

Production Order: 500000294408



Production Order Document
Production Order Qty: 500

PC
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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>Am 68 11:00am 13 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 9:00am 16 Jan 24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	12 Jan 24	TR06
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
	MM0179-01	D <u>D</u>	PC	500	<u>000276172</u>	<u>500</u>
	MM1536-01	B <u>B</u>	PC	500	<u>000281412</u>	<u>500</u>

Notes: DA 2564, 2484.

N/A
N/A

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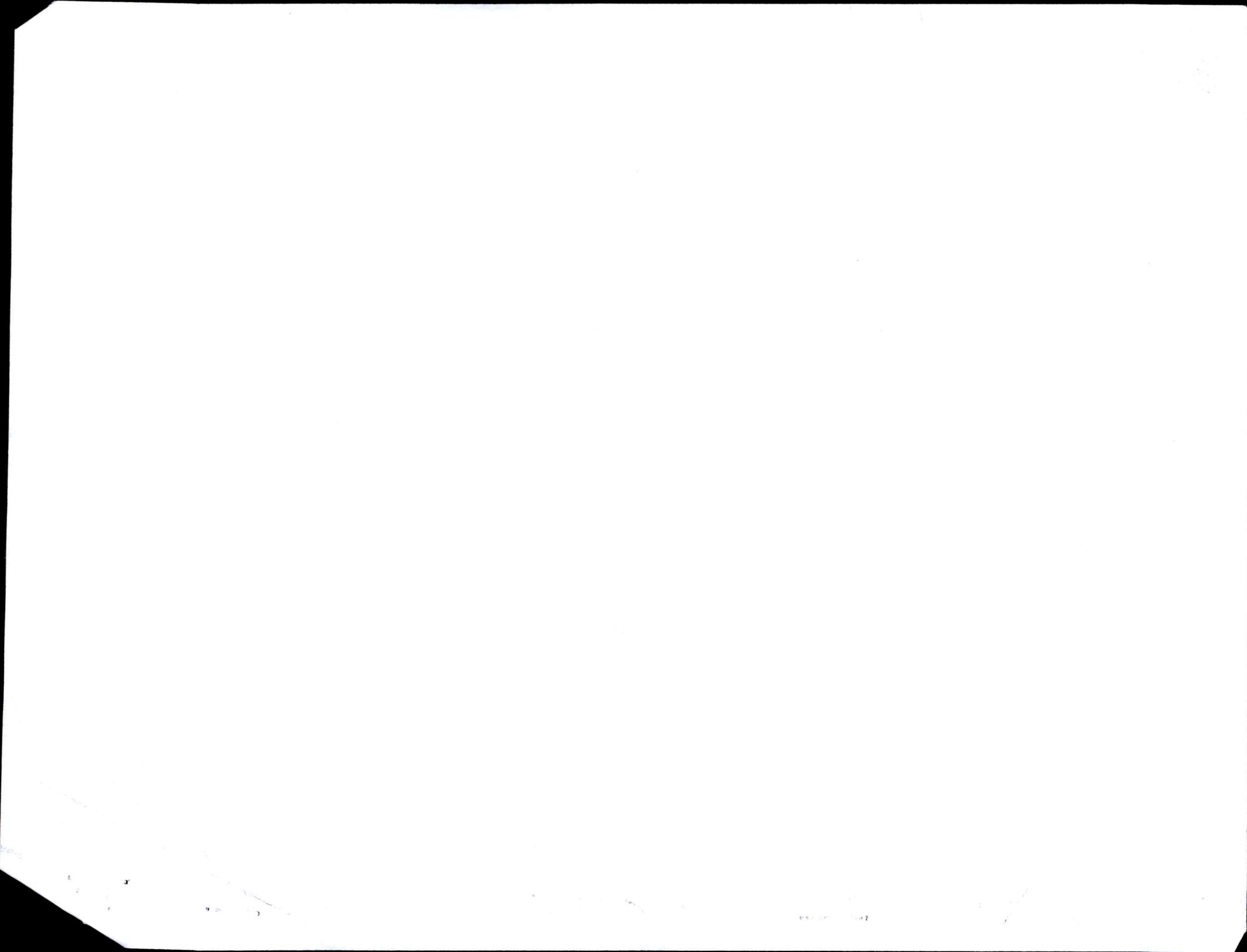
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Opr No.	Planned WorkCenter Description	Operation Details					Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	S	PC	200	N/A <u>58497</u>	N/A <u>150</u>		
		1000-1153-01	A	A	PC	594	N/A <u>87651</u> <u>87652</u> <u>87665</u>	N/A <u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	A	PC	500	N/A <u>0000278880</u>	N/A <u>500</u>		
		MM1537-02	A	A	PC	500	N/A <u>0000276175</u>	N/A <u>500</u>	N/A	N/A
		TL0167-02	E	E	PC	70	N/A	Bulk		
		TL0165-05	J	J	PC	5	N/A	Bulk		
		TL0165-03	J	J	PC	5	N/A	Bulk		
							N/A	Bulk		

