

Production Order: 500000300502



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: 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  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>X31 9:30AM 24JAN24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KDQ 11am 26Jan24</u> Record Dryer Shelf #: <u>N/A</u></p> <table border="1"> <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>0000276172</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>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>0000276172</u>	<u>500</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>	N/A	N/A	24JAN24 KL27
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
MM0179-01	D <u>D</u>	PC	500	<u>0000276172</u>	<u>500</u>																		
MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>																		

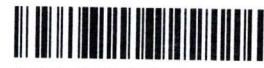
Notes: DA 2564, DA 2484

N/A

N/A

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N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	N/A 58497	N/A 133		
		RM0009-04	I	<u>I</u>	PC	1	N/A 79168	Bulk		
		RM0009-04	I	<u>I</u>	PC	1	N/A 79168	Bulk		
		MM1538-01	A	<u>A</u>	PC	500	0000278970	500 N/A	N/A	N/A
		MM1537-01	A	<u>A</u>	PC	1000	0000284209	1000 N/A		
		1000-2053-01	A	<u>A</u>	PC	500	0000278880	500 N/A		
		MM1537-02	A	<u>A</u>	PC	500	000028840)	500 N/A		

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	TL0167-02	E	E	PC	70	N/A	Bulk			
		TL0165-05	J	J	PC	5	N/A	Bulk			
		TL0165-03	J	J	PC	5	N/A	Bulk			
		141967-01	02	02	PC	500	85501	450			
		RM7349-02	C	C	PC	543	85502 82733 82833 82835 82851	75 100 200 200 100	N/A	N/A	N/A
		RM7348-01	C	C	PC	500	78688 78689 82885	150 150 300			
		RM4001-01	B	B	PC	125	① 82435 N/A 82456	100			
		RM0607-01	D	D	PC	56	74662	62			

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	RM0498-01	C	<u>C</u>	PC	500	<u>0000275492</u>	<u>N/A</u>		
		RM0362-01	E	<u>E</u>	PC	594	<u>0000287642</u>	<u>250</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>78862</u>	<u>200</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>78863</u>	<u>400</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000284208</u>	<u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000282490</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000295774</u>	<u>400</u>		
							<u>0000276174</u>	<u>100</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 Perform Line Clearance and Heat Gun Setting	500	0	27Jan24 CBS8	
	Line Clearance					
	Confirmation Reqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	27Jan24 SD34 YKHO SN67 AM47	
	Major and Minor Mandrel Assembly					
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)	500	0	27Jan24	MV50 MC17
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	27Jan24	RL47 PL22 AIGS OV39
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	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 .	500	0	27Jan24	SC10 RJLb P467
350	CATASY01 Catheter Assembly 1	Load Tubing .	500	0	27Jan24	UH45 BD64 CX63
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)		500	0	27Jan24	AM47 SN1607 PL22
450	CATASY01 Catheter	FEP Removal	500	0	27Jan24	AM47
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	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 #: 1000-1153-0 Batch #: 87654 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	483	EW-HH1111 OF-1X11 ND-11 17	TA36 AR02 CB81 27Jan24	L546
	In-process Inspection and Rework Confirmation Reqd(Milestone)					
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
		N/A	N/A	N/A		
			N/A			

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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)	478	MAH-HP 5	27Jan24	LH45 TRW MH10 PT09
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly	478	0	27Jan24	VAA6 PT09

Notes:

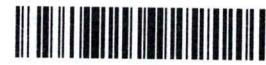
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	478	0	27Jan24	P459 PT09
	Loading Heat Shrink					
	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: 2083C Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24 Tipping	478	0	27Jan24	DY29
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
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 #: RM0607-01 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	478	0	27Jan24	BIGO DX35
800	CATASY01 Catheter Assembly 1 Major Mandrel Removal		478	0	27Jan24	YH40 BD64

