

# Production Order: 5000C0307846



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 	<p>Kitting Devices                      Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP                      Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>6S85 8:15AM 13 Feb 24</u>                      Record Time Extrusions First Exit Dryer (Initial/Time/Date):  <u>KP02 4:30am 15Feb24</u>                      Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table> <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>D</u></td> <td>PC</td> <td>500</td> <td><u>0000294700</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000290560</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>	N/A	N/A	12FEB24 BV57
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>D</u>	PC	500	<u>0000294700</u>	<u>500</u>																		
MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>																		

Notes: DA 2484 12564

N/A

N/A

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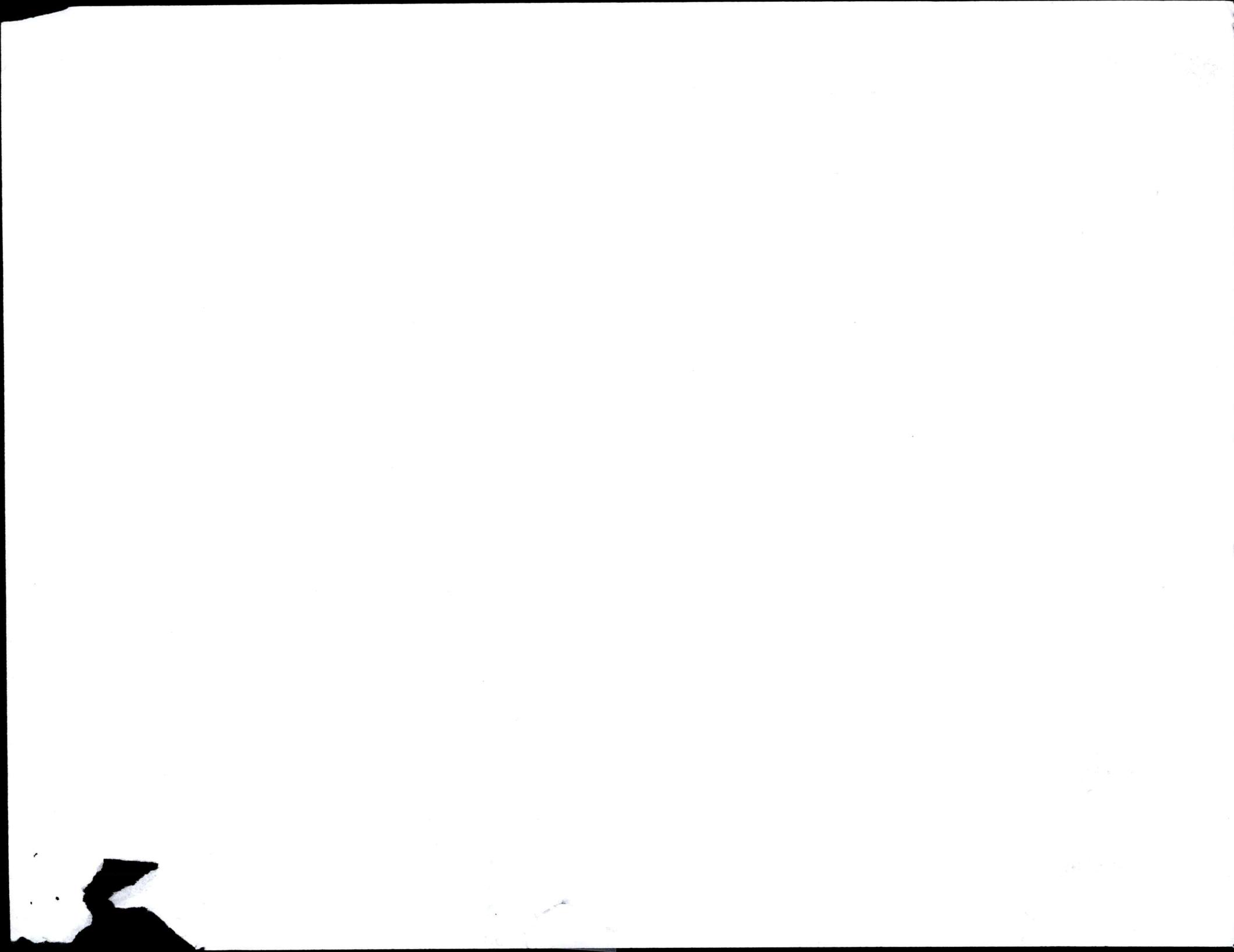
Page: 1 of 18