Notes:

N/A

N/A

N/A

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N/A	N/A	141967-01	02	02	PC	500	89500	525			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82734 82872, 82865 82854, 82851	295 57.51 86.70			
		RM7348-01	C	C	PC	500	78688 82884	450 100			
		RM4001-01	B	B	PC	125	N/A 824830	N/A			
		RM0607-01	D	D	PC	56	82434 71863	100 120	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	20202715490	479			
		RM0009-04	I	I	PC	1	82971 N/A	Bulk Bulk			
		RM0009-04	I	I	PC	1	82971	Bulk			

Notes:

N/A

N/A

N/A

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N/A		MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u>	<u>N/A</u> <u>Bulk</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u>	<u>N/A</u> <u>1000</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>00002789640</u>	<u>0000281413</u> <u>500</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>N/A</u> <u>500</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000274174</u>	<u>N/A</u> <u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>N/A</u> <u>500</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000292837</u>	<u>N/A</u> <u>516</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
NIA	NIA	NIA	NIA	NIA	NIA	NIA
100	CATASY01 Catheter Assembly 1  Line Clearance Confirmation Reqd(Milestone)	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	16Jan24	KL95
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	16Jan24	PM46 RN27 NKL AF54 CL30 Y04

Notes:

NIA

NIA

NIA

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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	16Jan24 MU50 SK11 ST96 NY35	
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	16Jan24 VP62 AS31 V078	

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)	Insert Cut Hypo Tube	500	0	16Jan24	VV25 CM46 CP32 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	16Jan24	C497 CT88 C105 N078

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	pm96 NK62 AX05 SH85 V078
450	CATASY01 Catheter	FEP Removal	500	0	16Jan24	pm96 JY90
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					
	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: 87651 Part # <u>1000-1153-D1</u> Batch #: <u>87650</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	487	WT-III EW-HHT II FM-1 EH-I DF-I 16Jan24 13	LL61 VCO9 CB81 mm02 1266 VL91	
N/A	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
<u>N/A</u>						
<u>N/A</u>						
<u>N/A</u>						
<u>N/A</u>						

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① LL61 16 Jan 24



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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 Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel	487	0	16 Jan 24	FBS01 RS23 Shelf
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	465	DL - III IDB - I MAH - III DF - I MAS - III III 22	16 Jan 24	DV39 ML60 CLO5

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	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)	465	0	16Jan24	VA96 MV78 ML38
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0386</u> Cal Due: <u>31 MAY 24</u> 31 may 24 TMI: <u>051</u> Cal Due: <u>31 MAY 24</u> 31 may 24 TMI: <u>2083C</u> Cal Due: <u>31 MAY 24</u> 31 may 24 TMI: <u>0936A</u> Cal Due: <u>31 MAY 24</u> 31 may 24 RS 23 JAN 17 24	465	0	16Jan24	RS23 STX48 ML38
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)	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <table> <tr><td>Part #:</td><td>RM4001-01</td><td>Batch #:</td><td>82423</td><td>Qty:</td><td>8</td></tr> <tr><td>Part #:</td><td>RM0607-01</td><td>Batch #:</td><td>71863</td><td>Qty:</td><td>5</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 #:	RM4001-01	Batch #:	82423	Qty:	8	Part #:	RM0607-01	Batch #:	71863	Qty:	5	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	465	0	16Jan24	STX48 Hv36
Part #:	RM4001-01	Batch #:	82423	Qty:	8																															
Part #:	RM0607-01	Batch #:	71863	Qty:	5																															
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																															
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		458	ACD-HHT 11 (7)	16Jan24	SS44 5G88 XL91																														

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1  Cut to Length Confirmation Reqd(Milestone)	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. pass 2. pass 3. pass 4. pass 5. pass	454	SKV-1111	16 Jun 24	Y936 AT39
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review Confirmation Reqd(Milestone) <i>N/A</i>	<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> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #<u>Rm4001-01</u> Batch #: <u>82433</u> Qty: <u>7</u> Part #<u>Rm0607-01</u> Batch #: <u>71863</u> Qty: <u>4</u> Part #<u>Rm0158-01</u> Batch #: <u>58497</u> Qty: <u>2</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>	433	<i>SCR = HT(sp) #700=11 #605-111 #905-11 DIS-1111 UOK-1 MHR-11 SCE-11</i>	<i>16 Jan 24</i>	<i>XL91 M165 HT72 P66 ST604 KL67</i>
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Record Caliper Information:</p>			<i>N/A</i>	<i>N/A</i>

Notes:

