

Production Order: 500000306370



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

Material: SA0155-01 Rev F

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

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																								
50	KITTING3 Kitting Devices 	<p>Kitting Devices</p> <p>Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>X31 11:09PM 12FEB24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>X32 2:08PM 14Feb24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	12FEB24	JH70																								
	Kitting Devices	<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</td> <td>PC</td> <td>500</td> <td><u>202621</u> <u>0000291 N/A</u></td> <td><u>N/A</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>0000293119</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1536-01</td> <td>B</td> <td>PC</td> <td>500</td> <td><u>0000290560</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D	PC	500	<u>202621</u> <u>0000291 N/A</u>	<u>N/A</u>					<u>0000293119</u>	<u>500</u>	MM1536-01	B	PC	500	<u>0000290560</u>	<u>500</u>				
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D	PC	500	<u>202621</u> <u>0000291 N/A</u>	<u>N/A</u>																									
				<u>0000293119</u>	<u>500</u>																									
MM1536-01	B	PC	500	<u>0000290560</u>	<u>500</u>																									

Notes: DA 2484, 2564.

N/A
N/A

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N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>88018</u>	<u>N/A</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>88344</u> <u>88350</u> <u>88221</u>	<u>N/A</u> <u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290571</u>	<u>500</u>	<u>N/A</u>	<u>N/A</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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N/A

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<i>N/A</i>		141967-01	02	<u>02</u>	PC	500	<u>87451</u>	<u>517</u>			
							<u>N/A</u>	<u>N/A</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82870</u>	<u>600</u>			
							<u>N/A</u>	<u>N/A</u>			
		RM7348-01	C	<u>C</u>	PC	500	<u>85677</u>	<u>500</u>			
							<u>N/A</u>	<u>N/A</u>			
		RM4001-01	B	<u>B</u>	PC	125	<u>89827</u>	<u>108200</u>			
							<u>89826</u>	<u>100</u>	<i>N/A</i>	<i>N/A</i>	<i>N/A N/A</i>
		RM0607-01	D	<u>D</u>	PC	56	<u>74663</u>	<u>69</u>			
							<u>N/A</u>	<u>N/A</u>			
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287649</u>	<u>494</u>			
							<u>N/A</u>	<u>N/A</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>			
							<u>N/A</u>	<u>Bulk</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>			

Notes:

N/A

N/A

N/A

N/A

N/A

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N/A N/A		MM1538-01	A	A	PC	500	<u>N/A</u>	Bulk				
							<u>0000290562</u>	<u>500</u>				
		MM1537-01	A	A	PC	1000	<u>N/A</u>	<u>N/A</u>				
							<u>0000290561</u>	<u>1,000</u>				
		MM0177-01	C	C	PC	500	<u>N/A</u>	<u>N/A</u>				
							<u>0000294697</u>	<u>500</u>				
		MM0180-01	E	E	PC	500	<u>N/A</u>	<u>N/A</u>				
							<u>0000294374</u>	<u>400</u>				
		MM0178-01	E	E	PC	500	<u>0000282490</u>	<u>100</u>	N/A	N/A	N/A	
							<u>0000290565</u>	<u>500</u>				
		MM0176-01	D	D	PC	500	<u>N/A</u>	<u>N/A</u>				
							<u>0000288413</u>	<u>500</u>				
		MM0074-01	G	G	PC	500	<u>N/A</u>	<u>N/A</u>				
							<u>0000303767</u>	<u>523</u>				
							<u>N/A</u>	<u>N/A</u>				

Notes:

N/A

N/A

N/A

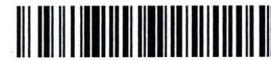
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N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1  Line Clearance Confirmation Rreqd(Milestone)	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	14Feb24	K295
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	14Feb24	NK62 AS31 Y015① Y014

Notes:

N/A

N/A

N/A

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① ② Y014 14FEB24 ③ Y014 14FEB24

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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	14Feb24	VPG2 ST96 NY35
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	14Feb24	MV50 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
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	14Feb24	LM46 CY97 TM AL34 CL30 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	14Feb24	VV25 CH05 GS22

