

Production Order: 500000304683



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>GS95 6:30AM 07 Feb 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 68 8:30am 09 Feb 24</u> Record Dryer Shelf #: <u>N/A</u>									
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
		MM0179-01	D <u>D</u>	PC	500	<u>00002414700</u>	<u>500</u>	N/A	N/A	<u>defeball</u>	<u>MJO</u>
		MM1536-01	B <u>B</u>	PC	500	<u>00002405300</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>		

Notes: DA2484, DA2564

N/A

N/A

Date Printed: 02/06/2024 / 15:28:48

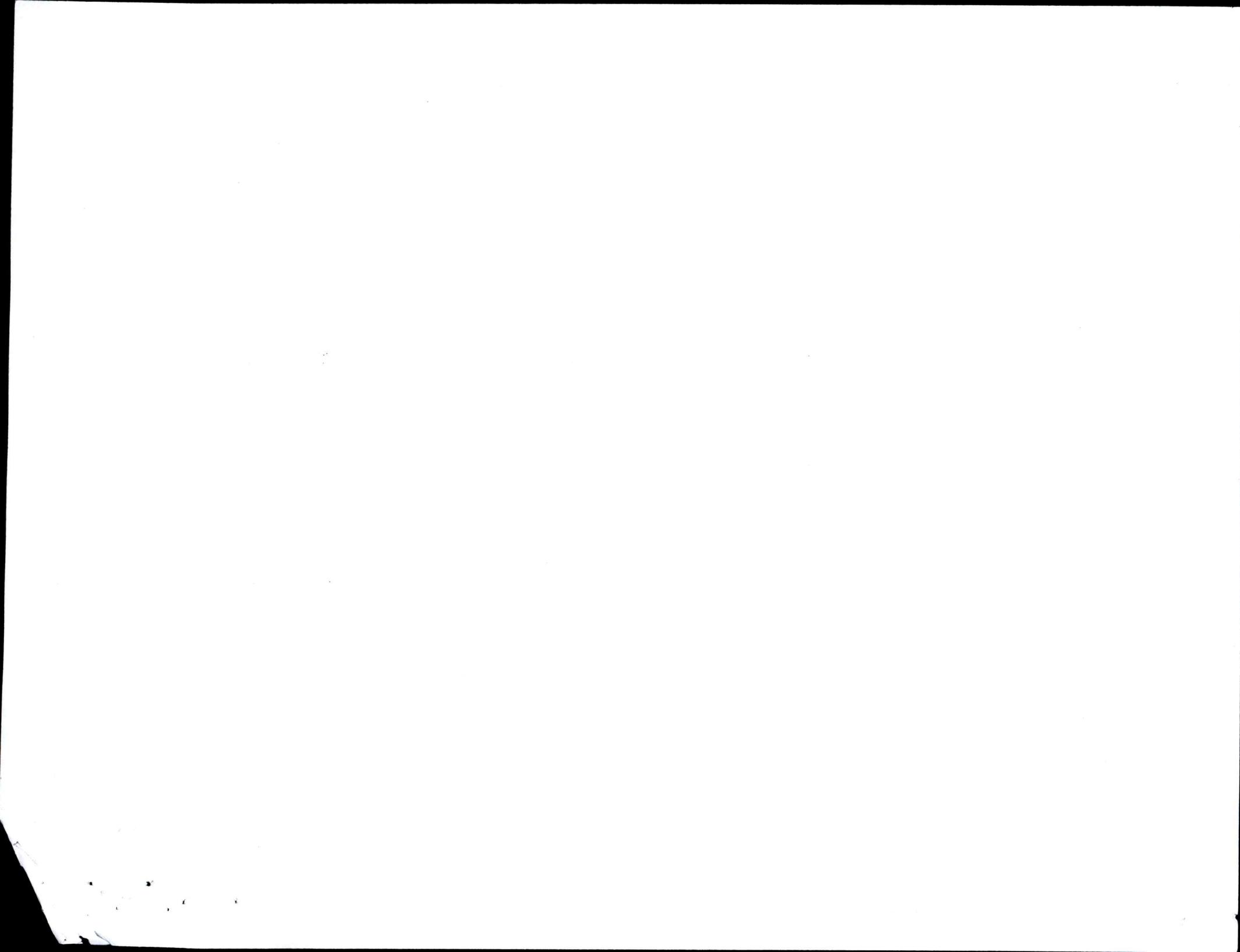
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Oper No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	N/A <u>81054</u>	N/A 100		
		1000-1153-01	A	<u>A</u>	PC	594	N/A <u>88074</u> <u>88075</u> <u>88076</u>	N/A 200 200 200		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288461</u>	<u>500</u>	N/A	N/A
		TL0167-02	E	<u>E</u> 4LC10 6feb24	PC	70	N/A	N/A		
		TL0165-05	J	<u>J</u>	PC	5	N/A	Bulk		
		TL0165-03	J	<u>J</u>	PC	5	N/A	Bulk		
							N/A	Bulk		

