

# Production Order: 500000297258



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
		Component Number	Req'd Rev Rev	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3 Kitting Devices 	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Am 68 7:30am 21 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 69 6:30pm 21 Jan 24</u> Record Dryer Shelf #: <u>N/A</u>						N/A	N/A	21Jan24	PKW
	Kitting Devices	Component Number	Req'd Rev Rev	UOM	Qty.	Batch No.	Actual Qty Used	N/A	N/A	23Jan24	ESG
		1000-2053-01	A A	PC	500	<u>0000278870</u>	<u>500</u>				
						<u>N/A</u>	<u>N/A</u>				
		MM1537-02	A A	PC	500	<u>0000288401</u>	<u>500</u>				

### Notes:

N/A

N/A

N/A

Date Printed: 21.01.2024 / 08:00:56

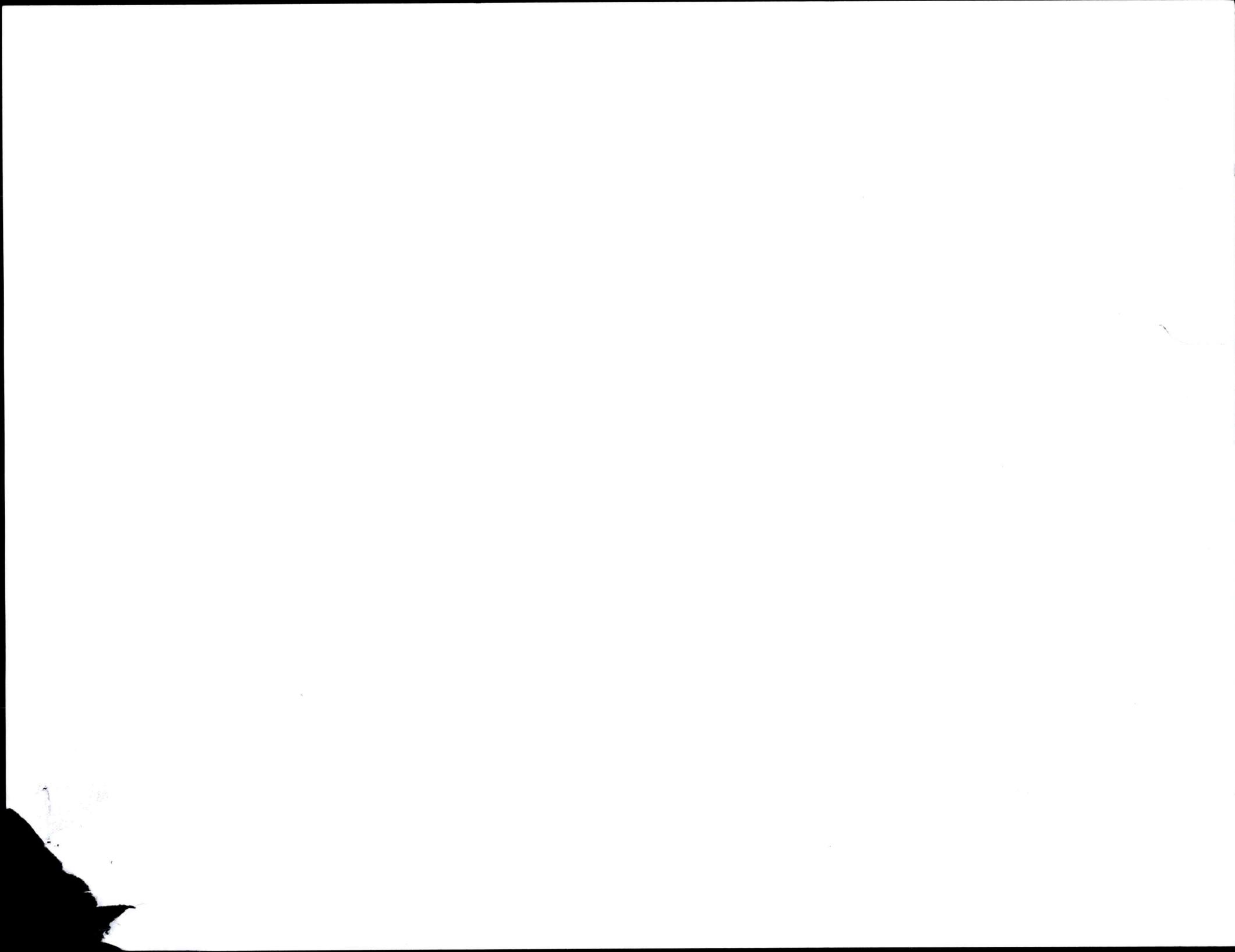
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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	RM0158-01	E	<u>E</u>	PC	200	<u>58497</u>	<u>N/A</u>	<u>224</u>		
						<u>N/A</u>	<u>N/A</u>			
	TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>			
						<u>N/A</u>	<u>Bulk</u>			
	TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>			
						<u>N/A</u>	<u>Bulk</u>			
	TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
						<u>N/A</u>	<u>Bulk</u>			
N/A	141967-01	02	<u>02</u>	PC	500	<u>85501</u>	<u>503</u>			
						<u>N/A</u>	<u>N/A</u>			
	RM7349-02	C	<u>C</u>	PC	543	<u>82568</u>	<u>518</u>			
						<u>N/A</u>	<u>N/A</u>			
	RM7348-01	C	<u>C</u>	PC	500	<u>78690</u>	<u>550</u>			
						<u>N/A</u>	<u>N/A</u>			

