

# Production Order: 500000307848



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 Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>GS85 6:05AM 14 Feb 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Ans 6:08 8:30am 16 Feb 24</u> Record Dryer Shelf #: <u>N/A</u>				
	Kitting Devices	Component Number Req'd Rev UOM Qty. Batch No. Actual Qty Used	N/A	N/A	(13 Feb 24) TR20	
		MM0179-01 D <u>D</u> PC 500 <u>0200293119</u> 500				
				N/A		
		MM1536-01 B <u>B</u> PC 500 <u>0000290560</u> 500				
				N/A		

Notes: DA 2564, 2484

N/A

N/A

Date Printed: 02/13/2024 / 17:53:46

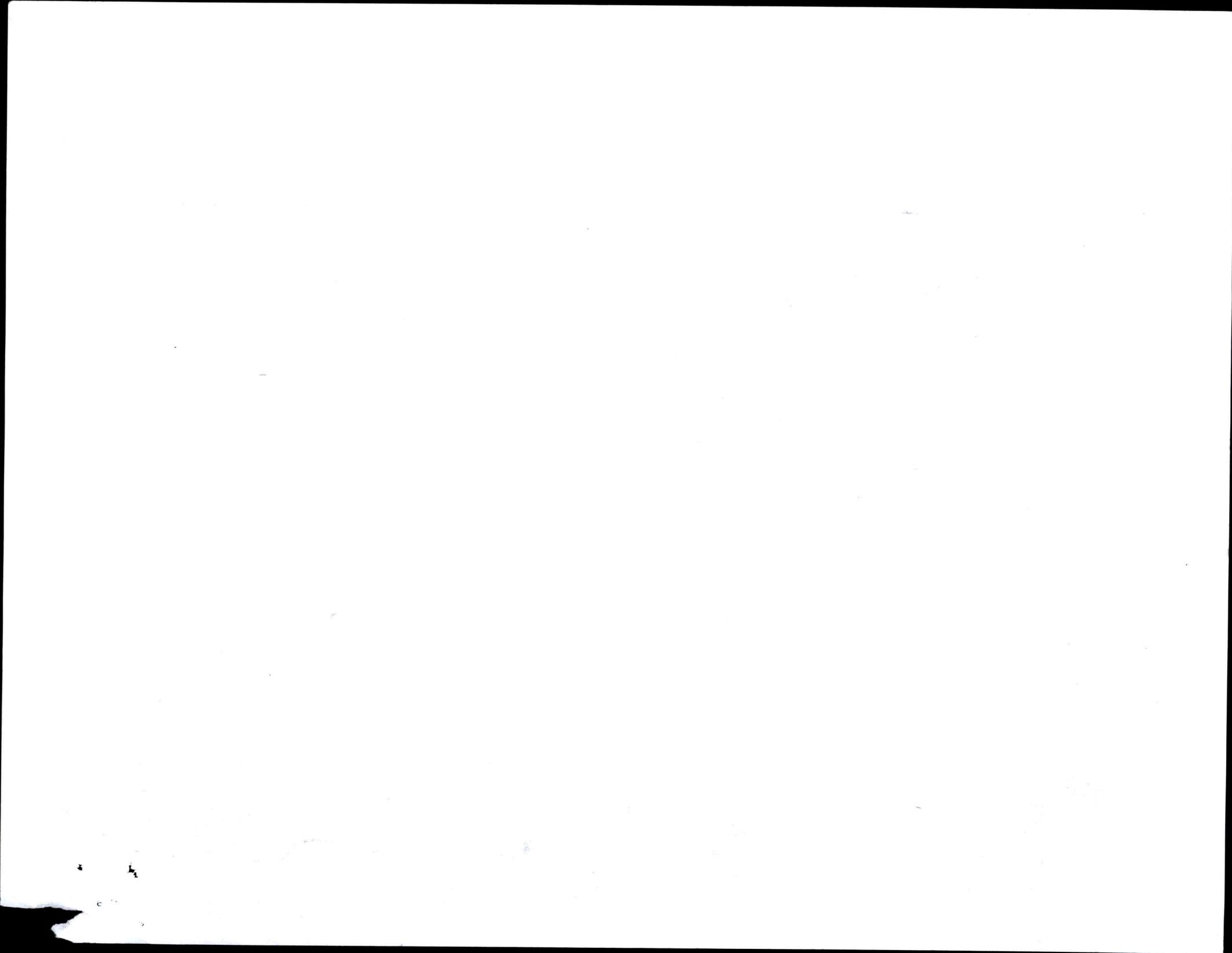
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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>①554477</u> N/A	N/A			
							<u>81054</u>	200			
		1000-1153-01	A	<u>A</u>	PC	594	<u>88225</u> <u>88345</u> <u>88340</u>	200 200 200			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	500			
							<u>N/A</u>	N/A	N/A	N/A	N/A
		MM1537-02	A	<u>A</u>	PC	500	<u>0000290971</u> <u>0000288401</u>	500 60	N/A	N/A	
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	Bulk Bulk			
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	Bulk Bulk			

