

Production Order: 500000300503



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 26 Jan 24 Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Am68 26 Jan 24 11:00 am</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am68 2:15 pm 27 Jan 24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	24 JAN 24	DT70
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
	MM0179-01	D <u>D</u>	PC	500	<u>0000276172</u>	<u>540</u> <u>N/A</u>
	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>

Notes: DA2484, 2564

N/A

N/A

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① Am68 26 Jan 24

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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	<u>e</u>	PC	200	<u>58497</u>	<u>N/A</u>	<u>N/A</u>	<u>ISO</u>	
		RM0009-04	I	<u>l</u>	PC	1	<u>79168</u>	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	
		RM0009-04	I	<u>l</u>	PC	1	<u>79168</u>	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	
		MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u>	<u>N/A</u>	<u>N/A</u>	<u>1060</u>	<u>N/A</u>
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278880</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	<u>N/A</u>

Notes:

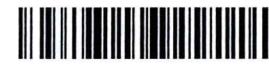
N/A

N/A

N/A

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N/A	N/A	TL0167-02	E	<u>E</u>	PC	70	N/A	Bulk			
							N/A	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	N/A	Bulk			
							N/A	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	N/A	Bulk			
							N/A	Bulk			
		141967-01	02	<u>02</u>	PC	500	85793	525			
							N/A	N/A	N/A	N/A	
		RM7349-02	C	<u>C</u>	PC	543	82863	500			
							N/A	N/A			
		RM7348-01	C	<u>C</u>	PC	500	82886	600			
							N/A	N/A			
		RM4001-01	B	<u>B</u>	PC	125	82473	100			
							① 82461 N/A	N/A			
		RM0607-01	D	<u>D</u>	PC	56	74663	78			

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	N/A	RM0498-01	C	<u>C</u>	PC	500	<u>0000275492</u>	N/A		
		RM0362-01	E	<u>E</u>	PC	594	<u>80236</u>	N/A		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284203</u>	500		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000295774</u>	400		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000282490</u>	100		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000276174</u>	500		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000281411</u>	500		
							<u>0000271036</u>	80		
							<u>0000295127</u>	514		
							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
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	500	0	28Jan24	V078
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	28Jan24	YK40 SD34 CXG3 TANV678

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	28Jan24	DX35 LH45
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	28Jan24	AJ65 PY67 LH45
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	28Jan24	DV39 RL47
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	28Jan24	SN4 CD19
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)	.	500	0	28Jan24	SN67 AL67
450	CATASY01 Catheter	FEP Removal	500	0	28Jan24	YK40 SN67
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	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 In-process Inspection and Rework Material Consumed: Part #: 10001153-01 Batch #: 87654 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	In-process Inspection and Rework Material Consumed: Part #: 10001153-01 Batch #: 87654 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	480	EN-1001/2024 OF-III 20	LS46 VC09 AR02 28Jan24 SX11	
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	468	MAH-14K HHR II 12	28Jan24	RS 23 MH10 YK95
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly	468	0	28Jan24	MH10 PT09

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	468	0	28Jan24	LH45
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: <u>2083C</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0521</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0386</u> Cal Due: <u>31 MAY 24</u> TMI: <u>0936A</u> Cal Due: <u>31 MAY 24</u> Tipping	468	0	28Jan24	LH45 BI60
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															
750	CATASY01 Catheter Assembly 1 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <table> <tr> <td>Part #: RM0607-01</td> <td>Batch #: 74663</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: RM4001-01</td> <td>Batch #: 82461</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #: N/A</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #: N/A</td> <td>Qty: N/A</td> </tr> <tr> <td>Part #: N/A</td> <td>Batch #: N/A</td> <td>Qty: N/A</td> </tr> </table> <p>Tip Inspection/ Flash Removal</p> <p>Confirmation Reqd(Milestone)</p>	Part #: RM0607-01	Batch #: 74663	Qty: N/A	Part #: RM4001-01	Batch #: 82461	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	465	DS-1 EH-11 ③	28Jan24	PT09 BI60
Part #: RM0607-01	Batch #: 74663	Qty: N/A																			
Part #: RM4001-01	Batch #: 82461	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																			
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	465	0	28Jan24	BD64 KL45 ALU2TRN															

