

Production Order: 500000294406



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

Material: SA0155-01 Rev F

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

Order Type: ZSTD

Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																	
50	KITTING3 Kitting Devices  Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>XC31 10:50AM 09JAN24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 10pm 10 Jan 24</u> Record Dryer Shelf #: <u>N/A</u>	N/A	N/A	09 JAN 24	OLAS																	
		<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>7</u></td> <td>PC</td> <td>500</td> <td><u>0000276172</u></td> <td><u>500</u> <u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>5</u></td> <td>PC</td> <td>500</td> <td><u>0000281412</u></td> <td><u>500</u> <u>N/A</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>7</u>	PC	500	<u>0000276172</u>	<u>500</u> <u>N/A</u>	MM1536-01	B <u>5</u>	PC	500	<u>0000281412</u>	<u>500</u> <u>N/A</u>			
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>7</u>	PC	500	<u>0000276172</u>	<u>500</u> <u>N/A</u>																		
MM1536-01	B <u>5</u>	PC	500	<u>0000281412</u>	<u>500</u> <u>N/A</u>																		

Notes: DH QDA 2484, 2564

N/A

N/A

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		RM0158-01	E	<u>E</u>	PC	200	<u>81054</u>	<u>N/A</u>	<u>N/A</u>	<u>250</u>	
		1000-1153-01	A	<u>A</u>	PC	594	<u>87099</u>	<u>N/A</u>	<u>200</u>	<u>200</u>	
							<u>87219</u>		<u>200</u>	<u>200</u>	
							<u>87220</u>		<u>200</u>	<u>200</u>	
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278830</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000276175</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		

Notes:

N/A

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NP	N/A	141967-01	02	02	PC	500	85500	506			
							N/A	N/A			
		RM7349-02	C	C	PC	543	83425	363			
							82678	68			
		RM7348-01	C	C	PC	500	83433	100			
							82882	450			
		RM4001-01	B	B	PC	125	83127	50	N/A	N/A	N/A
							82877	100			
		RM0607-01	D	D	PC	56	74662	100			
							N/A	N/A			
		RM0498-01	C	C	PC	500	0000275489	500			
							N/A	N/A			
		RM0009-04	I	I	PC	1	82971	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	82971	Bulk			

Notes:

N/A

N/A

N/A

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N/A	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>0000281413</u>	<u>N/A</u>	<u>500</u>	
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>N/A</u>	<u>1080</u>	
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282489</u>	<u>N/A</u>	<u>N/A</u>	
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>500</u>	
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>N/A</u>	<u>N/A</u>	
		MM0074-01	G	<u>G</u>	PC	500	<u>0000291662</u> <u>0000276843</u> <u>0000286923</u>	<u>522</u> <u>10</u> <u>32</u>	<u>N/A</u>	

Notes:

N/A

N/A

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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	11 Jan 24	V078
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	0	11 Jan 24	SX60 SH23 JY90 NK62 AF54 AX05 pm 96
Notes:						
N/A						
N/A						
N/A						

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NP	Confirmation Reqd(Milestone)		N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	11 Jan 2024	DX35 Y04 M450 C497
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	11 Jan 2024	ZL30 AS31 SXII C497
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1 	Insert Cut Hypo Tube Insert Cut Hypo Tube Confirmation Reqd(Milestone)	500	0	11Jan24	cp32 GS22 VP62 LM46
350	CATASY01 Catheter Assembly 1	Load Tubing	500 ① acts ①	② 500 0	11Jan24	ST96 ny35 W25 lmub
Notes:						
N/A N/A N/A						

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	 Load Tubing Confirmation Reqd(Milestone)		N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)		500	0	11/04/24	S785 V078 NK62 RN21 AF54 AX05 Pm96 LL61
450	CATASY01 Catheter	FEP Removal	500	0	11/04/24	SG88 Pm96

Notes:

N/A
N/A
N/A

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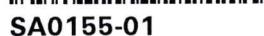
Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 FEP Removal Confirmation Reqd(Milestone)		n/a	n/a	n/a	n/a
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Confirmation Reqd(Milestone)	In-process Inspection and Rework Material Consumed: Part #: <u>1000-1153-01</u> Batch #: <u>87099</u> Qty: <u>16</u> Part #: <u>1000-1153-01</u> Batch #: <u>63127</u> Qty: <u>12</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>	493	OF-1111 EW-111 +10 ⑦	11Jan24 24 ⑦	P66 PP40 TD45 TA 36 CB 32 VL 09 LL61
			n/a	n/a	n/a	n/a
			n/a	n/a	n/a	n/a
			n/a	n/a	n/a	n/a
			n/a	n/a	n/a	n/a
			n/a	n/a	n/a	n/a

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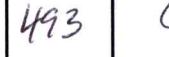
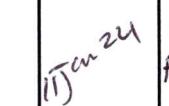
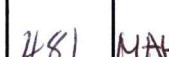
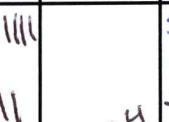
① KLG5 11Jan24

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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 Rreqd(Milestone)	Remove Heat Shrink & Mandrel	493	0  (1) w 20	  H61 RS23	CL05 ML38 HL34 H61 RS23
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	481	DL-HH1 IIII MAH - III  (12) (1) w 24	  SV46 VA96 RS23	

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	Reqd(Milestone)	~1A	~1A	~1A	~1A	MA
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink .	481	0	~1A 11JW~ ~1A	ML38 MV78 BV39
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 may 24 TMI: 2083C Cal Due: 31 may 24 TMI: 6386 Cal Due: 31 may 24 TMI: 09364 Cal Due: 31 may 24	481	0	~1A 11JW~ ~1A	ML38 STX48
Notes:						
~1A						
~1A						
~1A						

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Opn 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
750	CATASY01 Catheter Assembly 1 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <p>Part #: 2m4061-c Batch #: 83127 Qty: 10</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	481	0	ITW 24	M002 STR48 Hv36
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	474	ACD-HT II ⑦	ITW 24	M005 SS44

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
850	CATASY01 Catheter Assembly 1 	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. passed 2. passed 3. passed 4. passed 5. passed	474	0	11Jan24	SS52
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A
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Opr. No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP	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>D700-01</u> Cal Due: <u>31may24</u> TMI: <u>MA</u> Cal Due: <u>MA</u> TMI: <u>MA</u> Cal Due: <u>N/A</u> TMI: <u>MA</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>MA</u> TMI: <u>MA</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>D2401-01</u> Batch #: <u>83127</u> Qty: <u>21</u> Part #: <u>4000-1530</u> Batch #: <u>87099</u> Qty: <u>18</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>	408	<p>DIS-<u>4H 4H</u> <u>4H 4H 4H</u> <u>4H 4H 4H 4H</u> <u>"</u> Del-<u>4H</u> <u>H6WS-111</u> <u>HGS-1</u> <u>ID-11</u> <u>Ew-1H 11</u></p> <p>(66)</p>	11/5am/24	PY46 T636 KT217
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>MA</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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	 Quality Inspection & Review Confirmation Reqd(Milestone)	<p>TMI: <u>MA</u> Cal Due: <u>MA</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30sep25</u> TMI: <u>0692</u> Cal Due: <u>30sep25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u></p>	368	DIS-4444H HHT LHT HHT HHT HHT (SP) STR-44H 40 11Jan24	D 1 11Jan24	PY46
1000	 QUALITY1 Quality Inspection & Review Confirmation Reqd(Milestone)	<p>Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31may24</u> Record Length Gage Information: TMI: <u>08891D</u> Cal Due: <u>30sep24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30sep24</u></p>	331	LT-HHHHH HAH LHT LHT HLT LHT II 37 11Jan24	KT217	PY46