*N/A**N/A**N/A*

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: N/A Cal Due: N/A Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30Sep25 TMI: 0692 Cal Due: 30Sep25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	402	DIS - HHHHH HHH III Str - HHH III WK - IIII DEL-1	16 Jan 24	XL91 KL69
1000	 QUALITY1 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: 1056 Cal Due: 31 May 24 Record Length Gage Information: TMI: 0889D Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 Sep 24	389	LT - HHHHH III	16 Jan 24	XL91 KL69

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
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	365 24	SCR-XTI (IT) Del - MM (IT) Del - I Disc - IIII DL - II UD - II Mex - I DIS - I KNK - I GNII - I SKV - I	17Jan24	SV43
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		17Jan24	KP02

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
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	-365	O 19 Jan 24	AP10	

Notes:

N/A AP10 19 Jan 24

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Batch Number: 000294408

By: ABW

Date: 19 Jan 24

Reviewed By:

RB29

Date:

19 JAN 24

Notes:

N/A AS/IO 19 Jan 24 /

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* See attached email extension to 24 SEP 2023
1512 24 AUG 2023 23 OCT 2023 24 NOV 2023

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484

* See attached email extension to 24 SEP 25

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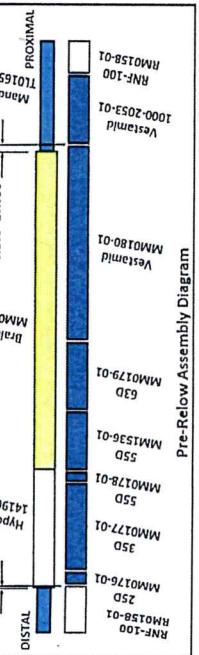
Requestor Name: Udhesh Kapadnis

Requester, Name: Jinesh Kaprauns	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.

FEP RM0362-01 or 1000-1153-01
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) OP 1050. See instructions attached to this DA.

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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 layer of inspection at final QC inspection to avoid incorrect assembly defects.

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

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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.	
Training Required:	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No

① UK55, 23JW 2023

DA 2484
2468

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Description/Objectives of Training:
DA- Inspection at final QC, Op#1050.

Group Training Record

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and ~~MM1536-02~~ fixture for inspection. (See image 1)
① **MM1536-01** **Type Correction TS12** 10AUG23



Image- 1

Step 1:

- Visually locate the MM0180-01 (Vestamid) transition to MM0179-01 on the completed part approximately 9.75" from the distal end using magnification light 2.25X minimum.
- Align the fixture MM0179-01 extrusion proximal end to the Vestamid transition on completed part.
(See image 2)



Image- 2

- Visually verify the MM0179-01 distal end of the fixture is approximately at the same location on the completed part. (See image 3)

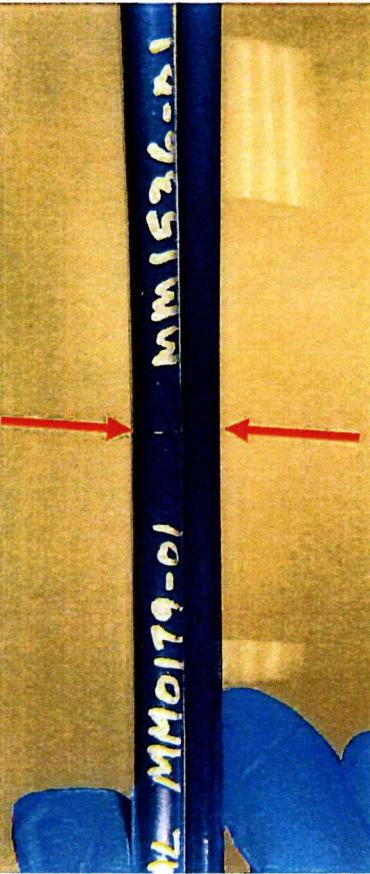


Image- 3

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, move to Step 2.

CONTROLLED COPY

Step 2:

- Visually verify the MM1536-01 distal end of the fixture is approximately at the same location on the completed part. (See image 4)

