

# Production Order: 500000303481



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>KP02 8:00am 31Jan24</u>                      Record Time Extrusions First Exit Dryer (Initial/Time/Date):  <u>XR31 10:20pm 31JAN24</u>                      Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	① START 30JAN24	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>0000281412</u>	<u>N/A</u>

Notes: DA2484, 2564

N/A

N/A

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① Correction  
Correction for BV57

Page: 1 of 18



SA0155-01

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## Production Order: 500000303481



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	N/A 88018	N/A 150		
		1000-1153-01	A	<u>A</u>	PC	594	N/A 88560 88559 88558	N/A 200 200 200		
		1000-2053-01	A	<u>A</u>	PC	500	0000287543	500		
		MM1537-02	A	<u>A</u>	PC	500	0000288401	500		
		TL0167-02	E	<u>E</u>	PC	70	N/A	N/A		
		TL0165-05	J	<u>J</u>	PC	5	N/A	Bulk	N/A	N/A
		TL0165-03	J	<u>J</u>	PC	5	N/A	Bulk	N/A	N/A
							N/A	Bulk		

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 22:53:49

Page: 2 of 18



SA0155-01

CREGANNA  
MEDICAL  
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## Production Order: 500000303481



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	141967-01	02	02	PC	500	88399 85793 85502	150 75 300			
		RM7349-02	C	C	PC	543	82848 82868 82863	85501 200 200 143			
		RM7348-01	C	C	PC	500	85428		500		
		RM4001-01	B	B	PC	125	82823 82969		N/A		
		RM0607-01	D	D	PC	56	78322		100 25	N/A	N/A
		RM0498-01	C	C	PC	500	0000287644 000287647		350 100	N/A	N/A
		RM0009-04	I	I	PC	1	79170		Bulk		
		RM0009-04	I	I	PC	1	79170		Bulk		

## Notes:

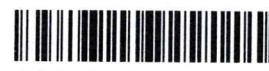
N/A

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Date Printed: 01/30/2024 / 22:53:49

Page: 3 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000303481



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>0000278970</u>	<u>N/A</u>	<u>Bulk</u>	
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>Ex</u>	
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284708</u>	<u>N/A</u>	<u>1000</u>	
		MM0180-01	E	<u>E</u>	PC	500	<u>0000295774</u>	<u>N/A</u>	<u>500</u>	
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>500</u>	
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>N/A</u>	<u>40</u>	
		MM0074-01	G	<u>G</u>	PC	500	<u>0000297030</u>	<u>N/A</u>	<u>500</u>	

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 22:53:49

Page: 4 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000303481



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  Line Clearance  Confirmation Rreqd(Milestone )	500	0	V078 02Feb24 02Feb23①	
150	CATASY01  Catheter Assembly 1  	Major and Minor Mandrel Assembly  Major and Minor Mandrel Assembly	500	0	CL30 V078 JY96 SJSA YK40 S6① 02Feb24	
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 5 of 18



SA0155-01

①CB58 02Feb24

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000303481**



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	02Feb24	cp32 Y014
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	02Feb24	c405 hy35 CD19 ADG5
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 6 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000303481**



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End  Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
300	CATASY01  Catheter Assembly 1  	Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	500	0	02Feb24	AS31 GS22 RL47 N/A PY67
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	02Feb24	SH23 ST96 CX63 BD64
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 7 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of





Material: SA0155-01 Rev F

PC  
Sheet: 1 of 1

Opn 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	02Feb24	SY47 SH85 BNP PL22
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	02Feb24	Y014 AM47

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 22:53:49

Page: 8 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

# Production Order: 500000303481



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	N/A	N/A	N/A	N/A
N/A	FEP Removal					
	Confirmation Reqd(Milestone )					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 88747 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	482	DL-1 EW-1H1H11 OF-1H 18	VL91 P266 1546 TA36 02Feb24	
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone )					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						

Date Printed: 01/30/2024 / 22:53:49

Page: 9 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of





Material: SA0155-01 Rev F

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 )	477	DL-11 MAH-11 IDB-1  	02Feb24	MU78 PP40 MH10
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Confirmation	Distal Tip Assembly	477	0	02Feb24 SR46 D429	ML60