Notes:

N/A
N/A
N/A

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	 Load Tubing <i>N/A</i> Confirmation Reqd(Milestone)					
400	 CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	14Feb24 <i>AX05 TA36 SY47 SARS</i>	
450	 CATASY01 Catheter	FEP Removal	500	0	16Feb24 <i>0 JY90 Phao</i>	
Notes:						
<i>N/A</i> <i>N/A</i> <i>N/A</i>						

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OP446 16 Feb 24 Late entry

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Op. No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty. & Desc.	Date Comp.	Initials
	Assembly 1 FEP Removal <i>N/A</i>			<i>N/A</i>	<i>N/A</i>	<i>N/A</i>
	Confirmation Reqd(Milestone)					
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 #: 38213 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	<i>4864</i>	<i>EN-HH1111</i> <i>Fm-11</i> <i>DF-14t</i> <i>(1b)</i>	<i>P266</i> <i>MU78</i> <i>LL61</i> <i>15Feb24</i> <i>1009</i>	
<i>N/A</i>	<i>N/A</i>		<i>N/A</i>	<i>N/A</i>	<i>N/A</i>	<i>N/A</i>
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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	48 ^u	0	15 Feb ²⁴	Y936 F B01 R523 AK82
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	477	DL-LHT1 MAH-1 (7)	15 Fe ³ 2024 PH59 VA96 FB01 AK82	SV46

Notes:

N/A

N/A

N/A

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MA	Reqd(Milestone)	MA	MA	MA	MA	MA
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink Loading Heat Shrink Confirmation Reqd(Milestone)	477	0	15 Fe ²⁴	ML38 PH59 VA96 FBD1 AX82
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	477	0	15 Fe ²⁴	ML38 Hv36

Notes:

MA
MA
MA

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
M5	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
750	CATASY01 Catheter Assembly 1 Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	Tip Inspection/ Flash Removal Material Consumed: Part #: RM14001-01 Batch #: 89827 Qty: 10 Part #: RM01207-01 Batch #: 14663 Qty: 5 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	0	15 Feb 24	MM02 STX48 Hv36
800	CATASY01 Catheter Assembly 1 Major Mandrel Removal		H666	ACD-111 HTT 11	15 Feb 24	SG88 SSHH
Notes:						
MA						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Major Mandrel Removal MP Confirmation Rreqd(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>pass</u> 2. <u>pass</u> 3. <u>pass</u> 4. <u>pass</u> 5. <u>pass</u> Cut to Length Confirmation Rreqd(Milestone)	460	SKV-JH/1 ⑥ 15Feb24	Y936 KL67	
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MA	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: <u>0200-01</u> Cal Due: <u>31 may 24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>TMI: <u>0.1AA/NIA</u> Cal Due: <u>N/A</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>PN400-01</u> Batch #: <u>89827</u> Qty: <u>15</u></p> <p>Part #: <u>1000-153-01</u> Batch #: <u>48344</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>① PY46 15 Feb 24</p>	447	#6 US-11 #5 US-11 DIY-11 FF903-1 DLH-1 #103-1 DE2-1 EW-11 SER-1 BP-1 (13)	15 Feb 24	DY29 PY46 KT27
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>0.1AA</u> Cal Due: <u>0.1AA TMA5 TM150713B</u> 12 APR 24</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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N/A	 Quality Inspection & Review	<p>TMI: 0733 Cal Due: 30APR24</p> <p>Record DIM02 Go/No-Go Gage Information:</p> <p>TMI: 0691 Cal Due: 30SEP25</p> <p>TMI: 0692 Cal Due: 30SEP25</p> <p>Record DIM02 Inspection Results N = 54:</p> <p>Pass: 54 Fail: 0</p>	434	4+R-111 Dis-144 (SP) 111 (13)	15Feb24	DS21
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: <p>TMI: 1056 Cal Due: 31May24</p> Record Length Gage Information: <p>TMI: 08890 Cal Due: 30SEP24</p> Record Calibrated Ruler Information: <p>TMI: 0629 Cal Due: 30SEP24</p>	426	L+LH-111 (8)	15Feb24	SS44

