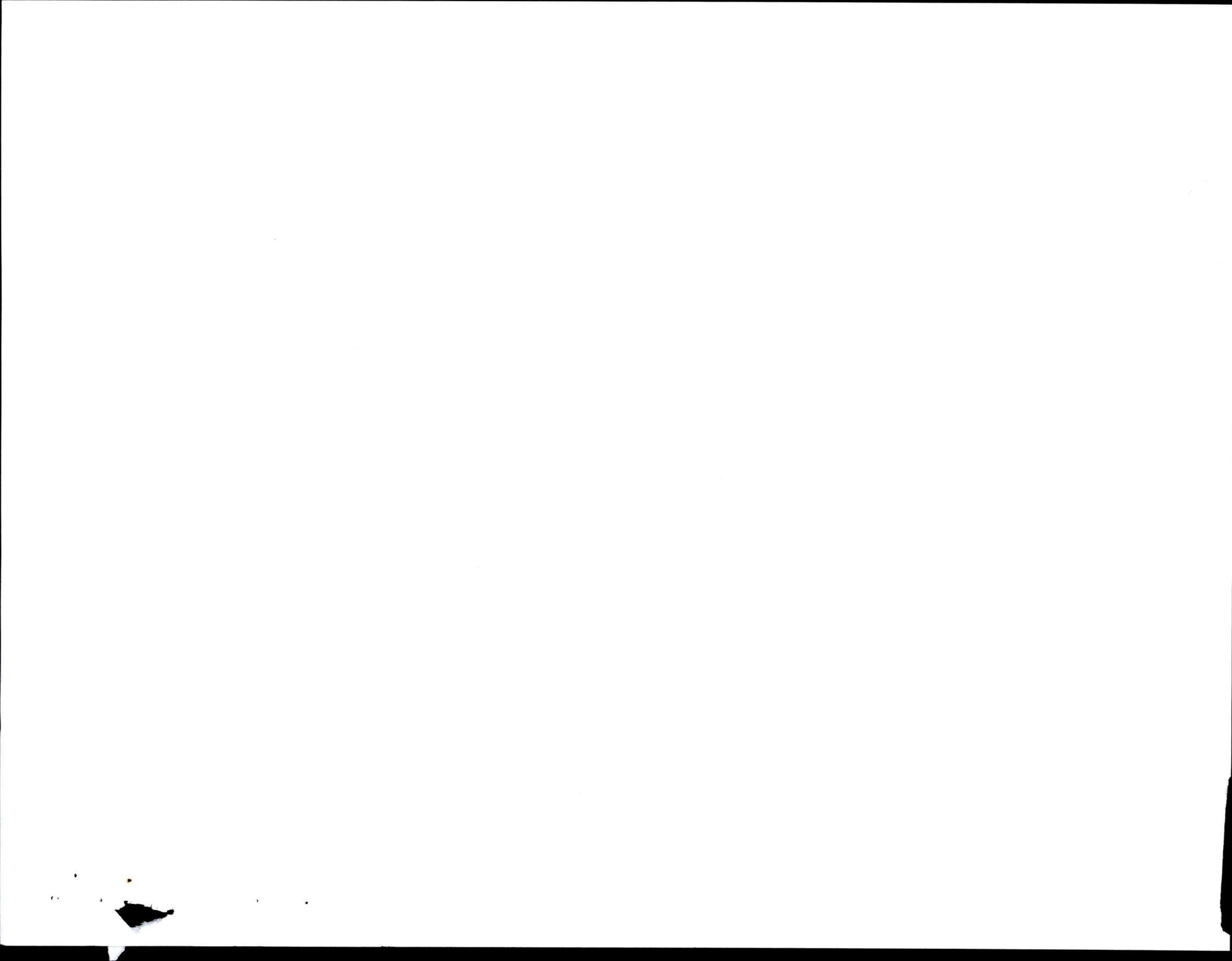
Document No: 5105589  
FM5104665 Rev: C  
Document Type: Manufacturing Form  
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306368

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	3:00pm	429	Ax05	13 Feb 24	3:12pm	415	Ax05	13 Feb 24	12
Tm10942	44	4:21pm	430	SH85	13 Feb 24	4:33pm	415	SH85	13 Feb 24	16
Tm10942	44	4:40pm	430	JY90	13 Feb 24	4:52pm	415	JY90	13 Feb 24	16
Tm10942	44	5:22pm	430	Sy47	13 Feb 24	5:34pm	415	Sy47	13 Feb 24	16
Tm10942	44	6:35pm	430	SH85	13 Feb 24	6:47pm	415	SH85	13 Feb 24	16
Tm10942	44	7:00pm	427	SH85	13 Feb 24	7:10pm	415	SH85	13 Feb 24	16
Tm10942	44	7:24pm	427	SH85	13 Feb 24	7:36pm	415	SH85	13 Feb 24	16
Tm10942	44	7:47pm	427	SH85	13 Feb 24	7:59pm	415	SH85	13 Feb 24	16
Tm10942	44	9:07pm	430	SH85	13 Feb 24	9:17pm	415	V078	13 Feb 24	16
Tm10942	44	9:35pm	428	Sy47	13 Feb 24	9:47pm	415	Sy47	13 Feb 24	16
Tm10942	44	10:14pm	430	V078	13 Feb 24 13 Feb 24	10:26pm	415	Sy47	13 Feb 24	16
Tm10942	44	10:46pm	428	Sy47	13 Feb 24	10:52pm	415	Sy47	13 Feb 24	16