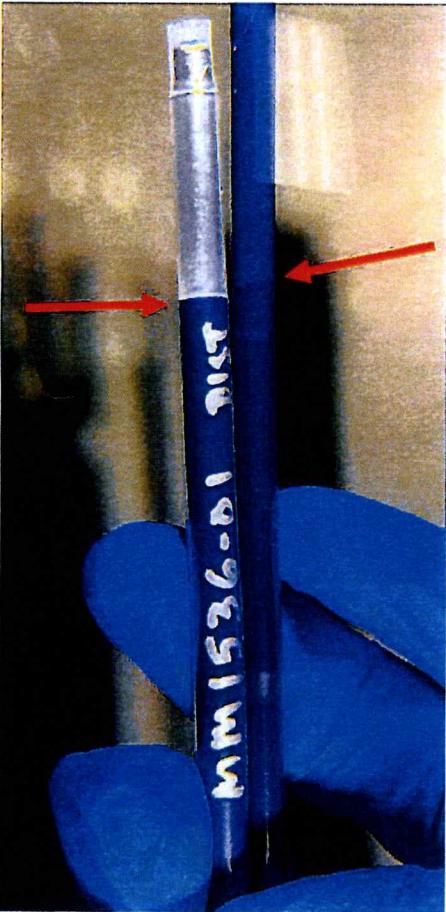


Image- 4

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

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

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

Entered to HMI064 J228 12/15/2023

Entered to HMI064 J228 12/15/2023

CONTROLLED COPY DEVIAITON 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# 500000294408

OP 400



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000294408

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	9:25am	430	0521	16Jan24	9:37am	415	0521	16Jan24	16
TM10942	44	10:00am	430	0521	16Jan24	10:12am	415	0521	16Jan24	16
TM10942	44	10:58am	430	AX05	16Jan24	11:10am	415	AX05	16Jan24	16
TM10942	44	11:30am	430	AX05	16Jan24	11:42am	415	AX05	16Jan24	16
TM10942	44	① 12:14PM	430	AX05	16Jan24	12:26PM	415	AX05	16Jan24	16
TM10942	44	12:40PM	430	0521	16Jan24	12:52PM	415	0521	16Jan24	15
TM10942	44	1:30 PM	430	RN27	16Jan24	1:42 PM	415	RN27	16Jan24	16
TM10942	44	2:30pm	430	AF54	16Jan24	2:42pm	415	AF54	16Jan24	16
TM10942	44	3:00pm	430	KL95	16Jan24	3:12pm	415	KL95	16Jan24	16
TM10942	44	4:08pm	430	SH85	16Jan24	4:20pm	415	SH85	16Jan24	16
TM10942	44	4:45pm	430	SH85	16Jan24	4:57pm	415	SH85	16Jan24	16
TM10942	44	5:23pm	430	V078	16Jan24	5:35pm	415	SA07	16Jan24	16