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	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. Pass 2. Pass 3. Pass 4. Pass 5. Pass	478	0	27Jan24	KL45
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						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>D700-01</u> Cal Due: <u>31 MAY 2024</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>87654</u> Qty: <u>N/A</u> Part #: <u>RM4001-01</u> Batch #: <u>82456</u> Qty: <u>N/A</u> Part #: <u>RM0607-01</u> Batch #: <u>71863</u> Qty: <u>N/A</u> Part #: <u>RM0158-01</u> Batch #: <u>58497</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	453	DIS-LH(SP) DEL-HF(H) LH #54S-1 EW-LH SKV-11 DS-11 25		KX54 MC17 DX52 28Jan24	
950	QUALITY1 Quality Inspection & Review Quality Inspection & 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:		N/A	N/A	N/A	N/A

Notes:

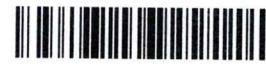
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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 2025</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 2025</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	450	DIS-111 <u>3</u>	28Jan24	R110
1000	QUALITY1  Quality Inspection & Review  Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31 MAY 2024</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 SEP 2024</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 2024</u>	439	LT-LHT LHT <u>11</u>	28Jan24	CB58 R110 PL22

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
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	401	SCR - MM 1111 Del - MM MM 1 SKV - MM EW - 11 Dis - 11 VD - 11 FL - 1 AB - 1 PDC - 1 GN11 - 1 FM - 1	29Jan24	SV43 KISS (38)
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02</u> <u>29Jan24</u>	N/A	N/A	29Jan24	KP02

Notes:

N/A

N/A

N/A

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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	401	0	29Jan2024	mm

Notes:

N/A
N/A
N/A

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Batch Number: 0000300502

By: mme7

Date: 29 Jan 24

Reviewed By:

RB29

Date:

30 JAN 24

Notes:

N/A

N/A

N/A

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Edited to **Hanish** 3228 1/1/2023
Edited to **13 Feb 2024** 3228 1/1/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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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

Batches to 2024 3228 U/A/523
Expiry to 19 Feb 2024 3228 1/16/2024
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DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 2484
TS12
24AUG23 3228 1/16/2023
Extend to 22 Nov 2023 3228 1/16/2024
Batch to 20 Dec 2023 3228 1/16/2024
DEVIATION AUTHORIZATION FORM Extends to 23 Oct 2023 3228 1/16/2024

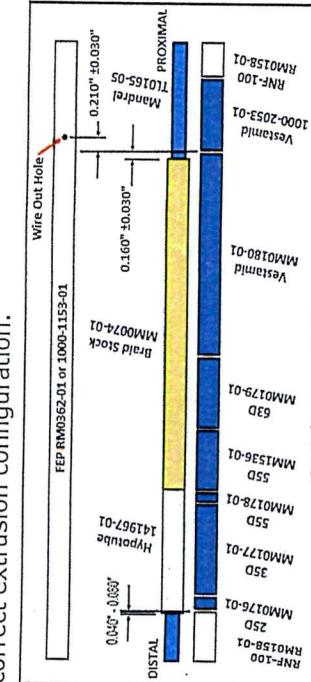
CONTROLLED COPY

Requestor Name: Udhesh Kapadnis

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.

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
SA0155-01	H

Start Date:	End Date:	Lot Number:
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: 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 Stanislowski		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:

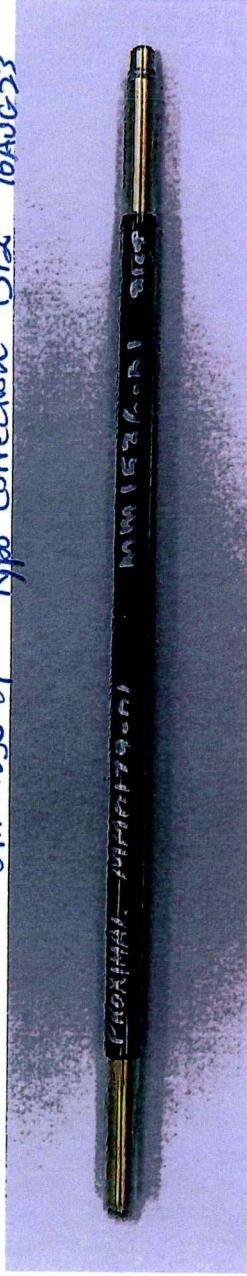
- 100% inspection at Op#1050 per the instructions below.
 - Inspect 1 part at a time.
 - Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
 - Use the example MM0179-01 and MM1536-02 fixture for inspection. (See image 1)
① MM1536-01 type connection TS12 10AUG23
- 

