

Production Order: 500000300508



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:	7988		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</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>xc81 30Jan24 8:20PM</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KD2 11:00am 01Feb24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	30Jan24	PLS

Notes: DA 2564, 2484

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 1 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

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>58497</u>	<u>N/A</u>	<u>200</u>	
		RM0009-04	I	<u>I</u>	PC	1	<u>79170</u>	<u>N/A</u>	<u>Bulk</u>	
		RM0009-04	I	<u>I</u>	PC	1	<u>79170</u>	<u>N/A</u>	<u>Bulk</u>	
		MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>N/A</u>	<u>500</u>	
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>1,000</u>	
		1000-2053-01	A	<u>A</u>	PC	500	<u>00002841209</u>	<u>0.60120</u>	<u>N/A</u>	<u>N/A</u>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>N/A</u>	<u>500</u>	
							<u>0000288401</u>	<u>N/A</u>	<u>500</u>	
							<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

① Am 68 02 Jan 24

Page: 2 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
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>	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	Bulk			
		141967-01	02	<u>02</u>	PC	500	<u>85794</u>	<u>507</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82860</u>	<u>593</u>			
		RM7348-01	C	<u>C</u>	PC	500	<u>85428</u>	<u>500</u>	N/A	N/A	N/A
		RM4001-01	B	<u>B</u>	PC	125	<u>88702</u>	<u>200</u>			
		RM0607-01	D	<u>D</u>	PC	56	<u>78848</u>	<u>100</u>			

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 3 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0498-01	C	<u>C</u>	PC	500	<u>0000287644</u>	<u>515</u>			
		RM0362-01	E	<u>E</u>	PC	594	<u>0000287643</u>	<u>123</u>			
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>500</u>			
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>500</u>			
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>500</u>	N/A	N/A	N/A
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>	N/A	N/A	N/A
		MM0074-01	G	<u>G</u>	PC	500	<u>0000297037</u>	<u>513</u>			
							<u>0000292833</u>	<u>50</u>			

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 4 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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	01Feb24	KL95
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	01Feb24	NK62 pmq6 CL30 Y014 JY90

Notes:

N/A
N/A
N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 5 of 18



SA0155-01

CREGANNA MEDICAL
is part of



Production Order: 500000300508Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

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
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	01/Feb/24	AL34 VP62 ST96 ny35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	01/Feb/24	MU50 CY97 AS31 V078

Notes:

N/A
N/A
N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 6 of 18



SA0155-01

CREGANNA MEDICAL
is part of

Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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	01Feb24	SK11 D1V39 C105 As22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	01Feb24	VV25 iMub cp32

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 7 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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)	-	500	O	AX05 TA36 SJ47 SH85 +Feb 24 01Feb24	
450	CATASY01 Catheter FEP Removal	-	500	O	01Feb24	PM96 JY90
Notes: N/A N/A N/A						

Date Printed: 30.01.2024 / 17:42:03

Page: 8 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials																													
N/A	Assembly 1 	N/A	N/A	N/A	N/A	N/A																													
N/A	FEP Removal																																		
N/A	Confirmation Reqd(Milestone)																																		
500	CATASY01 Catheter Assembly 1 	<p>In-process Inspection and Rework</p> <p>Material Consumed:</p> <table> <tr> <td>Part #:</td> <td>100-153-01</td> <td>Batch #:</td> <td>8874F7</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> </table>	Part #:	100-153-01	Batch #:	8874F7	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	Part #:	N/A	Batch #:	N/A	Qty:	N/A	484	EW-1H-1H WT-11 SKV-1 DF-1 Fm-11 16	PH59 CB81 LL61 VL91 R66 TB45
Part #:	100-153-01	Batch #:	8874F7	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																														
Part #:	N/A	Batch #:	N/A	Qty:	N/A																														
N/A	In-process Inspection and Rework																																		
N/A	Confirmation Reqd(Milestone)																																		
N/A	N/A	N/A	N/A	N/A	N/A	N/A																													
Notes:																																			
		N/A																																	
		N/A																																	
		N/A																																	

