

Production Order: 500000306365



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

Material: SA0155-01 Rev F

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

Order Type: ZSTD

Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3 Kitting Devices 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Am 68 10:00am Feb 11</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>11Feb24</u></p> <p>Record Dryer Shelf #: <u>n/a</u></p>				

Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
MM0179-01	D D	PC	500	<u>0000261884</u> <u>XCB 13FEB24</u>	<u>500</u>
MM1536-01	B B	PC	500	<u>00002910560</u>	<u>500</u>

Notes: DA 2484, 2564

N/A

N/A

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(1) Am 68 11Feb24

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	RM0158-01	E	<u>E</u>	PC	200	N/A 81054	N/A 150			
		A	<u>A</u>	PC	594	N/A 88214 88217 88218	N/A 200 200 200			
		A	<u>A</u>	PC	500	0000287543	500			
		A	<u>A</u>	PC	500	N/A 0000288401	N/A 500	N/A	as feb all	VLG0
		E	<u>E</u>	PC	70	N/A	N/A			
		J	<u>J</u>	PC	5	N/A	Bulk			
		J	<u>J</u>	PC	5	N/A	Bulk			
						N/A	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
M8 N/A	141967-01	02	02	PC	500	85794 <i>XC31 13FEB24</i>	463 <i>87453 87435 85502</i>				
	RM7349-02	C	C	PC	543	82871 <i>82872 82873</i>	200 <i>200 130</i>				
	RM7348-01	C	C	PC	500	84588 N/A	N/A				
	RM4001-01	B	B	PC	125	88536	550				
	RM0607-01	D	D	PC	56	82807 <i>N/A</i>	100 <i>N/A</i>				
	RM0498-01	C	C	PC	500	74662 <i>N/A</i>	84 <i>N/A</i>				
	RM0009-04	I	I	PC	1	00602857648 <i>N/A</i>	476 <i>N/A</i>				
	RM0009-04	I	I	PC	1	88992 <i>N/A</i>	Bulk <i>Bulk</i>				

Notes:

N/A

N/A

N/A

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① 09FEB24 T804

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Material: SA0155-01 Rev F

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials	
		MM1538-01	A	<u>A</u>	PC	500	<u>0000241052</u> <u>00002410562</u> <u>0000258434</u> <u>0000265874</u>	Bulk 20 500 120 360			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	1.080			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	500	N/A		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	500	N/A	08 Feb 24	
		MM0178-01	E	<u>E</u>	PC	500	<u>0000290565</u>	500	N/A	08 Feb 24	
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	500	N/A	08 Feb 24	
		MM0074-01	G	<u>G</u>	PC	500	<u>0000361889</u>	512	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	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	12Feb24 ny35-	ST96
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	12Feb24 AS31 AT39	
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 . .	500	0	12Feb24	ep22 as22
350	CATASY01 Catheter Assembly 1	Load Tubing . .	500	0	12Feb24	CL05 DX35

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				
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	12Feb24 SY47 V078	
450	CATASY01 Catheter	FEP Removal	500	0	13Feb24 JY90 PM96	
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
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	485	0	13 Feb 24	PP40 mmoz FB01 R523
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	478	DL- ⑦	13 Feb 24	AT39 PH59 FB01

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
MR	Reqd(Milestone)		MA		N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink Loading Heat Shrink Confirmation Reqd(Milestone)	478	O 13 Feb 24	ML38 VA96	
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0521</u> Cal Due: <u>31 May 24</u> TMI: <u>2083C</u> Cal Due: <u>31 May 24</u> TMI: <u>0386</u> Cal Due: <u>31 May 24</u> TMI: <u>0936A</u> Cal Due: <u>31 May 24</u>	476	O 13 Feb 24	ML38 STX48 HV36	
Notes:						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MX	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Material Consumed: Part #: RM0607-01 Batch #: 74662 Qty: 5 Part #: RM4001-01 Batch #: 82801 Qty: 10 Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	478	0	13 Feb 2024	SV46 STX48 Hv36	
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal	H63	ACD-111111 111 15	13 Feb 2024	SG88 SS44 SS52	