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	2 AS	SCR - 4M11 (TT) Del - 11 (TT) PM - 1 (TT) DL - 1111 DIS - 1111 VD - 111 POC - 111 SKV - 111 SCR - 111 Mar - 1 #505 - 1 EW - 1 GN4 - 1 CRK - 1 FM - 1	SV43 12 Jan 24 12 Jan 24	XN26 SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>Xc31</u> <u>11JAN24</u>	N/A	N/A	11JAN24 Xc31	

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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	295	0	12Jan24	BMI

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Batch Number: 0000294406

By: BA71

Date: 12 Jan 24

Reviewed By:

RB29

Date:

12 JAN 24

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Beta to 2024 3208 19/6/23



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Extend to 2023 3208 19/6/23
Beta to 2023 3208 19/6/23

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484

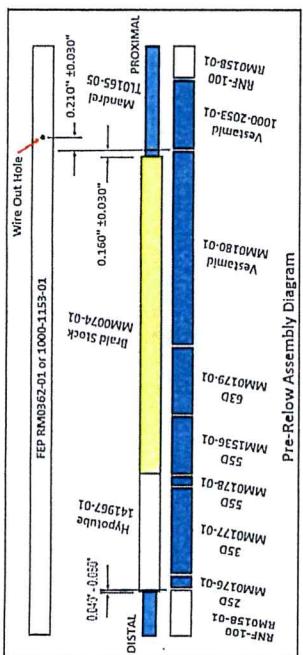
* See attached email extension to 24SEP23
TSD
24AUG23 3208
Extend to 2023 3208 19/6/23

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.



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.

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	End Date:	Revision
SA0155-01	25 Aug 2023	H

Start Date: 26 Jul 2023 **End Date:** 25 Aug 2023 **Lot Number:** 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 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:

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: Yes No **If no, explain:**

① UK55, 23 Jul 2023



DA | 2484
2468

Group Training Record

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

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and MM1536-01 fixture for inspection. (See image 1)
① MM01536-01 type connection 512 10AUG-23



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)

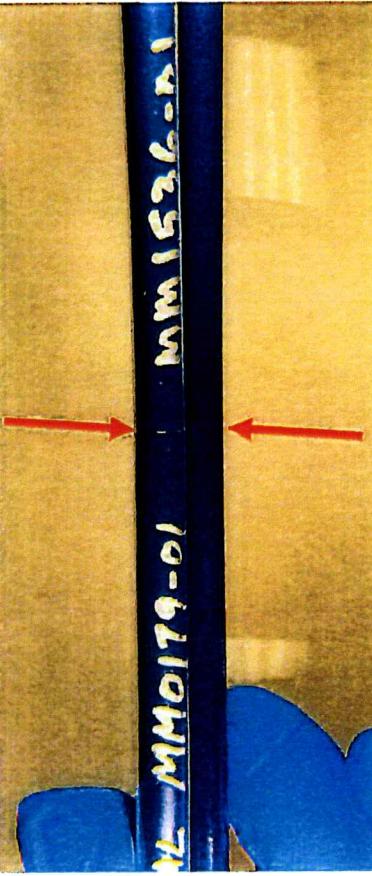


Image- 3

- 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.

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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)