Date Printed: 30.01.2024 / 17:42:03

Page: 9 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



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

Material: SA0155-01 Rev F

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)	484	0	OK/Feb 24	RS23 AX82 SV416 PP40
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	464	DL-III MAS-III EW-III DF-III EH-1 OF-1 20	OK/Feb 24	FBD1 DY29 AX82 ML60

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 10 of 18



SA0155-01

CREGANNA MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

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 Loading Heat Shrink Confirmation Reqd(Milestone)	464	0	01 Feb 24	VA96 FBO1 ML38
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: <u>0936A</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>0521</u> Cal Due: <u>31 May 24</u> Tipping	464	0	01 Feb 24	STX48 ML38
Notes:		N/A N/A N/A				

Date Printed: 30.01.2024 / 17:42:03

Page: 11 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

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 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <p>Part #: RM0007-01 Batch #: 788702 Qty: N/A</p> <p>Part #: RM4001-01 Batch #: 88702 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	464	①	01/Febr24	Hv36 STX48 HT72 mm02
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	456	ACD-ATT ⑧	01/Febr24	SG88

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 12 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

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 Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>PASS</u> 2. <u>PASS</u> 3. <u>PASS</u> 4. <u>PASS</u> 5. <u>PASS</u>	456	0	02Feb24	SKL-HH(1) 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	MV33 MV46 SH04 MV78

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 13 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



①CB58 02Feb24

Production Order: 500000300508



Production Order Document

Production Order Qty: 500

PC
Sheet: 1 of 1

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:</p> <p>TMI: <u>0700-01</u> Cal Due: <u>31 MAY 24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>1000-1153-01</u> Batch #: <u>88747</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM4001-01</u> Batch #: <u>88702</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM0158-01</u> Batch #: <u>58497</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM0607-01</u> Batch #: <u>78848</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>		TD-1 DEL-1H1TT EW-1 EH-1 FM-1H1TT DIS-1H1I MAR-1H1TT III 416	#5US-11 #6US-11 #6OS-1II	02 Feb 24	KL67
950	QUALITY1 Quality Inspection & Review <p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>50713B</u> Cal Due: <u>12 Apr 24</u></p> <p>Record Caliper Information:</p>		N/A	N/A	N/A	MV78

Notes:

N/A

NA

N/A

Date Printed: 30.01.2024 / 17:42:03



SA0155-01

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is part of





Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: 50317 Cal Due: 31 Aug 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	409	DIS(SP) 111 DIS 111111 (2)	02 Feb 24	KL67
1000	 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: 08890 Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 04056 0629 Cal Due: 30 Sep 24	406	LT-111 (3)	02 Feb 24	KL67 CB58

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 15 of 18



SA0155-01

(1) MV33 01 Feb 24

(2) CB58 02 Feb 24

CREGANNA
MEDICAL
is part of



Material: SA0155-01 Rev F

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	1h	<ul style="list-style-type: none"> • SCR -UN UN • DIS -111 • SKV -111 • EW -11 • FL -11 • WK -11 • GNI -1 • RDG -1 • VD -1 • ET -1 • DEI -1 • MP -1 • BP -1 • CK -1 • Mar -1 <p>(32)</p>	08 Feb 24	DX52 SV43 YK95
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>An 08 02 Jun 24</u>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 16 of 18



SA0155-01

CREGANNA MEDICAL
is part of

Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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	374	0	2:0 02 Feb 24	M/28