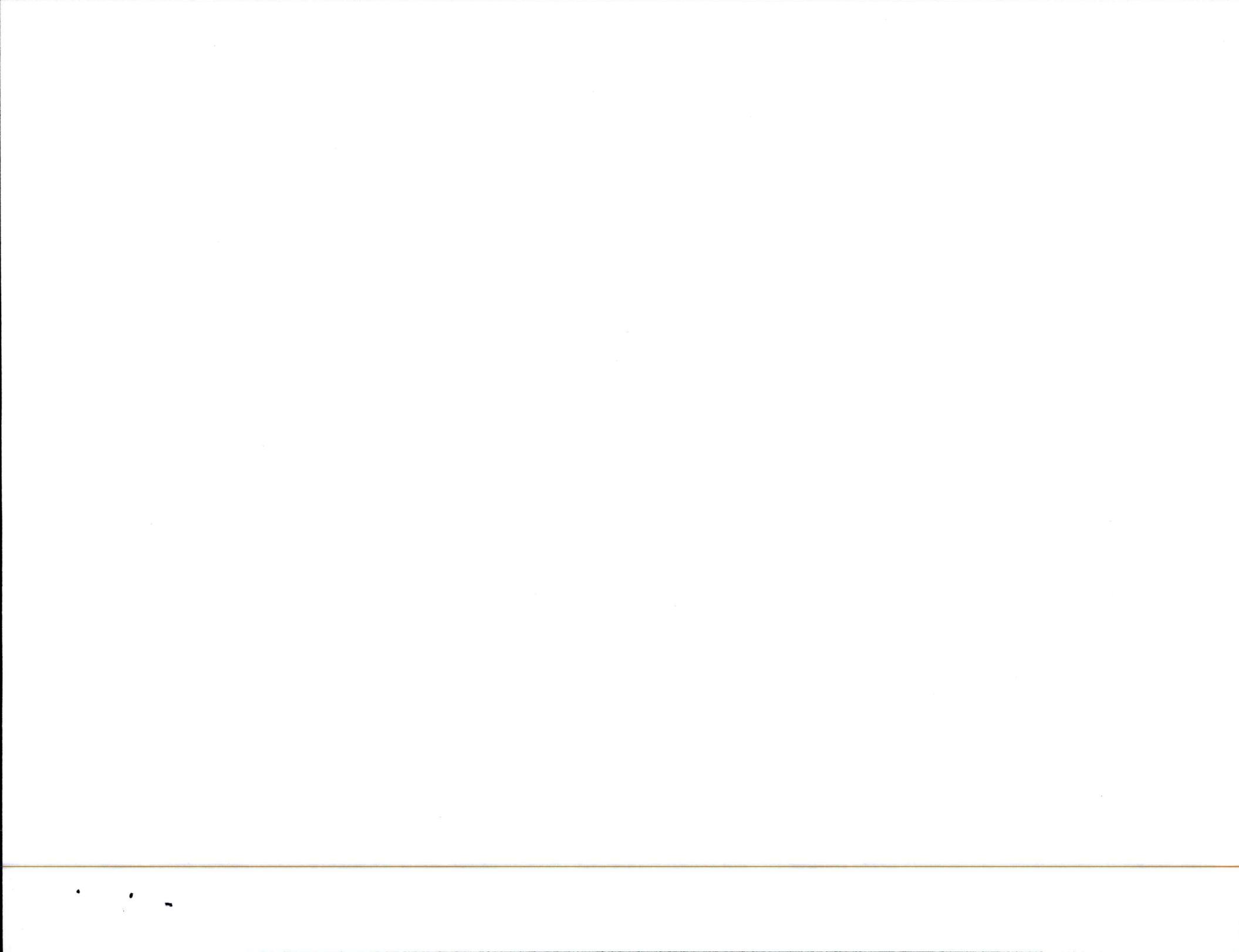
① AX05 16Jan24



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

PRODUCTION ORDER# 500000294408

OP 400



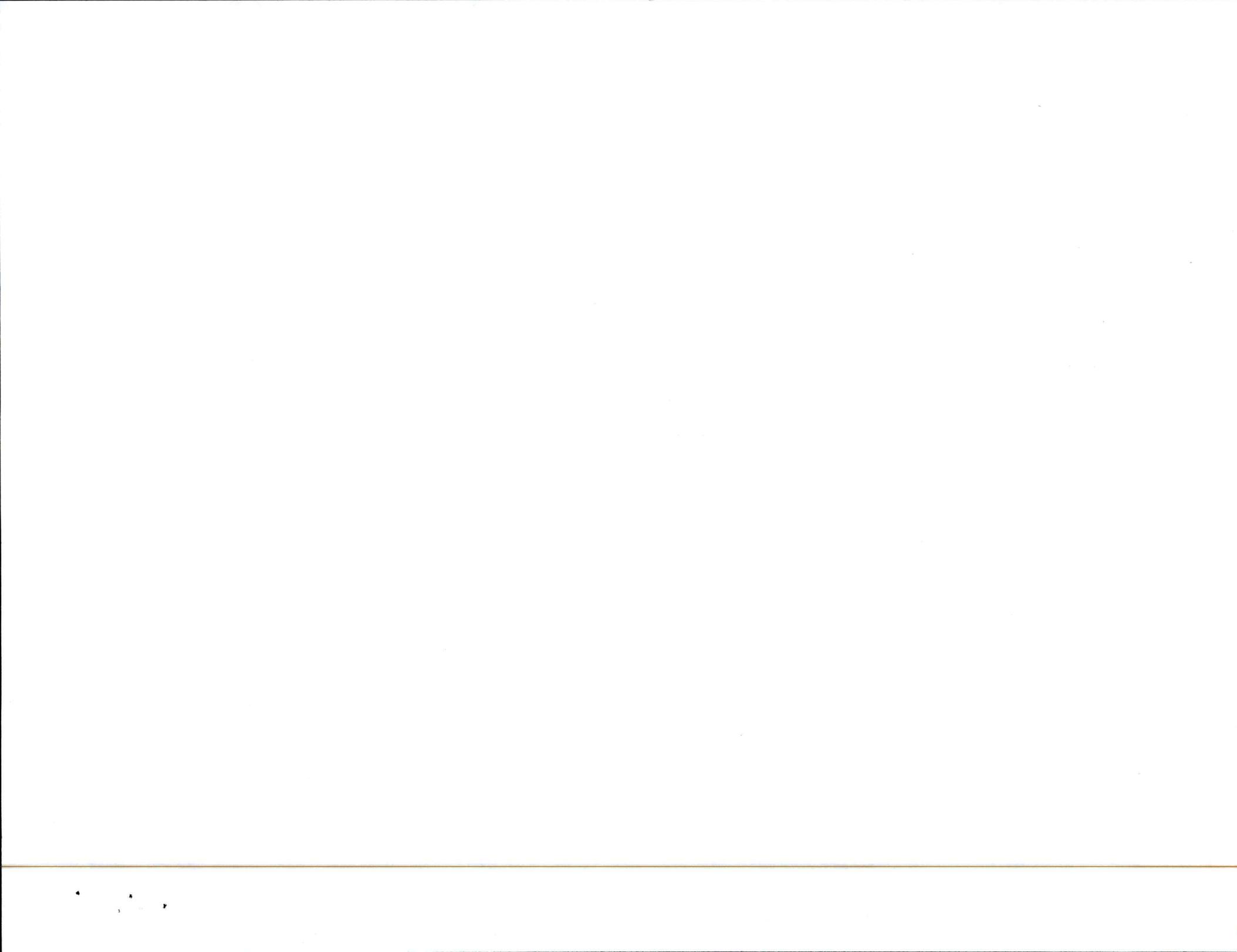


Document No: 5105589
FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000294408

