

Production Order: 500000310880



Production Order Document
Production Order Qty: 500

PC
Sheet: 1 of 1

Material: SA0155-01 Rev F

Material Type: ZFRT Description: Edwards Flex Shaft Commander
155885 Order Type: ZSTD
Production Version: 7987 Project Phase:
Plant / Business Unit: 1213 / AC5

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3 Kitting Devices  Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): _____ Record Time Extrusions First Exit Dryer (Initial/Time/Date): _____ Record Dryer Shelf #: _____				

Notes:

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap. Qty & Desc.	Date Comp.	Initials
		RM0158-01	E	—	PC	200	_____	_____		
		1000-1153-01	A	—	PC	594	_____	_____		
		1000-2053-01	A	—	PC	500	_____	_____		
		MM1537-02	A	—	PC	500	_____	_____		
		TL0167-02	E	—	PC	70	_____	Bulk		
		TL0165-05	J	—	PC	5	_____	Bulk		
		TL0165-03	J	—	PC	5	_____	Bulk		

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		141967-01	02	—	PC	500	_____	_____		
		RM7349-02	C	—	PC	543	_____	_____		
		RM7348-01	C	—	PC	500	_____	_____		
		RM4001-01	B	—	PC	125	_____	_____		
		RM0607-01	D	—	PC	56	_____	_____		
		RM0498-01	C	—	PC	500	_____	_____		
		RM0009-04	I	—	PC	1	_____	<u>Bulk</u>		
		RM0009-04	I	—	PC	1	_____	<u>Bulk</u>		
								<u>Bulk</u>		

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		MM1538-01	A	—	PC	500	_____	Bulk		
		MM1537-01	A	—	PC	1000	_____	_____		
		MM0177-01	C	—	PC	500	_____	_____		
		MM0180-01	E	—	PC	500	_____	_____		
		MM0178-01	E	—	PC	500	_____	_____		
		MM0176-01	D	—	PC	500	_____	_____		
		MM0074-01	G	—	PC	500	_____	_____		

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
100	CATASY01 Catheter Assembly 1  Line Clearance Confirmation Reqd(Milestone)	Line Clearance Perform Line Clearance and Heat Gun Setting				
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly				
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone)					
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Confirmation Reqd(Milestone)	Loading Braid Stock				
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End	Trim Braid Wire at Proximal End				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)					
300	CATASY01 Catheter Assembly 1  Insert Cut Hypo Tube Confirmation Reqd(Milestone)	Insert Cut Hypo Tube .				
350	CATASY01 Catheter Assembly 1	Load Tubing .				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Load Tubing Confirmation Reqd(Milestone)					
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow				
450	CATASY01 Catheter	FEP Removal				
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 					
	FEP Removal					
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Confirmation Reqd(Milestone)	<p>In-process Inspection and Rework</p> <p>Material Consumed:</p> <p>Part #: _____ Batch #: _____ Qty: _____</p>				
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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 .				
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly .	Distal Tip Assembly .				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials		
	Reqd(Milestone)							
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink .						
	Loading Heat Shrink							
	Confirmation Reqd(Milestone)							
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: _____ Cal Due: _____ TMI: _____ Cal Due: _____ TMI: _____ Cal Due: _____ TMI: _____ Cal Due: _____ Tipping						
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone)					
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <p>Part #: _____ Batch #: _____ Qty: _____</p>				
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal	.				
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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)					
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. _____ 2. _____ 3. _____ 4. _____ 5. _____				
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS				
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: _____ Cal Due: _____ TMI: _____ Cal Due: _____ Material Consumed: Part #: _____ Batch #: _____ Qty: _____ Part #: _____ Batch #: _____ Qty: _____					
950	QUALITY1 Quality Inspection & Review Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: _____ Cal Due: _____ Record Caliper Information:					

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: _____ Cal Due: _____ Record DIM02 Go/No-Go Gage Information: TMI: _____ Cal Due: _____ TMI: _____ Cal Due: _____ Record DIM02 Inspection Results N = 54: Pass: _____ Fail: _____				
1000	QUALITY1  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: _____ Cal Due: _____ Record Length Gage Information: TMI: _____ Cal Due: _____ Record Calibrated Ruler Information: TMI: _____ Cal Due: _____				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
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				
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): _____				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone)					
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts				

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By: _____

Date: _____

Reviewed By: _____

Date: _____

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