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 17 of 18

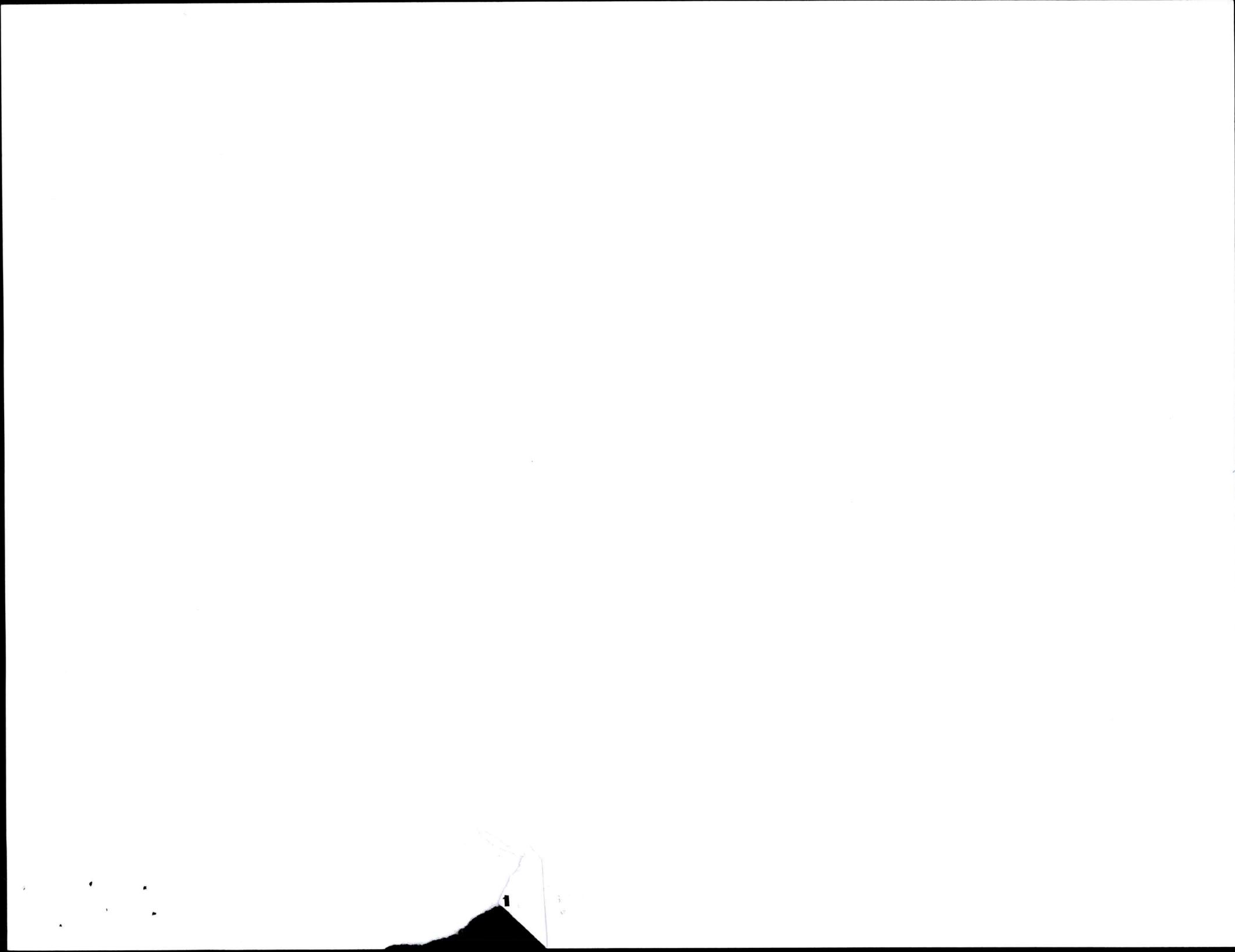


SA0155-01

CREGANNA
MEDICAL
is part of



① M/28 02 Feb 24



Production Order: 500000300508



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

Batch Number: 0000300508

By: M/28

Date: 02 Feb 24

Reviewed By:

RB29

Date:

02 feb 24

Notes:

N/A

N/A

N/A

Date Printed: 30.01.2024 / 17:42:03

Page: 18 of 18



SA0155-01

CREGANNA
MEDICAL
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BRAD & DEBORAH 1/15/23
ERIKS & DEBORAH 1/16/23

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CREGANNA
MEDICAL

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

Latent to 20 Dec 2003 DEVIATION AI
Latent to 20 Dec 2003 J228 11/27/2003

Requestor Name: Udhesh Kapadnis

Document Number Affected
3107610

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

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DEVIATION FORM B767 to 23C042023 **21523**

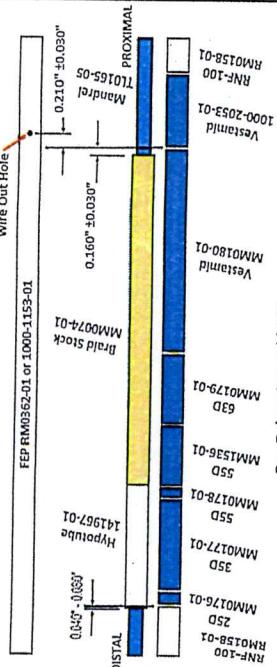
* See attached email extension to 24SE023
1512 24AUG23 24AUG23

