

# Production Order: 500000306367



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 Order Type: ZSTD  
Plant / Business Unit: 1213 / AC5 Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
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>X031 10:50pm 21FEB24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>0000290560 9:45AM 22/Feb 24</u> Record Dryer Shelf #: <u>N/A</u>	N/A	N/A	19 FEB 24	BV57

Notes: DA 2564, 2484.

N/A

N/A

N/A

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0GS85 22 Feb 24

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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	E	PC	200	81054	N/A	116		
		1000-1153-01	A	A	PC	594	88539 88568 88564	N/A	200 200 200		
		1000-2053-01	A	A	PC	500	0000287543	N/A	500		
		MM1537-02	A	A	PC	500	0000288401	N/A	N/A	N/A	ref024 VAG
		TL0167-02	E	E	PC	70	0000290571	N/A	620		
		TL0165-05	J	J	PC	5	N/A	N/A	Bulk		
		TL0165-03	J	J	PC	5	N/A	N/A	Bulk		
							N/A	N/A	Bulk		

### 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	141967-01	02	02	PC	500	85502	75			
							85794	1132			
		RM7349-02	C	C	PC	543	82863	100			
							82857	100			
		RM7348-01	C	C	PC	500	82859 / 82866	100/100			
							82862 / 90045	100/49			
		RM4001-01	B	B	PC	125	88492	300			
							88491	150			
		RM0607-01	D	D	PC	56	82807	100			
							N/A	N/A			
		RM0498-01	C	C	PC	500	78315	200			
							0200-N/A	N/A			
		RM0009-04	I	I	PC	1	0000287652	4741			
							N/A	N/A			
		RM0009-04	I	I	PC	1	88993	Bulk			
							N/A	Bulk			
							88993	Bulk			

### Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opt No.	Planned WorkCenter Description	Operation Details							Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	A	PC	500	0000265874 0000290562	<u>N/A</u> <u>N/A</u>	Bulk			
		MM1537-01	A	A	PC	1000	0000294701		1,000			
		MM0177-01	C	C	PC	500	0000294697	<u>N/A</u>	<u>N/A</u>			refeb24
		MM0180-01	E	E	PC	500	0000287541		300			UKW
		MM0178-01	E	E	PC	500	0000294374		200			
		MM0176-01	D	D	PC	500	0000290565		500			
		MM0074-01	G	G	PC	500	0000288413		500			
								<u>N/A</u>	<u>N/A</u>			
								<u>N/A</u>	<u>N/A</u>			
								<u>N/A</u>	<u>N/A</u>			

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 Confirmation Reqd(Milestone )	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	22Feb24	KL95
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	22Feb24	PM96 NK62 SY47 Y014

**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  Loading Braid Stock  Confirmation Reqd(Milestone )	Loading Braid Stock	500	0	22Feb24	VRG2 SX11 ST96 NY35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End	Trim Braid Wire at Proximal End	500	0	22Feb24	MY50 SX11 CL05 AS31 DX35

**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	Trim Braid Wire at Proximal End  Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
300	CATASY01  Catheter Assembly 1  	Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	500	0	22Feb24	VV25 AS 31 GS22
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	22Feb24	C497 AL34 cp32

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Load Tubing Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1  Reflow Confirmation Reqd(Milestone )	Reflow	500	0	22Feb24	PM 96 NKHZ AX05 TA36 V078 SH85
450	CATASY01 Catheter	FEP Removal	500	0	22Feb24	PM 96 JY90
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
	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 #: 886 ① Qty: N/A Part #: N/A Batch #: N/A Qty: N/A		EW-HH 11 VD-1 OF-11 490		EL61 VC09 CB81 RL66 VLQJ ML65 10 22Feb24	
N/A	In-process Inspection and Rework Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
Notes: N/A N/A N/A						

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(2) KL45 23 Feb 24

(2) SA0155-01

(1) KL95 22 Feb 22  
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**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	485	ZH-1 MAH-11 DL-1 Fm-1  5	22Feb24	LL61 FB01 RS23 AX82 SV46 Y936
600	CATASY01 Catheter Assembly 1  Distal Tip Assembly Confirmation	Distal Tip Assembly	469	MAH - 111 DL - 1111  16	22Feb24	FB01 AX82 PP40 ML60

