

Production Order: 500000300506



Production Order Document
Production Order Qty: 500

Material: SA0155-01 Rev F

PC
Sheet: 1 of 1

Material Type: ZFRT Description: Edwards Flex Shaft Commander 155885
 Production Version: 7988
 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>KP2 20pm 30Jan24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP2 11:00am 31Jan24</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>0000293119</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>0000276172</u></td> <td><u>40</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000281412</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>0000293119</u>	<u>500</u>					<u>0000276172</u>	<u>40</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>	N/A	N/A	30JAN24	KL27
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>																									
				<u>0000276172</u>	<u>40</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>																									

Notes: PA 2564, 2484.

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	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>0000271063</u> <u>58497</u>	<u>40</u> <u>200</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>① 79170 N/A</u> <u>N/A-N/A ①</u> <u>79170</u>	<u>N/A</u> <u>Bulk</u> <u>Bulk</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>N/A</u> <u>79170</u>	<u>Bulk</u> <u>Bulk</u>			
		MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u> <u>0000258434</u>	<u>500</u> <u>40</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u> <u>0000290561</u>	<u>560</u> <u>560</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u> <u>N/A</u>	<u>500</u> <u>N/A</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u> <u>0000271023</u>	<u>560</u> <u>60</u>			

Notes:

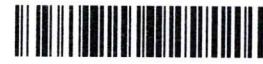
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Op. No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty. & Desc.	Date Comp.	Initials
N/A	N/A	TL0167-02	E	<u>E</u>	PC	70	N/A N/A	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		141967-01	02	<u>02</u>	PC	500	N/A 85502	Bulk 520			
		RM7349-02	C	<u>C</u>	PC	543	N/A 82729 82835 82837.82865 83860 828630	N/A 100, 14 100,142 200	N/A	N/A	N/A
		RM7348-01	C	<u>C</u>	PC	500	85428	500			
		RM4001-01	B	<u>B</u>	PC	125	N/A 82435 82823	N/A 75 100			
		RM0607-01	D	<u>D</u>	PC	56	74662	67			

Notes:

N/A

N/A

N/A

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N/A	N/A	RM0498-01	C	<u>C</u>	PC	500	<u>0000287643</u>	<u>489</u>	<u>N/A</u>		
		RM0362-01	E	<u>E</u>	PC	594	<u>78856</u>	<u>600</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>560</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000252923</u>	<u>40</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>0000282490</u>	<u>400</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>560</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000297033</u>	<u>515</u>	<u>N/A</u>		
							<u>0000292833</u>	<u>15</u>			

Notes:

N/A
N/A
N/A

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N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting Line Clearance Confirmation Rreqd(Milestone)	500	0	31Jan 24 KL95 DX35	
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	0	31Jan 24 AX05 NK62 PM 96 SY47 X01A	
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	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	31Jan24 Sx11 7935	VP62
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	31Jan24 ST96 V078	MY50

Notes:

N/A

N/A

N/A

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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	31Jan24 LM46 AS31 GS22	VV25
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	31Jan24 LM46 CP32 GS22 VO78	C497

Notes:

N/A
N/A
N/A

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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)	Reflow	500	0	31Jan24	AL34 NK62 CL30 V078
450	CATASY01 Catheter	FEP Removal	500	0	31Jan24	TM96 JY90
Notes:						
N/A						
N/A						
N/A						

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	Assembly 1 					
N/A	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 #: 100-1153-01 Batch #: 88747 Qty: 15 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 Part #: N/A Batch #: N/A Qty: N/A	① 496 ② 497 ③ 482	EW - HTT FD - HTT DL - II SK - I DF - HTT 1 FM - HTT 2 18	31 Jan 24	U60 TA36 NL91 RL66 HT72 TD45
N/A	In-process Inspection and Rework					
N/A	Confirmation Reqd(Milestone)					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes: N/A N/A N/A N/A						

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 ① 31 Jan 24 SA07
 ② 31 Jan 24 mmo2

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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)	482	0	31-Jan-24	VA96 FB01 AX82 Y936 PP40 (TRN) uv18
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	470	DL-III MAS-III (12)	31-Jan-24	DV39 FB01 AX82 AT39 mnoz

Notes:

NIA
NIA
NIA

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N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink Loading Heat Shrink Confirmation Reqd(Milestone)	470	0	31Jan24	FB01 Ax82 MV78 ML38
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	470	0	31Jan24	ML38

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	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	Tip Inspection/ Flash Removal Material Consumed: Part #: RM4001-01 Batch #: 82435 Qty: N/A Part #: RM0401-01 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	470	O	21Jan24	SV46 ML60
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		468	ACD-11 (2)	21Jan24	SG88 SS44

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
	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1  Cut to Length Confirmation Reqd(Milestone)	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>	468	0	01Feb24	ML65 KL67 Y936 SS52
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	SHay ML46 HT72 MV33

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	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: MA Cal Due: MA TMI: MA Cal Due: MA TMI: MA Cal Due: MA TMI: N/A Cal Due: N/A TMI: MA Cal Due: N/A TMI: MA Cal Due: N/A Material Consumed: Part #: Pm1001-01 Batch #: 82435 Qty: 16 Part #: 1000-1153-01 Batch #: 88747① Qty: 12 Part #: MA Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A ① 88747</p>	436	WK-1 DEL-11 MAR-1111 DIS-111111 #94S-1 #60S-111 H5US-11 EW-111 ③②	01Feb24 01Feb24	X91 KL67 ML65
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: 50713B Cal Due: 12 APR 24 Record Caliper Information:</p>	MA	MA	MA	N/A

Notes:

MA

N/A

N/A

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① PY4601Feb24



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Opn No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: 50317 Cal Due: 31AUG24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30SEP25 TMI: 0692 Cal Due: 30SEP25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	424	DIS(SP)HII DIS-III STR-II WK-I DEL-I (12)	01Feb24	XL91 KL67 ML65
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: 1056 Cal Due: 31MAY24 Record Length Gage Information: TMI: 0889 D Cal Due: 30SEP24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30SEP24 ① 30 SEP24	415	OAL-II LT-HII (9)	01Feb24	XL91 KL67 SS44

Notes:

N/A

N/A

N/A

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① KL67 31Jan24

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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	① 308 303	SKV-WH11 DIS-III Del-III(ET) SCR-11(ET) FL-1 PBC-1 (ET) WH ⑦ ②	01 Feb 24	XN26 SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>KP02 01 FEB 24</u>	N/A	N/A	01 Feb 24	KP02
Notes:						
N/A N/A N/A						

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① SV43 01 Feb 24



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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	393	0 02 Feb 24	AP10	

Notes:

N/A AP10 02 Feb 24

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Batch Number: 0000300506

By: AP10

Date: 02 Feb 24

Reviewed By:

RB29

Date:

02 feb 24

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VA AP10 02 Feb 24

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11/16/23
11/17/23
11/18/23



CREGANNA
MEDICAL

is part of **TECHNIQUE**

Extend to 2020-2023
End to 20 Dec 2023 DEVIATION A
11/27/2023

DEVIATION AUTHORIZATION NUMBER: 2484
 See attached email extension to 34STEP

ESTIMATED **TO** **23 Oct 2023** **21FEB2028**

Requestor Name: Udhesh Kapadnis

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.

Micro Structure

FEP RM0362-D1 or 1000-1153

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.

See instructions attached to this DA

Document Number Affected

Review

REVISION

3107610

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 OC inspection to avoid incorrect

Part Number Affected	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

Risk Assessment

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

figures to any of the above subjects.

Somatische Auffälligkeiten

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

卷之三

Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 JUL 2023
Mgr. Manufacturing Engineering	Jake Stanislowski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 JUL 2023

FM0002.RevF Deviation Authorization

CONTROLLED COPY

① UK55, 23JW 2023



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 MM0179-01 type connection TS12 10AUG23