Notes:

N/A

N/A

N/A

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Op. No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty. & Desc.	Date Comp.	Initials
N/A	N/A	141967-01	02	02	PC	500	85794	515			
		RM7349-02	C	C	PC	543	82872	523	N/A		
		RM7348-01	C	C	PC	500	85697	500	N/A		
		RM4001-01	B	B	PC	125	82806	200		06feb24	WGD
		RM0607-01	D	D	PC	56	74662	108	N/A		
		RM0498-01	C	C	PC	500	000287647	479	N/A		
		RM0009-04	I	I	PC	1	88992	Bulk	N/A		
		RM0009-04	I	I	PC	1	88992	Bulk	N/A		

Notes:

N/A

N/A

N/A

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Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details					Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	K	PC	500	N/A 0000290562	Bulk 500		
		MM1537-01	A	H	PC	1000	N/A 0000290561	N/A 1000		
		MM0177-01	C	L	PC	500	N/A 0000284208	N/A 500		
		MM0180-01	E	E	PC	500	N/A 0000287541	N/A 500	N/A	06feb24 WGD
		MM0178-01	E	E	PC	500	N/A 0000290565	N/A 500		
		MM0176-01	D	D	PC	500	N/A 0000288413	N/A 500		
		MM0074-01	G	G	PC	500	N/A 0000301886	N/A 521		
							N/A 0000300401	N/A 626		

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	10Feb24	CB58
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	10Feb24	YK40 SN67 SD34 AM47
	Major and Minor Mandrel Assembly					
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 Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	10Feb24	MY150 MC17 LH45
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	10Feb24	R44T P767
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	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	10Feb24	AIGS PL22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	10Feb24	AIG7 CD19 MC17 BD64
Notes:						
N/A						
N/A						
N/A						

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Oper 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	10Feb24	R110 SN67
450	CATASY01 Catheter FEP Removal		500	0	10Feb24	Jc92 AM47 SD34
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
	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: Part #: 1000-1153-01 Batch #: 88074 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A		485	EW-HH-JHT OF-11 SCR-1 DL-11 15	2S46 CX63 CB81 10Feb24	
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)	467	MAH-HH 1X 1X DL-11 IDB-1 <u>18</u>	10Feb24	MH10 SC10
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly Distal Tip Assembly Confirmation	467	0	10Feb24	PT09 VAP16

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 Confirmation Reqd(Milestone)	Loading Heat Shrink	467	0	10Feb24	LH45
700	CATASY01 Catheter Assembly 1 Tipping Record Tipping Oven Information: TMI: 09364 Cal Due: 31May24 TMI: 20836 Cal Due: 31May24 TMI: 6386 Cal Due: 31May24 TMI: 0521 Cal Due: 31May24	Tipping Record Tipping Oven Information: TMI: 09364 Cal Due: 31May24 TMI: 20836 Cal Due: 31May24 TMI: 6386 Cal Due: 31May24 TMI: 0521 Cal Due: 31May24	467	0	10Feb24	JL83
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 	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4001-01 Batch #: 82806 Qty: N/A Part #: RM0607-01 Batch #: 74662 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	458	EH-IH1111 ⑨	10Feb24	BIGO IC83
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	452	ACD-IH1 ⑥	10Feb24	BD64 ALX12 TRN
Notes:						
N/A						
N/A						
N/A						