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	9:30am	430	0521	16Jan24	9:42am	415	0521	16Jan24	16
TM10745	44	9:48am	430	0521	16Jan24	10:00am	415	0521	16Jan24	16
TM10745	44	11:15am	430	AX05	16Jan24	11:27am	415	AX05	16Jan24	16
TM10745	44	11:45am	430	AX05	16Jan24	11:57am	415	AX05	16Jan24	16
TM10745	44	12:25pm	430	AX05	16Jan24	12:37pm	415	AX05	16Jan24	16
TM10745	44	1:28pm	430	RN27	16Jan24	1:40pm	415	RN27	16Jan24	16
TM10745	44	1:48pm	429	0521	16Jan24	2:00pm	415	0521	16Jan24	16
TM10745	44	2:02pm	429	RN27	16Jan24	2:14pm	415	RN27	16Jan24	16
TM10745	44	2:35pm	430	AF54	16Jan24	2:47pm	415	AF54	16Jan24	16
TM10745	44	3:00pm	430	KL95	16Jan24	3:12pm	415	KL95	16Jan24	6
TM10745	44	4:28pm	430	V078	16Jan24	4:40pm	415	V078	16Jan24	16
TM10745	44	5:07pm	430	V078	16Jan24	5:19pm	415	V078	16Jan24	16





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

PO #: 500000294408 OP #: 500 Shift #: 1st

Total Parts Reworked:		50	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		12
EW	Exposed Wire		33
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks	N/A	N/A
VD	Voids		6
N/A	N/A	N/A	N/A

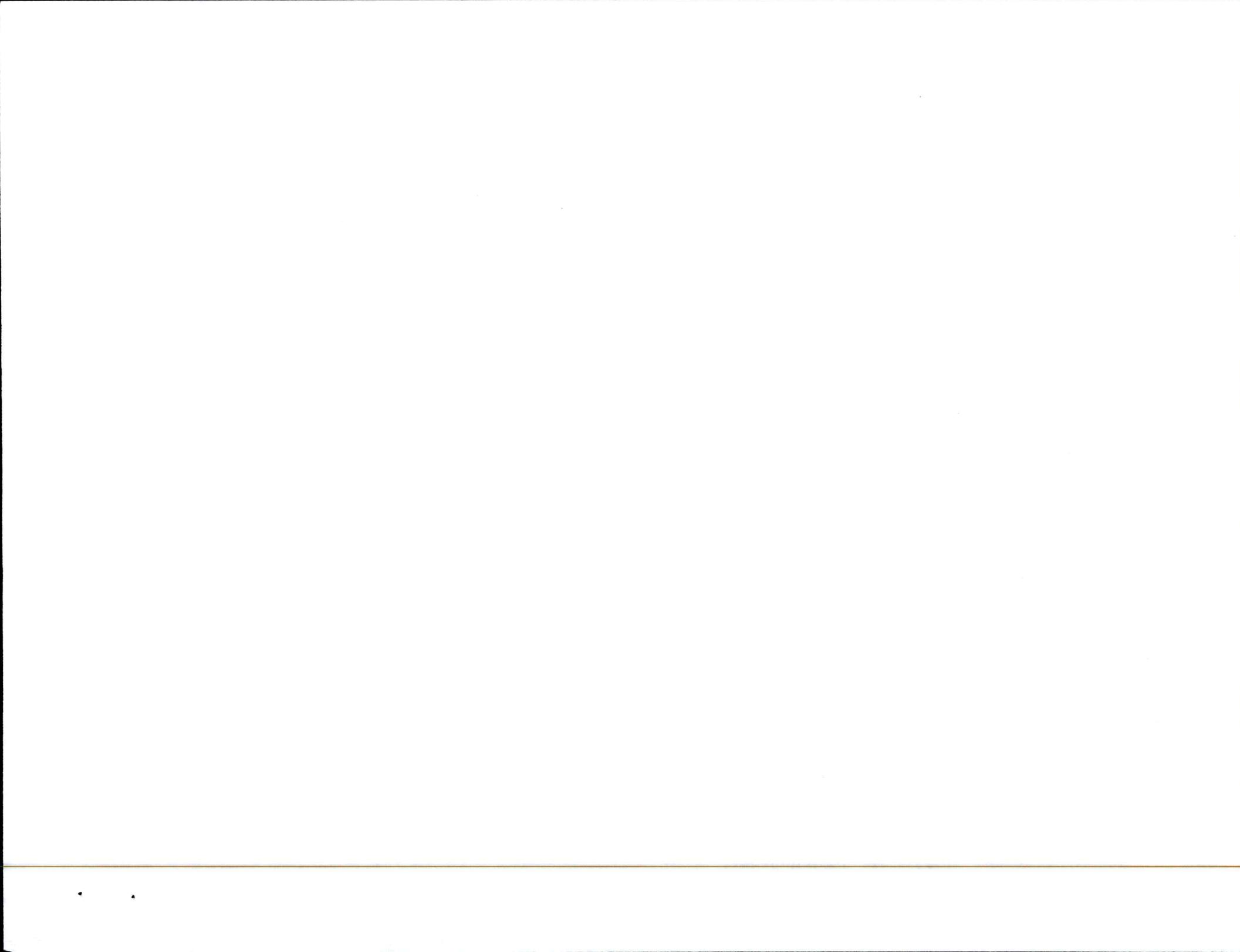
Inspected By (Sign and Date):

