

# Production Order: 500000301829



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 Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>1002 8:30 am 01Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 68 11:00pm 03 Feb 24</u> Record Dryer Shelf #: <u>N/A</u></p> <table border="1"> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev Used</th> <th>UOM</th> <th>Qty.</th> <th>Batch No.</th> <th>Actual Qty Used</th> </tr> </thead> <tbody> <tr> <td>MM0179-01</td> <td>D <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000294700</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>N/A</u></td> <td><u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></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 <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>	N/A	N/A	31/01/24 LAK70
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																								
MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u>																								
				<u>N/A</u>	<u>N/A</u>																								
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>																								

Notes: DA 2564, 2484

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u> <u>81054</u>	<u>N/A</u> <u>130</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>88367</u> <u>88382</u> <u>88441</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>N/A</u> <u>0000288401</u>	<u>N/A</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>N/A</u>	<u>Bulk</u> <u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>Bulk</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	85794	502			
		RM7349-02	C	c	PC	543	82865 82860 82852	200 16 400	N/A		
		RM7348-01	C	c	PC	500	84584	500	N/A		
		RM4001-01	B	B	PC	125	82819	100	N/A	N/A	N/A
		RM0607-01	D	D	PC	56	78846	50	N/A	N/A	N/A
		RM0498-01	C	c	PC	500	0000287646	468	N/A		
		RM0009-04	I	I	PC	1	79170	Bulk			
		RM0009-04	I	I	PC	1	79170	Bulk			

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	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>N/A</u>	<u>Bulk</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>N/A</u>	<u>1000</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>N/A</u>	<u>60</u>		
		MM0178-01	E	<u>e</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000271050</u>	<u>N/A</u>	<u>40</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000288413</u>	<u>N/A</u>	<u>500</u>		
							<u>0000281411</u>	<u>N/A</u>	<u>40</u>		
Notes:											

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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	04Feb24	CB58
	Line Clearance  Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	04Feb24	YK40 SD34
	Major and Minor Mandrel Assembly					

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
200	CATASY01  Catheter Assembly 1  	Loading Braid Stock    Loading Braid Stock  Confirmation Reqd(Milestone )	500	0	04Feb24 ST96 MC17	MY50
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	04Feb24 V078 MC17 PL22	CD19

**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 )	500	0	04Feb24	AIGS PY67 MC17
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	04Feb24	CX63 RL47 MC17

**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	 Load Tubing  Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	<b>CATASY01</b> Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone)		500	0	04Feb24	AM47 SN47
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	04Feb24	YKHO

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
	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 <b>Material Consumed:</b> Part #: <u>1000-1153-01</u> Batch #: <u>88367</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	492	EIU-HP11 VD-1 ⑧	MM02 LS46 MV33 5V46 04Feb24	
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone )					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
<b>Notes:</b>						
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 )	461	MAH - IHT 111 IHT 1X IHT  DL-IHT 1 IDB - 1 EH - 1  31	04Feb24	RS23 AX82 SC10
600	CATASY01  Catheter Assembly 1  	Distal Tip Assembly  Distal Tip Assembly  Confirmation	461	0	04Feb24	AX82 SC10

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink	461	0	04Feb24	LH45
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01  Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31MAR24 TMI: 2083C Cal Due: 31MAR24 TMI: 0386 Cal Due: 31MAR24 TMI: 0521 Cal Due: 31MAR24  Tipping	461	0	04Feb24	IIC83 B160
<b>Notes:</b>						
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	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 #: 82819 Qty: N/A Part #: RM0607-01 Batch #: 78846 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	459	EH - 1 DL - 1  ②	04Feb24 IC83	BIGO
800	CATASY01  Catheter Assembly 1    Major Mandrel Removal		457	ACD-11  ②	04Feb24	KL45 AL42 TRN