SA0155-01

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## Production Order: 500000307846



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

Material: SA0155-01 Rev F

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>N/A</u> <u>81054</u>	<u>N/A</u> <u>100</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>88223</u> <u>88226</u> <u>88294</u>	<u>N/A</u> <u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>N/A</u> <u>0000287543</u>	<u>N/A</u> <u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>N/A</u> <u>0000290571</u>	<u>N/A</u> <u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>		
		TL0165-05	J	<u>J</u>	PC	5	<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>Bulk</u>		

## Notes:

N/AN/AN/A

Date Printed: 02/12/2024 / 21:29:53

Page: 2 of 18



SA0155-01

CREGANNA  
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## Production Order: 500000307846

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

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	141967-01	02	02	PC	500	89482 88394 87451 8082857 82861 82862 88523 82869	450 22 33 100 200 140 100 600			
		RM7349-02	C	C	PC	543	① 89587 N/A 89582	N/A	N/A		
		RM7348-01	C	C	PC	500			N/A		
		RM4001-01	B	B	PC	125	② 78846 N/A 78845 74 ③ 78846	N/A 69 N/A	N/A	N/A	
		RM0607-01	D	D	PC	56	④ 0000281649	487			
		RM0498-01	C	C	PC	500			N/A		
		RM0009-04	I	I	PC	1	88992 ⑤ 88992 N/A	Bulk Bulk			
		RM0009-04	I	I	PC	1	88992	Bulk			

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

② AM 68 16 Feb 24

Page: 3 of 18

12 FEB 24 BU57  
①

SA0155-01

CREGANNA  
MEDICAL  
is part of

# Production Order: 500000307846



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## 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	<u>A</u>	PC	500	<u>N/A</u>	Bulk			
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000294701</u>	<u>500</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000294697</u>	<u>500</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000295774</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>0000290565</u>	<u>500</u>	<u>N/A</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000303768</u>	<u>520</u>	<u>N/A</u>		

Notes:

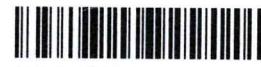
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Date Printed: 02/12/2024 / 21:29:53

Page: 4 of 18



SA0155-01

CREGANNA  
MEDICAL  
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**Production Order: 500000307846**Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**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	500	0	15 Feb 24	AT39
	Line Clearance					
	Confirmation Reqd(Milestone )					
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly	500	0	15 Feb 24	QS31 SH23 NK02 PM96 CL30 SH23 QS31 Y014
	Major and Minor Mandrel Assembly					
<b>Notes:</b>						
N/A						
N/A						
N/A						

Date Printed: 02/12/2024 / 21:29:53

Page: 5 of 18



SA0155-01

CREGANNA MEDICAL  
is part of

**Production Order: 500000307846**



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
200	CATASY01  Catheter Assembly 1  	Loading Braid Stock    Loading Braid Stock  Confirmation Reqd(Milestone )	500	0	15 Feb 24 ST96 AL34 CL05	
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	15 Feb 24 CL30 VP62 DU39 CL05	

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 6 of 18



SA0155-01

CREGANNA MEDICAL  
is part of



**Production Order: 500000307846**



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

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  Confirmation Reqd(Milestone )	Insert Cut Hypo Tube	500	0	15 Feb 24 ep82 LMUB DV39 CY97 tm AL34 ap32 GS22	
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	15 Feb 24 ny35 CY97 ny35 GS22	

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 7 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000307846**



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

**Material: SA0155-01 Rev F**

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	<b>CATASY01</b> Catheter Assembly 1  Reflow Confirmation Reqd(Milestone )	Reflow	500	0	15 Feb 24	NFGZ AX05 PM196 SY47 SH85
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	15 Feb 24	PM 96 JY90

Notes:

N/A
N/A
N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 8 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000307846

Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1  					
N/A	FEP Removal					
	Confirmation Reqd(Milestone )					
		N/A	N/A	N/A	N/A	N/A
500	CATASY01  Catheter Assembly 1  	In-process Inspection and Rework Material Consumed: Part #: 100-115301 Batch #: 88233 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	490	OF - 11 EW - HII SKU - III 10	15 Feb 24 CB 81 TA 36 SV 46 VL 91 P 66 TD 45	LL 61 VC 09
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone )					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

