

Production Order: 500000300501



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:	7988		Project Phase:
Plant / Business Unit:	1213 / AC5		

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3 Kitting Devices Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>G585 7:00AM 24 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>G585 1:23PM 24 Jan 24</u> Record Dryer Shelf #: <u>N/A</u>									
		MM0179-01	D D	PC	500	0000276172	500	N/A	N/A	① 01JAN 22JAN24 25Jan24 G585	BV57
		MM1536-01	B B	PC	500	0000281412	500	N/A	N/A		

Notes: DA 2484, 2564

N/A
N/A

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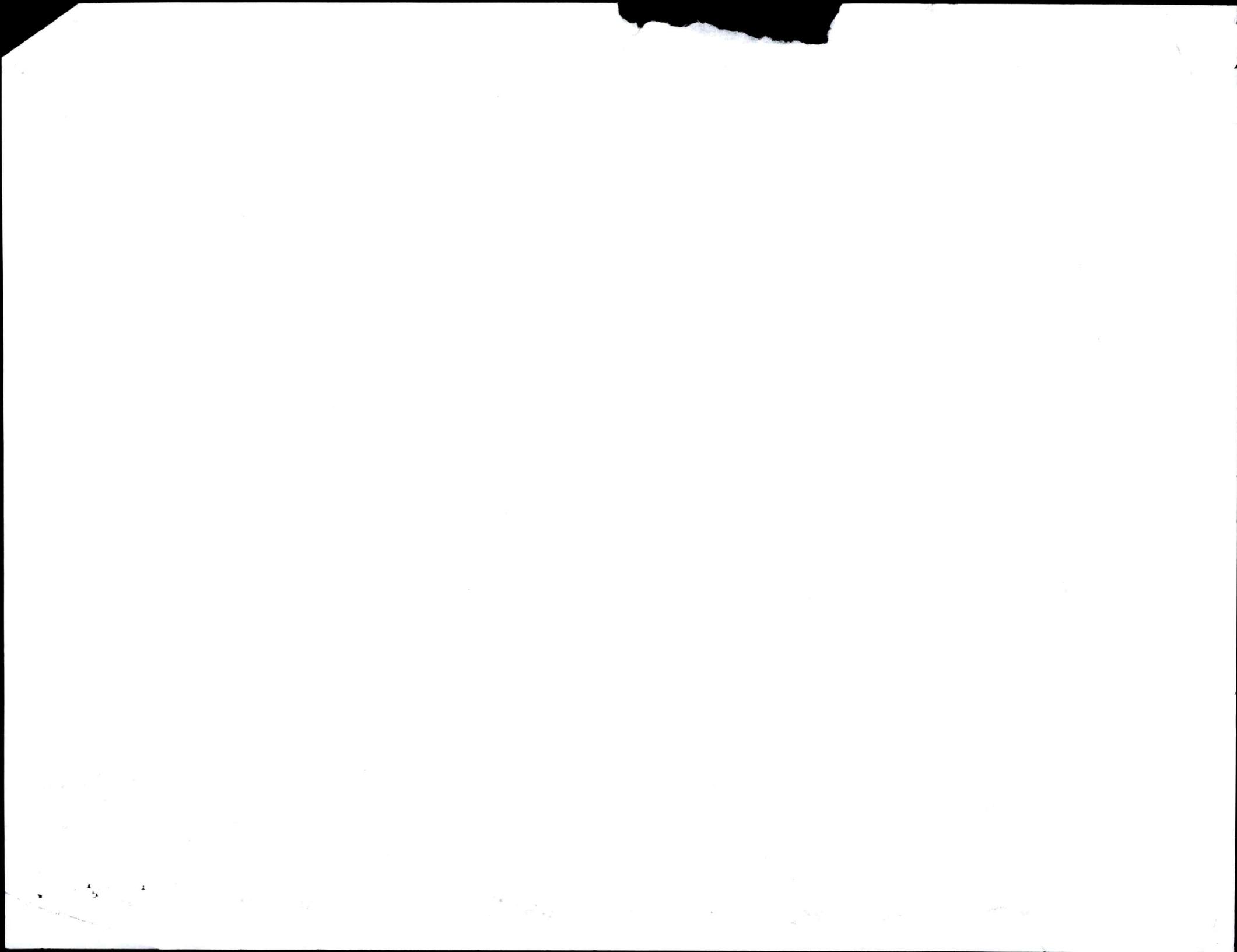