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 22:53:49

Page: 10 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

## Production Order: 500000303481

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	477	0	02Feb24	ML38 PT09
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
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	477	0	02Feb24	ML38 MV78 IL83
	Tipping					
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 11 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

## Production Order: 500000303481

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	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 #: 82823 Qty: N/A Part #: RM0607-01 Batch #: 78322 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	477	0	02Feb24	BIGO T83
800	CATASY01  Catheter Assembly 1    Major Mandrel Removal		477	0	02Feb24	KL45
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 12 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

## Production Order: 500000303481

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	Major Mandrel Removal  Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
850	CATASY01  Catheter Assembly 1  	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. Pass    2. Pass    3. Pass    4. Pass    5. Pass	477	0	03Feb24	KL45 K155
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 22:53:49

Page: 13 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

# Production Order: 500000303481



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	Quality Inspection & Review  Confirmation Reqd(Milestone )	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31 MAY 24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>1000-1153-01</u> Batch #: <u>88747</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82469</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>78322</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>88018</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	455	FM-JH(5P) DEL-JH(JH (TT) DS-1 EU-1 EH-11 MAR-111  <u>22</u>	03Feb24	DLO7 KT47 MC17 KX54 PL22
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

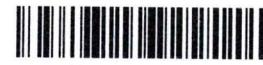
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Date Printed: 01/30/2024 / 22:53:49

Page: 14 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000303481

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	 Quality Inspection & Review	<p>TMI: <u>N/A</u> Cal Due: <u>N/A</u>            Record DIM02 Go/No-Go Gage Information:            TMI: <u>0691</u> Cal Due: <u>30Sep25</u>            TMI: <u>0692</u> Cal Due: <u>30Sep25</u>            Record DIM02 Inspection Results N = 54:            Pass: <u>54</u> Fail: <u>0</u></p>	444	DIS-14TII STR-1111 <u>11</u>	03Feb24	OS21 PL22
1000	 QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone)	<p>Quality Inspection &amp; Review            Leak Test            Record Inspection Data in SAP ROS            Record Leak Tester Information:            TMI: <u>1056</u> Cal Due: <u>31MAY24</u>            Record Length Gage Information:            TMI: <u>0889D</u> Cal Due: <u>30Sep24</u>            Record Calibrated Ruler Information:            TMI: <u>0629</u> Cal Due: <u>30Sep24</u></p>	435	LT-14TII #3US_1 <u>9</u>	03Feb24	CB58 PL22

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 22:53:49

Page: 15 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

# Production Order: 500000303481



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
1050	<b>QUALITY1</b> Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone ) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	404	7-SKV 4-DIS 1-FM 6-SCK 3-DEL 1-KNR 2-GNII 1-BP 1-STN 5-EW (31)	03 Feb 24 DV52	SV43
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>XC31 05FEB24</u>	N/A	N/A	05FEB24	XC31

Notes:

Date Printed: 01/30/2024 / 22:53:49

Page: 16 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000303481**



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
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	UOU	0	06 Feb 24 AP10	AP10

Notes:

N/A AP10 06 Feb 24 /

Date Printed: 01/30/2024 / 22:53:49

Page: 17 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000303481**



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Batch Number: 0000303481

By: AP10

Date: 06 Feb 24

Reviewed By:

RB 29

Date:

06 feb 24

Notes:

1/1 AP10 06 Feb 24

Date Printed: 01/30/2024 / 22:53:49

Page: 18 of 18



SA0155-01

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Basis to 2024 3208 1/1/23  
Ex-As to 19 Feb 2024 3208 1/1/23  
CREGANNA MEDICAL

is part of  
**CREGANNA MEDICAL**



Extend to 2023 3208 1/1/23  
Basis to 2023 3208 1/1/23

DEVIATION AUTHORIZATION NUMBER: 2484  
\* See attached email extension to 24SEP23  
TS12  
24AUG23  
23072023 3208 1/1/23

## CONTROLLED COPY

<b>DEVIATION AUTHORIZATION FORM</b> <del>Extend to 23072023 3208 1/1/23</del>		
Requestor Name: Udhesh Kapadnis		
Document Number Affected	Revision	Revision
3107610	L	

**Deviation From:**  
QP3107610, 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-Rewind Assembly Diagram:**

**Justification:** Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-263390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with out of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid incorrect assembly defects.