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	RM4001-01	B	<u>B</u>	PC	125	82455	266				
		D	<u>D</u>	PC	56	74662	① N/A 100 N/A				
		C	<u>C</u>	PC	500	0000287641 000275990 0000275491	266 73 135				
		E	<u>E</u>	PC	594	78862 80240	600 83	N/A	N/A	N/A	N/A
		I	<u>I</u>	PC	1	82971 N/A	Bulk Bulk				
		I	<u>I</u>	PC	1	82971 N/A	Bulk Bulk				
		A	<u>A</u>	PC	500	0000278970 N/A	500 N/A				
		A	<u>A</u>	PC	1000	0000284209	1080				

Notes:

N/A

N/A

N/A

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① GS05 23 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	MM1536-01	B	<u>B</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000281412</u>	<u>500</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000282490</u>	<u>400</u>		
		MM0179-01	D	<u>D</u>	PC	500	<u>0000282489</u>	<u>100</u>		
							<u>0000276172</u>	<u>500</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000276174</u>	<u>500</u>		
N/A	N/A	MM0177-01	C	<u>C</u>	PC	500	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
							<u>0600284208</u>	<u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
N/A	N/A	MM0074-01	G	<u>6</u>	PC	500	<u>0000281411</u>	<u>500</u>		
							<u>0000292834</u>	<u>519</u>		
							<u>0000292834</u>	<u>500</u>		
							<u>0000285406</u>	<u>103</u>		

Notes:

N/A

N/A

N/A

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① GS85 23 Jan 24

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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	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	22Jan24	V078
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	22Jan24	YK40 AM47
<b>Notes:</b>						
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	22Jan24	SCID
	Loading Braid Stock					
	Confirmation Reqd(Milestone )					
250	CATASY01 Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	22Jan24	CD19 RLH AIGS
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	Trim Braid Wire at Proximal End					
	Confirmation Reqd(Milestone )	NIA	NIA	NIA	NIA	NIA
300	CATASY01  Catheter Assembly 1  	Insert Cut Hypo Tube	500	0	22Jan 24	AL42 AL67
	Insert Cut Hypo Tube					
	Confirmation Reqd(Milestone )					
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	22Jan 24	CX63
Notes:						
NIA						
NIA						
NIA						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	NIA Load Tubing Confirmation Reqd(Milestone )	NIA	NIA	NIA	NIA	NIA
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone )	Reflow	500	0	22Jan24	SN67 PL22
450	CATASY01 Catheter	FEP Removal	500	0	22Jan24	JY90
Notes:		NIA NIA NIA				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 					
	FEP Removal					
N/A	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 #: 87656 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	456	EW-IHT IHT IHT IHT IHT IHT I OF-IHT IHT III (44)	22 Jan 24	LLG61 VC09 CB81 VC91 R66 mm02 TD45
N/A	In-process Inspection and Rework					
N/A	Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
<b>Notes:</b>						
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
550	CATASY01 Catheter Assembly 1  Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone )	Remove Heat Shrink & Mandrel	456	0	22 Jan 24	FB01 DV39 RS23 ML38 PP40
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	444	DL - HTI MAH - HTI 11 (12)	23 Jan 24	FB01 VA96 PX82 SV46