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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>	452	0	10Feb24	ALIZ TRN DL07
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
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>31 MAY 2024</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>1000-1153-01</u> Batch #: <u>88075</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82806</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>74662</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>81054</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	427	FM-14HTT DEL-14HTT DIS-14HSP DIS-1111 ND-11 SKV-11 MEX-1 EW-1 <u>25</u>	10Feb24	PL07 PP40 KX54 PL22 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

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>30 Sep 2025</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 2025</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	411	DIS-LHT111 STR-LHT #90S-11 #10S-1 (16)	10Feb24	PL22
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>31 MAY 2024</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 Sep 2024</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 2024</u>	403	LT-LHT111 (8)	10Feb24	CB58 PL22

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
1050	QUALITY1 Quality Inspection & Review 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS Quality Inspection & Review Confirmation Reqd(Milestone)	383	MAR - 1 DIS - 4 SCR - 3 DEL - 2 DL - 1 FM - 1 FL - 1 EH - 2 BP - 2 WK - 1 EW - 2	11 Feb 24	SV43 YK95
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KPD2 12 Feb 24	N/A	N/A	12 Feb 24	KPD2
Notes:						
<i>N/A</i>						
<i>N/A</i>						
<i>N/A</i>						

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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	383	0 12 Feb 24	AB10 12 Feb 24	AB10

Notes:

N/A AB10 12 Feb 24

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Material: SA0155-01 Rev F

Batch Number: 000304683

By: APIU

Date: 12 Feb 24

Reviewed By:

RB29

Date:

13 Feb 24

Notes:

N/A APIU 12 Feb 24

Date Printed: 02/06/2024 / 15:28:48

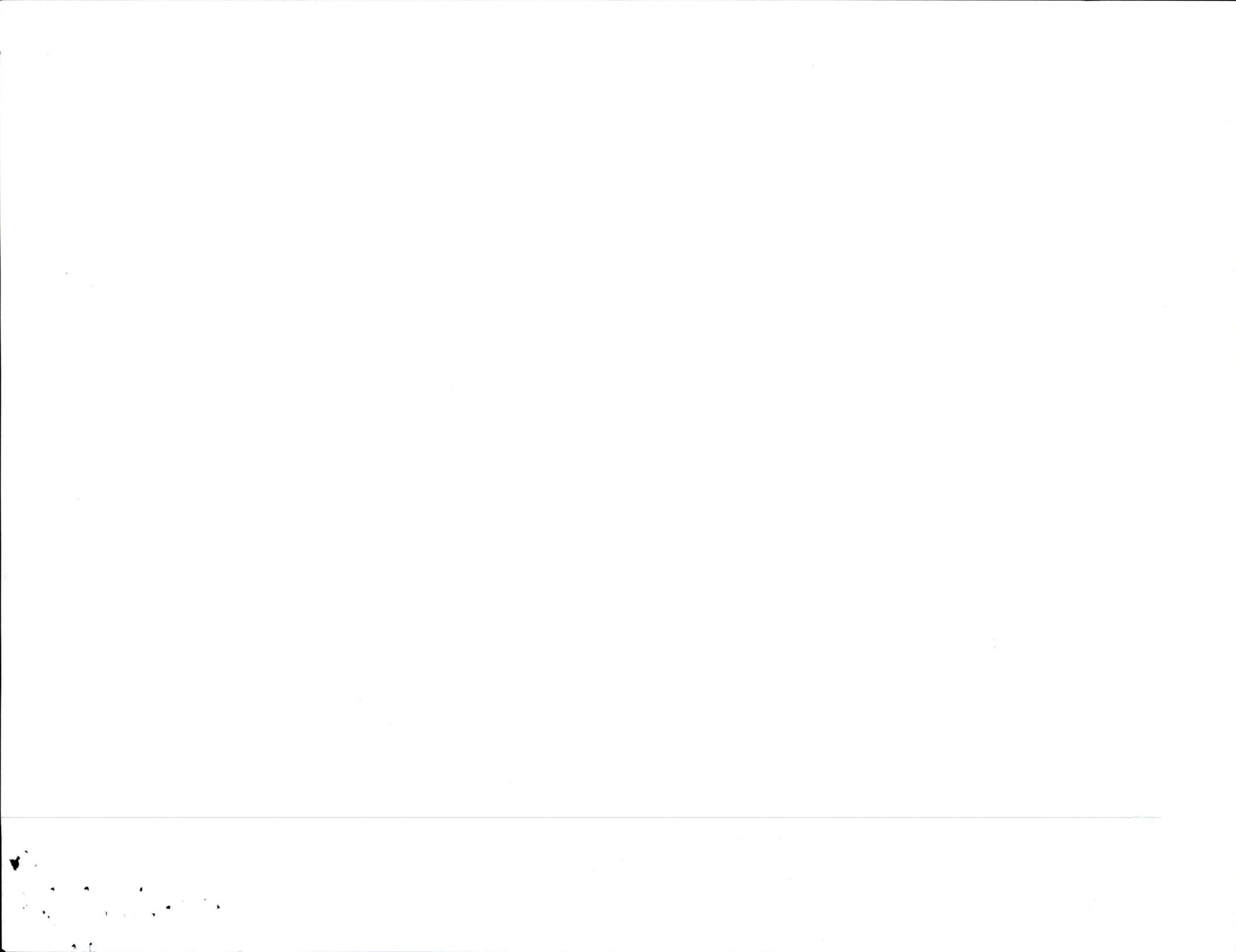
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Beta → 2024 5228 11/16/23
ExAs → 19F 2024 5228 11/16/23
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Extends to 2023 5228 11/16/23
Ends to 2023 5228 11/16/23

DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 2484 SEP 23

1512
24 AUG 23
23 OCT 2023 - 3228 11/16/23

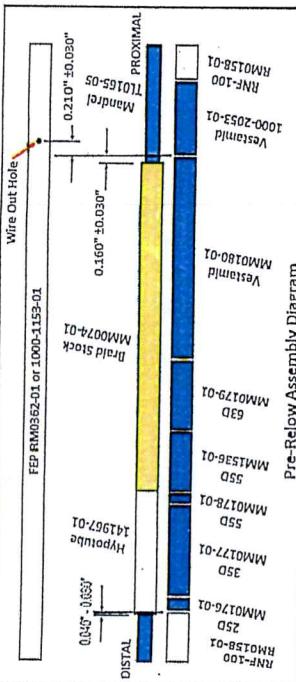
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Requestor Name: Udhesh Kapadnis

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	Revision
SA0155-01	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: Yes 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:**

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

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DA 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 **MM1536-01** **type correction TS12** 10AUG23

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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)

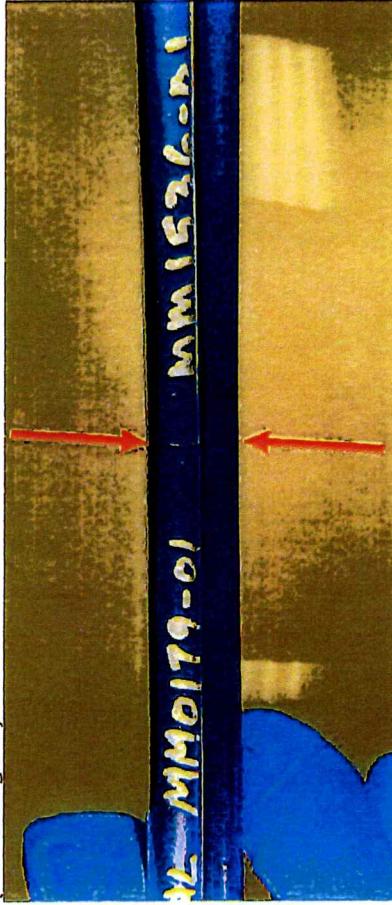


Image- 3

- 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)