① V078 13 Feb 24





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

PRODUCTION ORDER# 500000306368

OP 400



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306368

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	2:45pm	430	0821	13Feb24	2:57pm	415	0821	13Feb24	12
Tm10745	44	4:04pm	430	SH85	13Feb24	4:16pm	415	SH85	13Feb24	16
Tm10745	44	5:04pm	428	SH85	13Feb24	5:16pm	415	SH85	13Feb24	16
Tm10745	44	6:16pm	430	SH85	13Feb24	6:28pm	415	SH85	13Feb24	16
Tm10745	44	6:50pm	429	JY90	13Feb24	7:02pm	415	SH85	13Feb24	16
Tm10745	44	7:14pm	428	SH85	13Feb24	7:26pm	415	SH85	13Feb24	16
Tm10745	44	7:35pm	428	Sy47	13Feb24	7:47pm	415	Sy47	13Feb24	16
Tm10745	44	7:56pm	428	SH85	13Feb24	8:08pm	415	SH85	13Feb24	16
Tm10745	44	8:55pm	430	Sy47	13Feb24	9:07pm	415	Sy47	13Feb24	16
Tm10745	44	9:23pm	430	V078	13Feb24	9:35pm	415	Sy47	13Feb24	16
Tm10745	44	9:55pm	429	Sy47	13Feb24	10:07pm	415	Sy47	13Feb24	15
Tm10745	44	10:26pm	429	Sy47	13Feb24	10:38pm	415	Sy47	13Feb24	15



PRODUCTION ORDER# 500008306368

OP 400

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



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

PO #: 50000306368 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>24</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube		2
EW	Exposed Wire	HH HH HH HH /	21
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	///	3
N/A	N/A	N/A	0
Inspected By (Sign and Date):		<u>Anil</u> DX35	13 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 #:** 500000306368    **OP #:** 500    **Shift #:** 2nd

Total Parts Reworked:		54	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	///	3
EW	Exposed Wire	XXXXXX//HHHHHHHHHHHHHH	36
MP	Micropores	N/A	N/A
SCR	Scratch	////	4
SKV	Skive Marks	///	3
VD	Voids	X//H//N//	12
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):**



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

PO #: 500000306368

OP #: 500 Shift #: 2nd

Total Parts Reworked:		33	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	/
EH	Exposed Hypotube		6
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		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mv18 13 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 #: 500000306368 OP #: 750 Shift #: 2<sup>nd</sup>

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		50	
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)		5
EH	Exposed Hypotube		20
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mm02	13 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 #: 500000306368

OP #: 750 Shift #: 1st

Total Parts Reworked:		18	
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)		2
EH	Exposed Hypotube	N/A	N/A
N/A	Glue - stopper		12
Inspected By (Sign and Date):		STX48	14 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):

PRODUCTION ORDER# 500000306368

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	7:10pm	190°F	SG88	13 Feb 24	8:12 PM	190°F	XL91	13 Feb 24	39
TM12036	N/A	7:51pm	190°F	SG88	13 Feb 24	9:01 PM	190°F	SG88	13 Feb 24	40
TM10409	N/A	9:18PM	190°F	SG88	13 Feb 24	10:28PM	190°F	SG88	13 Feb 24	40
TM12036	N/A	9:47pm	190°F	SG88	13 Feb 24	10:57pm	190°F	SG88	13 Feb 24	34
TM10409	N/A	10:34pm	190°F	SG88	13 Feb 24	11:44pm	190°F	SG88	13 Feb 24	42
TM12036	N/A	11:01pm	190°F	SG88	13 Feb 24	<sup>12:11 AM</sup> <del>12:11 AM</del>	190°F	SG88	14 Feb 24	28
TM10409	N/A	11:56pm	190°F	SG88	13 Feb 24	1:06AM	190°F	SG88	14 Feb 24	44
TM12036	N/A	12:52AM	190°F	SG88	14 Feb 24	2:02AM	190°F	SG88	14 Feb 24	47
TM10409	N/A	1:23AM	190°F	SG88	14 Feb 24	2:33AM	190°F	SG88	14 Feb 24	31
TM10409	N/A	4:40am	190°F	SS44	14 Feb 24	5:50am	190°F	SS44	14 Feb 24	30
TM12036	N/A	5:25am	190°F	SS44	14 Feb 24	6:35am	190°F	SS44	14 Feb 24	35
TM10409	N/A	5:55am	190°F	SS44	14 Feb 24	7:05am	190°F	SS44	14 Feb 24	35
TM12036	N/A	6:40am	190°F	OS21	14 Feb 24	7:50am	190°F	OS21	14 Feb 24	36

①

OP 146 14 Feb 24 correction for SG88



Document No: 6102619

Rev: B

**Document Type: Manufacturing Form**

Title: SA0155-01 Dimensional/Visual Rework Form

**PO #:** 500000306368    **OP #:** 900    **Shift #:** 2

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):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 50000306368

OP #: 900 Shift #: 2nd

Total Parts Reworked:		27	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		5
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks	① N/A N/A	0
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		3
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 13 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): 

OP146 14 Feb 24



**PO #:** 500000306368

**OP #: 900 Shift #: L**

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

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):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023



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

**PO #:** 500000306368    **OP #:** 900    **Shift #:** 1st

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):**

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Status CURRENT Effective 5/8/2023

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be selected and tensile tested)																
Sample # -->	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	27.11	30.98	25.81	26.39	26.72	26.77	27.26	30.42	25.29	25.55	27.23	1.944611	4.378	18.716494	8.542	PASS
Seg B	57.17	58.82	59.59	62.2	59.17	58.98	64.23	60.74	59.78	59.02	59.97	1.988271	3.981	52.0546925	8.542	PASS
Seg C	83.65	79.76	81.45	82.41	77.29	73.72	83.66	76.31	79.03	76.18	79.346	3.437393	2.911	69.3397488	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 #: 500000306368

Date: 15 Feb 24

Inspector Name: Javier Olivares

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

J001 15 feb 24