### **Notes:**

NIA  
NIA  
NIA

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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	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 )	469	C	22Feb24	PH59 F B01 AX82 AB9 mm02
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: 2083C Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24  Tipping	469	C	22Feb24	Hv36 AT39
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	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 #: 82807 Qty: N/A Part #: Rm0607-01 Batch #: 78315 Qty: N/A Part #: Rm0158-01 Batch #: 81054 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	469	O	22Feb24	STR48 MV78
800	CATASY01  Catheter Assembly 1    Major Mandrel Removal		434	ACD-# # # # # # # # # 35	22Feb24	SSSL 1/T26

Notes:

N/A

N/A

N/A

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OKL95 22Feb24

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Material: SA0155-01 Rev F

Opr 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  Confirmation Reqd(Milestone )	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>	431	SK4- III  22Feb24  ③	Y936 KL67 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 SH04 HT72 PP40 ①
Notes:  N/A  N/A  N/A						

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① MV33 22 Feb 24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
21A	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: 0700-01 Cal Due: 31 May 24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: RM4001-01 Batch #: 82807 Qty: N/A</p> <p>Part #: RM0607-01 Batch #: 78315 Qty: N/A</p> <p>Part #: 1000-1153-01 Batch #: 88564 Qty: N/A</p> <p>Part #: RM0158-01 Batch #: 81054 Qty: N/A</p> <p>Part #: P/A Batch #: N/A Qty: N/A</p>	398	BW-1111 MAR-111 ACD-11 DC-1 DIS-11111 WL-1 SKV-1 FM-1 #5US-1 #6CS-11 #7GS-1 #6US-11  <i>(33)</i>	22Feb24	XL91 KL67 MV33 TRN PP40 ML65
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: 50713B Cal Due: 12 Apr 24</p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

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	Quality Inspection & Review  Confirmation Reqd(Milestone )	TMI: 0733 Cal Due: 30 Apr 24 Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 Sep 25 TMI: 0692 Cal Due: 30 Sep 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	375	DIS(SP) HHH DIS-HHH HHH HHH WK- 1 STR- II  23	22Feb24	XL91 KL67
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: 31 MAY 24 Record Length Gage Information: TMI: 0889 D Cal Due: 30 SEP 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 SEP 24	354	LT-HHH HHH HHH HHH 1  21	22Feb24	XL91 KL67

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
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	338	0 23 Feb 24	AP10	

Notes:

N/A APW 23 Feb 24

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**Material: SA0155-01 Rev F**

Batch Number: 0000306367

By: APW

Date: 23 Feb 24

Reviewed By:

RBZ9

Date:

23 Feb 24

Notes:

u/a APW 23 Feb 24

Date Printed: 02/19/2024 / 15:50:09

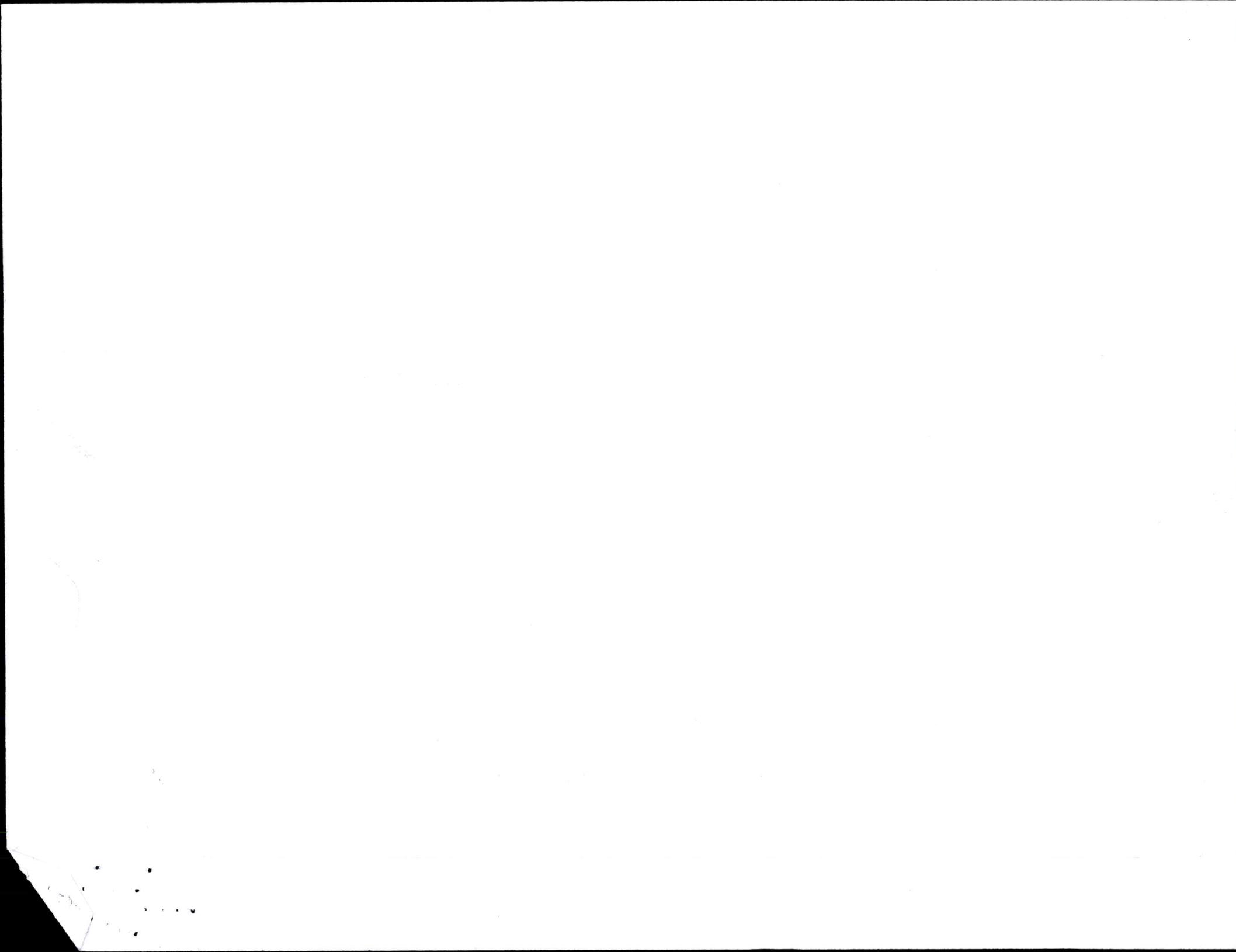
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Batches to 2023 3228 11/15/23  
Excess to 19 Feb 2024 3228 11/15/23  
CREGANNA MEDICAL



is part of  
Extends to 2023 3228 11/15/23  
Batches to 2023 3228 11/15/23

DEVIATION AUTHORIZATION NUMBER: 2484  
\* See attached email extension to 24 SEP 2023

TS2  
24 AUG 2023  
23 OCT 2023  
24 SEP 2023

## CONTROLLED COPY

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.

**Pre-Release Assembly Diagram:**

Pre-Release Assembly Diagram

**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	End Date:	Revision
SA0155-01	25 Aug 2023	H

Start Date:	End Date:	Lot Number:
26 Jul 2023		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 FMEAs  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:	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No
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

**CONTROLLED COPY**

① UK55, 23JW 2023



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 MM1536-01 fixture for inspection. (See image 1)  
① **MM1536-01** **TYPE CONNECTION TS12** **10AUG23**