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(1) G585 24 Jan 24



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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP N/A	RM0158-01	E	E	PC	200	N/A	N/A			
						81054	100			
	RM0009-04	I	I	PC	1	N/A	N/A			
						82971	Bulk			
	RM0009-04	I	I	PC	1	N/A	Bulk			
						82971	Bulk			
	MM1538-01	A	A	PC	500	N/A	Bulk			
						0000278970	500			
MP N/A	MM1537-01	A	A	PC	1000	N/A	N/A			
						0000284209	1120			
	1000-2053-01	A	A	PC	500	N/A	N/A			
						0000278880	500			
	MM1537-02	A	A	PC	500	N/A	N/A			
						0000288401	500			
						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
		TL0167-02	E	<u>E</u>	PC	70	N/A N/A	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		141967-01	02	<u>02</u>	PC	500	87436 85501	395 149	N/A	N/A	N/A
		RM7349-02	C	<u>C</u>	PC	543	82864 82833 82734	① 460 403 50 50			
		RM7348-01	C	<u>C</u>	PC	500	84584 82886 N/A	545	N/A		
		RM4001-01	B	<u>B</u>	PC	125	82472 82471	100 100			
		RM0607-01	D	<u>D</u>	PC	56	NA 78322	N/A			

Notes:

N/A

N/A

N/A

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N/A	RM0498-01	C	C	PC	500	74662	56			
						0000287412	500			
						N/A	N/A			
		RM0362-01	E	E	PC	594	85886	600		
						78860	90			
		MM0177-01	C	C	PC	500	0000284208	500		
						N/A	N/A			
		MM0180-01	E	E	PC	500	0000295774	500		
						N/A	N/A	N/A	N/A	N/A
	MM0178-01	E	E	PC	500	0000276174	500			
						N/A	N/A			
	MM0176-01	D	D	PC	500	0000281411	500			
						N/A	N/A			
	MM0074-01	G	G	PC	500	① N/A 000029 0000293928	N/A 523			

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
MA	N/A	N/A	MA	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	25 Jan 24	V078
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	25 Jan 24	RN27 AF54 Pm96 SY47 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
MP	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	25 Jan 24	SXII CY97 ST96 NY35
250	CATASY01 Catheter Assembly 1 Trim Braid Wire at Proximal End		500	0	25 Jan 24	MY50 LM46 AS31 V078

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 MA Confirmation Reqd(Milestone)		MA	MA	MA	MA
300	CATASY01 Catheter Assembly 1 Insert Cut Hypo Tube Insert Cut Hypo Tube Confirmation Reqd(Milestone)	Insert Cut Hypo Tube	500	0 25J cm ²⁴	V P62 DV39 ep82 GS22	
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0 25J cm ²⁴	VV25 SX11 C105 GS22	

Notes:
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MA
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Load Tubing Confirmation Reqd(Milestone)		N/A	N/A	N/A	N/A
400	 CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	25 JUN 2024	NK62 AX05 Pmg6 CL3.0 V078 SH85
450	CATASY01 Catheter	FEP Removal	500	0	25 JUN 2024	Pmg6 JY90

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
	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 #: <u>Pr4001-01</u> Batch #: <u>82492</u> Qty: <u>15</u> Part #: <u>1000-1153-01</u> Batch #: <u>87654</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> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	489	(11) 25 Jan 2024	VD-III FM-1 EW-11111 VL91 P266 TD45	
	N/A	N/A	N/A	N/A	N/A	N/A
	Notes:		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)	489	0 25 Jan 2024		PP40 DX35 VA96 FBOJ PH59
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly Distal Tip Assembly Confirmation	482	DL-11 MTS-111 ID-1 MAS-1 ① 25 Jan 2024		SV46 ML60 PH59 AX82