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 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. Pass    2. Pass    3. Pass    4. Pass    5. Pass	450	SKV-NHII 7	04Feb24	KL45
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
<b>Notes:</b>						
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	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>31MAY24</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>82819</u> Qty: <u>N/A</u> Part #: <u>RM0607-0</u> Batch #: <u>78846</u> Qty: <u>N/A</u> Part #: <u>1000-1153-01</u> Batch #: <u>88441</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>	412	SCR-HH/SP SCR-HK/TT FM-HK/TT #1DS-1111 EW-HKII HK #6DS-1 #6US-1 DS-11 #7DS-1 EH-1 MAR-1 38	04Feb24	MV33 PP40 KX54 DL09
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

N/A

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N/A	 <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	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>30Sep25</u> TMI: <u>0692</u> Cal Due: <u>30Sep25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	391	DIS-IH #90S-III STR-III (2)	04Feb24	A67
1000	<b>QUALITY1</b>   <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31MAY24</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30Sep24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30Sep24</u>	385 384	LT-IH II (1) (6) (7)	04Feb24	CB58

Notes:

N/A

N/A

N/A

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① P446 05 Feb 24 signed for CB58

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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	3ub	- Del - M1 III - DIS - M1 III - VD - M1 - SCR - III - DISC - III - Mex - III - Mar - III - STN - 1 - BP - 1 - PBC - 1 ew - 1  (28)	05 Feb 24	SV43
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): KFD2 05Feb24	N/A	N/A	05 Feb 24	KFD2

Notes:

N/A

N/A

N/A

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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	346 ① Hot	○ 06 Feb 24	06 Feb 24 AP10	AP10 06 Feb 24

**Notes:**

N/A AP10 06 Feb 24

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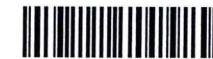


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**Batch Number:** 0000301829

**By:** AP10

**Date:** 06 Feb 24

**Reviewed By:**

RB29

**Date:**

06 Feb 24

**Notes:**

N/A AP10 06 Feb 24

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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

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**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 MM1536-01 fixture for inspection. (See image 1)  
*①MM0179-01 type correction TS12 10AUG23*

**CONTROLLED COPY**



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)

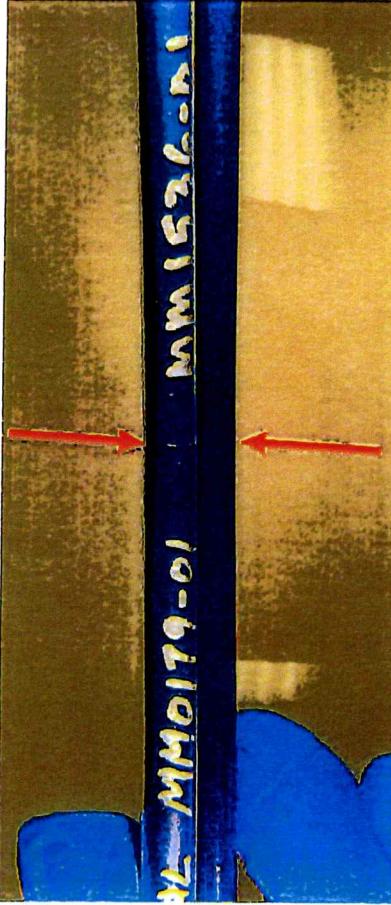
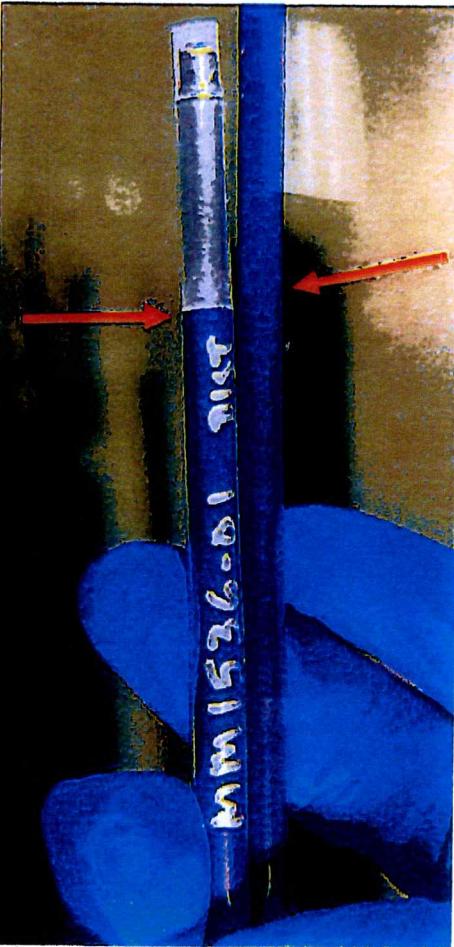