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	① 382 385	SCR - III (TT) FM - II (TT) DIS - III VD - III STN - I DL - III DISC - I DNT - I MAR - III SKV - III DEL - I PBC - I DT - I FL - I MEX - I DIS - III (41)	SV43 XN26 ISFeb24	
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>Am68 16 Feb 2024</u>	N/A	N/A	N/A	N/A

Notes:

N/A

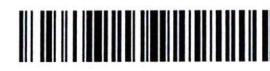
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N/A

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① SV43 16 Feb 24



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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	385	0	16 Feb 24	AP10

Notes:

N/A AP10 16 Feb 24

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Batch Number: 0000306370

By: APW

Date: 16 Feb 24

Reviewed By:

RB29

Date:

16 FEB 24

Notes:

N/A APW 16 Feb 24

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Batches to 2024 3228 U/A/23
Expiry to 19 Feb 2024 3228 1/1/23
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=IE

Extend to 2023 3228 1/1/23
Batches to 2023 3228 1/1/23

DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 2484-
TSIS 24AUG23 3228
Extend to 2023 3228 1/1/23

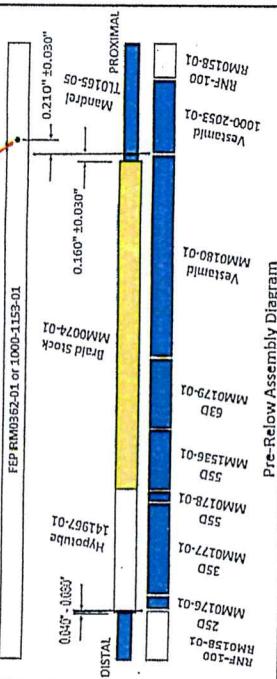
CONTROLLED COPY

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	Lot Number:
SA0155-01	25 Aug 2023	N/A	

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

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

Corrective Action Required: Yes No

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

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

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

FM0002.RevF Deviation Authorization

CONTROLLED COPY

(1) UK55, 23JW 2023

CREGANNA MEDICAL
is part of
=TE

DA | 2484:
2468:
①

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

Group Training Record

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and ~~MM1536-02~~ fixture for inspection. (See image 1)
① **MM1536-01** **Type Connection TS12** 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)

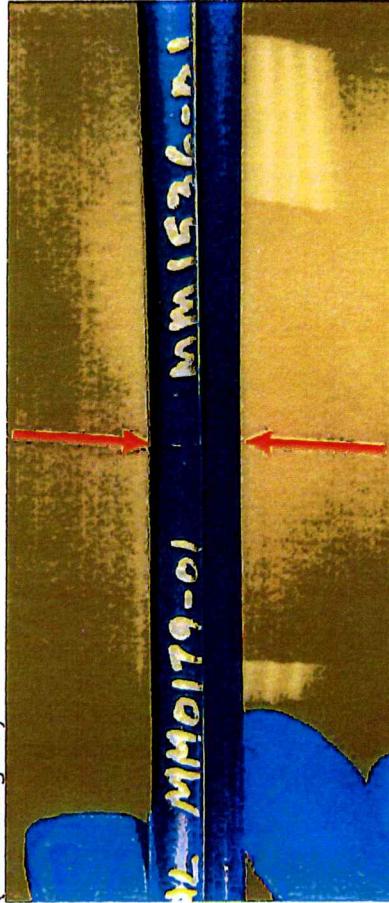


Image- 3

- 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)