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 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	463	0	13 Feb 2024	Y986 SS52
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	SH04 HT72 MK33 TRN KY86

Notes:

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MIA	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 #: 202401-01 Batch #: 82807 Qty: 16</p> <p>Part #: 1000-1153-01 Batch #: 88216 Qty: N/A</p> <p>Part #: 202407-01 Batch #: 74662 Qty: 8</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	419	DIS-HH-HH MAR-1111 SCR-11 BW-1 EW-111 WKL-11-SP DEL-11-SP DS-1 #10S-11 #60S-HH #90S-111 #50S-1 DL-11 #10S-11 ACD-1	266 XL91 k155 P146 FCN (44)	
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: 50713B Cal Due: 12 Apr 24</p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

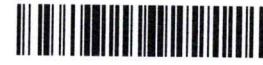
N/A

N/A

N/A

N/A

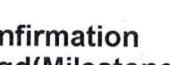
N/A



SA0155-01



Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: 0733 Cal Due: 30 Apr 24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 Sep 25 TMI: 0692 Cal Due: 30 Sep 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	402	KNK-11 DIS-444 HTT 1 SFP ① STK-1111 ⑦	14 Feb 24	XL91
1000	QUALITY1  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: 1056 Cal Due: 31 May 24 Record Length Gage Information: TMI: 0629 ① Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 Sep 24	397	LT-444 ⑤	14 Feb 24	XL91 SS44

Notes:

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① incorrect value
 TMI: 0889D

XL91 12 Feb 24

① P446 13 Feb 24

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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	361	SCR- 111111 (TT) FM-11 VD- 111111 TL-11 DIS-111 FB-11 BP-1 DISC-11 DEL-1 GN11-1 PBC-11 (36)	13Feb24	SV43 Zg50 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>XC31</u> <u>13FEB24</u>	N/A	N/A	13FEB24	XC31
Notes:		N/A N/A N/A				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	361	0 <i>14Feb24</i>	<i>BA71</i>	

Notes:

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Material: SA0155-01 Rev F

Batch Number: 0000306365

By: BA71

Date: 14 FEB 24

Reviewed By:

RB29

Date:

16 FEB 24

Notes:

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Entered to Handout 3208 12/16/2023

Entered to 13 February 3208 1/6/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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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 lasemic 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

EDWARD & ROSE
EDWARD & ROSE 11/15/23



CREGANNA

Expiry Date + **22-Nov-2023** **5288** **P061123**
is part of **MEDICAL**

Requestor Name: Utkarsh Kannan
Date to 2023 DE VATICAN
1/31/2023

DEVIATION FORM B767-2 to 2308-2023
* See attached email extension to 24SÉP23
TS2 24AUG23 2308-2023 J28
2157

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

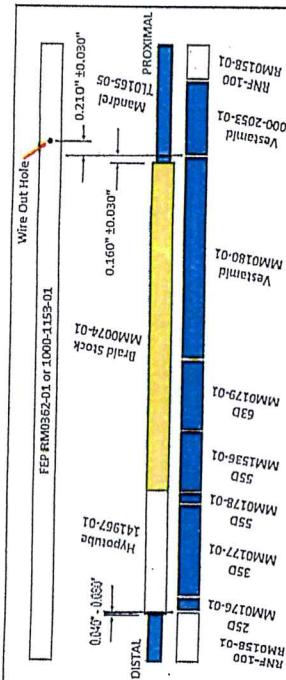
CONTROLLED COPY

Document Number Affected

Deviation From:

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

...הנִזְבֵּן עַל־תְּחִילָה כְּגַם־בְּגַדְיוֹן.



Dantzig

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 Form 2020-07-01.

See instructions attached to this DA.

Dantzig

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 Form 2020-07-01.

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 flavor of inspection to the existing ones.

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

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Risk Assessment: Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:
Control Plans Yes No FMEA's Yes No Validations Yes No

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Corrective Action Required: 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.

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:

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



DA | 2484
DA | 2468*

Group Training Record

Description/Objectives of Training:

DA- Inspection at final QC, Op#1050.