Image- 3

- 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)



- 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 14 Jan 2028 12/12/0623  
Entered to 13 Feb 2028 1/9/2024

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is part of



## 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 <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.		
<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 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



Document No: 5105589  
FM104665 Rev: C  
Document Type: Manufacturing Form  
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000301829

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:04PM	430	RL47	03Feb24	12:16 PM	415	RL47	03Feb24	16
TM10942	44	1:44pm	430	SD34	03Feb24	1:54pm	415	SD34	03Feb24	16
TM10942	44	2:16PM	430	SD34	03Feb24	2:28pm	415	SD34	03Feb24	18
TM10942	44	2:30pm	430	SD34	03Feb24	2:42pm	415	SD34	03Feb24	16
TM10942	44	3:08PM	430	V078	03 Feb 24	3:20pm	415	V078	03 Feb 24	16
TM10942	44	4:40pm	430	cm99	03Feb24	4:52pm	415	cm99	03Feb24	16
TM10942	44	5:30PM	430	V078	03 Feb 24	5:42pm	415	SN47	03 Feb 24	16
TM10942	44	6:11pm	430	cm99	03Feb24	6:23pm	415	cm99	03Feb24	16
TM10942	44	7:09am	430	cm99	04Feb24	7:21am	415	cm99	04Feb24	16
TM10942	44	7:35AM	430	AM47	04Feb24	7:47am	415	AM47	04Feb24	16
TM10942	44	8:04am	430	cm99	04Feb24	8:16am	415	cm99	04Feb24	16
TM10942	44	8:29am	430	cm99	04Feb24	8:41am	415	cm99	04Feb24	16



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

**Title: SA0155-01 Reflow Log Sheet Form**

**PRODUCTION ORDER#** 500000301829

OP 400

① cm99 04Feb24



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

PRODUCTION ORDER# 500000 301829

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:50am	430	SN67	03Feb24	12:02pm	415	SN67	03Feb24	16
Tm10745	44	12:21pm	430	CD19	03Feb24	12:23pm	415	CD19	03Feb24	16
Tm10745	44	1:30pm	430	cm99	03Feb24	1:42pm	415	cm99	03Feb24	16
TM10745	44	2:02pm	430	SD34	03Feb24	2:14pm	415	SD34	03Feb24	16
TM10745	44	2:46pm	430	SD34	03Feb24	2:58pm	415	SD34	03Feb24	16
TM10745	44	3:23pm	430	SD34	03Feb24	3:35pm	415	SD34	03Feb24	16
TM10745	44	4:24pm	430	SD34	03Feb24	4:38pm	415	SD34	03Feb24	16
Tm10745	44	5:01pm	430	YK40	03Feb24	5:13pm	415	YK40	03Feb24	16
Tm10745	44	5:52pm	430	cm99	03Feb24 <sup>①</sup>	6:04pm	415	cm99	03Feb24	16
TM10745	44	6:22PM	430	AM47	03Feb24	6:34PM	415	AM47	03 Feb24	8
Tm10745	44	8:16am	430	cm99	04Feb24	8:28am	415	cm99	04Feb24	16
Tm10745	44	9:11am	430	cm99	04Feb24	9:23am	415	cm99	04Feb24	16