Part Number Affected	Revision	Start Date:	End Date:	Lot Number:
SA0155-01	H	26 Jul 2023	25 Aug 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:**  Yes  No **If no, explain:** \_\_\_\_\_

**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 | 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 MM1536-01 fixture for inspection. (See image 1)  
**① MM0179-01 type connection TS12 10AUG23**

**Group Training Record**

**CONTROLLED COPY**

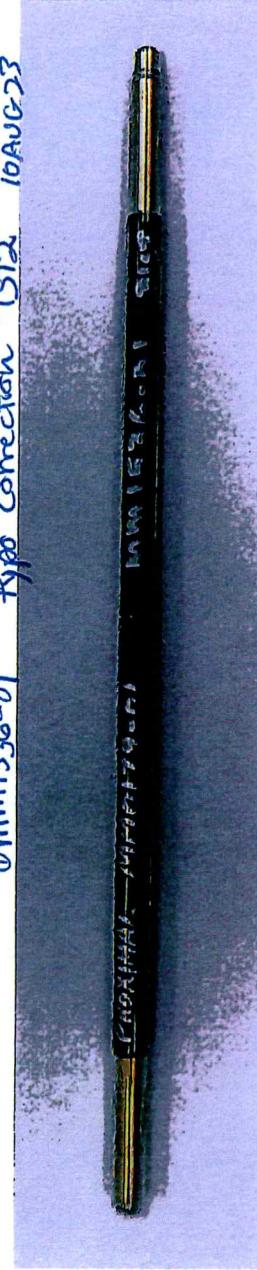


Image- 1

**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)

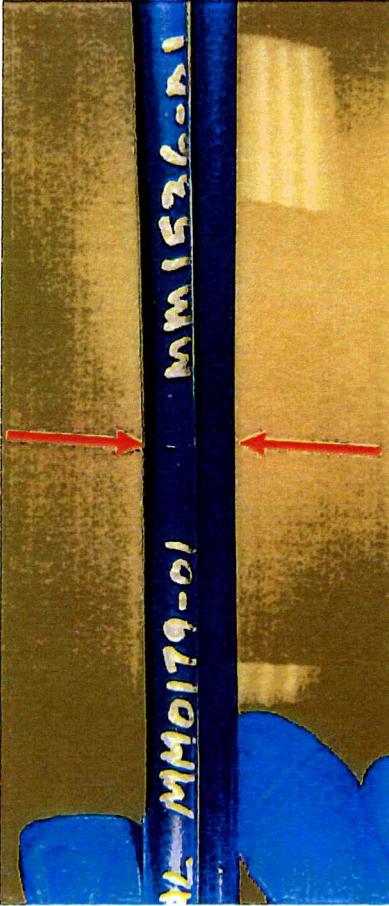


Image- 3

- 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)

