

Production Order: 500000297269



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>GS85 7:00 AM 24 Jun 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>X31 12:30AM 25JAN24</u> Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev Used</th> <th>UOM</th> <th>Qty.</th> <th>Batch No.</th> <th>Actual Qty Used</th> </tr> </thead> <tbody> <tr> <td>1000-2053-01</td> <td>A <u>A</u></td> <td>PC</td> <td>500</td> <td><u>0000278880</u></td> <td><u>500</u></td> </tr> <tr> <td>MM1537-02</td> <td>A <u>A</u></td> <td>PC</td> <td>500</td> <td><u>0000288481</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>	MM1537-02	A <u>A</u>	PC	500	<u>0000288481</u>	<u>500</u>	N/A	N/A	23JAN24 CB58	KL27
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																			
1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>																			
MM1537-02	A <u>A</u>	PC	500	<u>0000288481</u>	<u>500</u>																			

Notes: DA 2484, 2564

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	RM0158-01	E	E	PC	200	N/A 58497	N/A 150			
		E	N/A	PC	70	N/A	N/A	Bulk		
		J	N/A	PC	5	N/A	N/A	Bulk		
		J	N/A	PC	5	N/A	N/A	Bulk		
		02	02	PC	500	N/A 85501	500			
		C	C	PC	543	N/A 82729	N/A 400			
		C	C	PC	500	N/A 82831 82874	100 350	N/A N/A	N/A	N/A
						82885	150			

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	N/A	RM4001-01	B	<u>B</u>	PC	125	<u>82433</u>	<u>100</u>		
		RM0607-01	D	<u>D</u>	PC	56	<u>82455</u>	<u>100</u>		
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287642</u>	<u>466</u>		
		RM0362-01	E	<u>E</u>	PC	594	<u>78858</u>	<u>600</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>82971</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>82971</u>	<u>Bulk</u>		
		MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u>	<u>500</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u>	<u>1,100</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	MM1536-01	B <u>B</u>	PC	500	0000281413	20				
		MM0180-01	E <u>E</u>	PC	500	0000281412	500				
		MM0179-01	D <u>D</u>	PC	500	0000271063	40				
		MM0178-01	E <u>E</u>	PC	500	0000282490	500				
		MM0177-01	C <u>C</u>	PC	500	0000275691	31				
		MM0176-01	D <u>D</u>	PC	500	0000276172	500				
		MM0074-01	G <u>G</u>	PC	500	N/A	N/A	N/A	N/A	N/A	
						0000276174	500	N/A	N/A	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
MA	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	25Jan24	V078
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	25Jan24	CL30 JY90 SH23 NK62 AX05 AP54

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 Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	25 Jan 24	OPS& Y014 MU50 SXTI
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	25 Jan 24	OL05 NY35 VP62 C497
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
	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	25 Jan 24	AS31 GS22 SH23 PV39 Lmub
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	25 Jan 24	ST96 SH23 PL34 W25
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)	MIA	MIA	MIA	MIA	MIA
400	CATASY01 Catheter Assembly 1 Reflow Reflow Confirmation Reqd(Milestone)		500	0	25 Jun 24	SY47 PM 96 NK62 RN27 TA 36 AP54
450	CATASY01 Catheter	FEP Removal	500	0	25 Jun 24	PM 96

Notes:

MIA
MIA
MIA

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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)	N/A	N/A	N/A	N/A	N/A
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Confirmation Reqd(Milestone)	In-process Inspection and Rework Material Consumed: Part #: 100-153-0 Batch #: 87694 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	472	Fm - 111 EW - HHT 1111 OF - HHT HHT HHT 1 28	25Jan24	LL61 VC 09 LB 81 JA 36
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	472	0	25Jan24	VA96 F1301 PH59 RS23
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	458	1 14	DL -HTT 111 MHT -HTT 25Jan24	VA96 F1301 PH59 Ax82 SV40

Notes:

N/A
N/A
N/A

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Opn No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	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)	458	O	25Jan24	FBS01 PH59 DY29 AK82 ML38
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0286 Cal Due: 31MAY24 TMI: 0571 Cal Due: 31MAY24 TMI: 2683 Cal Due: 31MAY24 TMI: 0936A Cal Due: 31MAY24 Tipping	458	O	25Jan24	RS23 ML38

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 #: 82433 Qty: 5 Part #: RM607-01 Batch #: 71863 Qty: 5 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	458	○	25Jan24	STX48 Hv36 MM02 HTT72
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		457	ACD-1	25Jan24	SS52 SS44 PM96 SG88

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 Record DIM05 gage result for the first 5 parts at the start of operation: 1. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	457	0	25Jan24	SS58 ML65 TRN K161 Y936
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 ML46 SH04
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	Quality Inspection & Review Confirmation Reqd(Milestone)	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: 0700-01 Cal Due: 31 may 24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: RM4001-01 Batch #: S2433 Qty: 5 Part #: RM6007-01 Batch #: J1843 Qty: 3 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</p>	437	#5US-1 #70S-1 #6US-111 #90S-1 WK-11 DIS-11 EW-144 1 DL-11 DEL-1 ACD-1 (20)	25Jan24	P146 KT47 K155 XL91 KL67
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: N/A Cal Due: N/A Record Caliper Information:</p>	N/A	N/A	N/A	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	Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: <u>M/A</u> Cal Due: <u>M/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>	419	DIS(SP)HHT Str-111 Dis-HHT 1111 Str-1 (18)	25Jan24	OS21 SS44 TRM XL91 KL67
1000	QUALITY1 Quality Inspection & 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>088910</u> Cal Due: <u>30sep24</u> Record Calibrated Ruler Information: TMI: <u>0692</u> Cal Due: <u>30sep24</u>		405	Lt-HHT HHT 1111	25Jan24	SS44 UL61 XL91 KL67

Notes:

N/A

N/A

N/A

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	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	n/a	SCR-HH III (TT) FM-II (TT) VD-II DIS-III SKV-II eu-II KNK-I eH-I BP-I Mex-I CRK-I 25	26 Jan 24	XN26 Zys50 SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>CB58</u> <u>26Jan24</u>	N/A	N/A	26Jan24	CB58

Notes:

N/A

N/A

N/A

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Opn No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	380	0	26 Jan 24	BMT

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Material: SA0155-01 Rev F

Batch Number: 0000297269

By: BAZ

Date: 26 Jan 24

Reviewed By:

RB29

Date:

26 JAN 24

Notes:

M/N
N

Date Printed: 01/23/2024 / 14:10:30

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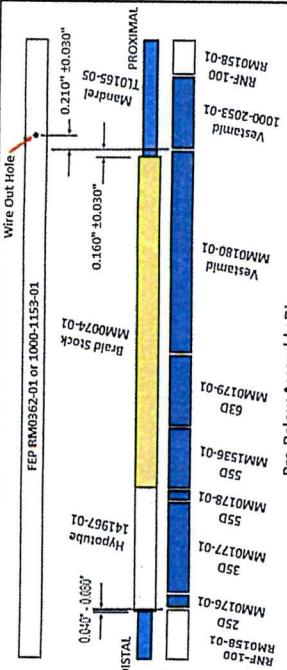


Dates to 2024 3228 1/1/23
 Extend to 2024 3228 1/1/23
 Dates to 2023 3228 1/1/23
 Extend to 2023 3228 1/1/23
 Dates to 2023 3228 1/1/23
 Extend to 2023 3228 1/1/23



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Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L
Deviation From:	Deviation To:
<p>QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050: Current QIP3107610 does not state to inspect for the correct extrusion configuration.</p>	<p>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.</p> 

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.

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

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.