Notes:

N/A

N/A

N/A

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① 13FEB24 7P040

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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	<u>02</u>	PC	500	<u>85678</u>	<u>505</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82865</u>	<u>486</u>			
		RM7348-01	C	<u>C</u>	PC	500	<u>88490</u>	<u>450</u>			
		RM4001-01	B	<u>B</u>	PC	125	<u>82809</u>	<u>100</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		RM0607-01	D	<u>D</u>	PC	56	<u>74662</u>	<u>72</u>			
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287650</u>	<u>493</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>			

Notes:

N/AN/AN/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	N/A	MM1538-01	A	A	PC	500	N/A	Bulk 500 N/A ①		
		MM1537-01	A	A	PC	1000	N/A	N/A		
		MM0177-01	C	C	PC	500	N/A	N/A	N/A	N/A
		MM0180-01	E	E	PC	500	N/A	N/A		
		MM0178-01	E	E	PC	500	0000295774	100		
		MM0176-01	D	D	PC	500	0000294374	400		
		MM0074-01	G	G	PC	500	0000290516	500		
							N/A	N/A		
							N/A	N/A		
							N/A	N/A		
							N/A	N/A		

Notes:

N/A

N/A

N/A

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① GS85 19 Feb 24

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① 13PE6247806

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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  Confirmation Reqd(Milestone )	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	17Feb24	CB58
150	CATASY01  Catheter Assembly 1    Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	17Feb24	YK70 SN61 SD34 AM47 JC92

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	17Feb24	VPC2 PY67 ST96
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	17Feb24	C497 MC17
Notes:		N/A				
		N/A				
		N/A				

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Op 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 )	500	0	17Feb24	RL47 AEGS
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	17Feb24	CX63 BD64 AL67 QW6

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	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	17Feb24	AL67 SN67 CD19 AM47 Q116
450	CATASY01  Catheter	FEP Removal	500	0	17Feb24	AM47 JC92 SD34 YKHD
Notes:						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 					
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 #: 88345 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A In-process Inspection and Rework Confirmation Reqd(Milestone )	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 88345 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A In-process Inspection and Rework Confirmation Reqd(Milestone )	497	EW-III ③	17 Feb 24	D429 LS46 AP07 MV33 LL61 CB81
N/A	N/A	N/A	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
550	CATASY01 Catheter Assembly 1  Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone )	Remove Heat Shrink & Mandrel	492	MAH-1111 DL-1 ⑤	17Feb24	MHID SC10
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	492	0	17Feb24 PT09 PY46 BT60	

**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	492	0	17Feb24	LH45 B160
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01  Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: <u>0936A</u> Cal Due: <u>31mAY24</u> TMI: <u>2083C</u> Cal Due: <u>31mAY24</u> TMI: <u>0386</u> Cal Due: <u>31mAY24</u> TMI: <u>0521</u> Cal Due: <u>31mAY24</u>  Tipping	492	0	17Feb24	IC83
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
750	CATASY01  Catheter Assembly 1    Tip Inspection/ Flash Removal Confirmation Reqd(Milestone )	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4001-01 Batch #: 82809 Qty: N/A Part #: RM0607-01 Batch #: 74662 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	492	0	17Feb24	IL83 MM02
800	CATASY01  Catheter Assembly 1    Major Mandrel Removal		491	ACO - 1 (1)	17Feb24	YTR40 KUYS BD64