#### CONTROLLED COPY

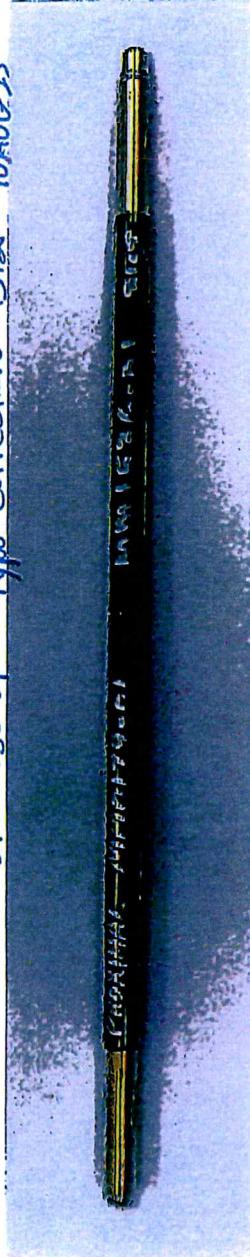


Image- 1

#### 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)

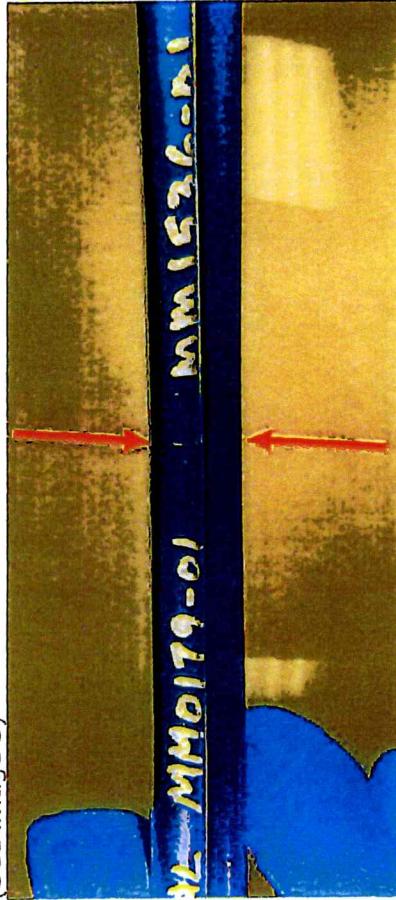


Image- 3

- 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)

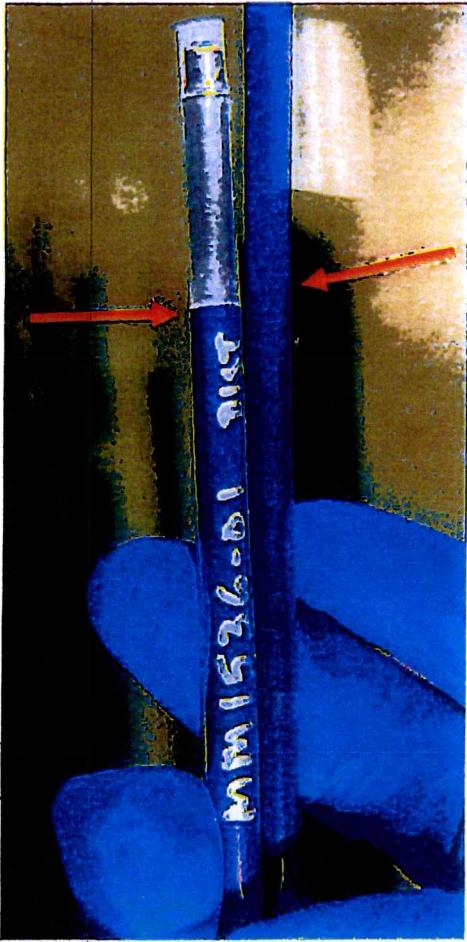


Image- 4

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

Image - 5



Entered to IM004 D228 12/1/2023  
 Entered to IM004 D228 1/9/2024  
 DEVIATION AUTHORIZATION NUMBER: DA2564  
 Entered to IM004 D228 1/10/2024

## 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): OPER850.11:</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>Deviation To:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b> Using a laser micrometer at <b>OPER900 (TMI0700-01)</b> , 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.