① SD34  
03Feb24



**PRODUCTION ORDER#** 30000501829

OP 400

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

① cm99 04Feb24



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

PO #: 500000301829 OP #: 500 Shift #: 2<sup>nd</sup>

Total Parts Reworked:		25	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		1
EW	Exposed Wire		20
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):		MM02	03Feb24

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 50000301828

N/A ① ①

PO #: 50000301828  
50000301829

OP #: 500 Shift #: 3

Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

Total Parts Reworked:		129	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		4
EH	Exposed Hypotube		34
EW	Exposed Wire		70
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		5
VD	Voids		10
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

Ls46 - ARD

03 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):

①

Ls46 03 Feb 24



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

PO #: 500000301829 OP #: 500 Shift #: 3

**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 PY46 05 Feb 24

PRODUCTION ORDER# 500000301829

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	6:00 AM	190F	KL4S	04 FEB 24	7:10 AM	190F	KL4S	04 FEB 24	66
TM10409	N/A	7:22 AM	190F	KL4S	04 FEB 24	8:32 AM	190F	KL4S	04 FEB 24	45
TM12036	N/A	7:59 AM	190F	KL4S	04 FEB 24	9:09 AM	190F	KL4S	04 FEB 24	45
TM10409	N/A	9:30 AM	190F	SN67	04 FEB 24	10:40 AM	190F	SN67	04 FEB 24	45
TM12036	N/A	10:19 AM	190F	KL4S	04 FEB 24	11:29 AM	190F	KL4S	04 FEB 24	50
TM10409	N/A	11:05 AM	190F	AL42	04 FEB 24	12:15 PM	190F	AL42	04 FEB 24	39
TM12036	N/A	12:03 PM	190F	AL42	04 FEB 24	01:13 PM	190F	AL42	04 FEB 24	54
TM10409	N/A	12:25 PM	190F	AL42	04 FEB 24	01:35 PM	190F	AL42	04 FEB 24	23
TM10409	N/A	01:36 PM	190F	AL42	04 FEB 24	02:46 PM	190F	AL42	04 FEB 24	30
TM12036	N/A	02:15 PM	190F	AL42	04 FEB 24	3:25 PM	190F	AL42	04 FEB 24	29
TM10409	N/A	2:50 PM	190F	KL4S	04 FEB 24	4:00 PM	190F	KL4S	04 FEB 24	31
				N/A						
				KL4S	04 FEB 24					



PO #: 500000301829

OP #: 750 Shift #: 3

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		54	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		22
DIM07 US / WC	DIM07 Undersized (Window Closed)		2
EH	Exposed Hypotube		16
GD / AB	glue damages/air bubbles		24
Inspected By (Sign and Date):		BT60 04 FEB 2024	

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 #: 500 060 361 829 OP #: 750 Shift #: 3

Total Parts Reworked:		35	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		22
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		7
GD	Glue Damage		3
Inspected By (Sign and Date):		IL83	04FEB24

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 #: 500000301829OP #: 900 Shift #: 3

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		193	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		14
EH	Exposed Hypotube		13
EW	Exposed Wire		89
MP	Micropores	N/A	N/A
SCR	Scratch		84
SKV	Skive Marks		9
VD	Voids		32
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		19
DIM06 OS	DIM06 OD Oversized		14
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		DL07, 1946, KX54	04Feb24

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	25.92	24.89	25.91	26.22	24.97	24.85	26.9	25.18	25.29	26.62	25.675	0.7448378	4.378	22.4141002	8.542	PASS
Seg B	59.26	56.48	60.33	58.45	66.35	55.78	73.29	57.44	57.61	62.16	60.715	5.3957128	3.981	39.2346673	8.542	PASS
Seg C	83.25	78.4	80.28	81.76	76.96	78.86	71.82	78.67	75.47	79.36	78.483	3.2221216	2.911	69.1034039	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 #: 500000301829

Date: 05 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TM10311B

Cal Due Date: 27 OCT 24

05Feb24