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Major Mandrel Removal  Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
850	CATASY01  Catheter Assembly 1    Cut to Length  Confirmation Reqd(Milestone )	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. Pass    2. Pass    3. Pass    4. Pass    5. Pass	491	0	17Feb24	KLW PLZ
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						
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: TMI: <u>0700-01</u> Cal Due: <u>31 MAY 2024</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>1000-1153-01</u> Batch #: <u>88225</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82809</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>74662</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>81054</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	467	DEL-14H(14H) (TT)  DIS-14H(SP)  MAR-1111  #GOS-111  SKU-11  24	17Feb24	PV16  KX54  PP40
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

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	 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 2025</u>            TMI: <u>0692</u> Cal Due: <u>30 Sep 2025</u>            Record DIM02 Inspection Results N = 54:            Pass: <u>54</u> Fail: <u>0</u></p>	465	#90S-1 DIS-1 <u>(2)</u>	17Feb24	GWb
1000	 Quality Inspection & Review	<p>Quality Inspection &amp; Review            Leak Test            Record Inspection Data in SAP ROS            Record Leak Tester Information:            TMI: <u>1056</u> Cal Due: <u>31 MAY 2024</u>            Record Length Gage Information:            TMI: <u>0889D</u> Cal Due: <u>30 Sep 2024</u>            Record Calibrated Ruler Information:            TMI: <u>0629</u> Cal Due: <u>30 Sep 2024</u></p>	455	LT-UH14H <u>(10)</u>	17Feb24	CB58

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
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	423	• 4-SKV • 10-SCR • 14-EW • 2-DEL FM-1 1-MEX 32	18 Feb 24	DX52
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): GSE5 19 Feb 24	N/A	N/A	19 Feb 24	GSE5
Notes:						
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	423	0	19 Feb 24	DMJ

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**Material: SA0155-01 Rev F**

Batch Number: 0060307848

By: BA71

Date: 19 Feb 24

Reviewed By:

RB29

Date:

20 Feb 24

Notes:

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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



TE	DA	2484 2468 ①
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**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 MM1536-01 fixture for inspection. (See image 1)  
**①MM1536-01 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)

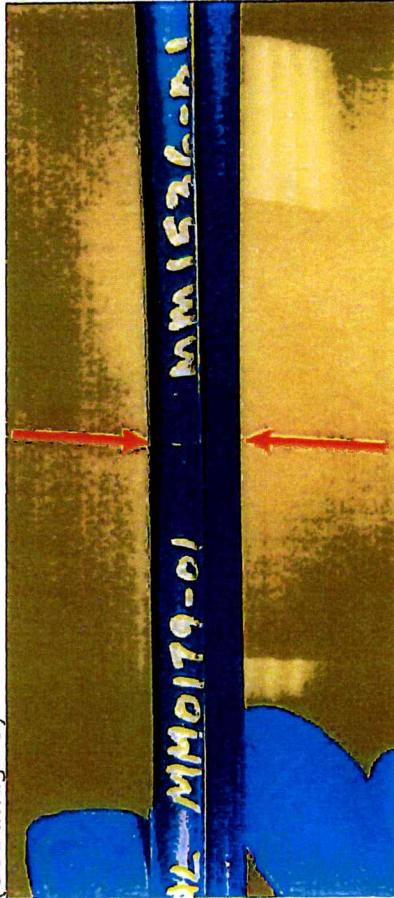


Image- 3

- 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.

## **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)

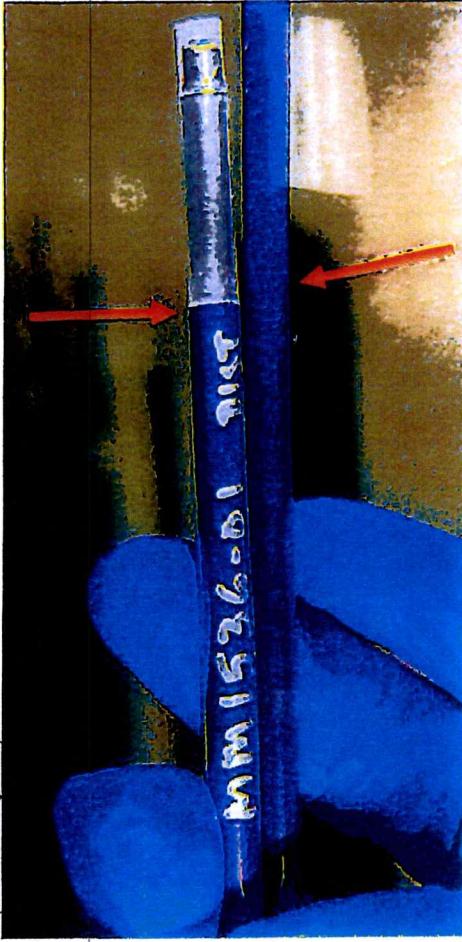


Image- 4

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.