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)

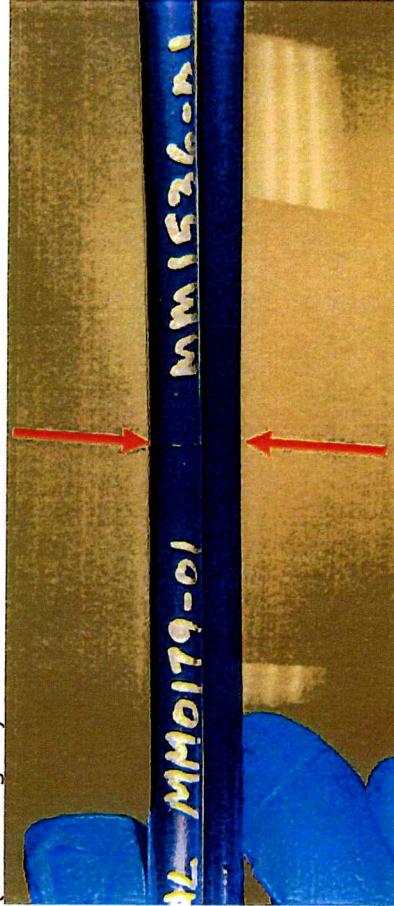


Image- 3

- 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



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

PRODUCTION ORDER# 500000300502

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	4:41PM	430	YK40	26Jan24	4:53PM	415	YK40	26Jan24	16
TM10942	44	5:02pm	430	YK4	26Jan24	5:14pm	415	YK40	26Jan24	16
TM10942	44	5:30pm	430	CB58	26Jan24	5:42pm	415	CB58	26Jan24	16
TM10942	44	5:48pm	430	CB58	26Jan24	6:00pm	415	CB58	26Jan24	16
TM10942	44	5:20pm	430	CB58	26Jan24	6:32pm	415	CB58	26Jan24	16
TM10942	44	6:40AM	430	CB58	27Jan24	6:52AM	415	CB58	27Jan24	16
TM10942	44	7:10AM	430	CB58	27Jan24	7:22AM	415	CB58	27Jan24	16
TM10942	44	8:05am	430	CB58	27Jan24	8:17am	415	CB58	27Jan24	16
TM10942	44	8:25am	430	TA36	27Jan24	8:37am	415	TA36	27Jan24	16
TM10942	44	9:10AM	430	KL45	27JAN24	9:22AM	415	KL45	27JAN24	12
TM10942	44	9:52AM	430	KL45	27JAN24	① 9:04 Am	415	KL45	27JAN24	16
TM10942	44	10:35am	430	TA36	27 Jan 24	10:47am	415	TA36	27 Jan 24	16

① KL45 27JAN24



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FM5104665 Rev: C
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PRODUCTION ORDER# 500000300502

OP 400



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

PRODUCTION ORDER# 500000300562

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	3:30PM	430	0521	26Jan24	3:42PM	415	0521	26Jan24	16
TM10745	44	4:26pm	430	YK40	26Jan24	4:38pm	415	YK40	26Jan24	16
TM10745	44	4:52PM	430	YK40	26Jan24	5:04pm	415	YK40	26Jan24	16
TM10745	44	5:15pm	430	YK40	26Jan24	5:27pm	415	YK40	26Jan24	16
TM10745	44	6:10pm	430	CB58	26Jan24	6:22pm	415	CB58	26Jan24	16
TM10745	44	6:48AM	430	CB58	27Jan24	7:00AM	415	CB58	27Jan24	16
TM10745	44	7:25AM	430	CB58	27Jan24	7:37AM	415	CB58	27Jan24	16
TM10745	44	9:38 AM	430	KL45	27JAN24	9:50 AM	415	KL45	27JAN24	16
TM10745	44	10:15AM	430	CD19	27Jan24	10:27AM	415	CD19	27Jan24	16
TM10745	44	11:06 AM	430	PL22	27 Jan 24	11:18AM	415	PL22	27 Jan 24	16
TM10745	44	11:39AM	430	AL67	27Jan24	11:51AM	415	AL67	27 Jan 24	16
TM10745	44	12:22pm	430	V078	27Jan24	12:34PM	415	KL45	27JAN24	11