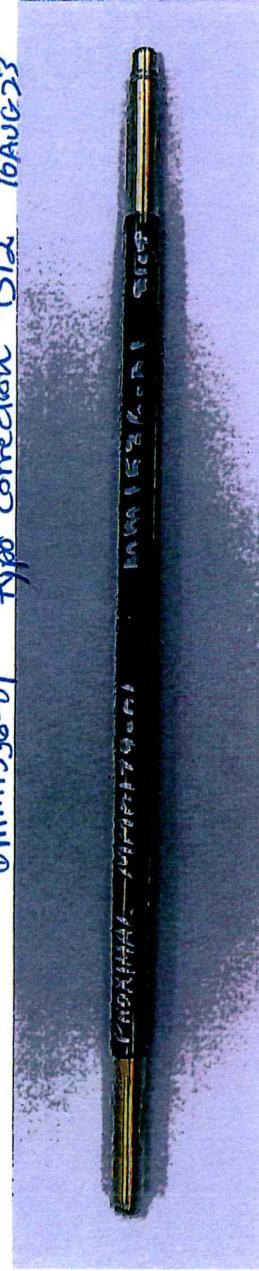


Image- 1

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)

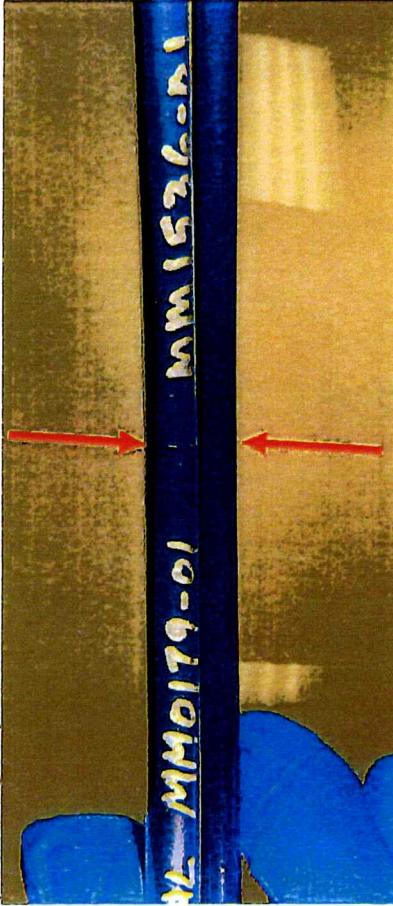


Image- 3

- 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)

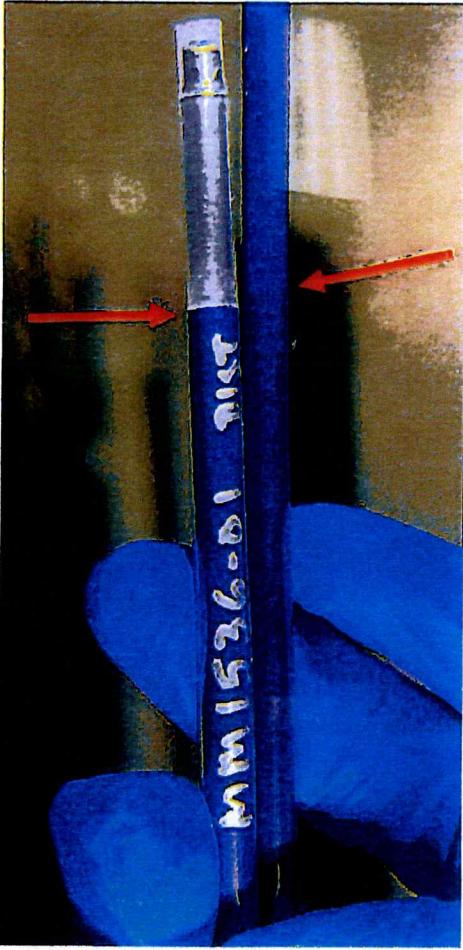


Image- 4

- 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

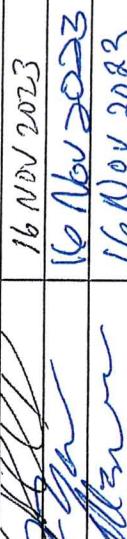
Image - 5

Beta 2 to HENNAH 3228 1/1/2023
Beta 2 to 13 FEB 2024 3228 1/4/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

CREGANNA
MEDICAL
is part of


DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision	Revision	Revision
Doc #3005206 (MPI0238)	BP	H	
Deviation From:	Deviation To:		
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.	Doc #3005206 (Flex Commander MPI0238): OPER850.11: 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.		
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	Revision	Revision
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
16 Nov 23	15 DEC 23	N/A	
Risk Assessment: Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A			
If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
Corrective Action Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
If no, explain: This is a temporary change to use 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