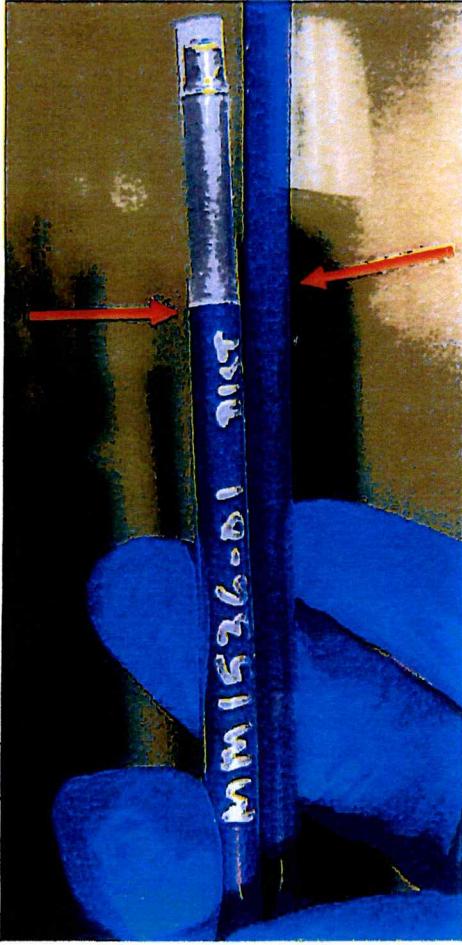


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

1	MM0179-01 GOOD PART	MM1536-01
2	MM1536-01	MM0179-01
3	MM0179-01	MM0179-01 TWO MM0179-01 - BAD PART
4	MM1536-01	MM1536-01 TWO MM1536-01 - BAD PART

Image - 5



DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	
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.	
Deviation To:	
Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer at OPER900 (TMI0700-01) , 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:

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	
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 TMI0700-01. DA will be removed once the lasermic TMI0602 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
FM15104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306370

OP 400



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#: 500000306370

OP 400



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

PRODUCTION ORDER# 500000306370

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	2:20 pm	430	TA36	14 Feb 24	2:32 pm	415	TA36	14 Feb 24	16
TM10942	44	3:00 pm	430	NK62	14 Feb 24	3:12 pm	415	NK62	14 Feb 24	15
TM10942	44	4:05 pm	430	JY90	14 Feb 24	4:17 pm	415	JY90	14 Feb 24	16
TM10942	44	4:37 pm	429	Sy47	14 Feb 24	4:49 pm	415	SH85	14 Feb 24	16
TM10942	44	5:17 pm	430	SH85	14 Feb 24	5:29 pm	415	SH85	14 Feb 24	16
TM10942	44	6:32 pm	430	Y014	14 Feb 24	6:44 pm	415	Sy47	14 Feb 24	16
TM10942	44	7:07 pm	429	Sy47	14 Feb 24	7:19 pm	415	Sy47	14 Feb 24	16
TM10942	44	7:35 pm	430	SH85	14 Feb 24	7:47 pm	415	SH85	14 Feb 24	16
TM10942	44	9:05 pm	430	CL30	14 Feb 24	9:17 pm	415	CL30	14 Feb 24	16
TM10942	44	9:34 pm	430	CL30	14 Feb 24	9:46 pm	415	CL30	14 Feb 24	16
TM10942	44	10:11 pm	430	CL30	14 Feb 24	10:23 pm	415	CL30	14 Feb 24	16
TM10942	44	10:40 pm	430	CL30	14 Feb 24	10:52 pm	415	CL30	14 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306370

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	2:05pm	430	TA36	14 feb 24	2:17pm	415	TA36	14 feb 24	16
Tm10745	44	2:40pm	430	TA36	14 feb 24	2:52pm	415	TA36	14 feb 24	16
Tm10745	44	4:20pm	430	SY90	14Feb24	4:32pm	415	SY90	14Feb24	16
Tm10745	44	4:58pm	428	STH85	14Feb24	5:10pm	415	Sy47	14Feb24	16
Tm10745	44	6:18 pm	430	Sy47	14Feb24	6:30pm	415	Sy47	14Feb24	16
TM10745	44	6:50PM	428	Y014	14Feb24	7:02PM	415	Sy47	14Feb24	16
Tm10745	44	7:24pm	429	Sy47	14Feb24	7:36pm	415	Sy47	14Feb24	16
Tm10745	44	7:52pm	428	STH85	14Feb24	8:04pm	415	STH85	14Feb24	16
Tm10745	44	8:50pm	430	Sy47	14Feb24	9:02pm	415	Sy47	14Feb24	16
Tm10745	44	9:20pm	429	Sy47	14Feb24	9:32pm	415	Sy47	14Feb24	16
Tm10745	44	9:52 pm	429	Sy47	14Feb24	10:04pm	415	Sy47	14Feb24	16
Tm10745	44	10:26pm	430	CL30	14Feb24	10:38PM	415	CL30	14Feb24	16