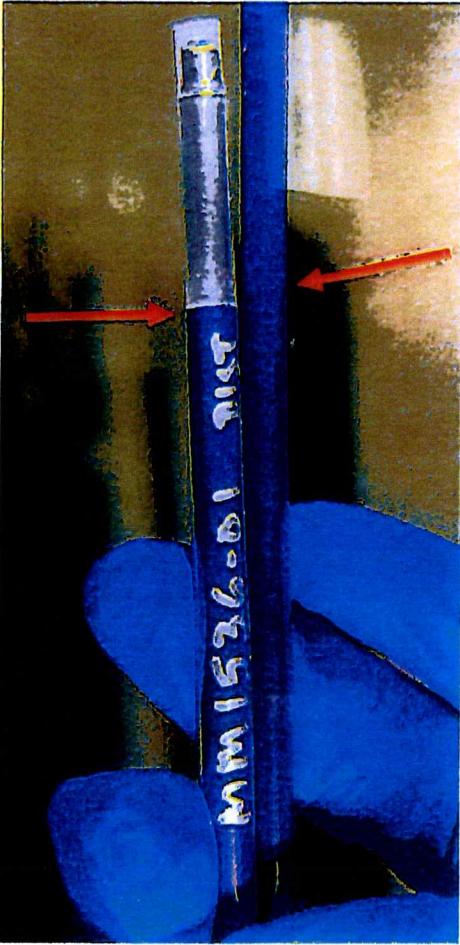


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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

Edits to Item 3228 12/11/2023
Edits to Item 3228 13 Feb 2024 V9.0.4

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:			
<p>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.</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. 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 FMEAs <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# 500000 304683

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	9:48am	430	0521	09Feb24	10:00am	415	0521	09Feb24	16
TM10942	44	10:10am	430	0521	09Feb24	10:22am	415	0521	09Feb24	16
TM10942	44	10:30am	430	CB58	09Feb24	10:42am	415	CB58	09Feb24	16
TM10942	44	11:10am	430	CB58	09Feb24	11:22am	415	CB58	09Feb24	16
TM10942	44	11:30am	430	CB58	09Feb24	11:42am	415	CB58	09Feb24	16
TM10942	44	12:00pm	430	CB58	09Feb24	12:12pm	415	CB58	09Feb24	16
TM10942	44	12:20pm	430	CB58	09Feb24	12:32pm	415	CB58	09Feb24	16
TM10942	44	12:25pm	430	CB58	09Feb24	12:37pm	415	CB58	09Feb24	16
TM10942	44	2:54pm	430	XK40	09Feb24	3:06pm	415	XK40	09Feb24	16
TM10942	44	3:30pm	430	CB58	09Feb24	3:42pm	415	CB58	09Feb24	16
TM10942	44	4:44PM	430	PL22	09 Feb 24	4:56PM	415	PL22	09 Feb 24	16
TM10942	44	5:21PM	430	PL22	09 Feb 24	5:33PM	415	PL22	09 Feb 24	16

① CB58 09Feb24



PRODUCTION ORDER#: 500000 304683

OP 400

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

① SD 34
10 feb 24



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

PRODUCTION ORDER# 500000304683

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	9:30am	430	OS 21	09 Feb 24	9:42am	415	OS 21	09 Feb 24	16
TM10745	44	10:00am	430	OS 21	09 Feb 24	10:12am	415	OS 21	09 Feb 24	16
TM10745	44	10:25am	430	OS 21	09 Feb 24	10:37am	415	OS 21	09 Feb 24	16
TM10745	44	11:00am	430	CB58	09 Feb 24	11:12am	415	CB58	09 Feb 24	16
TM10745	44	11:20am	430	CB58	09 Feb 24	11:32am	415	CB58	09 Feb 24	16
TM10745	44	11:45am	430	CB58	09 Feb 24	11:57am	415	CB58	09 Feb 24	16
TM10745	44	12:10pm	428	OS 21	09 Feb 24	12:22pm	415	OS 21	09 Feb 24	16
TM10745	44	2:10pm	430	CB58	09 Feb 24	2:22pm	415	CB58	09 Feb 24	16
TM10745	44	2:35pm	430	CB58	09 Feb 24	2:47pm	415	CB58	09 Feb 24	16
TM10745	44	3:10pm	430	CB58	09 Feb 24	3:22pm	415	CB58	09 Feb 24	16
TM10745	44	4:33pm	430	PL22	09 Feb 24	4:45PM	415	PL22	09 Feb 24	16
TM10745	44	5:08PM	430	PL22	09 Feb 24	5:20PM	415	PL22	09 Feb 24	16

