

Production Order: 500000294407



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

Material: SA0155-01 Rev F

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

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials																								
50	KITTING3 Kitting Devices 	<p>Kitting Devices</p> <p>Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Am 68 11:00 PM 11 Jan 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 68 10:30 am 13 Jan 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	11 JAN 24	SA10																								
	Kitting Devices	<table border="1"> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev Used</th> <th>UOM</th> <th>Qty.</th> <th>Batch No.</th> <th>Actual Qty Used</th> </tr> </thead> <tbody> <tr> <td>MM0179-01</td> <td>D <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000276172</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>0000281412</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>0000276172</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>				
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D <u>D</u>	PC	500	<u>0000276172</u>	<u>500</u>																									
				<u>N/A</u>	<u>N/A</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>																									

Notes: DA2584, 2484

N/A

N/A

Date Printed: 11.01.2024 / 15:20:50

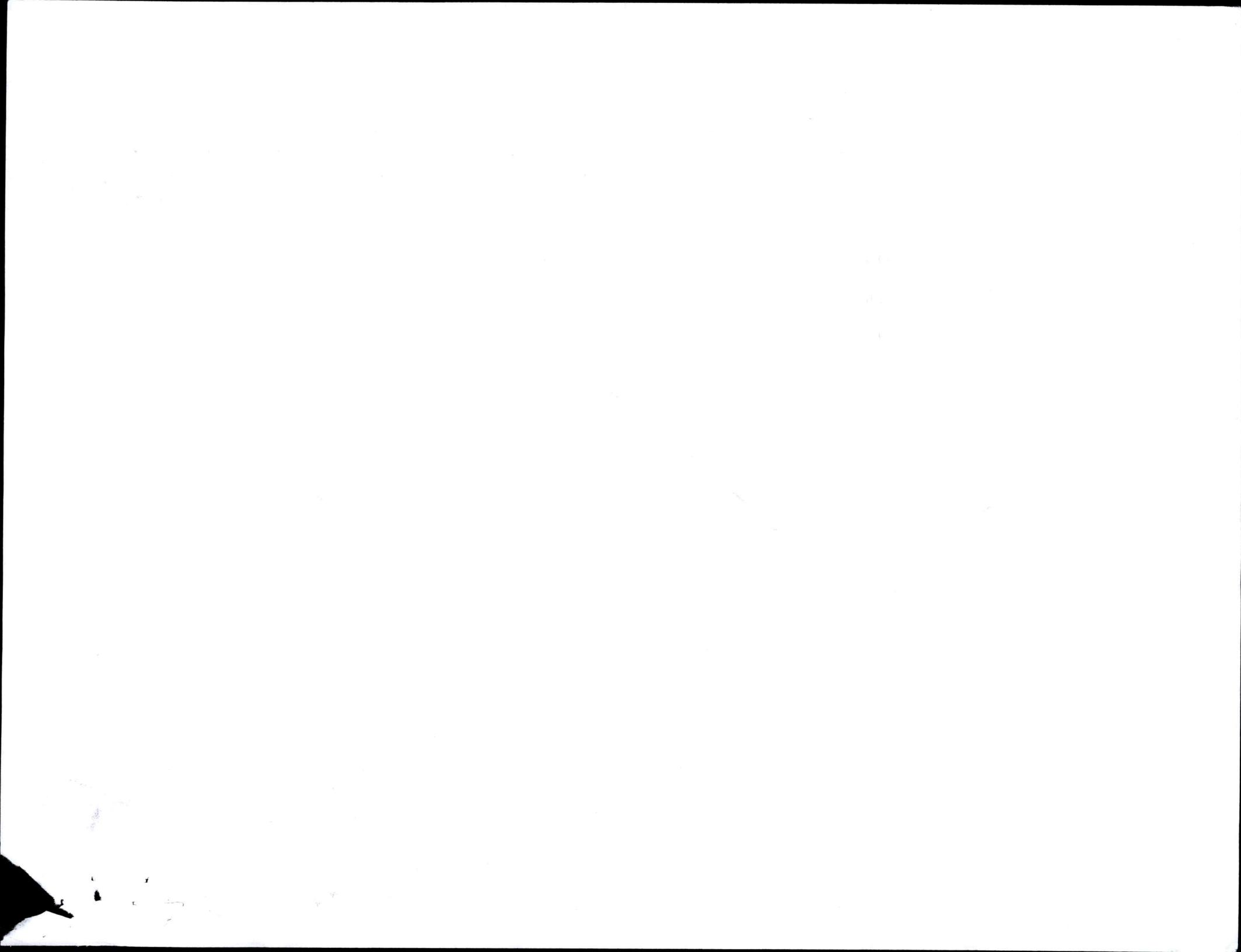
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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	RM0158-01	E	<u>E</u>	PC	200	<u>58497</u>	<u>N/A</u>	<u>ISO</u>			
		A	<u>A</u>	PC	594	<u>87648</u> <u>87649</u> <u>87450</u>	<u>N/A</u>	<u>200</u> <u>200</u> <u>200</u>			
		A	<u>A</u>	PC	500	<u>0000278880</u>	<u>N/A</u>	<u>500</u>			
		A	<u>A</u>	PC	500	<u>0000276175</u>	<u>N/A</u>	<u>500</u>			
		E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>				
		J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>				
						<u>N/A</u>	<u>Bulk</u>				