Notes:

v/a

v/a

v/a

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MD	Reqd(Milestone)		N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	482	0	25)	ML38 PH59 DY29
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
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: 63986 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24 Tipping	482	0	25)	ML38 RS23
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
M1A	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)	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <p>Part #: <u>Raw4001-01</u> Batch #: <u>82472</u> Qty: <u>12</u></p> <p>Part #: <u>Raw0602-01</u> Batch #: <u>78322</u> Qty: <u>14</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>	482	0 <i>(1)</i> <i>(5)</i>	<i>HT72</i> <i>mn02</i> <i>STX48</i> <i>Hv36</i>	
800	CATASY01 Catheter Assembly 1 Major Mandrel Removal		482 475 <i>(1)</i>	ACD - HT11 <i>(1)</i> <i>(5)</i>	<i>5G88</i> <i>5SH44</i>	

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
	Major Mandrel Removal		n/a	n/a	n/a	
	Confirmation Reqd(Milestone)		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>	474	#5/US-1 (1) e5] m24		Y936 5552
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 MV46 S1to4 ML65

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Material: SA0155-01 Rev F

Opn 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 #: P400L-01 Batch #: 82472 Qty: 15</p> <p>Part #: 1000-153-01 Batch #: 87654 Qty: N/A</p> <p>Part #: P400L-01 Batch #: 78322 Qty: 5</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	465	ACD-1 DIS-1 EW-1 MAR-11 #605-1 #605-111	25 Jun 2024 ⑨	XL91 KL67 PY46 KT4T
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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Material: SA0155-01 Rev E

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review Confirmation Reqd(Milestone)	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>	449	DIS(SP) HHT DIS-HHT 111 STR-11 (16)	25 Jun 24	XL91 KL67
1000	QUALITY1  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>0889 D</u> Cal Due: <u>30 SEP 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u>	438	LT-HHT HHT ① HHT ① OAL-1 (11)	25 Jun 24	XL91 KL67	

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① XL91 24 Jan 2L



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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
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	420	VD-1111① VD-1HT EW-11 DEL-1 SCR-1HT 1HT (TT) 18	25Jan24	SV43 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): GS85 25 Jan 24	N/A	N/A	25 Jan 24 GS85	
Notes:						
N/A						
N/A						
N/A						

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① XN26 25Jan24

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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	420	0 <i>26Jan24</i>	<i>AP10</i>	

Notes:

N/A AP10 26Jan24

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(1) AP10 26 Jan 24

(1)

Batch Number: ~~XXXX~~ XXXX300501

By: AP10

Date: 26 Jan 24

Reviewed By: TY13

Date: 26 Jan 24

Notes:

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Exhibit A - DRAFT
10/15/03



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Requestor Name: Ullrich Kanadri
Request to Date to Deviation Date to Deviation Date to Deviation

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

RECEIVED
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RECEIVED

DEVIATION AUTHORIZATION NUMBER: 2484

APPLICATION FORM Extended to 23 Oct 2023
See attached email extension to 07 SEP 2023
T512
24 AUG 23
328

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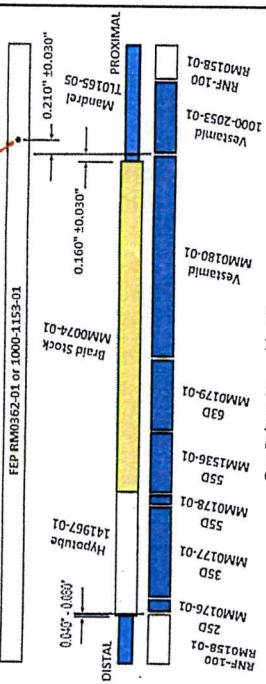
Requestor Name: Udhesh Kapadnis			
Document Number Affected	Revision	Document Number Affected	Revision
3107610	L		
Deviation From:			
<p>QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050:</p> <p>Current QIP3107610 does not state to inspect for the correct extrusion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

Deviation From:

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

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.