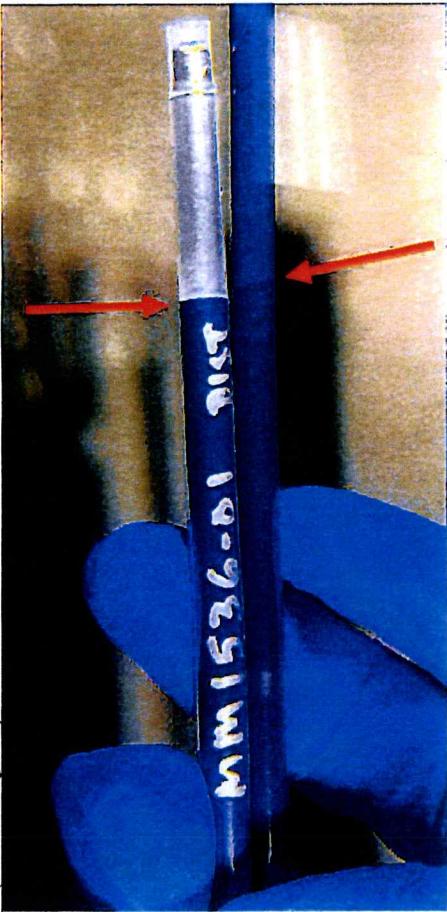


Image- 4

- 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 Two MM0179-01 - BAD PART
4	MM1536-01 Two MM1536-01 - BAD PART	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 Stanislawski		25 Jul 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF

Deviation Authorization

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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:	Doc #3005206 (Flex Commander MPI0238): OPER850.11:		
<p>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.</p>			

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.

TM10700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TM10700-01 is already qualified to inspect Dim 6 per ES0647; Laser micrometer equivalency test, there is no additional risk in using TM10700-01 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 TM10700-01. 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# 500000294406

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	9:32pm	429	SH85	10Jan24	9:44pm	415	SH85	10Jan24	16
Tm10942	44	10:02pm	430	V078	10Jan24	10:14pm	415	V078	10Jan24	16
Tm10942	44	10:28pm	427	SH85	10Jan24	10:40pm	415	V078	10Jan24	16
Tm10942	44	11:50pm	430	V078	10Jan24	12:02AM	415	V078	11Jan24	16
Tm10942	44	12:15AM	427	V078	11Jan24	12:27AM	415	V078	11Jan24	16
Tm10942	44	12:40AM	428	V078	11Jan24	12:52AM	415	V078	11Jan24	16
Tm10942	44	1:01AM	427	V078	11Jan24	1:13AM	415	V078	11Jan24	16
Tm10942	44	1:28AM	426	V078	11Jan24	1:40AM	415	V078	11Jan24	16
Tm10942	44	1:55AM	430	V078	11Jan24	2:07AM	415	AT39	11Jan24	① 16 ¹⁴
Tm10942	44	5:25am	430	AX05	11Jan24	5:37am	415	AX05	11Jan24	16
Tm10942	44	5:58am	430	AX05	11Jan24	6:10am	415	AX05	11Jan24	16
Tm10942	44	6:23am	428	AX05	11Jan24	6:35am	415	AX05	11Jan24	16

① V078 11Jan24



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

PRODUCTION ORDER# 500000294406

OP 400

① AF54 11 Jan 24



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

PRODUCTION ORDER# 500000294406

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	9:18pm	430	V078	10Jan24	9:30pm	415	SH85	10Jan24	16
TM10745	44	9:44pm	428	SH85	10Jan24	9:56pm	415	SH85	10Jan24	16
TM10745	44	10:11pm	428	V078	10Jan24	10:23pm	415	SH85	10Jan24	16
TM10745	44	10:44pm	429	SH85	10Jan24	10:56pm	415	SH85	10Jan24	16
TM10745	44	11:36pm	430	V078	10Jan24	11:48pm	415	V078	10Jan24	16
TM10745	44	12:00AM	430	V078	11Jan24	12:12AM	415	V078	11Jan24	16
TM10745	44	12:22AM	429	V078	11Jan24	12:34AM	415	V078	11Jan24	16
TM10745	44	12:49AM	428	V078	11Jan24	1:01AM	415	V078	11Jan24	16
TM10745	44	1:18AM	430	V078	11Jan24	1:30AM	415	SA07	11Jan24	16
TM10745	44	1:50AM	429	SH85	11Jan24	2:02AM	415	AT39	11Jan24	16
TM10745	44	5:20am	430	AX05	11Jan24	5:32am	415	AX05	11Jan24	16
TM10745	44	① 5:45am 5:40	429	AX05	11Jan24	5:57am	415	AX05	11Jan24	16