Notes:

N/A

N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MA N/A		141967-01	02	02	PC	500	85500	505	N/A		
		RM7349-02	C	C	PC	543	82851 82852 82726 82728	130 100 200 100	N/A		
		RM7348-01	C	C	PC	500	82884	500	N/A		
		RM4001-01	B	B	PC	125	82472	200	N/A		
		RM0607-01	D	D	PC	56	71863	120	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	0000287640	435	N/A	N/A	
		RM0009-04	I	I	PC	1	82971	Bulk	N/A	N/A	
		RM0009-04	I	I	PC	1	82971	Bulk	N/A	N/A	

Notes:

N/A
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Opr No.	Planned WorkCenter Description	Operation Details					Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	MM1538-01	A	<u>A</u>	PC	500	<u>N/A</u>	<u>Bulk</u>			
						<u>0000278970</u>	<u>500</u>			
						<u>N/A</u>	<u>N/A</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000281413</u>	<u>1180</u>		
						<u>N/A</u>	<u>N/A</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>500</u>		
						<u>N/A</u>	<u>N/A</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>
						<u>N/A</u>	<u>N/A</u>			
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>500</u>		
						<u>N/A</u>	<u>N/A</u>			
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>500</u>		
						<u>N/A</u>	<u>N/A</u>			
		MM0074-01	G	<u>G</u>	PC	500	<u>0000286951</u>	<u>517</u>		
						<u>N/A</u>	<u>N/A</u>			

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	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 Line Clearance Confirmation Reqd(Milestone)	500	0	16Jan24	CB58
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	16Jan24	JCGZ SD34 YK40 AM47 PM96 RN27 AF54

Notes:

N/A

N/A

N/A

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N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	16Jan24	P767 CD19 AL34 SXII
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	16Jan24	LH45 CD19 MU50 MU6
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
	Trim Braid Wire at Proximal End N/A Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1 Insert Cut Hypo Tube Insert Cut Hypo Tube Confirmation Reqd(Milestone)	Insert Cut Hypo Tube	500	0	16Jan24	S10 PV16 VPG2 W25
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	16Jan24	S1067 CDP1 RL47 CX03 C975
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	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	16Jan24	AM47 TRN R11P PM96 NK62 AX05 AF54 SN67
450	CATASY01 Catheter	FEP Removal	500	0	16Jan24	SD34 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
	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 #: 87109 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	473	EW-11 SKV-11 EW-11K OF-1XX 1XX 111 SKV- 1111 Bmp -1 (27)	16Jan24	CB81 PT09 VC09 TA36 LL61
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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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)	473	① MAH-II 0	16Jan24	MH10 LL61 FB01 RS23 VA96
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	451	DL - HHT HHT 1 MAH - HHT II IDB - III (22)	15Jan24	MH10 FB01 RS23 VA96