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)

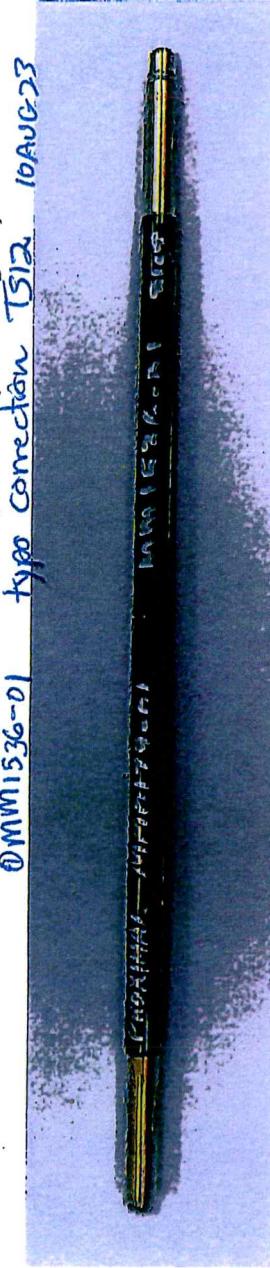


Image- 1

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)

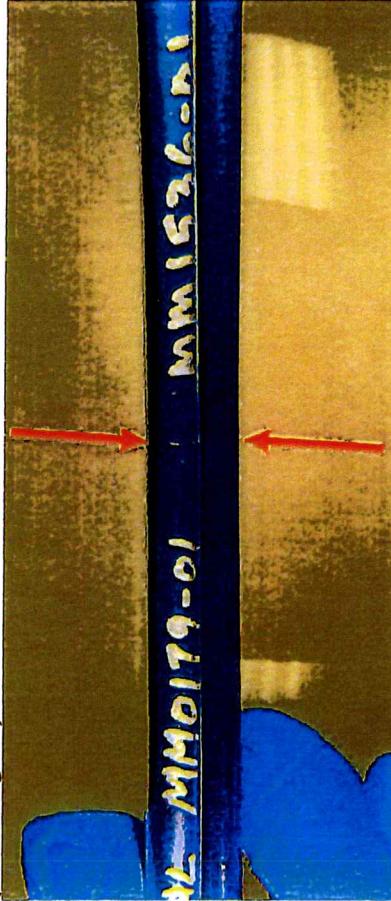


Image- 3

- 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)

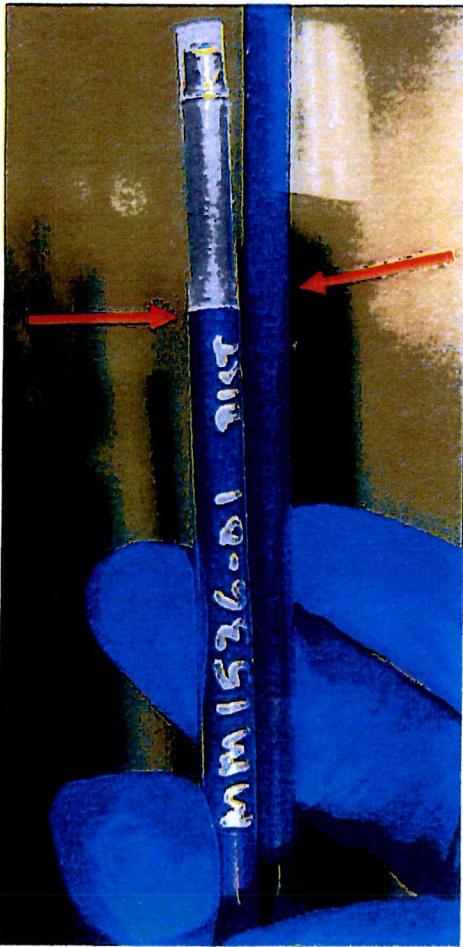


Image- 4

- 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	MM1536-01
GOOD PART		
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