Requestor Name:	Udhes Kapadnis
Document Number Affected	3107610
Deviation From:	<p>QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050;</p> <p>Current QIP3107610 does not state to inspect for the correct extrusion configuration.</p>
Deviation To:	<p>This DA allows addition inspection for correct assembly of extrusion material MM0179-01 and MM1536-01 during performing QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050.</p> <p>See instructions attached to this DA.</p>
Revision	L

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) OP 1050. See instructions attached to this DA.

See instructions attached to this DA



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) OP 1050. See instructions attached to this DA.

See instructions attached to this DA

Justification: Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-26390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with put of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid in-

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:	<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.		

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		

Tribute Society

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
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 MM1536-02 fixture for inspection. (See image 1)
① MM01536-01 type correction TS12 10AUG23

CONTROLLED COPY

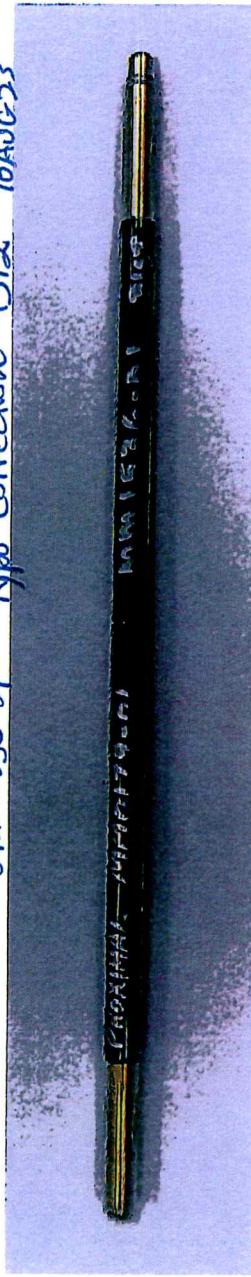


Image- 1

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)

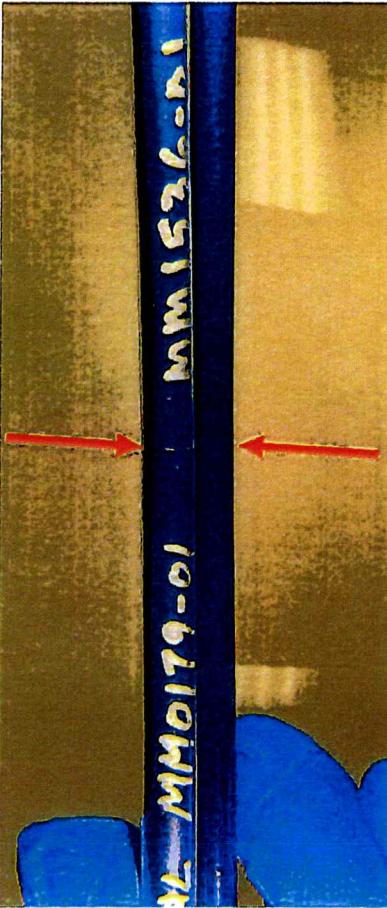


Image- 3

- 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)