<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

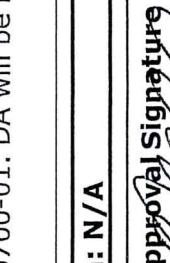
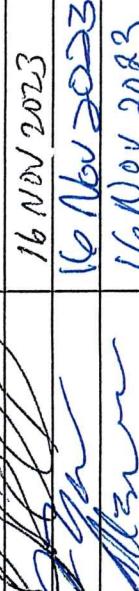
## DEVIATION AUTHORIZATION FORM

<b>Requestor Name:</b> Krishna Selvaraj		
<b>Document Number Affected</b>	<b>Revision</b>	
Doc #3005206 (MPI0238)	BP	
<b>Deviation From:</b> <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>Deviation To:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b> Using a laser micrometer at <b>OPER900 (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.		

**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.

<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	
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 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			
<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



PRODUCTION ORDER# 500000307848

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	9:12AM	430	SNL67	16Feb24	9:24AM	415	SNL67	16Feb24	16
Tm10942	44	9:40AM	430	SNL67	16Feb24	9:52AM	415	SNL67	16Feb24	16
Tm10942	44	10:13AM	430	YKH0	16Feb24	10:26AM	415	YKH0	16Feb24	16
Tm10942	44	10:40AM	430	OS21	16Feb24	10:52AM	415	OS21	16Feb24	16
Tm10942	44	11:22AM	430	YKH0	16Feb24	11:34AM	415	YKH0	16Feb24	16
Tm10942	44	11:40AM	430	YKH0	16Feb24	11:52AM	415	YKH0	16Feb24	16
Tm10942	44	11:57AM	430	YKH0	16Feb24	12:09PM	415	YKH0	16Feb24	16
Tm10942	44	1:16pm	430	SNL67	16Feb24	1:28pm	415	SNL67	16Feb24	16
Tm10942	44	1:40pm	430	CB58	16Feb24	1:52pm	415	CB58	16Feb24	16
Tm10942	44	2:10pm	430	CB58	16Feb24	2:22pm	415	CB58	16Feb24	16
Tm10942	44	2:38pm	430	CB58	16Feb24	2:50pm	415	CB58	16Feb24	16
Tm10942	44	3:15pm	430	SD34	16Feb24	3:27pm	415	SD34	16Feb24	16

① 0521 16 Feb 24



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

**PRODUCTION ORDER#** 500000307848

OP 400

① SD 34  
16 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000307848

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	9:28AM	430	SN667	16 Feb 24	9:40AM	415	SN667	16 Feb 24	16
Tm10745	44	9:57AM	430	YK40	16 Feb 24	10:09AM	415	YK40	16 Feb 24	16
Tm10745	44	10:27AM	430	YK40	16 Feb 24	10:39AM	415	YK40	16 Feb 24	16
Tm10745	44	10:48AM	430	0521	16 Feb 24	11:00AM	415	0521	16 Feb 24	16
Tm10745	44	11:07AM	430	YK40	16 Feb 24	11:19AM	415	YK40	16 Feb 24	16
Tm10745	44	11:47AM	430	YK40	16 Feb 24	11:59AM	415	YK40	16 Feb 24	16
Tm10745	44	12:10PM	430	0521	16 Feb 24	12:22PM	415	0521	16 Feb 24	16
Tm10745	44	1:25pm	430	CB58	16 Feb 24	1:37pm	415	CB58	16 Feb 24	16
Tm10745	44	1:55pm	430	CB58	16 Feb 24	2:07pm	415	CB58	16 Feb 24	16
Tm10745	44	2:20pm	430	CB58	16 Feb 24	2:33pm	415	CB58	16 Feb 24	16
Tm10745	44	2:58pm	430	SN667	16 Feb 24	3:10pm	415	SN667	16 Feb 24	16
Tm10745	44	3:28pm	430	CB58	16 Feb 24	3:40pm	415	CB58	16 Feb 24	16