## **Notes:**

11A

N/A

NIA

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① P446 23 Jan 24 Late entr

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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	444	0	22Jan24 P146 TRN D429	AX82
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					

Notes:

N/A

N/A

N/A

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23 Jan 24

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(2) 23 Jan 23

(2) RS 23 23 Jan 24

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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 #: 82455 Qty: 8 Part # RM0607-01 Batch #: 74662 Qty: 4 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	444	0	22 Jan 24	Hv36 STX48 ML60
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	424	ADC -                HH (20)	22 Jan 24	SSW4 SS52 KT47 SG88
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
	Major Mandrel Removal  N/A 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>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	423	X5 U/S -1	22Jan24	SS52 YQ36
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	0 N/A	SQR - HT (SP) EW - HT II #10S - I MAR - II DIS - III	0 N/A	HT72 ML65 PP40 DX35
Notes:						
N/A						
N/A						
N/A						

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(1)V078 22 Jan 24

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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:</p> <p>TMI: <u>0700-01</u> Cal Due: <u>31 May 24</u>  TMI: <u>NIA</u> Cal Due: <u>NIA</u>  TMI: <u>NIA</u> Cal Due: <u>NIA</u></p> <p>Material Consumed:</p> <p>Part #: <u>RMD101-01</u> Batch #: <u>82455</u> Qty: <u>7</u>  Part #: <u>RMD07-01</u> Batch #: <u>74662</u> Qty: <u>5</u>  Part #: <u>RMD158-01</u> Batch #: <u>58497</u> Qty: <u>2</u>  Part #: <u>NIA</u> Batch #: <u>NIA</u> Qty: <u>NIA</u>  Part #: <u>NIA</u> Batch #: <u>NIA</u> Qty: <u>NIA</u></p>	394	#505-III #705-II #805-II Del-1 #105-1 EH-1 FM-1	22 Jan 24 29	DY29 PY46 KL67
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>NIA</u> Cal Due: <u>NIA</u></p> <p>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
NIA	 <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	TMI: <u>NIA</u> Cal Due: <u>NIA</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>	348	DIS - MM MM MM MM MM MM I  DEL - II WK - II STR - MM MM I (46)	22Jan24	0521 KL67 NY35
1000	 <b>Quality Inspection &amp; Review</b>   <b>Quality Inspection &amp; Review</b>   <b>Confirmation Reqd(Milestone)</b>	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>1889</u> Cal Due: <u>30SEP24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30SEP24</u>	312	LT - MM MM MM MM MM MM MM I  (36)	22Jun24	RS23 KL67

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	N/A	N/A	N/A	N/A	N/A	N/A
1050	<b>QUALITY1</b> 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	278	SCR-11 (TT) FM-111 (GT) Del - K11 (TT) Del - II SCR-111 FM-1 EW - XN1 CRK - III PBC - II STN - 1 KNK - 1 VD - 1 DNT - 1 SKV - 1 BP - 1 FB - 1  (3M)	23 Jan 24	SV43
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>GSO5</u> <u>23 Jun 24</u>	N/A	N/A	23 Jun 24	GSO5
<b>Notes:</b> 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
1150	PACKINT1  Packing assembly    Package Confirmation Reqd(Milestone )	Package Package, Label, and Ship Finished Parts	278	0	23.Jun.24 BPA1	BPA1

Notes:

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**Batch Number:** 0000297258