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

Risk Assessment:

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

Ergonomics and Safety in Manufacturing

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

Training Required: Yes No If no, explain:

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

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FM0002.RevF Deviation Authorization

① UK55, 23JW 2023



DA | 2484
① 2468.

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 MM01536-01 *typo correction TS12 10AUG23*

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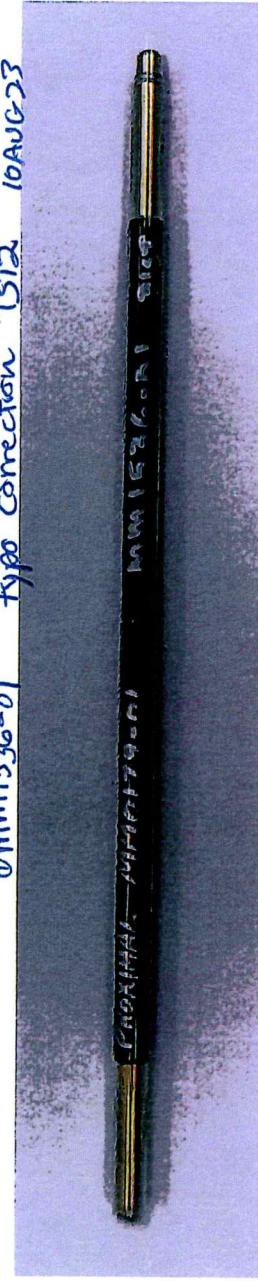


Image- 1

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)

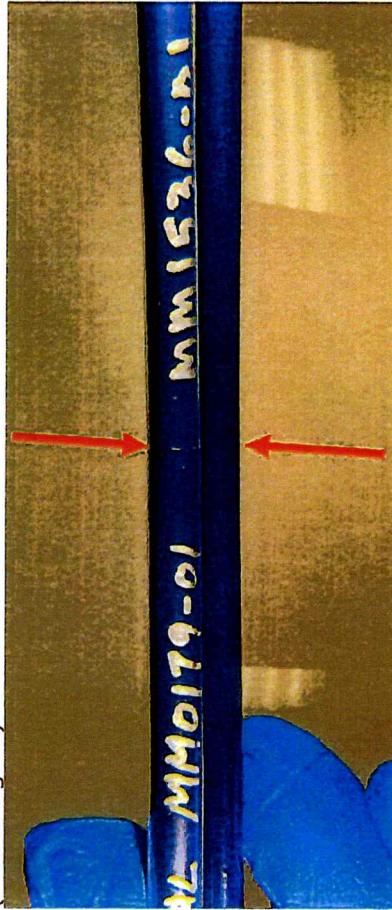
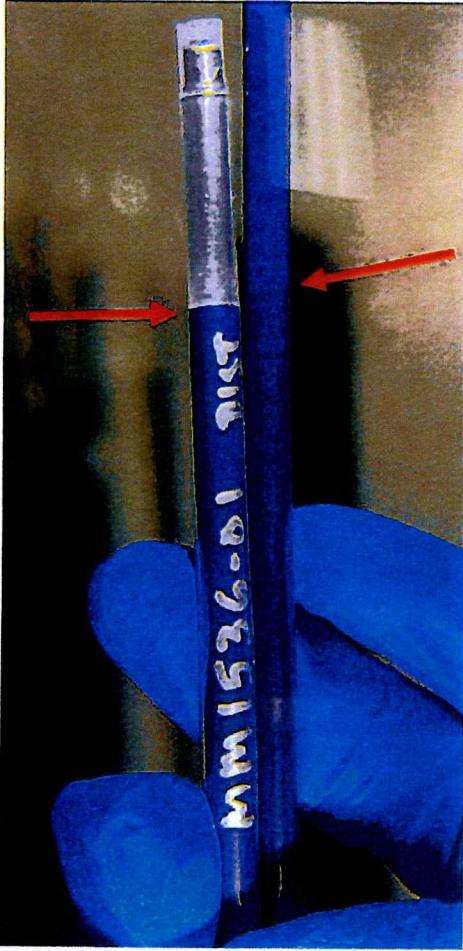