PRODUCTION ORDER#: 500000300506

OP 400

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



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000300506

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	11:45 AM	430	NK62	31Jan24	11:57	415	NK62	31Jan24	16
TM10745	44	12:23 PM	430	NK62	31Jan24	12:35 PM	415	NK62	31Jan24	16
TM10745	44	1:28 PM	430	AX05	31Jan24	1:40 PM	415	AX05	31Jan24	16
TM10745	44	2:05 PM	430	AX05	31Jan24	2:17 PM	415	AX05	31Jan24	16
TM10745	44	2:50 PM	430	AX05	31Jan24	3:02 PM	415	AX05	31Jan24	16
TM10745	44	3:10 PM	430	NK62	31Jan24	3:22 PM	415	NK62	31Jan24	0 ¹⁶ / ₁₆
TM10745	44	4:16 PM	430	CL30	31Jan24	4:28 PM	415	CL30	31Jan24	16
TM10745	44	5:10 PM	430	V078	31Jan24	5:22 PM	415	CL30	31Jan24	16
TM10745	44	6:48 PM	430	SY47	31Jan24	7:00 PM	415	SY47	31Jan24	16
TM10745	44	7:15 PM	429	SY47	31Jan24	7:27 PM	415	SY47	31Jan24	16
TM10745	44	7:42 PM	429	V078	31Jan24	7:54 PM	415	V078	31Jan24	16
TM10745	44	9:13 PM	430	V078	31Jan24	9:25 PM	415	V078	31Jan24	16

④ NK62 31Jan24



PRODUCTION ORDER#: 500000300506

OP 400

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

① Sy47 31 Jan 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000300506

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:00pm	430	NK62	31Jan24	12:12PM	415	NK62	31Jan24	16
TM10942	44	1:53 PM	430	AX05	31Jan24	2:05PM	415	AX05	31Jan24	16
TM10942	44	2:15PM	429	AX05	31Jan24	2:27PM	415	AX05	31Jan24	16
TM10942	44	2:33PM	430	AX05	31Jan24	2:45PM	415	AX05	31Jan24	16
TM10942	44	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
TM10942	44	2:55PM	429	AX05	31Jan24	3:07PM	415	AX05	31Jan24	16
TM10942	44	4:38pm	430	CL30	31Jan24	4:50PM	415	CL30	31Jan24	16
TM10942	44	5:23pm	430	V078	31Jan24	5:35PM	415	SA07	31Jan24	16
TM10942	44	5:53PM	430	V078	31Jan24	6:05PM	415	V078	31Jan24	16
TM10942	44	6:28PM	430	Sy47	31Jan24	6:40PM	415	Sy47	31Jan24	16
TM10942	44	7:02PM	429	Sy47	31Jan24	7:14PM	415	Sy47	31Jan24	16
TM10942	44	7:27PM	426	V078	31Jan24	7:39pm	415	V078	31Jan24	16
TM10942	44	7:58PM	427	V078	31Jan24	8:10 pm	415	Sy47	31Jan24	16

00521 31Jan24



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000300506 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):



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

PO #: 500000300506 OP #: 500 Shift #: 2nd

Total Parts Reworked:		26	
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		18
MP	Micropores	N/A	N/A
SCR	Scratch	///	4
SKV	Skive Marks	N/A	N/A
VD	Voids		6
N/A	N/A	N/A	N/A

Inspected By (Sign and Date): Vannmeeg Lor 31 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 #: 50000300506 OP #: 500 Shift #: 2

Total Parts Reworked:		26	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube	HHH H	10
EW	Exposed Wire	HH HHH HH III	18
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	II	2
VD	Voids	N/A	0
N/A	N/A	N/A	0

Inspected By (Sign and Date):

Amrit 31 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):



PO #: 500000300506 OP #: 750 Shift #: 2nd.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		20
DIM07 US / WC	DIM07 Undersized (Window Closed)		28
EH	Exposed Hypotube		25
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	30 Jan 24
		30 Jan 24	PY4601 Feb 24 correction for

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):

MM02



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000 300506OP #: 750 Shift #: 2N8

Total Parts Reworked:		47	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	N/A	N/A
DIM07 US / WC	DIM07 Undersized (Window Closed)		26
EH	Exposed Hypotube		21
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		ML60 PP40 31 Jan 24	

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

Data Uploaded for Engineering Review (Check):