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	451	0	16Jan24	IC83 TPA PT09 FBO1 DV39
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31May24 TMI: 2083C Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 6521 Cal Due: 31May24	451	0	16Jan24	IC83 HV36 RS23

Notes: N/A
N/A
N/A

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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 #: 82472 Qty: N/A Part #: RM0607-01 Batch #: 71863 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	451	0	16Jan24	I683 STX48 Hv36
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		444	ACD-HIT 11 (7)	16Jan24	SSH4 SS52

Notes:

N/A

N/A

N/A

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	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. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	① 444 443	① ② SKV-1	16 Jan 24	SS52 Y936
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:

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
NA	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 24</u> TMI: <u>1000-153-01</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>Pm6001-01</u> Batch #: <u>82422</u> Qty: <u>17</u> Part #: <u>1000-153-01</u> Batch #: <u>87648</u> Qty: <u>14</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></p>	362	<p>DEL-HHHTH HHHTHHTH HHHTHHTH WK-HHHTH #70S-III DIS-HHHTH II DZ-III SKV-1 SCR-III #90S-III EW-HHHTH #10S-III BP-1</p>	16 Jan 24	DS21 SSH44TRN SH04 HT72 M6b5 PY46 KT217 K155 XL91 KL67
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & 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>	NA	NA	NA	NA

Notes:

N/A

N/A

N/A

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OPY46 16 Jan 24



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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)	TMI: <u>MA</u> Cal Due: <u>MA</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>	329	DIS - HHT HHT HHT CM WK-1 SP - HM	16 Jan 24	XL91 KL67
1000	 Quality Inspection & Review Quality Inspection & Review Confirmation Reqd(Milestone)	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>08890</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u>	317	LT - HHT HHT 16 Jan 24		SS H4 XL91 KL67

Notes:

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N/A



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N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone)	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	285	• SCR - II (TT) • DL - II (TT) • DIS - II • V.D - II • SKV - II • RDG - I • DISC - II • DL - II • EW - II • KVK - I B2	16 Jan 24	SV43 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02</u> <u>17Jan24</u>	N/A	N/A	17 Jan 24	KP02

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	285	0 19 Jan 24 AP10	AP10	

Notes:

N/A AP10 19 Jan 24

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Batch Number: 0000294407

By: AP10

Date: 19 Jan 24

Reviewed By:

RB29

Date:

19 JAM 24

Notes:

N/A AP10 19 Jan 24

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Entered to Krishna 3228 11/16/2023
Entered to 13 Feb 2024 3228 1/9/2024

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 FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A If yes to any of the above, what controls are being put in place to mitigate the risk - N/A		
Corrective Action Required:	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		
If no, explain:	This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.		
Training Required:	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	If no, explain: N/A	
Title	Approval Name	Approval Signature	Date
Engineering Manager	Jake Stanislowski		16 Nov 2023
Quality Manager	Jay Zabel		16 Nov 2023
Operations Manager	Matthew Benson		16 Nov 2023

BUHLER, ERIC - 2004 DEC-2008 11/15/2013

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* See attached email extension to 24SEP23

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484

PUBLISHERS

Engineering to 2023 DEVIATION A
Dated to 2023 3228 11/27/2023

Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

Deviation From:

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

Wire Out Hole

Deviation To:

This DA allows addition inspection for correct assembly of extrusion material MM0179-01 and MM1536-01 during performing QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) CP 1050. See instructions attached to this DA.

SEE INSTRUCTIONS ATTACHED TO THIS DA.

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
Details (if any): N/A

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

Corrective Action Required:	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> 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.		