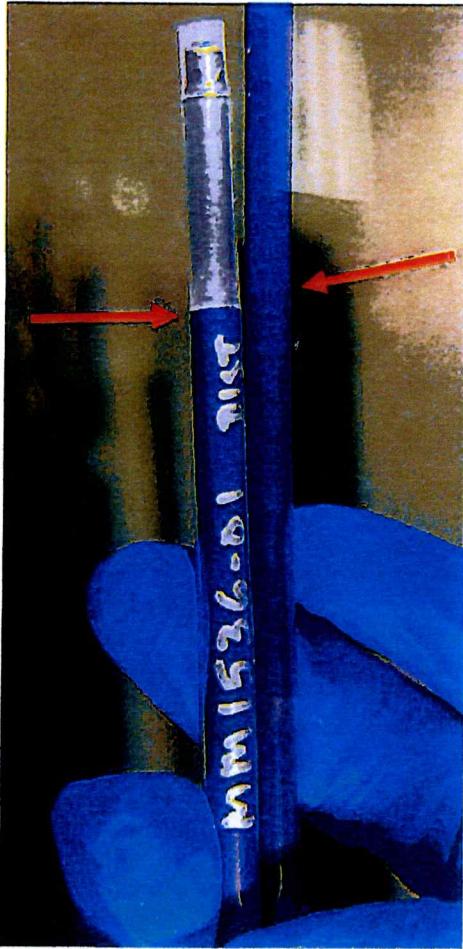


Image- 4  
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

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

<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

Entered to HMI064 J228 12/15/2023

Entered to HMI064 J228 13 Feb 2024 12/22 1/9/2024

CREGANNA  
MEDICAL  
is part of



**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: DA2564

## DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<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>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.		
<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.			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
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 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 checked="" type="checkbox"/> Yes <input 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			
Title	Approval Name	Approval Signature	Date
Engineering Manager	Jake Stanislowski		16 Nov 2023
Quality Manager	Jay Zabel		16 Nov 2023
Operations Manager	Matthew Benson		16 Nov 2023



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000303481

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	10:59pm	430	SH85	01 Feb 24	11:11 pm	415	SA09	01 Feb 24	16
Tm10942	44	11:58pm	430	SH85	01 Feb 24	12:10 Am	415	SH85	02 Feb 24	16
Tm10942	44	12:30Am	429	SH85	02 Feb 24	12:42Am	415	SH85	02 Feb 24	16
Tm10942	44	01:05AM	429	Sy47	02 Feb 24	01:17AM	415	Sy47	02 Feb 24	16
Tm10942	44	1:40Am	429	SH85	02 Feb 24	1:52Am	415	SH85	02 Feb 24	16
Tm10942	44	6:48am	430	OS21	02 Feb 24	7:00am	415	OS21	02 Feb 24	11
Tm10942	44	7:25am	430	OS21	02 Feb 24	7:37am	415	OS21	02 Feb 24	16
Tm10942	44	8:00am	430	OS21	02 Feb 24	8:12am	415	OS21	02 Feb 24	16
Tm10942	44	8:25am	430	OS21	02 Feb 24	8:37am	415	OS21	02 Feb 24	16
Tm10942	44	9:48am	430	OS21	02 Feb 24	10:00am	415	OS21	02 Feb 24	16
Tm10942	44	10:25am	430	CB58	02 Feb 24	10:37am	415	CB58	02 Feb 24	16
Tm10942	44	10:45am	430	CB58	02 Feb 24	10:57am	415	CB58	02 Feb 24	16



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000030348

OP 400

① C B 58 02 Feb 24



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

PRODUCTION ORDER# 500000303481

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
JM10745	44	11:40PM	430	SH85	01 Feb 24	11:52PM	415	SH85	01 Feb 24	16
JM10745	44	12:15AM	428	SH85	02 Feb 24	12:27AM	415	SH85	02 Feb 24	16
JM10745	44	12:47AM	429	SH85	02 Feb 24	12:59AM	415	SH85	02 Feb 24	16
JM10745	44	01:25AM	429	Sy47	02 Feb 24	01:37AM	415	Sy47	02 Feb 24	16
JM10745	44	1:57AM	429	SH85	02 Feb 24	2:09AM	415	V078	02 Feb 24	13
JM10745	44	7:05AM	430	OS21	02 Feb 24	7:17AM	415	OS21	02 Feb 24	14
JM10745	44	7:48AM	430	OS21	02 Feb 24	8:00AM	415	OS21	02 Feb 24	16
JM10745	44	8:15AM	430	OS21	02 Feb 24	8:27AM	415	OS21	02 Feb 24	16
JM10745	44	8:35AM	430	OS21	02 Feb 24	8:47AM	415	OS21	02 Feb 24	16
JM10745	44	9:24AM	430	PL22	02 Feb 24	9:36AM	415	PL22	02 Feb 24	16
JM10745	44	10:00AM	430	OS21	02 Feb 24	10:12AM	415	OS21	02 Feb 24	16
JM10745	44	10:22AM	430	KL45	02 Feb 24	10:32AM	415	KL45	02 Feb 24	16

①KL45 02 Feb 24



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

Title: SA0155-01 Reflow Log Sheet Form

**PRODUCTION ORDER#** 50000030348

OP 400



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

PO #: 500000303481

OP #: 500 Shift #: 2nd

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	n/a	n/a
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		4
MP	Micropores	n/a	n/a
SCR	Scratch	/	1
SKV	Skive Marks		4
VD	Voids	///	3
n/a	n/a	n/a	n/a