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 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>	465	0	28Jan24	DLOT KX5 ALU2 TRN
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	DLOT KX54
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)	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31May24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>1006-1153-01</u> Batch #: <u>87654</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>58497</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82473</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>74663</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	442	23 DEL-HI SP SCR-111(GT) DEL-111(T) DS-111(T) EW-HI I #90S_1 MP-1	28Jan24	DX52
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

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: <u>N/A</u> Cal Due: <u>N/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30Sep24</u> 30Sep25 TMI: <u>0692</u> Cal Due: <u>30Sep25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	437	#90S-1111 STR-1 <u>5</u>	28Jan24	KL45 AL42
1000	 QUALITY1 Quality Inspection & Review Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31May24</u> Record Length Gage Information: TMI: <u>08890</u> Cal Due: <u>30Sep24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30Sep24</u>	433	LT-1111 <u>4</u>	28Jan24	CBS8 KL45

Notes:

N/A

N/A

N/A

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(1) CBS8 28Jan24



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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 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	383	DIS-III SCR-III BP-III AB-II STN-II SKV-II VD-III MEX-I KNK-I EW-II FM-III CRK-I DL-III DNT-I DEL-III (50)	29 Jan 24	K155 SV43 XN26
1100	CATASY01 Catheter Assembly 1 	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): K02 29 Jan 24	N/A	N/A	29 Jan 24	K02
Notes:						
N/A						
N/A						
N/A						

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1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	383	0 N/A APR 20 JUN 2024	APR 10 JUN 2024	APR 10

Notes:

N/A APR 20 JUN 2024

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Batch Number: 0000.300503

By: AP10

Date: 30 Jan 24

Reviewed By:

RB 29

Date:

30 JAN 24

Notes:

N/A AP10 30 Jan 24

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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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① UK55, 23JW 2023



DA DA 2484-
2468-①

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

Group Training Record

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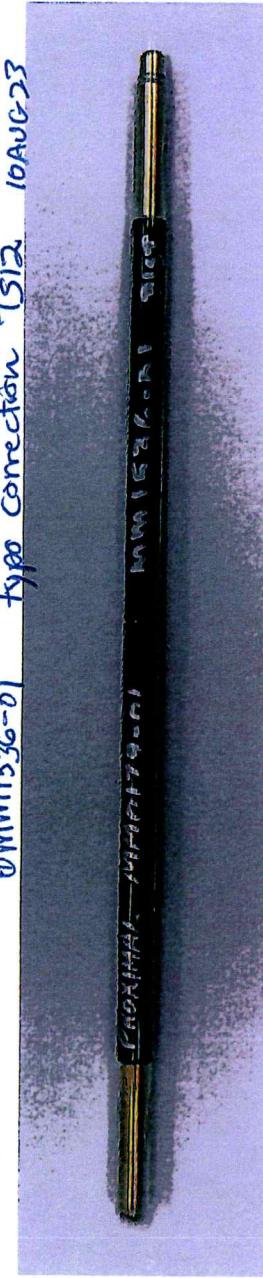


Image- 1

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)