<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	N/A
16 Nov 23	15 DEC 23		
<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 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			
<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



PRODUCTION ORDER#: 500000306367

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# 500000306367

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	10:58 AM	430	PM 96	22 Feb 24	11:10 AM	415	PM 96	22 Feb 24	16
Tm10745	44	11:25 AM	430	PM 96	22 Feb 24	11:37 AM	415	PM 96	22 Feb 24	16
Tm10745	44	12:00 PM	429	PM 96	22 Feb 24	12:12 PM	415	PM 96	22 Feb 24	16
Tm10745	44	12:30 PM	430	OS 21	22 Feb 24	12:42 PM	415	OS 21	22 Feb 24	16
Tm10745	44	1:20 PM	430	AX 05	22 Feb 24	1:32 PM	415	AX 05	22 Feb 24	16
Tm10745	44	1:50 PM	430	TA 36	22 Feb 24	2:02 PM	415	TA 36	22 Feb 24	16
Tm10745	44	2:15 PM	430	TA 36	22 Feb 24	2:27 PM	415	TA 36	22 Feb 24	16
Tm10745	44	2:45 PM	430	AX 05	22 Feb 24	2:57 PM	415	AX 05	22 Feb 24	8
Tm10745	44	4:25 PM	430	JY 90	22 Feb 24	4:37 PM	415	JY 90	22 Feb 24	16
Tm10745	44	5:23 PM	430	SH 85	22 Feb 24	5:37 PM	415	SH 85	22 Feb 24	16
Tm10745	44	6:31 PM	430	SH 85	22 Feb 24	6:43 PM	415	SH 85	22 Feb 24	16
Tm10745	44	6:53 PM	428	SH 85	22 Feb 24	7:07 PM	415	SH 85	22 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

**PRODUCTION ORDER#** 500000306367

OP 400



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

PRODUCTION ORDER# 500000306367

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	10:48AM	430	PM96	22 Feb 24	11:00AM	415	PM96	22 Feb 24	16
TM10942	44	11:20am	430	OS21	22 Feb 24	11:32am	415	OS21	22 Feb 24	16
TM10942	44	11:37AM	427	NK62	22 Feb 24	11:49AM	415	NK62	22 Feb 24	16
TM10942	44	12:16PM	430	PM96	22 Feb 24	12:28PM	415	PM96	22 Feb 24	16
TM10942	44	1:30pm	430	TA36	22 Feb 24	1:42pm	415	TA36	22 Feb 24	16
TM10942	44	2:05 PM	430	AX05	22 Feb 24	2:17 PM	415	AX05	22 Feb 24	16
TM10942	44	2:35pm	430	TA36	22 Feb 24	2:47pm	415	TA36	22 Feb 24	16
TM10942	44	4:27pm	430	JY90	22 Feb 24	4:39pm	415	JY90	22 Feb 24	16
TM10942	44	4:46 PM	427	SH85	22 Feb 24	4:58 PM	415	SH85	22 Feb 24	16
TM10942	44	5:14pm	430	V078	22 Feb 24	5:26 pm	415	Sy47	22 Feb 24	16
TM10942	44	6:20PM	430	Sy47	22 Feb 24	6:32pm	415	Sy47	22 Feb 24	16
TM10942	44	8:41PM	427	SH85	22 Feb 24	6:53pm	415	SH85	22 Feb 24	16



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

**PO #:** 500000306367

**OP #:** 500    **Shift #:** 1st

**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 #: 50000306367

OP #: 500 Shift #: 2

Total Parts Reworked:		25	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		1
EW	Exposed Wire		25
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids		7
N/A	N/A	N/A	0

Inspected By (Sign and Date):

*Linda - Hand* 22Feb24

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 #: 500000306367

OP #: 500 Shift #: 2nd

Total Parts Reworked:		41	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	//	2
EH	Exposed Hypotube	//	2
EW	Exposed Wire	/ / / /	26
MP	Micropores	N/A	N/A
SCR	Scratch	///	3
SKV	Skive Marks	N/A	N/A
VD	Voids		10
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Vamsee Lai 22 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: 5106073  
Rev: E  
Document Type: Manufacturing Form  
Title: SA0155-01 Visual Rework Form

PO #: 50000306367 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>030</u> 30	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		8
EW	Exposed Wire		19
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids		7
N/A	N/A	N/A	0
Inspected By (Sign and Date):		<u>Craig</u>	22 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 P66 22 Feb 24