(P) YK40 16 Feb 24



**PRODUCTION ORDER#** 500000304848

OP 400

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



500000307848

5000037848 ①

PO #: PY4619 Feb 24

OP #: 500 Shift #: 3

Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

Total Parts Reworked:		121	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		9
EH	Exposed Hypotube		20
EW	Exposed Wire		63
MP	Micropores	N/A	N/A
SCR	Scratch		11
SKV	Skive Marks		10
VD	Voids		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		PY 291546 MV33.RA02 ①	16 Feb 24 H Fed 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 PY 19 Feb 24  
correction for RA02



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

PO #: 500000307848 OP #: 500 Shift #: 3rd

Total Parts Reworked:		36	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire		26
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks		1
VD	Voids		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LL61, AR02, CB81 16 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 #: 500000307848OP #: 750 Shift #: 2<sup>nd</sup>

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

Total Parts Reworked:		28	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		10
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Mm02	17Feb24

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 #: 500 600 307848OP #: 750 Shift #: 3

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

Total Parts Reworked:		34	
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)		4
EH	Exposed Hypotube		12
GD	Glue Damage		3
Inspected By (Sign and Date):		IC83	17 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):  X

**PRODUCTION ORDER#** 50000307848

**OP 800**

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	1:10PM	190F	AL42	16 Feb 24	2:20 PM	190F	AL42	16 Feb 24	38
TM12036	N/A	1:40PM	190F	AL42	16 Feb 24	2:50PM	190F	AL42	16 Feb 24	38
TM10409	N/A	2:22PM	190F	KL45	16 Feb 24	3:32 PM	190F	KL45	16 Feb 24	48
TM12036	N/A	3:00 PM	190F	KL45	16 Feb 24	4:10 PM	190F	KL45	16 Feb 24	31
TM10409	N/A	4:25PM	190F	YK40	16 Feb 24	5:35PM	190F	YK40	16 Feb 24	29
TM12036	N/A	5:06PM	190F	YK40	16 Feb 24	6:16PM	190F	YK40	16 Feb 24	30
TM10409	N/A	5:07AM	190F	KL45	17 Feb 24	6:10 AM	190F	KL45	17 Feb 24	51
TM10409	N/A	6:57AM	190F	PL22	17 Feb 24	8:07AM	190F	PL22	17 Feb 24	25
TM12036	N/A	7:25AM	190F	PL22	17 Feb 24	8:35AM	190F	PL22	17 Feb 24	30
TM10409	N/A	8:11AM	190F	PL22	17 Feb 24	9:21 AM	190F	PL22	17 Feb 24	51
TM12036	N/A	8:40AM	190F	BD64	17 Feb 24	9:50AM	190F	BD64	17 Feb 24	32
TM10409	N/A	9:30AM	190F	BD64	17 Feb 24	10:40AM	1990F	BD64	17 Feb 24	33
TM12036	N/A	1:00AM	190F	BD64	17 Feb 24	11:10AM	190F	BD64	17 Feb 24	① 4655

① BD64 17 Feb 24



**PO #:** 500000307848

OP #: 900 Shift #: 3

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.

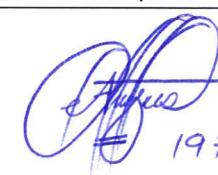
**Data Uploaded for Engineering Review (Check):**

- CONFIDENTIAL -

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	27.82	26.06	28.68	24.69	22.6	28.64	27.86	29.12	27.23	24.6	26.73	2.1623547	4.378	17.2632112	8.542	PASS
Seg B	70.21	69.69	68.39	66.97	57.65	69.34	63.76	73.81	67.77	71.75	67.934	4.517581	3.981	49.9495102	8.542	PASS
Seg C	75.8	82.26	71.79	77.34	79.08	91.73	78.31	87.69	90.28	86.87	82.115	6.7148414	2.911	62.5680968	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 #: 500000307848  
 Date: 19FEB2024  
 Inspector Name: AUGUSTINE JAH  
 Equipment ID: TMI0311B  
 Cal Due Date: 27 OCT 24



se.  
 # 19 FEB 2024