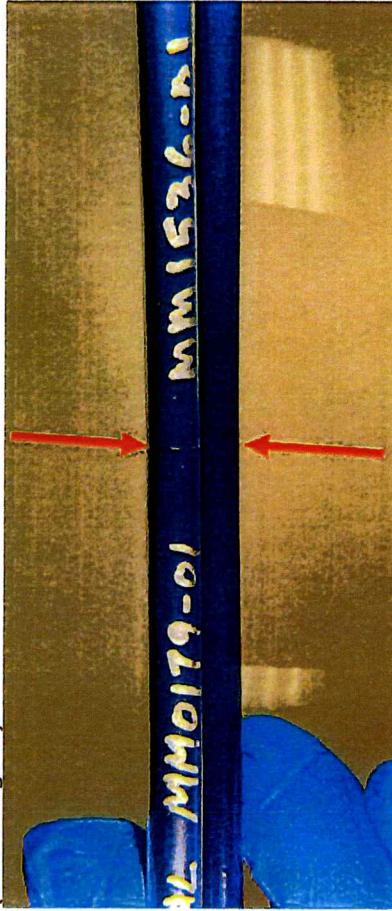
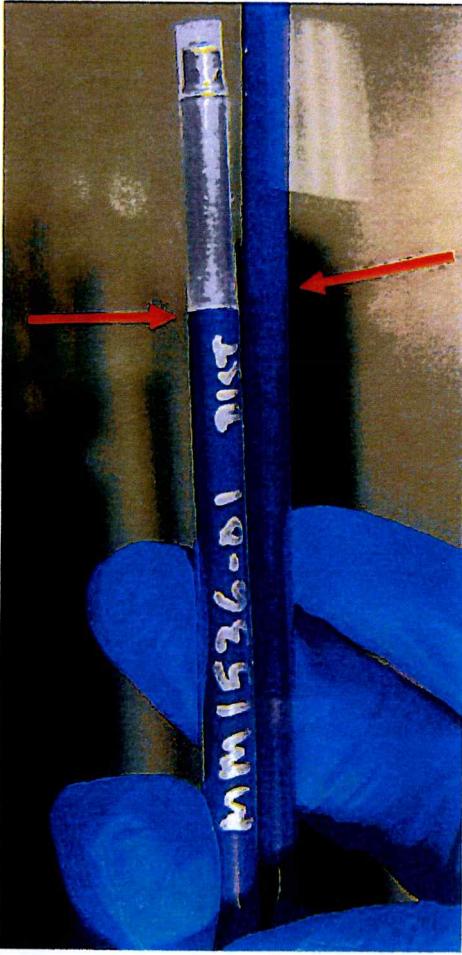


Image- 3

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

Image - 5

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Entered to 13 Feb 2024 328 1/9/2024

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DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc # 3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<p>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</p> <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>	<p>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</p> <p>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.</p>		
Justification:			
<p>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.</p> <p>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.</p>			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:		
16 Nov 23	15 DEC 23		
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 <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 checked="" type="checkbox"/> Yes <input 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# 500000300503

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	2:50pm	430	CB58	27Jan24	3:02pm	415	CB58	27Jan24	16
TM10745	44	3:25pm	430	CB58	27Jan24	3:37pm	415	CB58	27Jan24	16
TM10745	44	4:45pm	430	CD19	27Jan24	4:57pm	415	CD19	27Jan24	16
TM10745	44	5:18pm	430	SN67	27Jan24	5:36pm	415	SN67	27Jan24	16
TM10745	44	5:50pm	430	CD19	27Jan24	6:02pm	415	CD19	27Jan24	16
TM10745	44	6:18pm	430	CD19	27Jan24	6:20pm	415	CD19	27Jan24	16
TM10745	44	6:56AM	430	SN67	28Jan24	7:08AM	415	SN67	28Jan24	16
TM10745	44	7:18AM	430	PL22	28Jan24	7:30AM	415	PL22	28Jan24	16
TM10745	44	7:47AM	430	SN67	28Jan24	7:59AM	415	SN67	28Jan24	16
TM10745	44	8:21AM	430	SN67	28Jan24	8:33AM	415	SN67	28Jan24	16
TM10745	44	9:42AM	430	AL67	28Jan24	9:54AM	415	AL67	28Jan24	16
TM10745	44	10:17AM	430	AL67	28Jan24	10:29AM	415	AL67	28Jan24	16

① SN67 28Jan24



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PRODUCTION ORDER# 500000300503

OP 400



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FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000300503

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	2:35 PM	430	KL45	27JAN24	2:45PM	415	KL45	27JAN24	16
TM10942	44	3:15pm	430	CB58	27Jan24	3:27pm	415	CB58	27Jan24	16
TM10942	44	^{3:46pm} 9:18pm ①	430	VO78	27Jan24	3:52pm	415	CB58	27Jan24	16
TM10942	44	4:20 pm	430	CD19	27Jan24	4:32pm	415	CD19	27Jan24	16
TM10942	44	4:57pm	430	SN67	27Jan24	5:09pm	415	SN67	27Jan24	15
TM10942	44	5:35pm	430	SN67	27Jan24	5:47pm	415	SN67	27Jan24	16
TM10942	44	6:05pm	430	CD19	27Jan24	6:17PM	415	CD19	27Jan24	16
TM10942	44	6:31 AM	430	PL22	28Jan24	6:43AM	415	PL22	28Jan24	16
TM10942	44	7:08 AM	430	PL22	28Jan24	7:20AM	415	PL22	28Jan24	16
TM10942	44	7:31 AM	430	PL22	28Jan24	7:43AM	415	PL22	28Jan24	16
TM10942	44	8:07AM	430	SN67	28Jan24	8:19 AM	415	SN67	28Jan24	16
TM10942	44	8:35 AM	430	KL45	28JAN24	8:47AM	415	KL45	28JAN24	16