**Inspected By (Sign and Date):** Vannej Lor 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 50000303481

OP #: 500 Shift #: 2

**Total Parts Reworked:**

6

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		4
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	/	1
N/A	N/A	N/A	0
<b>Inspected By (Sign and Date):</b>		<i>Craig</i>	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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000 303 481

OP #: 500 Shift #: 3

Total Parts Reworked:		101	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		3
EH	Exposed Hypotube		25
EW	Exposed Wire		65
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks		5
VD	Voids		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		2S46, TA36 Aron	02 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 #: 500 066 303 481OP #: 750 Shift #: 3

Total Parts Reworked:		37	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		12
DIM07 US / WC	DIM07 Undersized (Window Closed)		7
EH	Exposed Hypotube		11
GD	Glue Damage		7
Inspected By (Sign and Date):		IC83 02FEB24	

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: 6102646  
Rev: A  
Document Type: Manufacturing Form  
Title: SA0155-01 Tipping Rework Form

PO #: 500000303481

OP #: 750 Shift #: 3

Total Parts Reworked:		24	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		4
DIM07 US / WC	DIM07 Undersized (Window Closed)		6
EH	Exposed Hypotube		8
GD/AB	glue damages/air bubbles		6
Inspected By (Sign and Date):		B160 02 FEB 2024	

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# 500000303481

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	6:50AM	190F	KL4S	02FEB24	8:00AM	190F	KL4S	02FEB24	32
TM12036	N/A	7:22AM	190F	KL4S	02FEB24	8:32AM	190F	KL4S	02FEB24	24
TM10409	N/A	8:05AM	190F	KL4S	02FEB24	9:15AM	190F	KL4S	02FEB24	35
TM12036	N/A	8:35AM	190F	KL4S	02FEB24	9:45AM	190F	KL4S	02FEB24	35
TM10409	N/A	9:30AM	190F	KL4S	02FEB24	10:40AM	190F	KL4S	02FEB24	25
TM12036	N/A	10:16 AM	190F	KL4S	02FEB24	11:26 AM	190F	KL4S	02FEB24	41
TM10409	N/A	10:43AM	190F	KL4S	02FEB24	11:53AM	190F	KL4S	02FEB24	34
TM12036	N/A	11:38AM	190F	KL4S	02FEB24	12:48PM	190F	KL4S	02FEB24	36
TM10409	N/A	12:10PM	190F	KL4S	02FEB24	1:20 PM	190F	KL4S	02FEB24	44
TM12036	N/A	1:23PM	190F	KL4S	02FEB24	2:33 PM	190F	KL4S	02FEB24	27
TM10409	N/A	1:50PM	190F	KL4S	02FEB24	3:00 PM	190F	KL4S	02FEB24	25
TM12036	N/A	2:34 PM	190F	KL4S	02FEB24	3:44 PM	190F	KL4S	02FEB24	37
TM10409	N/A	3:14 PM	190F	KL4S	02FEB24	4:24 PM	190F	KL4S	02FEB24	① 2882

① KL4S 02FEB24

Page 1 of 1



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000303481OP #: 900 Shift #: 3

Total Parts Reworked:		159	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		9
EH	Exposed Hypotube		12
EW	Exposed Wire		73
MP	Micropores	N/A	N/A
SCR	Scratch		79
SKV	Skive Marks		3
VD	Voids		37
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized		12
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		DLO7 KX54, PH59	03 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	27.2	25.9	30.62	26.67	30.51	25.73	24.12	25.44	28.03	28.15	27.237	2.132969	4.378	17.8988618	8.542	PASS
Seg B	65.33	65.32	62.26	63.8	66.47	68.45	68.43	60.1	73.73	62.02	65.591	3.9524632	3.981	49.8562439	8.542	PASS
Seg C	80.75	78.64	77.69	76.76	79.29	79.3	77.67	78.4	75.7	75.03	77.923	1.7410217	2.911	72.8548857	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 #: 500000303481

Date: 05 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



05 Feb 24