①CB58 09Feb24



Document No: 5105589
FM15104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000 304683

OP 400



PO #: 50000 500000304683

OP #: 500 Shift #: 3

Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

Total Parts Reworked:		105	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		16
EW	Exposed Wire		75
MP	Micropores	N/A	N/A
SCR	Scratch		5
SKV	Skive Marks	/ /	7
VD	Voids	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		L546, ARO2 SVR/S	09 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):

(1)CB5810Feb24



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

PO #: 500006304683 OP #: 500 Shift #: 3rd

Total Parts Reworked:		60	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube		17
EW	Exposed Wire		43
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		2
VD	Voids		2
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB81 AR27 LS46	10 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):



PO #: 500000304683

OP #: 750 Shift #: 3

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		52	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		16
DIM07 US / WC	DIM07 Undersized (Window Closed)	NA	NA
EH	Exposed Hypotube		12
GD/AB	glue damage / Air Bubbles		24
Inspected By (Sign and Date):		BI60 ^① 10 feb 2024 + 10 Feb 24	OCB58 10 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):

OCB58 10 Feb 24



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

PO #: 1500 000 304 683 OP #: 750 Shift #: 3

Total Parts Reworked:		52	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		22
DIM07 US / WC	DIM07 Undersized (Window Closed)		12
EH	Exposed Hypotube		15
GD	Glue Damage		3
Inspected By (Sign and Date):		IC83 10 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):

PRODUCTION ORDER# 500000304683

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	3:15PM	190F	BD64	09Feb24	4:25PM	190F	BD64	09Feb24	43
TM10409	N/A	4:40PM	190F	BD64	09Feb24	5:50PM	190F	BD64	09Feb24	① +30
TM10409	N/A	6:10AM	190F	AL42	10Feb24	7:20AM	190F	AL42	10Feb24	45
TM12036	N/A	6:45AM	190F	AL42	10Feb24	7:55AM	190F	AL42	10Feb24	35
TM12036	N/A	8:25AM	190F	AL42	10Feb24	9:35AM	190F	AL42	10Feb24	71
TM10409	N/A	9:13AM	190F	PL22	10Feb24	10:23AM	190F	PL22	10Feb24	48
TM12036	N/A	9:40AM	190F	AL42	10Feb24	10:50AM	190F	AL42	10Feb24	43
TM10409	N/A	10:25AM	190F	AL42	10Feb24	11:35AM	190F	AL42	10Feb24	30
TM12036	N/A	10:53AM	190F	AL42	10Feb24	12:03PM	190F	AL42	10Feb24	34
TM10409	N/A	12:00PM	190F	AL42	10Feb24	1:10PM	190F	AL42	10Feb24	73
				N/A						
								AL42	10Feb24	

① BD64 09 Feb 24



PO #: 500000304683

OP #: 900 Shift #: 3

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):

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Page 1 of 1

Status CURRENT Effective 5/8/2023

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be selected and tensile tested)																
Sample # →	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	23.64	26.26	27.51	28.15	26.93	28.24	26.71	27.02	29.37	26.79	27.062	1.5154523	4.378	20.42735	8.542	PASS
Seg B	62.81	63.9	63.24	64.57	61.94	66.54	64.39	59.89	67.11	64.09	63.848	2.0954225	3.981	55.5061229	8.542	PASS
Seg C	77.46	81.16	75.86	72.31	79.41	78.49	82.94	79.42	78.92	76.76	78.273	2.9348445	2.911	69.7296677	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 #: 500000304683

Date: 10 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

10Feb24