① CB58 27Jan23



PRODUCTION ORDER# 500000 300503

OP 400

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



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000300503OP #: 500 Shift #: 3

Total Parts Reworked:		213	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		3
EH	Exposed Hypotube		69
EW	Exposed Wire		108
MP	Micropores	N/A	N/A
SCR	Scratch		7
SKV	Skive Marks		10
VD	Voids		16
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LS46, AR02 VC09	28 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):

①CB58 28Jan24



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000 300503

OP #: 750 Shift #: 3

Total Parts Reworked:		125	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		35
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube		60
GD / AB	Glue damage / Air Bubbles		30
Inspected By (Sign and Date):		B160 28 Jan 2024	

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# 50000300503

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	5:00 AM	190°F	KL4S	28JAN24	6:10 AM	190°F	KL4S	28JAN24	33
TM10409	N/A	6:50 AM	190°F	AL42	28JAN24	8:00 AM	190°F	AL42	28JAN24	21
TM12036	N/A	7:25AM	190°F	KL4S	28JAN24	8:35AM	190°F	KL4S	28JAN24	27
TM10409	N/A	8:10 AM	190°F	AL42	28JAN24	9:20AM	190°F	AL42	28JAN24	29
TM12036	N/A	8:40 AM	190°F	KL4S	28JAN24	9:50AM	190°F	KL4S	28JAN24	27
TM10409	N/A	9:35AM	190°F	KL4S	28JAN24	10:45AM	190°F	KL4S	28JAN24	28
TM12036	N/A	10:05 AM	190°F	AL42	28 JAN24	11:15 AM	190°F	AL42	28 JAN24	23
TM10409	N/A	10:50AM	190°F	KL4S	28JAN24	12:05 PM	190°F	KL4S	28JAN24	35
TM12036	N/A	11:19 AM	190°F	KL4S	28 JAN24	12:29PM	190°F	KL4S	28 JAN24	31
TM10409	N/A	12:00PM	190°F	AL42	28JAN24	1:10PM	190°F	AL42	28 JAN24	45
TM10409	N/A	2:00 PM	190°F	KL4S	28JAN24	3:10 PM	190°F	KL4S	28JAN24	44
TM12036	N/A	2:15PM	190°F	KL4S	28 JAN24	3:25 PM	190°F	KL4S	28 JAN24	26
TM10409	N/A	3:15PM	190°F	KL4S	28JAN24	4:25PM	190°F	KL4S	28JAN24	96

PO #: 500000300503OP #: 900 Shift #: 3

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		<u>179</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>XX</u>	10
EH	Exposed Hypotube	<u>XXX</u>	16
EW	Exposed Wire	<u>XXXXXXXXXXXXXXXXXXXX</u>	110
MP	Micropores	<u>XX</u>	6
SCR	Scratch	<u>XXXXXXXXXXXXXXXXXXXX</u>	82
SKV	Skive Marks	<u>XXX</u>	9
VD	Voids	<u>XXXXXXXXXXXXXXXXXXXX</u>	41
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	<u>XXXX</u>	19
DIM06 OS	DIM06 OD Oversized	<u>XXX</u>	9
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		<u>D207 12X54</u>	<u>28 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. 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	31.18	33.34	30.84	31.47	24.03	24.69	29.94	30.96	27.52	25.46	28.943	3.2620071	4.378	14.6619331	8.542	PASS
Seg B	71.89	79.27	72.83	80.32	67.64	74.86	79.18	74.65	69.1	72.27	74.201	4.3279363	3.981	56.9714858	8.542	PASS
Seg C	69.25	83.22	80.42	85.27	85.77	83.47	77.81	81.83	87.36	79.38	81.378	5.1953415	2.911	66.2543609	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

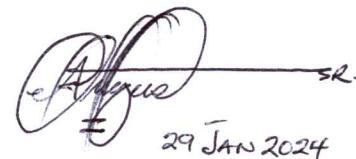
LOT #: 500000300503

Date: 29JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



29 JAN 2024