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: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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

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① UK55, 23JW 2023



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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 correction TS12 10AUG-23

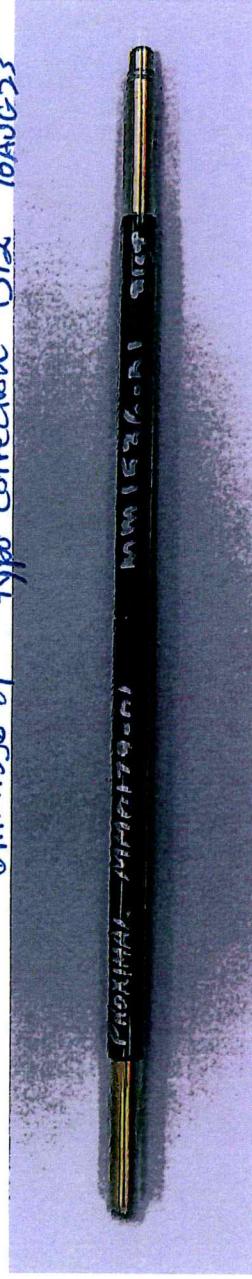


Image- 1

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)

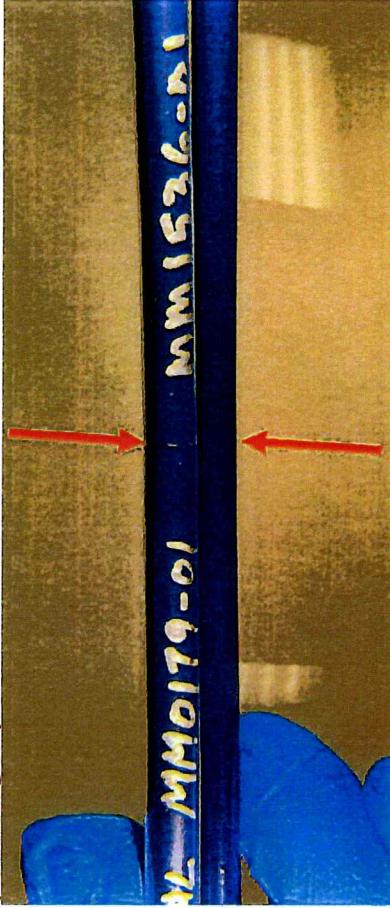
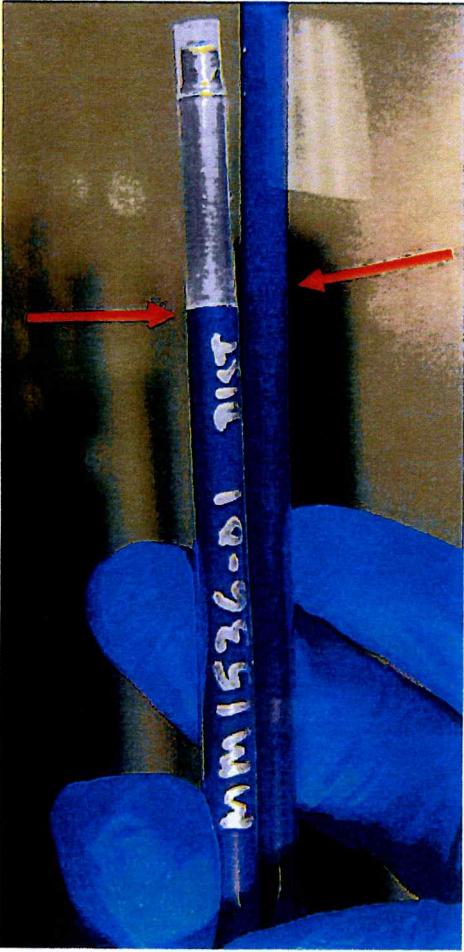


Image- 3

- 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	MM1536-01	GOOD PART
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

Entered to Hansa 3228 11/16/2023
Entered to 13 Feb 2024 3228 1/6/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
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.			
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			
SA0155-01		Revision	
		H	
Start Date:		End Date:	
16 Nov 23		15 DEC 23	
Lot Number:		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 checked="" type="checkbox"/> Yes <input 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