Date Printed: 02/12/2024 / 21:29:53

Page: 9 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

**Production Order: 500000307846**



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

**Material: SA0155-01 Rev E**

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	490	0	15Feb24	VA96 AX82 CLG1 RS23 FBO1 ML38
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	476	IDB - 1 DL - 11 MATT - 44T HHA 14	15Feb24	VA96 PH59 AX82 FBO1 SV46

**Notes:**

NIA

NIA

NIA

Date Printed: 02/12/2024 / 21:29:53



SA0155-01

**CREGANNA**  
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# Production Order: 500000307846



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

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	476	0	15 Feb 24 MV78	VA96 KX82 FB01
700	CATASY01 Catheter Assembly 1  Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 2083 C Cal Due: 31 May 24 TMI: 0936 A Cal Due: 31 May 24 Tipping	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 2083 C Cal Due: 31 May 24 TMI: 0936 A Cal Due: 31 May 24	476	0	15 Feb 24	Hv36

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 11 of 18



SA0155-01

mv78 15Feb24  
CREGANNA MEDICAL  
is part of



# Production Order: 500000307846



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

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 Material Consumed:</p> <p>Part #: RM4001-01 Batch #: 89582 Qty: N/A      Part #: RM0158-01 Batch #: 81054 Qty: N/A      Part #: RM0607-01 Batch #: 78846 Qty: N/A      Part #: N/A Batch #: N/A Qty: N/A      Part #: N/A Batch #: N/A Qty: N/A</p>	475	EH-1  (1)	15Feb24 MM02 DX35	STR48
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	463	ACD-4411 #12	15Feb24 SSW4 SG88	PM96

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 12 of 18



SA0155-01

CREGANNA  
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Material: SA0155-01 Rev F

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				
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>  Cut to Length  Confirmation Reqd(Milestone )	N/A  463	N/A  0	N/A  KT47  15Feb24	N/A  ML65
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	MV33 ML65 DX35 PP40
Notes:						
N/A N/A N/A						

Date Printed: 02/12/2024 / 21:29:53

Page: 13 of 18



SA0155-01

(1) MV33 15 Feb 24

CREGANNA  
MEDICAL  
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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	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: 0700-01 Cal Due: 31 May 24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: 100-1153-0 Batch #: 3854 Q(3) Qty: N/A Part #: RM4001-0 Batch #: 4780 Q(2) Qty: 15 Part #: RM0607-0 Batch #: 7884 Q(0) Qty: 10 Part #: RM0158-0 Batch #: 4105 Q(0) Qty: 10 Part #: N/A Batch #: N/A Qty: N/A</p>	405	#60S-111 #60S-1111 #10S-1H1111 #70S-1 #90S-1111 DL-1 TD-1 EH-1 #50S-11 BW-1H1 ACD-1H1 FM-1 DIS-1H111 MAR-1H111 111	15Feb24	Y936 HT72 TL66
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: N/A Cal Due: N/A Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53 ① 81054 MV78 15Feb24

② 89587 MV78 15Feb24 Page: 14 of 18

③ 78846 MV78 15Feb24



SA0155-01

CREGANNA  
MEDICAL  
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Material: SA0155-01 Rev F

Opr. No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  <i>N/A</i> Confirmation Reqd(Milestone )	TMI: <u>av/A</u> Cal Due: <u>av/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 25</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	<i>378</i>	<i>DIS(SP)###</i> <i>DIS-###</i> <i>STR-###</i> <i>####</i>	<i>15 Feb 24</i>	<i>Y936</i>
1000	 QUALITY1 Quality Inspection & Review   Quality Inspection & Review  Confirmation Reqd(Milestone )	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31 May 24</u> Record Length Gage Information: TMI: <u>08891</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u>	<i>365</i>	<i>LT-###</i> <i>WO-11</i> <i>OAL-11</i>	<i>15 Feb 24</i>	<i>Y936</i>

Notes:

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

Date Printed: 02/12/2024 / 21:29:53





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
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	334	SCR-1111(1) SCR-11 VD-111 YBC-11 EW-11 TL-1 MAR-1 RDG-1 DISC-1 CRK-1 SKV-1 FM-1  (29)	16 Feb 24	SV43
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>AM68 16 Feb 24</u>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

Date Printed: 02/12/2024 / 21:29:53

Page: 16 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

Production Order: 500000307846



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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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	336	0	16/02/24	16/02/24