PRODUCTION ORDER# 500000306365

OP 400

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



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

PRODUCTION ORDER# 500000306365

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	4:38pm	428	V078	12 Feb 24	4:50pm	415	JY90	12 Feb 24	16
Tm10745	44	5:18pm	430	V078	12 Feb 24	5:30pm	415	V078	12 Feb 24	16
Tm10745	44	6:33pm	430	V078	12 Feb 24	6:45pm	415	V078	12 Feb 24	16
Tm10745	44	7:05pm	429	Sy47	12 Feb 24	7:17pm	415	Sy47	12 Feb 24	16
Tm10745	44	7:32pm	429	Sy47	12 Feb 24	7:44pm	415	Sy47	12 Feb 24	16
Tm10745	44	8:00pm	429	Sy47	12 Feb 24	8:12pm	415	AT39	12 Feb 24	16
Tm10745	44	9:07PM	430	Sy47	12 Feb 24	9:19PM	415	Sy47	12 Feb 24	16
Tm10745	44	9:37PM	430	CL30	12 Feb 24	9:49PM	415	CL30	12 Feb 24	16
Tm10745	44	10:17PM	430	CL30	12 Feb 24	10:29PM	415	CL30	12 Feb 24	16
Tm10745	44	10:40PM	430	CL30	12 Feb 24	10:52PM	415	CL30	12 Feb 24	16
Tm10745	44	11:30PM	430	CL30	12 Feb 24	11:42PM	415	CL30	12 Feb 24	16
Tm10745	44	11:50 PM	430	CL30	12 Feb 24	12:02 AM	415	CL30	13 Feb 24	16



Document No: 5105589
FM15104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306365

OP 400



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

PRODUCTION ORDER#: 500000306365

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	5:05 pm	430	Sy47	12 Feb 24	5:17 pm	415	Sy47	12 Feb 24	16
Tm10942	44	5:32 pm	428	V078	12 Feb 24	5:44 pm	415	V078	12 Feb 24	16
Tm10942	44	6:23 pm	429	V078	12 Feb 24	6:35 pm	415	V078	12 Feb 24	16
Tm10942	44	6:47 pm	427	V078	12 Feb 24	6:59 pm	415	Sy47	12 Feb 24	16
Tm10942	44	7:18 pm	429	Sy47	12 Feb 24	7:30 pm	415	Sy47	12 Feb 24	16
Tm10942	44	7:45 pm	428	V078	12 Feb 24	7:57 pm	415	AT39	12 Feb 24	16
Tm10942	44	8:50 pm	430	AT39	12 Feb 24	9:02 pm	415	CL30	12 Feb 24	16
Tm10942	44	9:20 pm	428	Sy47	12 Feb 24	9:32 pm	415	Sy47	12 Feb 24	16
Tm10942	44	9:45 pm	430	CL30	12 Feb 24	9:57 pm	415	CL30	12 Feb 24	16
Tm10942	44	10:27 pm	430	Sy47	12 Feb 24	10:39 pm	415	Sy47	12 Feb 24	16
Tm10942	44	10:55 pm	430	CL30	12 Feb 24	11:07 pm	415	CL30	12 Feb 24	16
Tm10942	44	12:05 am.	430	CL30	13 Feb 24	12:17 am	415	CL30	13 Feb 24	16



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

PO #: 500000306365

OP #: 500 Shift #: 2nd

Total Parts Reworked:		51	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		5
EH	Exposed Hypotube		9
EW	Exposed Wire		25
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks	N/A	N/A
VD	Voids		9
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MV78 12 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 #: 500000306365

OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>57</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/ / /	<u>3</u>
EH	Exposed Hypotube	/ / /	<u>4</u>
EW	Exposed Wire	/ / / / / / / / / / / / / / / /	<u>32</u>
MP	Micropores	n/a	n/a
SCR	Scratch	/ / / / /	<u>7</u>
SKV	Skive Marks	n/a	n/a
VD	Voids	/ / / / / / / / / /	<u>18</u>
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		<u>Vammeej Lor 12 Feb 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):



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

PO #: 500000306365

OP #: 500

Shift #: (5)

Total Parts Reworked:		62	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire		50
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		DY29, LLG1, VC09	13 Feb 24

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

Data Uploaded for Engineering Review (Check):