**By:** BA71

**Date:** 23 Jan 24

**Reviewed By:**

RB29

**Date:**

23 JAN 24

**Notes:**

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

PRODUCTION ORDER# 500000297258

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	5:30am	436	AX05	22Jan24	5:42am	415	AX05	22Jan24	16
Tm10745	44	5:55 am	430	RN27	22Jan24	6:07 am	415	RN27	22Jan24	16
Tm10745	44	6:15 am	429	RN27	22Jan24	6:27 am	415	RN27	22Jan24	16
Tm10745	44	6:35 am	429	RN27	22Jan24	6:47 am	415	RN27	22Jan24	16
Tm10745	44	7:40AM	430	KL95	22Jan24	7:52AM	415	KL95	22Jan24	16
Tm10745	44	8:00 AM	430	OS21	22Jan24	8:12AM	415	OS21	22Jan24	16
Tm10745	44	8:15AM	430	KL95	22Jan24	8:27AM	415	KL95	22Jan24	16
Tm10745	44	8:50AM	428	NK62	22Jan24	9:02AM	415	NK62	22Jan24	16
Tm10745	44	9:17AM	430	KL95	22Jan24	9:29AM	415	KL95	22Jan24	16
Tm10745	44	9:45 AM	428	NK62	22Jan24	9:57AM	415	NK62	22Jan24	16
Tm10745	44	10:05AM	426	AX05	22Jan24	10:17AM	415	AX05	22Jan24	16
Tm10745	44	11:13AM	430	KL95	22Jan24	11:25AM	415	KL95	22Jan24	16



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Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	5:38pm	430	SN67	21 Jan 24	5:56pm	415	SN67	21 Jan 24	16
Tm10942	44	6:15pm	430	SN67	21 Jan 24	6:27pm	415	SN67	21 Jan 24	16
Tm10942	44	6:00 am	430	RN27	22 Jan 24	6:12 am	415	RN27	22 Jan 24	16
Tm10942	44	6:28 am	430	RN27	22 Jan 24	6:40 am	415	RN27	22 Jan 24	16
Tm10942	44	6:45 am	429	RN27	22 Jan 24	6:57 am	415	RN27	22 Jan 24	16
Tm10942	44	7:48am	430	0521	22 Jan 24	8:00am	415	0521	22 Jan 24	16
Tm10942	44	8:16am	430	KL95	22 Jan 24	8:28am	415	KL95	22 Jan 24	16
Tm10942	44	8:40am	430	AX05	22 Jan 24	8:52am	415	AX05	22 Jan 24	16
Tm10942	44	9:04am	427	KL95	22 Jan 24	9:16am	415	KL95	22 Jan 24	16
Tm10942	44	9:34am	430	KL95	22 Jan 24	9:46am	415	KL95	22 Jan 24	16
Tm10942	44	11:05am	430	KL95	22 Jan 24	11:17am	415	KL95	22 Jan 24	16
Tm10942	44	11:35am	430	0521	22 Jan 24	11:47am	415	0521	22 Jan 24	16



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**Title:** SA0155-01 Reflow Log Sheet Form

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00521 23 Jan 24



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

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Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000297258

OP #: 900 Shift #: 2nd

Total Parts Reworked:		52	
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	///	4
MP	Micropores	N/A	N/A
SCR	Scratch		46
SKV	Skive Marks	/	1
VD	Voids	N/A	N/A
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		14
DIM06 OS	DIM06 OD Oversized	//	2
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		PP40 22 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):

PO #: 500000297258OP #: 900 Shift #: 2

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		62	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	1	1
EW	Exposed Wire	11	2
MP	Micropores	N/A	0
SCR	Scratch		59
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
Inspected By (Sign and Date):		DX3522 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):



**PO #:** 500000297258

OP #: 900 Shift #: 2

Document No: 6102619

Rev: B

**Document Type: Manufacturing Form**

## **Title: SA0155-01 Dimensional/Visual Rework Form**

Total Parts Reworked:		56	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		15
EW	Exposed Wire		10
MP	Micropores	N/A	N/A
SCR	Scratch		61
SKV	Skive Marks		2
VD	Voids	/	1
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		3
DIM06 OS	DIM06 OD Oversized	/	1
DIM09 US	DIM09 OD Undersized	N/A	N/A

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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Status CURRENT Effective 5/8/2023



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 50000297258OP #: 750 Shift #: 2nd.