Notes:

AA  
AA  
N

Date Printed: 02/12/2024 / 21:29:53

Page: 17 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000307846**



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Batch Number: 0000307846

By: BA71

Date: 16 Feb 24

Reviewed By:

RB29

Date:

16 FEB 24

Notes:

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Date Printed: 02/12/2024 / 21:29:53

Page: 18 of 18



SA0155-01

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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

**CONTROLLED COPY**

(1) UK55, 23JW 2023

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**=TE**

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 **MM1536-01** **Type Correction TS12** 10AUG23

**CONTROLLED COPY**

**Group Training Record**

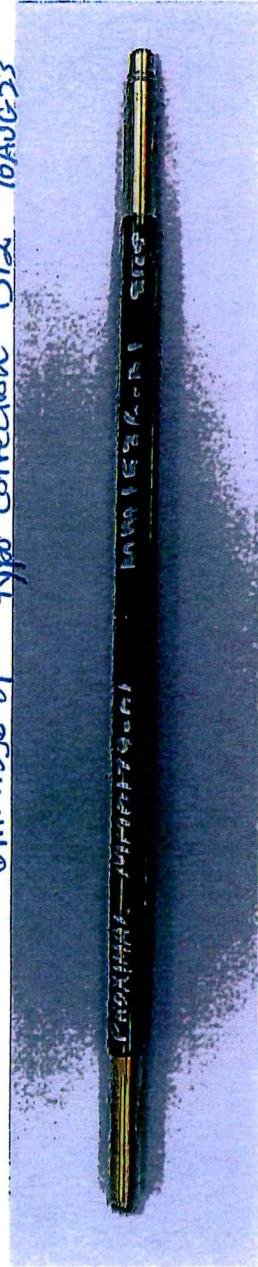


Image- 1

**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)

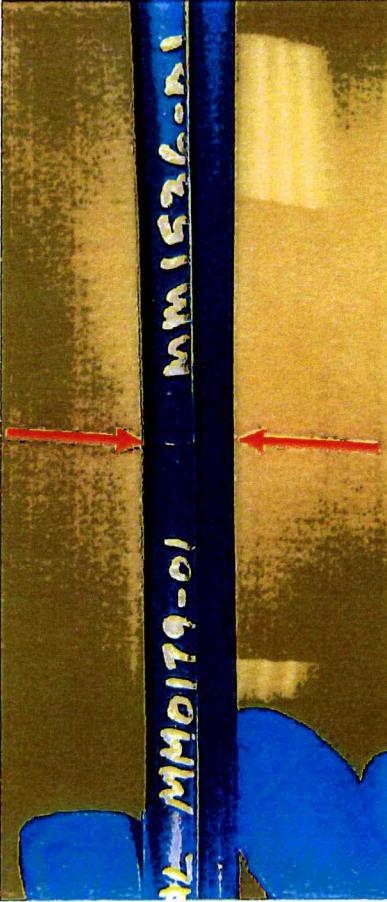


Image- 3

- 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)

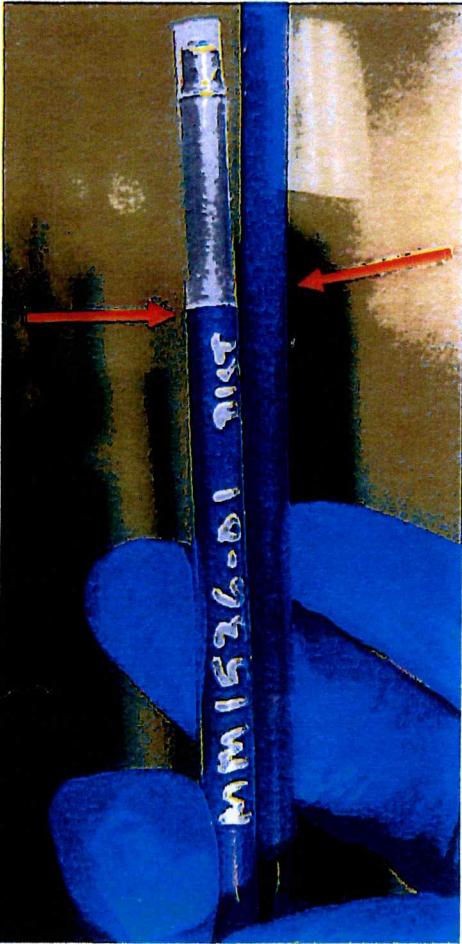


Image - 4  
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

<b>1</b>	MM0179-01 <b>GOOD PART</b>	MM1536-01
<b>2</b>	MM1536-01	MM0179-01 <b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>
<b>3</b>	MM0179-01	MM0179-01 <b>Two MM0179-01 - BAD PART</b>
<b>4</b>	MM1536-01	MM1536-01 <b>Two MM1536-01 - BAD PART</b>