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 5000030050

OP 400

PRODUCTION ORDER# 50000307502

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	7:09AM	190F	YKHO	27JAN24	8:19AM	190F	YKHO	27JAN24	29
Tm12036	N/A	8:02AM	190F	YKHO	27 JAN 24	9:12AM	190F	YKHO	27JAN24	37
Tm10409	N/A	8:27AM	190F	YKHO	27JAN24	9:37AM	190F	YKHO	27JAN24	45
Tm12036	N/A	9:27AM	190F	YKHO	27 JAN 24	10:37AM	190F	YKHO	27 JAN 24	51
Tm10409	N/A	9:57AM	190F	YKHO	27 JAN 24	11:07AM	190F	YKHO	27 JAN 24	38
Tm12036	N/A	10:47AM	190F	YKHO	27JAN24	11:57AM	190F	YKHO	27JAN24	45
Tm10409	N/A	11:14AM	190F	YKHO	27 Jan 24	12:24PM	190F	YKHO	27 Jan 24	① 29 ② 46
Tm12036	N/A	12:04PM	190F	YKHO	27 Jan 24	1:14 PM	190F	YKHO	27 Jan 24	35
Tm12036	N/A	1:25PM	190F	BD64	27JAN24	2:35PM	190F	BD64	27JAN24	43
Tm10409	N/A	2:25PM	190F	BD64	27JAN24	3:35PM	190F	BD64	27JAN24	25
Tm12036	N/A	3:15PM	190F	BD64	27Jan24	4:30PM	190F	BD64	27Jan24	28
Tm10409	N/A	4:30PM	190F	BD64	27Jan24	5:40PM	190F	BD64	27Jan24	26
Tm12036	N/A	5:05PM	190F	BD64	27Jan24	6:15PM	190F	BD64	27Jan24	27

① YKHO 27Jan24



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

PO #: 50000300502

OP #: 500 Shift #: 3

Total Parts Reworked:		16	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		3
EW	Exposed Wire		13
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LS46 . ARO2	26 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 #: 500000300502

OP #: 500 Shift #: 3

Total Parts Reworked:		193	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube		28
EW	Exposed Wire		115
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		22
VD	Voids		20
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		7A36.2546.AR02,CB81	27 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: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000300502

OP #: 750 Shift #: 3rd

Total Parts Reworked:		52	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		2
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		33
GD / AB	glue damage / Air Bubbles		14
Inspected By (Sign and Date):		BIBO 27 Jan 2023 ① 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):

① BIBO 27 Jan 24



PO #: 500000300502

OP #: 900 Shift #: 3

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

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

Data Uploaded for Engineering Review (Check):

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Page 1 of 1

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	30.55	24.18	30.87	26.5	28.21	26.97	31.36	31.51	27.27	23.8	28.122	2.8736458	4.378	15.5411788	8.542	PASS
Seg B	75.7	69.74	73.48	70.89	69.94	77.77	71.44	69.15	73.29	78.14	72.954	3.3074871	3.981	59.7868937	8.542	PASS
Seg C	75.77	86.64	79.57	79.17	84.87	80.51	74.54	71.64	68.01	77.92	77.864	5.6666278	2.911	61.3684463	8.542	PASS

EDW Commander Flex - Bend and Tensile Strength Testing

LOT #: 500000300502

Date: 29JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



29 JAN 2024