(S) Sy47 14Feb24



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

PO #: 500000306370

OP #: 500 Shift #: 1st

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		18
EW	Exposed Wire		59
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids		10
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		VC09, LL61, TA36	15 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 #: 500000306310 OP #: 500 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 50000306370

OP #: 500 Shift #: 2nd

Total Parts Reworked:		108	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		9
EW	Exposed Wire		73
MP	Micropores	N/A	N/A
SCR	Scratch		10
SKV	Skive Marks	N/A	N/A
VD	Voids		14
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		m018, m002 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.

Data Uploaded for Engineering Review (Check):



PO #: 50000306370 OP #: 750 Shift #: 2nd

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

Total Parts Reworked:		13	
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)	N/A	N/A
EH	Exposed Hypotube		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	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):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000306370 OP #: 750 Shift #: 2nd

Total Parts Reworked:		30	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	 	15
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube	 	10
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 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):

PO #: 50000306370OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		45	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		8
DIM07 US / WC	DIM07 Undersized (Window Closed)		7
EH	Exposed Hypotube		10
N/A	Glue, stopper		20
Inspected By (Sign and Date):		Hv36 15 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# 5D000D3D637D

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	7:47pm	190°F	SG88	14 Feb 24	8:57pm	190°F	SG88	14 Feb 24	51
TM10409	N/A	9:15pm	190°F	SG88	14 Feb 24	10:25pm	190°F	SG88	14 Feb 24	46
TM10409	N/A	10:29pm	190°F	SG88	14 Feb 24	11:39pm	190°F	SG88	14 Feb 24	49
TM12036	N/A	11:29pm	190°F	SG88	14 Feb 24	12:39am	190°F	SG88	15 Feb 24	40
TM10409	N/A	12:54am	190°F	SG88	15 Feb 24	2:04am	190°F	SG88	15 Feb 24	34
TM10409	N/A	5:15am	190°F	SS44	15 Feb 24	6:25 am	190°F	SS44	15 Feb 24	41
TM10409	N/A	6:30am	190°F	K155	15 Feb 24	7:40 am	190°F	K155	15 Feb 24	58
TM10409	N/A	8:10am	190°F	K155	15 Feb 24	9:20am	190°F	K155	15 Feb 24	60
TM12036	N/A	8:40am	190°F	K155	15 Feb 24	9:50am	190°F	K155	15 Feb 24	32
TM10409	N/A	9:25am	190°F	SS44	15 Feb 24	10:35am	190°F	SS44	15 Feb 24	55
TM10409	②	N/A	SS44	15 Feb 24						

① 6155 15 Feb 24
② 5544 15 Feb 24



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306370 **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.

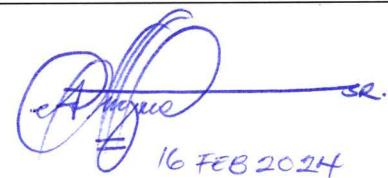
Data Uploaded for Engineering Review (Check):

- CONFIDENTIAL -

Page 1 of 1

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	29.17	29.24	25.81	35.61	25.61	29.17	28.26	28.87	27.66	27.89	28.729	2.7554691	4.378	16.6655562	8.542	PASS	EDW Commander Flex - Bend and Tensile Strength Testing
Seg B	66.35	77.91	66.07	71.19	65.97	70.43	84.04	80.89	66.75	73.19	72.279	6.6138851	3.981	45.9491233	8.542	PASS	LOT #: 500000306370 Date: 16FEB2024 Inspector Name: AUGUSTINE JAH Equipment ID: TMI0311B Cal Due Date: 27 OCT 24
Seg C	88.43	79.75	74.9	88.46	81.38	87.12	86.97	90.17	89.43	88.13	85.474	5.0408624	2.911	70.8000497	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.



16 FEB 2024