Image - 5



## DEVIATION AUTHORIZATION FORM

<b>Requestor Name:</b> Krishna Selvaraj			
<b>Document Number Affected</b>	<b>Revision</b>		
Doc #3005206 (MPI0238)	BP		
<b>Deviation From:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.1.1:</b> 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.			
<b>Justification:</b> 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.			

<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b> 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			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
<b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> N/A			
<b>Title</b>	<b>Approval Name</b>	<b>Approval Signature</b>	<b>Date</b>
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# 500000307846

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	4:09pm	430	SH85	15Feb24	4:20PM	415	Y014	15Feb24	16
Tm10942	44	4:54pm	430	SH85	15Feb24	5:06PM	415	SH85	15Feb24	16
Tm10942	44	6:17pm	430	Sy47	15Feb24	6:29pm	415	Sy47	15Feb24	16
Tm10942	44	6:45pm	428	SH85	15Feb24	6:57pm	415	SH85	15Feb24	4
				N/A						
				SIA07						
					15 Feb 24					



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

PRODUCTION ORDER# 500000307846

OP 400



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

PRODUCTION ORDER# 500 000 307846

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	5:45am	430	TA36	15 Feb 24	5:57am	415	TA36	15 Feb 24	16
TM10745	44	6:15am	430	AX05	15 Feb 24	6:27am	415	AX05	15 Feb 24	16
TM10745	44	7:24AM	430	NK62	15 Feb 24	7:36AM	415	NK62	15 Feb 24	16
TM10745	44	7:48am	430	OS21	15 Feb 24	8:00am	415	OS21	15 Feb 24	16
TM10745	44	8:10am	427	AX05	15 Feb 24	8:22am	415	AX05	15 Feb 24	16
TM10745	44	9:05am	430	OS21	15 Feb 24	9:17am	415	OS21	15 Feb 24	16
TM10745	44	9:45am	430	OS21	15 Feb 24	9:57am	415	OS21	15 Feb 24	16
TM10745	44	11:05am	430	TA36	15 Feb 24	11:17am	415	TA36	15 Feb 24	16
TM10745	44	12:00pm	430	OS21	15 Feb 24	12:12pm	415	OS21	15 Feb 24	16
TM10745	44	12:45PM	430	AX05	15 Feb 24	12:57PM	415	AX05	15 Feb 24	16
TM10745	44	2:00pm	430	KL95	15 Feb 24	2:12pm	415	KL95	15 Feb 24	16
TM10745	44	2:37PM	430	AX05	15 Feb 24	2:49PM	415	AX05	15 Feb 24	16



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

PRODUCTION ORDER# 500000307846

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	5:25am	430	AX05	15 Feb 24	5:37am	415	AX05	15 Feb 24	16
TM10942	44	6:05am	430	TA36	15 Feb 24	6:17am	415	TA36	15 Feb 24	16
TM10942	44	7:25AM	430	NK62	15 Feb 24	7:37AM	415	NK62	15 Feb 24	16
TM10942	44	8:05am	430	KC95	15 Feb 24	8:37am	415	OS21	15 Feb 24	16
TM10942	44	8:45am	430	OS21	15 Feb 24	8:57am	415	OS21	15 Feb 24	16
TM10942	44	9:20am	430	OS21	15 Feb 24	9:32am	415	OS21	15 Feb 24	16
TM10942	44	10:00am	430	OS21	15 Feb 24	10:12am	415	OS21	15 Feb 24	16
TM10942	V4	11:20am	430	AX05	15 Feb 24	11:32am	415	AX05	15 Feb 24	16
TM10942	44	11:45am	430	AX05	15 Feb 24	11:57am	415	AX05	15 Feb 24	16
TM10942	44	12:55PM	430	AX05	15 Feb 24	12:27PM	415	AX05	15 Feb 24	16
TM10942	44	1:35PM	430	AX05	15 Feb 24	1:47PM	415	AX05	15 Feb 24	16
TM10942	44	2:15PM	430	AX05	15 Feb 24	2:27PM	415	AX05	15 Feb 24	16