① UK55, 23JW 2023

2484
2468
①

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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)
①MM0179-01 **②MM1536-01** **10AUG-23**

CONTROLLED COPY

Group Training Record



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)

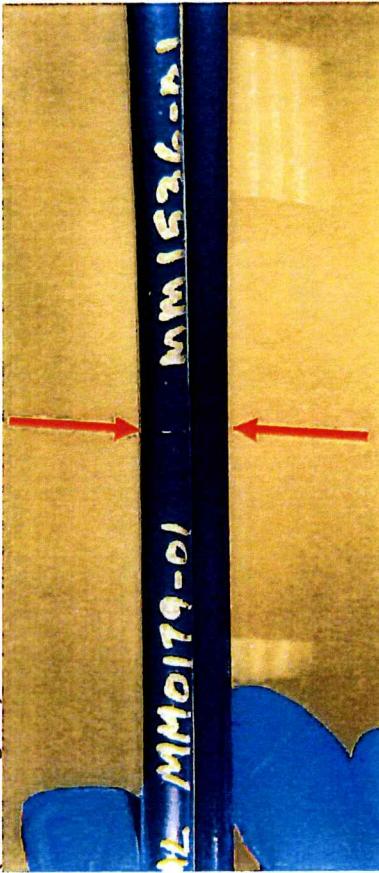


Image- 3

- 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.