Image- 3

- 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 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

Entered to HENRY 328 1/1/2023

Entered to 13 FLOW 328 1/1/2023

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

CREGANNA
MEDICAL
is part of



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: 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.	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 FMEAs <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
FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000300501

OP 400



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

PRODUCTION ORDER# 500000300501

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	2:30 PM	430	AX05	24Jan24	2:42 PM	415	AX05	24Jan24	16
Tm10745	44	2:55 PM	430	NK62	24Jan24	3:07 PM	415	NK62	24Jan24	16
Tm10745	44	4:11 PM	430	CL30	24Jan24	4:23 PM	415	CL30	24Jan24	16
Tm10745	44	4:25pm	428	JY90	24Jan24	4:37pm	415	CL30	24Jan24	16
Tm10745	44	5:30pm	430	V078	24Jan24	5:42PM	415	SH85	24Jan24	16
Tm10745	44	6:37PM	428	SH85	24Jan24	6:49PM	415	SH85	24Jan24	16
Tm10745	44	7:13PM	429	Sy47	24Jan24	7:25PM	415	Sy47	24Jan24	16
Tm10745	44	7:52PM	428	SH85	24Jan24	7:54PM	415	SH85	24Jan24	16
Tm10745	44	8:02PM	429	SH85	24Jan24	8:14PM	415	SH85	24Jan24	16
Tm10745	44	9:05pm	430	V078	24Jan24	9:17pm	415	CL30	24Jan24	16
Tm10745	44	9:18pm	430	V078	24Jan24	9:30PM	415	SH85	24Jan24	16
Tm10745	44	9:38PM	430	CL30	24Jan24	9:50PM	415	SH85	24Jan24	16



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

PRODUCTION ORDER# 500000300501

OP 400



PRODUCTION ORDER# 500000300501

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	2:14PM	429	AX05	24Jan24	2:26PM	415	AX05	24Jan24	16
TM10942	44	2:45PM	428	AX05	24Jan24	2:57PM	415	AX05	24Jan24	16
TM10942	44	4:41PM	429	SH85	24Jan24	4:53PM	415	SH85	24Jan24	16
TM10942	44	5:05PM	427	SH85	24Jan24	5:17PM	415	SH85	24Jan24	16
TM10942	44	6:22PM	430	SH85	24Jan24	6:34PM	415	SH85	24Jan24	16
TM10942	44	6:58PM	430	SH85	24Jan24	7:05PM	415	SH85	24Jan24	16
TM10942	44	7:17PM	428	SH85	24Jan24	7:29PM	415	SH85	24Jan24	16
TM10942	44	7:46PM	429	SH85	24Jan24	7:58PM	415	SH85	24Jan24	16
TM10942	44	9:50PM	430	SH85	24Jan24	10:02PM	415	SH85	24Jan24	16
TM10942	44	10:30PM	430	V078	24Jan24	10:42PM	415	CL30	24Jan24	16
TM10942	44	11:00PM	428	V078	24Jan24	11:12PM	415	V078	24Jan24	16
TM10942	44	11:48PM	430	V078	24Jan24	12:00AM	415	V078	25Jan24	16

① SH85 24Jan24



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

PO #: 500000300501 **OP #:** 500 **Shift #:** 2

Total Parts Reworked:		26	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	/
EH	Exposed Hypotube	///	5
EW	Exposed Wire		23
MP	Micropores	n/a	0
SCR	Scratch	n/a	0
SKV	Skive Marks	n/a	0
VD	Voids	n/a	0
n/a	n/a	n/a	0

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 #: 500000300501 OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>22</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>16</u>
MP	Micropores	<u>n/a</u>	<u>n/a</u>
SCR	Scratch	<u> </u>	<u>3</u>
SKV	Skive Marks	<u>n/a</u>	<u>n/a</u>
VD	Voids	<u> </u>	<u>5</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</u> <u>24 Jan 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):