CB81, LL61, VC09

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.

Data Uploaded for Engineering Review (Check):





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

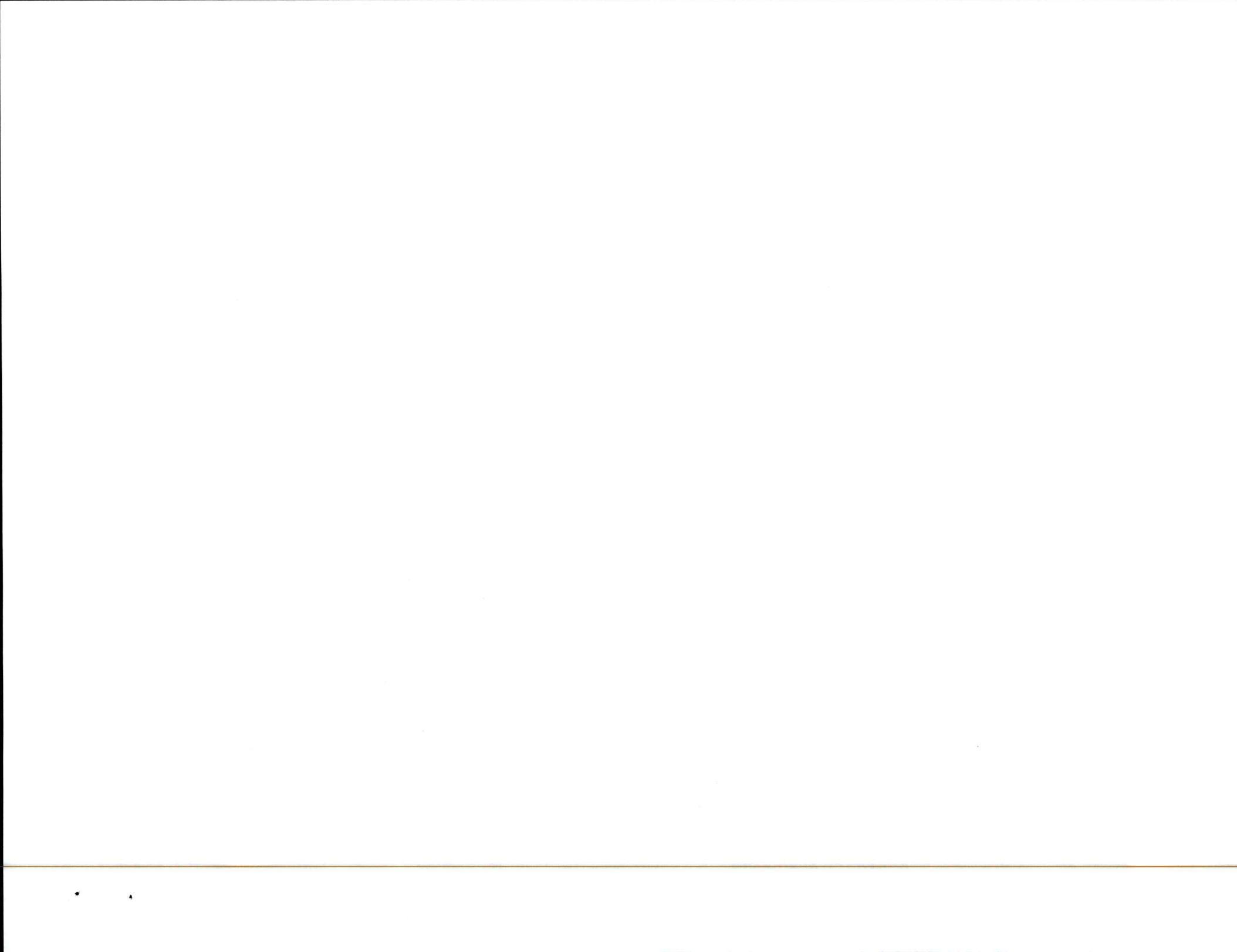
PO #: 50000294408

OP #: 500 Shift #: 2

Total Parts Reworked:		<u>20</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>0</u>
EH	Exposed Hypotube	<u> </u>	<u>4</u>
EW	Exposed Wire	<u> </u>	<u>14</u>
MP	Micropores	<u>N/A</u>	<u>0</u>
SCR	Scratch	<u>N/A</u>	<u>0</u>
SKV	Skive Marks	<u> </u>	<u>2</u>
VD	Voids	<u> </u>	<u>7</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Candy</u> 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.

Data Uploaded for Engineering Review (Check):





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

PO #: 500000294408 OP #: 500 Shift #: 2nd

Total Parts Reworked:		33	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		6
EW	Exposed Wire		16
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks	N/A	N/A
VD	Voids		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000294408 OP #: 500 Shift #: 2nd

Total Parts Reworked:		29	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		17
MP	Micropores	n/a	n/a
SCR	Scratch	///	3
SKV	Skive Marks	n/a	n/a
VD	Voids		12
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Vanneej Lor 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000294408

OP #: 750 Shift #: 2nd

Total Parts Reworked:		11	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	111	5
DIM07 US / WC	DIM07 Undersized (Window Closed)	1111	6
EH	Exposed Hypotube	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MV78 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):



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

PO #: 500000294408

OP #: 750 Shift #: 2

Total Parts Reworked:		46	
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)		5
EH	Exposed Hypotube		12
gd	glue damage		24
Inspected By (Sign and Date):		DX35 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):

PRODUCTION ORDER# 500000294408

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	2:40pm	190°F	SG44	16 Jan 24	3:50pm	190°F	SG88	16 Jan 24	22
TM10409	N/A	4:02pm	190°F	SG88	16 Jan 24	5:02pm	190°F	SG88	16 Jan 24	34
TM12036	N/A	4:40pm	190°F	SG88	16 Jan 24	5:50pm	190°F	SG88	16 Jan 24	30
TM10409	N/A	5:43PM	190°F	XL91	16 Jan 24	6:53PM	190°F	XL91	16 Jan 24	26