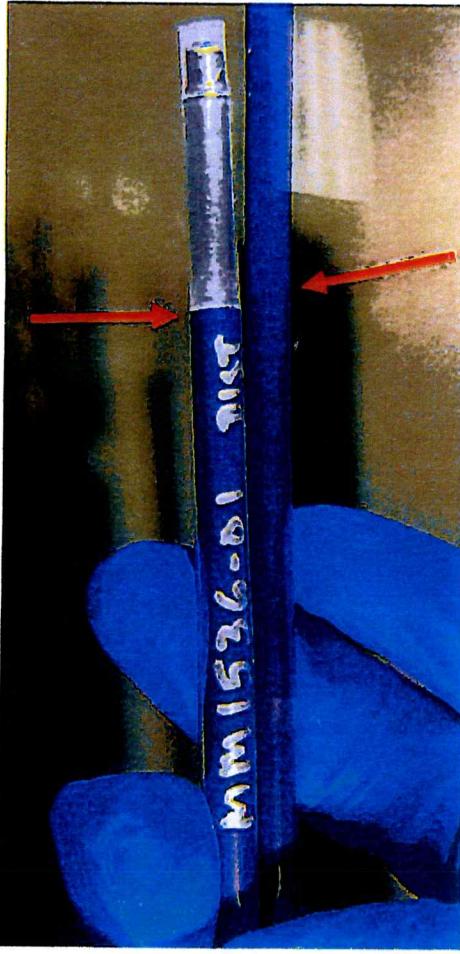


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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 Two MM0179-01 - BAD PART	MM0179-01
4	MM1536-01 Two MM1536-01 - BAD PART	MM1536-01

Image - 5

Entered to M3n34 D228 12/10/2023
Entered to 13 Feb 2024 5228 V4/2024

CONTROLLED COPY DEVIACTION AUTHORIZATION NUMBER: DA2564

CREGANNA
MEDICAL
is part of



DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.	Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer at OPER900 (TMI0700-01) , check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.		
Justification: TMI0602 lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable. TMI0700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified to inspect Dim 6 per ES0647: Laser micrometer equivalency test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
16 Nov 23	15 DEC 23	N/A	
Risk Assessment: Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No 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



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

PRODUCTION ORDER# 500000300508

OP 400

① DCB58 02Feb24



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

PRODUCTION ORDER# 500000300508

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0942	44	12:00pm	430	AX05	01Feb24	12:12pm	415	AX05	01Feb24	16
TMI0942	44	12:20pm	430	AX05	01Feb24	12:32pm	415	AX05	01Feb24	① 16
Tm10942	44	1:35pm	430	TA36	01feb24	1:47pm	415	TA36	01feb24	16
Tm10942	44	2:05pm	428	NK62	01Feb24	2:17pm	415	NK62	01Feb24	16
Tm10942	44	4:06pm	430	Sy47	01Feb24	4:18pm	415	Sy47	01Feb24	16
Tm10942	44	4:23pm	430	SH85	01Feb24	4:35pm	415	SH85	01Feb24	16
Tm10942	44	5:14pm	428	SH85	01Feb24	5:26pm	415	SH85	01Feb24	16
Tm10942	44	6:23pm	430	SH85	01Feb24	6:35pm	415	SH85	01Feb24	16
Tm10942	44	6:50pm	428	SH85	01Feb24	7:02pm	415	SH85	01Feb24	16
Tm10942	44	7:23pm	430	SH85	01Feb24	7:35pm	415	SH85	01Feb24	16
Tm10942	44	7:50pm	429	SH85	01Feb24	8:02pm	415	SH85	01Feb24	16
Tm10942	44	9:00pm	430	SH85	01Feb24	9:12pm	415	SH85	01Feb24	16

① CBS8 02 Feb 24



Document No: 5105589
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PRODUCTION ORDER# 500000300508

OP 400



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

PRODUCTION ORDER# 500000300508

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:55am	429	AX05	01Feb24	12:07pm	415	AX05	01Feb24	16
Tm10745	44	12:30pm	429	NK62	01Feb24	12:42pm	415	NK62	01Feb24	16
Tm10745	44	1:20pm	430	NK62	01Feb24	1:32pm	415	NK62	01Feb24	16
Tm10745	44	1:46pm	429	NK62	01Feb24	1:58pm	415	NK62	01Feb24	16
Tm10745	44	2:20pm	430	TA36	01Feb24	2:32pm	415	TA36	01Feb24	16
Tm10745	44	2:40pm	430	TA36	01Feb24	2:52pm	415	TA36	01Feb24	16
Tm10745	44	2:58pm	430	NK62	01Feb24	3:10pm	415	NK62	01Feb24	16
Tm10745	44	4:25pm	430	JY90	01Feb24	4:37pm	415	JY90	01Feb24	16
Tm10745	44	5:00pm	428	SH85	01Feb24	5:12pm	415	SH85	01Feb24	16
Tm10745	44	5:30pm	430	V078	01Feb24	5:42pm	415	V078	01Feb24	16
Tm10745	44	6:37pm	430	SH85	01Feb24	6:49pm	415	SH85	01Feb24	16
Tm10745	44	7:04pm	428	SH85	01Feb24	7:16pm	415	SH85	01Feb24	16