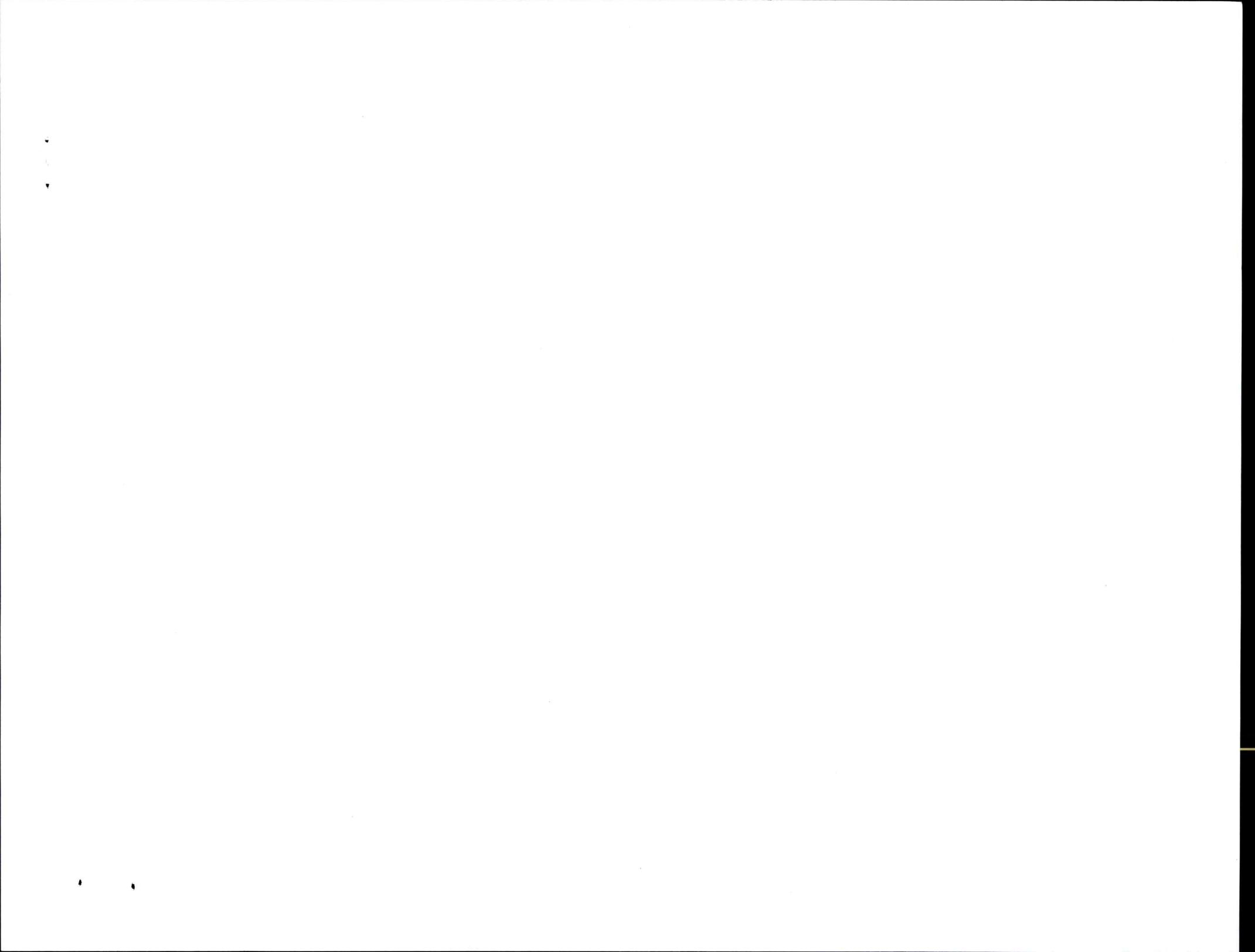


Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 Jul 2023
Mgr. Manufacturing Engineering	Jake Stanislowski		25 Jul 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF

Deviation Authorization

CONTROLLED COPY





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

PRODUCTION ORDER# 500000294407

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	11:36 AM	430	RL47	13Jan24	11:48 AM	415	RL47	13Jan24	16
TM10745	44	12:16 PM	430	RL47	13Jan24	12:28 PM	415	RL47	13Jan24	16
TM10745	44	1:38PM	430	cm99	13Jan24	1:50pm	415	cm99	13Jan24	16
TM10745	44	2:25PM	430	SN67	13Jan24	2:37PM	415	SN67	13Jan24	16
TM10745	44	3:12PM	430	SN67	13Jan24	3:24PM	415	SN67	13Jan24	16
TM10745	44	4:30 PM	430	RL47	13Jan24	4:42 PM	415	RL47	13Jan24	16
TM10745	44	5:18PM	430	SN67	13Jan24	5:30PM	415	SN67	13Jan24	16
TM10745	44	5:59 pm	430	SD34 ①	13Jan24	6:11pm	415	SD34	13Jan24	16
TM10745	44	6:13 PM	430	RL47	13Jan24	6:25 PM	415	RL47	13Jan24	16
③ TM10745	44	5:50am	430	NK62	16Jan24	6:02am	415	NK62	16Jan24	15
③ TM10745	44	6:10am	426	NK62	16Jan24	6:22am	415	NK62	16Jan24	16
③ TM10745	44	6:30am	427	NK62	16Jan24	6:42am	415	NK62	16Jan24	16

③ TM10745

① SD34
13Jan24

② RL47
13Jan24

③ NK62 16Jan24



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OP 400



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PRODUCTION ORDER# 500000294407

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	11:53am	430	SN67	13 Jan 24	12:05pm	415	SN67	13 Jan 24	16
Tm10942	44	1:24pm	430	cm99	13 Jan 24	1:36pm	415	cm99	13 Jan 24	16
Tm10942	44	1:58pm	430	SN67	13 Jan 24	2:10pm	415	SN67	13 Jan 24	16
Tm10942	44	2:54pm	430	cm99	13 Jan 24	3:06pm	415	cm99	13 Jan 24	16
Tm10942	44	3:27pm	430	SN67	13 Jan 24	3:39pm	415	SN67	13 Jan 24	16
Tm10942	44	4:55pm	430	SN67	13 Jan 24	5:07pm	415	SN67	13 Jan 24	16
Tm10942	44	5:35pm	430	SN67	13 Jan 24	5:47pm	415	SN67	13 Jan 24	16
Tm10942	44	6:45am	430	AX05	16 Jan 24	6:57am	415	AX05	16 Jan 24	16
Tm10942	44	7:30am	430	OS21	16 Jan 24	7:42am	415	OS21	16 Jan 24	16
Tm10942	44	7:55am	429	OS21	16 Jan 24	8:17am	415	OS21	16 Jan 24	16
Tm10942	44	8:25am	428	OS21	16 Jan 24	8:37am	415	OS21	16 Jan 24	16
Tm10942	44	8:45am	430	OS21	16 Jan 24	8:57am	415	OS21	16 Jan 24	16