① AX05 11Jan24



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

PO #: 50000294406

OP #: 500 Shift #: 2

Total Parts Reworked:		<u>16</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>11</u>	<u>2</u>
EW	Exposed Wire	<u>HHH HHH HH 1</u>	<u>16</u>
MP	Micropores	<u>N/A</u>	<u>0</u>
SCR	Scratch	<u>N/A</u>	<u>0</u>
SKV	Skive Marks	<u>N/A</u>	<u>0</u>
VD	Voids	<u>1</u>	<u>1</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Cauf</u>	<u>10 Jan 24</u>

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

Data Uploaded for Engineering Review (Check):



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

PO #: 500000294406

OP #: 500 Shift #: 2nd

Total Parts Reworked:		30	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	
EH	Exposed Hypotube	PP40 10 Jan 24	
EW	Exposed Wire	XXXXXXX 11	27
MP	Micropores		
SCR	Scratch	N/A	
SKV	Skive Marks	PP40 10 Jan 24	
VD	Voids		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		PP40 10 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 #: 500000294406 OP #: 500 Shift #: 1

Total Parts Reworked:		<u>103</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		
EH	Exposed Hypotube		27
EW	Exposed Wire		98
MP	Micropores	N/A	N/A
SCR	Scratch		4
SKV	Skive Marks		
VD	Voids		14
N/A	N/A	N/A	N/A

Inspected By (Sign and Date): LL61, CBSI, VC09, TA36 11 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 #: 500000294406 OP #: 750 Shift #: 2nd.

Total Parts Reworked:		5	
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)		2
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	10 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 #: 50000294406 OP #: 750 Shift #: 1st

Total Parts Reworked:		136	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		7
DIM07 US / WC	DIM07 Undersized (Window Closed)		14
EH	Exposed Hypotube		52
N/A	Glue, Stopper		63
Inspected By (Sign and Date):		STX48	11 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# 500000294406

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	1:15 am	190°F	ML65	11Jan24	2:25 am	190°F	ML65	11Jan24	40
TM10409	N/A	4:45 am	190°F	SS44	11Jan24	5:55 am	190°F	SS44	11Jan24	28
TM12036	N/A	5:40 am	190°F	SS44	11Jan24	6:50 am	190°F	SS44	11Jan24	42
TM10409	N/A	6:05 am	190°F	SS44	11Jan24	7:15 am	190°F	SS44	11Jan24	28
TM12036	N/A	7:00 am	190°F	SS44	11Jan24	8:10 am	190°F	SS44	11Jan24	42
TM10409	N/A	8:10 am	190°F	SS44	11Jan24	9:20 am	190°F	SS44	11Jan24	43
TM12036	N/A	8:50 am ^①	190°F	SS44	11Jan24	10:00 am	190°F	SS44	11Jan24	32
TM10409	N/A	9:25 AM	190°F	PM96	11Jan24	10:35 AM	190°F	PM96	11Jan24	43
TM12036	N/A	10:00 am	190°F	OS21	11Jan24	11:10 am	190°F	OS21	11Jan24	49
TM10409	N/A	11:25 am	190°F	SS44	11Jan24	12:35 pm	190°F	SS44	11Jan24	30
TM12036	N/A	12:05 pm	190°F	SS44	11Jan24	1:15 pm	190°F	SS44	11Jan24	63
TM10409	N/A	12:35 pm	190°F	OS21	11Jan24	1:45 pm	190°F	SS44	11Jan24	28
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① SS44 11Jan24

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be selected and tensile tested)																
Sample # -->	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	25.13	24.39	27.28	27.34	28.17	24.94	25.53	24.88	24.67	26.8	25.913	1.3508849	4.378	19.9988259	8.542	PASS
Seg B	68.34	60.04	61.45	59.58	61.89	75.86	62.42	60.5	63.94	65.42	63.944	4.9710589	3.981	44.1542145	8.542	PASS
Seg C	72.14	74.73	74.86	74.95	76.5	25.53	71.97	74.86	75.18	75.98	69.67	15.57744	2.911	24.3240715	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 #: 500000294406

Date: 12JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

Andrew Wipf 12 Jan 24