SH85 01Feb24



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

PO #: 500000300508

OP #: 500 Shift #: 2

Total Parts Reworked:

36

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube	///	5
EW	Exposed Wire		30
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks		4
VD	Voids	//	2
N/A	N/A	N/A	0
Inspected By (Sign and Date):		<u>Andy</u> 01 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 #: 500000300508

OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>38</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	///	<u>3</u>
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		<u>18</u>
MP	Micropores	n/a	n/a
SCR	Scratch	////	<u>4</u>
SKV	Skive Marks		<u>7</u>
VD	Voids		<u>9</u>
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		<u>Vanweej Lor 01 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):

PO #: 500000300508OP #: 750 Shift #: 2nd

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		75	
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)	 	35
EH	Exposed Hypotube	 	33
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	01Feb24

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 #: 50000300508OP #: 750 Shift #: 2

Total Parts Reworked:		35	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	N/A	N/A
DIM07 US / WC	DIM07 Undersized (Window Closed)		28
EH	Exposed Hypotube		7
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		HT72 01Feb24	

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# 500000300508

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	4:23pm	190°F	SG88	01 Feb 24	5:33pm	190°F	SG88	01 Feb 24	42
TM12036	N/A	5:11pm	190°F	SG88	01 Feb 24	6:21pm	190°F	SG88	01 Feb 24	45
TM10409	N/A	6:24pm	190°F	SG88	01 Feb 24	7:34pm	190°F	SG88	01 Feb 24	40
TM12036	N/A	7:12pm	190°F	SG88	01 Feb 24	8:22pm	190°F	SG88	01 Feb 24	42
TM10409	N/A	7:57pm	190°F	SG88	01 Feb 24	8:07pm	190°F	SG88	01 Feb 24	52
TM10409	N/A	9:18pm	190°F	SG88	01 Feb 24	10:28pm	190°F	SG88	01 Feb 24	36
TM12036	N/A	9:56pm	190°F	SG88	01 Feb 24	11:06pm	190°F	SG88	01 Feb 24	40
TM10409	N/A	10:47pm	190°F	SG88	01 Feb 24	11:57pm	190°F	SG88	01 Feb 24	47
TM10409	N/A	11:57pm	190°F	SG88	01 Feb 24	1:07Am	190°F	SG88	02 Feb 24	42
TM10409	N/A	1:33AM	190°F	SG88	02 Feb 24	2:43AM	190°F	SG88	02 Feb 24	70
		N/A		SG88	01 Feb 24					

① 5688 01 Feb 24
② 5688 01 Feb 24



PO #: 50000300508

OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		47	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		2
EW	Exposed Wire		3
MP	Micropores	N/A	0
SCR	Scratch		39
SKV	Skive Marks	N/A	0
VD	Voids		1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		18
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Joe H 01 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 #: 50000300508

OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		79	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	0
EH	Exposed Hypotube	NA	0
EW	Exposed Wire		10
MP	Micropores		3
SCR	Scratch		67
SKV	Skive Marks		10
VD	Voids		3
DIM01 US	DIM01 OD Undersized	NA	0
DIM06 US	DIM06 OD Undersized	NA	0
DIM06 OS	DIM06 OD Oversized	NA	0
DIM09 US	DIM09 OD Undersized	NA	0
Inspected By (Sign and Date):		Neil	01 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):

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	29.49	26.91	27.18	29.19	29.09	26.18	30.79	28.44	30.4	31.45	28.912	1.742283	4.378	21.2842837	8.542	PASS
Seg B	66.67	59.86	67.83	63.11	60.39	58.63	62.41	60.18	65.89	66.58	63.155	3.363319	3.981	49.7656259	8.542	PASS
Seg C	83.76	79.47	79.44	70.57	78.53	79.24	83.63	83.37	83.14	79.89	80.104	3.9538	2.911	68.594487	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 #: 500000300508

Date: 02 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24

02 Feb 24