Total Parts Reworked:		40	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		30
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	22 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):



PO #: 500000297258

OP #: 750 Shift #: 2<sup>nd</sup>.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		34	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		12
DIM07 US / WC	DIM07 Undersized (Window Closed)		11
EH	Exposed Hypotube		11
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		ML60 J.	22 Jan 24

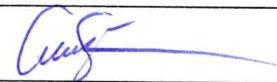
Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):  ① ML60 22 Jan 24



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

PO #: 50000297258 OP #: 500 Shift #: 2<sup>nd</sup>

Total Parts Reworked:		8	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	//	2
EW	Exposed Wire	/ /	4
MP	Micropores	N/A	N/A
SCR	Scratch		1
SKV	Skive Marks		1
VD	Voids	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):			22 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 #: 500000297258 OP #: 500 Shift #: 2<sup>nd</sup>

Total Parts Reworked:		7	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire		2
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks		1
VD	Voids		2
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	22Jan24

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 #: 500000297258

OP #: 900 Shift #: 1st

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		28	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	11	2
EW	Exposed Wire	HT HT 11	13
MP	Micropores	N/A	N/A
SCR	Scratch	HT HT HT HT 1	21
SKV	Skive Marks	N/A	N/A
VD	Voids	N/A	N/A
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	N/A	N/A
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		0429 P1 26 22 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):



PO #: 500000297258

OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		122	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		33
DIM07 US / WC	DIM07 Undersized (Window Closed)		15
EH	Exposed Hypotube		26
N/A	Glue, Stopper		48
Inspected By (Sign and Date):		Hv36 22 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: 5106073  
Rev: E  
Document Type: Manufacturing Form  
Title: SA0155-01 Visual Rework Form**

PO #: 500000297258 OP #: 500 Shift #: 1st

**Note:** Indicate tally marks 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):**

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Status CURRENT Effective 5/8/2023

**PRODUCTION ORDER#** 500000297258

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM102109	N/A	11:00am	190°F	KT47	22 Jan 24	12:10 pm	190°F	KT47	22 Jan 24	47
TM12036	N/A	11:20am	190°F	KT47	22 Jan 24	12:30pm	190°F	KT47	22 Jan 24	36
TM10409	N/A	12:10pm	190°F	SS52	22 Jan 24	1:20pm	190°F	SS52	22 Jan 24	54
TM12036	N/A	12:30pm	190°F	KL95	22 Jan 24	1:40pm	190°F	KT47	22 Jan 24	32
TM10409	N/A	2:20PM	19°F	KT47	22 Jan 24	3:30pm	190°F	KT47	22 Jan 24	50
TM10409	N/A	4:18pm	190F	SG88	22 Jan 24	5:28pm	190F	SG88	22 Jan 24	52
TM10409	N/A	5:34pm	190F	SG88	22 Jan 24	6:44pm	190F	SG88	22 Jan 24	38
TM10409	N/A	6:47pm	190F	SG88	22 Jan 24	7:57pm	190F	SG88	22 Jan 24	40
TM12036	N/A	7:38pm	190F	SG88	22 Jan 24	8:48pm	190F	SG88	22 Jan 24	46
TM10409	N/A	9:00pm	190F	SG88	22 Jan 24	10:10pm	190F	SG88	22 Jan 24	29
				N/A						
				SAD7	22 Jan 24					

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	26.42	28.27	27.79	26.57	26.88	28.83	27.49	25.97	27.17	28.93	27.432	1.0170852	4.378	22.9792012	8.542	PASS
Seg B	64.14	63.15	67.57	62.93	55.23	60.65	58.06	62.51	66.23	64.34	62.481	3.6860984	3.981	47.8066424	8.542	PASS
Seg C	80.8	81.67	78.59	77.54	76.7	78.78	79.23	75.6	80.73	78.5	78.814	1.9007846	2.911	73.2808159	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 #: 500000297258

Date: 23 JAN 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24

23 JAN 24