TM12036	N/A	6:53pm	190°F	SG88	16 Jan 24	8:03PM	190°F	SG88	16 Jan 24	33
TM10409	N/A	7:48PM	190°F	SG88	16 Jan 24	8:58pm	190°F	SG88	16 Jan 24	48
TM12036	N/A	8:35PM	190°F	XL91	16 Jan 24	9:45PM	190°F	XL91	16 Jan 24	38
TM10409	N/A	9:22pm	190°F	SG88	16 Jan 24	10:32pm	190°F	SG88	16 Jan 24	37
TM12036	N/A	9:53 pm	190°F	SG88	16 Jan 24	11:03pm	190°F	SG88	16 Jan 24	40
TM10409	N/A	10:36pm	190°F	SG88	16 Jan 24	11:46pm	190°F	SG88	16 Jan 24	48
TM12036	N/A	11:05pm	190°F	SG88	16 Jan 24	12:15am	190°F	SG88	17 Jan 24	48
TM10409	N/A	11:52pm	190°F	SG88	16 Jan 24	1:02AM	190°F	SG88	17 Jan 24	54
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A



PO #: 500000294408

OP #: 900 Shift #: 2

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		40	
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		42
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
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):

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023

PO #: 500000294408OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		52	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		① 2 3
EW	Exposed Wire		2
MP	Micropores	N/A	0
SCR	Scratch		51
SKV	Skive Marks	N/A	0
VD	Voids	/	1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	/	7
DIM06 OS	DIM06 OD Oversized		4
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H - 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): ① AT39 16Jan24
corrections of
quantity.



PO #: 500000294408

OP #: 900 Shift #: 2nd

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

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

Data Uploaded for Engineering Review (Check):

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023



PO #: 500000294408

OP #: 900 Shift #: 2

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.

Signed for HT72

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	29.31	25.91	26.77	27.54	24.14	27.66	29.91	30.85	26.73	24.96	27.378	2.149423	4.378	17.9678276	8.542	PASS
Seg B	62.97	60.48	65.07	59.55	57.81	62.36	63.44	56.49	57.71	60.32	60.62	2.808333	3.981	49.440027	8.542	PASS
Seg C	80	79.96	78.12	82.15	79.54	82.23	78.82	80.97	78.2	79.15	79.914	1.474405	2.911	75.6220061	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 #: 500000294408

Date: 17 jan 24

Inspector Name: Javier Olivares

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

JOOI 17 jan 24