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

PRODUCTION ORDER# 500000294407

OP 400



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

PO #: 500000294407 OP #: 500 Shift #: 3

Total Parts Reworked:		78	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		14
EW	Exposed Wire		53
MP	Micropores	N/A	N/A
SCR	Scratch		4
SKV	Skive Marks		11
VD	Voids	N/A	N/A
N/A	N/A	N/A	N/A

Inspected By (Sign and Date): PT09 13 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000294407

OP #: 500 **Shift #:** 1

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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 50000294407 OP #: 750 Shift #: 1st

Total Parts Reworked:		124	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		34
DIM07 US / WC	DIM07 Undersized (Window Closed)		16
EH	Exposed Hypotube		19
N/A	Glue, Stopper		55
Inspected By (Sign and Date):		KL95	17 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):

KL95 17 Jan 24 super. sign for
2nd shift.

PRODUCTION ORDER# 500000294407

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	5:45am	190°F	SSH4	16 Jan 24	6:55am	190°F	SSH4	16 Jan 24	24
TM10409	N/A	7:00am	190°F	OS21	16 Jan 24	8:10am	190°F	OS21	16 Jan 24	55
TM10409	N/A	8:20am	190°F	K155	16 Jan 24	9:30am	190°F	K155	16 Jan 24	40
TM12036	N/A	8:50am	190°F	SSH4	16 Jan 24	9:00 am	190°F	SSH4	16 Jan 24	63
TM10409	N/A	9:30am	190°F	SSH4	16 Jan 24	10:40am	190°F	SSH4	16 Jan 24	45
TM12036	N/A	10:00am	190°F	SSH4	16 Jan 24	11:10am	190°F	SSH4	16 Jan 24	36
TM10409	N/A	11:15am	190°F	SSH4	16 Jan 24	12:25pm	190°F	SSH4	16 Jan 24	34
TM12036	N/A	12:20pm	190°F	KL95	16 Jan 24	1:30pm	190°F	KL95	16 Jan 24	43
TM10409	N/A	1:20pm	190°F	KL95	16 Jan 24	2:30 pm	190°F	KL95	16 Jan 24	80
TM12036	N/A	1:35pm	190°F	SSH4	16 Jan 24	2:45pm	190°F	SSH4	16 Jan 24	24
	N/A	SSH4	16 Jan 24							

① K155 16 Jan 24



PO #: 500000294407

OP #: 900 **Shift #:** 1st

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):

① P44617 Jan 24



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

PO #: 500000294407 OP #: 900 Shift #: 2

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire		12
MP	Micropores	N/A	N/A
SCR	Scratch		32
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	HT 72 N/A 16 Jan 24	
Inspected By (Sign and Date):		HT 72 16 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 #: 500000294407

OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		48	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		6
EW	Exposed Wire		10
MP	Micropores	N/A	0
SCR	Scratch		53
SKV	Skive Marks	N/A	0
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized		1
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

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	30.04	26.85	26.49	24.66	26.68	27.36	28.69	26.16	24.72	26.38	26.803	1.632592	4.378	19.6555122	8.542	PASS
Seg B	62.88	61.06	64.3	69.66	59.72	60.13	59.71	66.5	58.07	63.52	62.555	3.5666363	3.981	48.3562209	8.542	PASS
Seg C	76.73	76.85	79.32	76.57	76.25	77.59	79.89	76.22	75.67	74.97	77.006	1.5428415	2.911	72.5147883	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 #: 500000294407

Date: 17JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24


17 Jan 24