PRODUCTION ORDER# 5000003005D6

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	5:07pm	190°F	SG88	31 Jan 24	6:17pm	190°F	SG88	31 Jan 24	51
TM10409	N/A	6:41pm	190°F	SG88	31 Jan 24	7:51pm	190°F	SG88	31 Jan 24	46
TM12036	N/A	7:32pm	190°F	SG88	31 Jan 24	8:42pm	190°F	SG88	31 Jan 24	50
TM10409	N/A	7:57pm	190°F	SG88	31 Jan 24	9:07pm	190°F	SG88	31 Jan 24	31
TM10409	N/A	9:26pm	190°F	SG88	31 Jan 24	10:36pm	190°F	SG88	31 Jan 24	46
TM12036	N/A	10:07pm	190°F	SG88	31 Jan 24	11:17pm	190°F	SG88	31 Jan 24	39
TM10409	N/A	10:44pm	190°F	SG88	31 Jan 24	11:54pm	190°F	SG88	31 Jan 24	42
TM10409	N/A	11:50pm	190°F	SG88	31 Jan 24	1:00AM	190°F	SG88	01 Feb 24	40
TM12036	N/A	12:20AM	190°F	SG88	01 Feb 24	1:30AM	190°F	SG88	01 Feb 24	31
TM10409	N/A	1:00AM	190°F	SG88	01 Feb 24	2:10AM	190°F	SG88	01 Feb 24	43
TM10409	N/A	4:25am	190°F	KISS	01 Feb 24	5:35am	190°F	KISS	01 Feb 24	49
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A



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

PO #: 500000300506 OP #: 900 Shift #: 2

Total Parts Reworked:		<u>23</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>N/A</u>
EH	Exposed Hypotube	<u>N/A</u>	<u>N/A</u>
EW	Exposed Wire	<u> </u>	<u>8</u>
MP	Micropores	<u>N/A</u>	<u>N/A</u>
SCR	Scratch	<u> </u>	<u>31</u>
SKV	Skive Marks	<u>N/A</u>	<u>N/A</u>
VD	Voids	<u> </u>	<u>2</u>
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):		<u>HT72 31Jan24</u>	

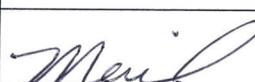
Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000300506 OP #: 900 Shift #: 2nd

Total Parts Reworked:		42	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	NA
EH	Exposed Hypotube	NA	NA
EW	Exposed Wire		5
MP	Micropores		3
SCR	Scratch		35
SKV	Skive Marks		3
VD	Voids		2
DIM01 US	DIM01 OD Undersized	NA	NA
DIM06 US	DIM06 OD Undersized		4
DIM06 OS	DIM06 OD Oversized	NA	NA
DIM09 US	DIM09 OD Undersized	NA	NA
Inspected By (Sign and Date):			31 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: 6102619
Rev: B
Document Type: Manufacturing Form
Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000300506 OP #: 900 Shift #: 2nd

Total Parts Reworked:		37	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		1
EW	Exposed Wire		1
MP	Micropores	N/A	0
SCR	Scratch		5
SKV	Skive Marks	N/A	0
VD	Voids		1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized		3
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 31 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: 6102619
Rev: B
Document Type: Manufacturing Form
Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000300506 OP #: 900 Shift #: 1st

Total Parts Reworked:		50	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	1	1
EW	Exposed Wire		3
MP	Micropores		25
SCR	Scratch		8
SKV	Skive Marks	N/A	N/A
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		K155, KT47 PYYB 01 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):

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	31.35	26.99	31.89	24.25	32.53	35.28	29.93	28.28	33.32	32.62	30.644	3.3082261	4.378	16.1605861	8.542	PASS
Seg B	69.29	74.66	73.4	69.47	70.68	68.55	71.55	75.5	74.94	67.1	71.514	2.9659108	3.981	59.7067092	8.542	PASS
Seg C	73.56	76.57	85.53	77.45	78.19	77.65	83.34	78.68	81.86	77.82	79.065	3.5195999	2.911	68.8194447	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

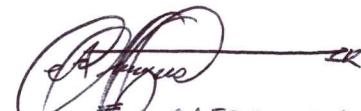
LOT #: 500000300506

Date: 01FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24



01 FEB 2024