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000306367

OP #: 750 Shift #: 2

Total Parts Reworked:		50	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	HHHH ① HHH HHH HHH	16
DIM07 US / WC	DIM07 Undersized (Window Closed)	HHH HHH HHH HHH	22
EH	Exposed Hypotube	11	12
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mmj8, HT72 22 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): 

KL45 23 Feb 24

PRODUCTION ORDER# 500000306367

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	1:40pm	190°F	KL95	22Feb24	2:50pm	190°F	KL95	22Feb24	17
Tm12036	N/A	2:10 pm	190°F	K155	22Feb24	3:20 pm	190°F	K155	22Feb24	33
Tm10409	N/A	3:41PM	190°F	KT26	22Feb24	4:51PM	190°F	KT26	22Feb24	28
Tm12036	N/A	4:32PM	190°F	KT26	22Feb24	5:42PM	190°F	KT26	22Feb24	31
Tm10409	N/A	5:15pm	190°F	KT26	22Feb24	6:25pm	190°F	KT26	22Feb24	27
Tm10409	N/A	6:26pm	190°F	KT26	22Feb24	7:36pm	190°F	KT26	22Feb24	28
Tm12036	N/A	6:55pm	190°F	KT26	22Feb24	8:05pm	190°F	KT26	22Feb24	48
Tm10409	N/A	7:37pm	190°F	KT26	22Feb24	8:47pm	190°F	KT26	22Feb24	31
Tm12036	N/A	8:06pm	190°F	KT26	22Feb24	9:16pm	190°F	KT26	22Feb24	32
Tm10409	N/A	9:02pm	190°F	KT26	22Feb24	10:12pm	190°F	KT26	22Feb24	33
Tm12036	N/A	9:47pm	190°F	KT26	22Feb24	10:57pm	190°F	KT26	22Feb24	33
Tm10409	N/A	10:31pm	190°F	KT26	22Feb24	11:41pm	190°F	KT26	22Feb24	30
Tm12036	N/A	10:59pm	190°F	KT26	22Feb24	12:09AM	190°F	KT26	23Feb24	22

**PRODUCTION ORDER#** 500000306367

OP 800



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 50000306367OP #: 900 Shift #: 2

Total Parts Reworked:		37	
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		8
MP	Micropores	N/A	0
SCR	Scratch		30
SKV	Skive Marks	N/A	0
VD	Voids		4
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):		① <del>ML65</del> ML65	22 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 ML65 22 Feb 24

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023



PO #: 50000306367 OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		63	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		5
EW	Exposed Wire		6
MP	Micropores	N/A	0
SCR	Scratch		46
SKV	Skive Marks	N/A	0
VD	Voids		2
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		15
DIM06 OS	DIM06 OD Oversized		4
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Joe H 22 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 #: 500000306367

OP #: 900 Shift #: 2

Total Parts Reworked:		28	
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		13
MP	Micropores	N/A	N/A
SCR	Scratch		21
SKV	Skive Marks	N/A	N/A
VD	Voids		5
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):		HT72	22 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 #: 500000306367

OP #: 900 Shift #: 2

Total Parts Reworked:		46	
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		7
MP	Micropores	N/A	N/A
SCR	Scratch		36
SKV	Skive Marks		2
VD	Voids	N/A	N/A
DIM01 US	DIM01 OD Undersized	N/A	7 N/A
DIM06 US	DIM06 OD Undersized		7
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		PP40	22 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	32.65	35.54	33.11	33.6	29.2	30.7	30.33	30.64	33.42	25.91	31.51	2.7410095	4.378	19.5098602	8.542	PASS
Seg B	70.02	77.92	77.24	80.76	76.22	73.68	69.59	71.35	67.41	70.57	73.476	4.3633657	3.981	56.1054413	8.542	PASS
Seg C	79.92	87.82	87.76	90.69	88.87	87.47	89.56	85.71	90.37	87.53	87.57	3.0789031	2.911	78.607313	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 #: 500000306367

Date: 23FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24

Augustine Jah  
23 FEB 2024