PO #: 500000306365

OP #: 750 Shift #: 2

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)		31
DIM07 US / WC	DIM07 Undersized (Window Closed)		6
EH	Exposed Hypotube		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 12 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 #: 50000306365 OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		33	
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)		2
EH	Exposed Hypotube		3
N/A	Glue - stopper		5
Inspected By (Sign and Date):		PH 59	13 Feb 24

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

PRODUCTION ORDER# 500008306365

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	8:00pm	190°F	SG88	12 Feb 24	9:10pm	190°F	SG 88	12 Feb 24	40
TM10409	N/A	9:37pm	190°F	SG88	12 Feb 24	10:47pm	190°F	SG88	12 Feb 24	59
TM12036	N/A	10:11pm	190°F	SG88	12 Feb 24	11:12pm	190°F	SG88	12 Feb 24	35
TM10409	N/A	10:54pm	190°F	SG88	12 Feb 24	12:04am	190°F	SG88	13 Feb 24	38
TM10409	N/A	12:22am	190°F	SG88	13 Feb 24	1:32am	190°F	SG88	13 Feb 24	39
TM12036	N/A	1:03am	190°F	SG88	13 Feb 24	2:13am	190°F	AT39	13 Feb 24	28
TM10409	N/A	5:00am	190°F	SS44	13 Feb 24	6:10am	190°F	SS44	13 Feb 24	33
TM12036	N/A	5:35am	190°F	SS44	13 Feb 24	6:45am	190°F	SS44	13 Feb 24	38
TM10409	N/A	6:15am	190°F	K155	13 Feb 24	7:25am	190°F	K155	13 Feb 24	30
TM10409	N/A	7:40am	190°F	SS44	13 Feb 24	8:50am	190°F	SS44	13 Feb 24	42
TM12036	N/A	8:10am	190°F	K155	13 Feb 24	9:20am	190°F	K155	13 Feb 24	31
TM10409	N/A	9:50am	190°F	SS44	13 Feb 24	11:00am	190°F	SS44	13 Feb 24	50
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① p46 14 Feb 24 correction for SG88



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306365 OP #: 900 Shift #: 2

Total Parts Reworked:		26	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	1	1
EW	Exposed Wire		10
MP	Micropores	N/A	N/A
SCR	Scratch		26
SKV	Skive Marks	N/A	N/A
VD	Voids		2
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	HT72 N/A 12 Feb 24	
Inspected By (Sign and Date):		HT72 12 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 #: 500000306365

OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		11	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		5
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		7
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Joe H 12 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 #: 500000 306365

OP #: 900 Shift #: 2

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		28	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		4
MP	Micropores	N/A	0
SCR	Scratch		30
SKV	Skive Marks	N/A	0
VD	Voids	/	1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	N/A	0
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	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. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

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Page 1 of 1

Status CURRENT Effective 5/8/2023



PO #: 500000306365 OP #: 900 Shift #: 1st

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		1
EW	Exposed Wire		25
MP	Micropores		N/A
SCR	Scratch		42
SKV	Skive Marks		1
VD	Voids		11
DIM01 US	DIM01 OD Undersized		N/A
DIM06 US	DIM06 OD Undersized		7
DIM06 OS	DIM06 OD Oversized		N/A
DIM09 US	DIM09 OD Undersized		N/A

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

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Status CURRENT Effective 5/8/2023

Maximum Force Reached During Tensile Test
 (10 samples accepted from final inspection for each lot shall be selected and tensile tested)

Sample # →	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	32.61	22.6	25.18	26.15	24.24	27.09	30.54	33.64	27.57	24.91	27.453	3.6780854	4.378	11.3503421	8.542	PASS
Seg B	70.96	67.26	77.12	72.57	76.08	76.01	68.56	71.43	71.94	71	72.293	3.250959	3.981	59.3509322	8.542	PASS
Seg C	77.24	86.31	82.64	82.58	90.62	76.4	79.41	78.53	78.71	87.38	81.982	4.7860719	2.911	68.0497446	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 #: 500000306365

Date: 14FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



14 FEB 2024