PO #: 50000300501OP #: 750 Shift #: 2nd.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		1
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV 46 24 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 #: 500000300501OP #: 750 Shift #: 2

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		6
DIM07 US / WC	DIM07 Undersized (Window Closed)		12
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		HT72 24 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 #: 500000300501OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		① <u>26</u> 35	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	N/A	N/A
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		5
N/A	Glue , stopper		17
Inspected By (Sign and Date):		STX 48 25 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):

① STX 48 25 Jan 24

PRODUCTION ORDER# 5000D0300501

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	6:46pm	190°F	SG88	24 Jan 24	7:56pm	190°F	SG88	24 Jan 24	37
Tm12036	N/A	7:23pm	190°F	SG88	24 Jan 24	8:33pm	190°F	SG88	24 Jan 24	40
Tm10409	N/A	7:59pm	190°F	SG88	24 Jan 24	9:09pm	190°F	SG88	24 Jan 24	49
Tm10409	N/A	9:20pm	190°F	SG88	24 Jan 24	10:30pm	190°F	SG88	24 Jan 24	50
Tm12036	N/A	9:54pm	190°F	SG88	24 Jan 24	11:04pm	190°F	SG88	24 Jan 24	34
Tm10409	N/A	10:55pm	190°F	SG88	24 Jan 24	12:05am	190°F	SG88	25 Jan 24	57
Tm10409	N/A	12:09am	190°F	SG88	25 Jan 24	1:19am	190°F	SG88	25 Jan 24	41
Tm12036	N/A	12:49am	190°F	SG88	25 Jan 24	1:59am	190°F	SG88	25 Jan 24	40
Tm10409	N/A	4:00am	190°F	K155	25 Jan 24	5:10am	190°F	K155	25 Jan 24	36
Tm10409	N/A	5:20am	190°F	K155	25 Jan 24	6:30am	190°F	K155	25 Jan 24	36
Tm10409	N/A	6:40am	190°F	K155	25 Jan 24	7:50am	190°F	K155	25 Jan 24	30
Tm12036	N/A	6:50am	190°F	K155	25 Jan 24	8:00am	190°F	K155	25 Jan 24	32
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	



PO #: 50000300501 OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		43	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		1
EW	Exposed Wire		4
MP	Micropores	N/A	0
SCR	Scratch		30
SKV	Skive Marks	N/A	0
VD	Voids		6
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized		3
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 24 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 #: 50000C300501

OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		58	
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		4
MP	Micropores	N/A	N/A
SCR	Scratch		36
SKV	Skive Marks		3
VD	Voids		27
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	N/A	N/A
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		<i>Mariel</i>	24 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 #: 500000300501 OP #: 900 Shift #: 1st

Total Parts Reworked:		58	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	/	1
EW	Exposed Wire	+ / / /	18
MP	Micropores	+ / / /	19
SCR	Scratch	+ + + + /	21
SKV	Skive Marks	N/A	N/A
VD	Voids	+ + + + / /	23
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	///	3
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		KT 207 6/55	25 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):

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	27.37	31.38	30.16	33.15	28.69	31.09	28.51	32.84	27.58	33.46	30.423	2.3093532	4.378	20.3126517	8.542	PASS
Seg B	70.29	71.2	70.91	80.75	77.12	71.84	71.43	70.56	69.34	81.83	73.527	4.5987971	3.981	55.2191889	8.542	PASS
Seg C	78.96	75.03	84.28	86.84	78.16	88.53	85.14	84.84	81.49	84.74	82.801	4.2571494	2.911	70.4084381	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

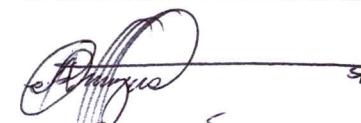
LOT #: 500000300501

Date: 26JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TM10311B

Cal Due Date: 27 OCT 24



26 Jan 2024