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

PO #: 500000307846

**OP #: 500 Shift #: 1**

**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 CBS8 16 Feb 24



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

PO #: 500000307846

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

Total Parts Reworked:		<u>20</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>0</u>
EH	Exposed Hypotube	<u>//</u>	<u>2</u>
EW	Exposed Wire	<u>     </u>	<u>18</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>    </u>	<u>4</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Candy</u>	<u>15 Feb 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 #: 500000307846

OP #: 500 Shift #: 2nd

Total Parts Reworked:		32	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		17
MP	Micropores	n/a	n/a
SCR	Scratch		5
SKV	Skive Marks		3
VD	Voids		8
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Varunee Lor 15 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):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000307846 OP #: 750 Shift #: 1st

Total Parts Reworked:		40	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		9
DIM07 US / WC	DIM07 Undersized (Window Closed)		8
EH	Exposed Hypotube		6
N/A	Glue , stopper		17
Inspected By (Sign and Date):		PH59	15 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):



PO #: 50000307846 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:		60	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		40
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	15 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# 500000 307846

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	10:30 am	190°F	K155	15 Feb 24	11:40 am	190°F	K155	15 Feb 24	38
TM12036	N/A	11:35 am	190°F	SS44	15 Feb 24	12:45 pm	190°F	SS44	15 Feb 24	43
TM10409	N/A	12:10 pm	190°F	SS44	15 Feb 24	1:20 pm	190°F	SS44	15 Feb 24	41
TM10409	N/A	1:30 pm	190°F	K155	15 Feb 24	2:40 pm	190°F	K155	15 Feb 24	39
TM10409	N/A	2:40 pm	190°F	SS44	15 Feb 24	3:50 pm	190°F	SS44	15 Feb 24	60
TM10409	N/A	4:56 pm	190°F	SG88	15 Feb 24	6:06 pm	190°F	SG88	15 Feb 24	45
TM12036	N/A	5:40 pm	190°F	AT39	15 Feb 24	6:50 pm	190°F	SG88	15 Feb 24	30
TM10409	N/A	6:50 pm	190°F	SG88	15 Feb 24	8:00 pm	190°F	SG88	15 Feb 24	39
TM12036	N/A	7:15 pm	190°F	SG88	15 Feb 24	8:20 pm	190°F	SG88	15 Feb 24	50
TM10409	N/A	8:05 pm	190°F	SG88	15 Feb 24	9:15 pm	190°F	SG88	15 Feb 24	44
TM10409	N/A	9:19 pm	190°F	SG88	15 Feb 24	10:29 pm	190°F	SG88	15 Feb 24	34
			N/A							
			SG88	15 Feb 24						



**PO #:** 500000307846

OP #: 900 Shift #: 2nd

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

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

**Data Uploaded for Engineering Review (Check):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023

PO #: 50000307846OP #: 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	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		5
MP	Micropores	N/A	0
SCR	Scratch		58
SKV	Skive Marks	N/A	0
VD	Voids	/	1
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):		Candy	15 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):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000307846 OP #: 900 Shift #: 2

Total Parts Reworked:		74	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		3
EW	Exposed Wire		14
MP	Micropores	N/A	N/A
SCR	Scratch		87
SKV	Skive Marks	N/A	N/A
VD	Voids		7
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	HT72 15 Feb 24	
Inspected By (Sign and Date):		HT72 15 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):



500000307846

PO #: 500000307846 ①

OP #: 900 Shift #: 2

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		20	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		2
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		DX35 15 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): 

① CB58 16 Feb 24

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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	29.58	29.46	26.46	30.27	28.68	29	34.04	30.18	23.52	30.61	29.18	2.7448416	4.378	17.1630834	8.542	PASS
Seg B	75.3	72.53	64.61	71.99	79.88	75.07	76.04	79.11	65.57	71.96	73.206	5.0659894	3.981	53.0382961	8.542	PASS
Seg C	86.92	79.35	89.22	83.06	74.97	93.92	89.66	87.25	91.18	68.1	84.363	8.0544743	2.911	60.9164252	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 #: 500000307846

Date: 16FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



16 FEB 2024