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

PRODUCTION ORDER# 500000297269

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	5:13 am	430	KL95	25Jan24	5:25am	415	KL95	25Jan24	16
Tm10745	44	5:45am	430	KL95	25Jan24	5:57am	415	KL95	25Jan24	16
Tm10745	44	6:00am	429	OS21	25Jan24	6:12am	415	OS21	25Jan24	16
Tm10745	44	6:20am	430	KL95	25Jan24	6:32am	415	KL95	25Jan24	16
Tm10745	44	6:55am	430	Ax05	25Jan24	7:07am	415	Ax05	25Jan24	16
Tm10745	44	7:40am	430	OS21	25Jan24	7:52am	415	OS21	25Jan24	16
Tm10745	44	7:58am	428	KL95	25Jan24	8:10am	415	KL95	25Jan24	16
Tm10745	44	8:16am	428	KL95	25Jan24	8:28am	415	OS21	25Jan24	16
Tm10745	44	8:48am	430	OS21	25Jan24	9:00am	415	OS21	25Jan24	16
Tm10745	44	9:10am	430	OS21	25Jan24	9:22am	415	OS21	25Jan24	16
Tm10745	44	9:25am	430	TB36	25Jan24	9:37am	415	TB36	25Jan24	16
Tm10745	44	9:45am	430	OS21	25Jan24	9:57am	415	OS21	25Jan24	16



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

PRODUCTION ORDER# 500000297269

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0745	44	10:05am	428	OS21	25Jan24	10:17am	415	OS21	25Jan24	14
TMI0745	44	10:59am	430	AX05	25Jan24	11:11am	415	AX05	25Jan24	16
TMI0745	44	11:30am	430	AX05	25Jan24	11:42am	415	AX05	25Jan24	16
TMI0745	44	12:10PM	430	AX05	25Jan24	12:22PM	415	AX05	25Jan24	16
TMI0745	44	12:30PM	428	AX05	25Jan24	12:42PM	415	AX05	25Jan24	12
				N/A						
						OS21	25Jan24			



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

PRODUCTION ORDER# 500000 297269

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	1:48am	430	SH85	25Jan24	2:00Am	415	SH85	25Jan24	16
TM10942	44	4:59am	430	KL95	25Jan24	5:11am	415	KL95	25Jan24	16
TM10942	44	5:25am	428	AX05	25Jan24	5:37am	415	AX05	25Jan24	16
TM10942	44	5:48am	430	OS21	25Jan24	6:00am	415	OS21	25Jan24	16
TM10942	44	6:15am	428	OS21	25Jan24	6:27am	415	OS21	25Jan24	16
TM10942	44	7:30am	430	OS21	25Jan24	7:42am	415	OS21	25Jan24	16
TM10942	44	7:55am	427	KL95	25Jan24	8:07am	415	KL95	25Jan24	16
TM10942	44	8:35am	430	OS21	25Jan24	8:47am	415	OS21	25Jan24	16
TM10942	44	9:00am	429	OS21	25Jan24	9:12am	415	OS21	25Jan24	16
TM10942	44	9:14am	426	KL95	25Jan24	9:26am	415	OS21	25Jan24	16
TM10942	44	9:49am	430	KL95	25Jan24	10:01am	415	KL95	25Jan24	16
TM10942	44	10:48am	430	AX05	25Jan24	11:00am	415	AX05	25Jan24	16



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

PO #: 500000297269 OP #: 500 Shift #: 1st

Total Parts Reworked:		<u>150</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>N/A</u>
EH	Exposed Hypotube	<u> </u>	<u>39</u>
EW	Exposed Wire	<u> </u>	<u>82</u>
MP	Micropores	<u> </u>	<u>6</u>
SCR	Scratch	<u> </u>	<u>3</u>
SKV	Skive Marks	<u> </u>	<u>2</u>
VD	Voids	<u> </u>	<u>23</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
Inspected By (Sign and Date):		<u>CB81, LLG1, VC09, TA36</u>	<u>25 Jan 24</u>

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000297269

OP #: 750 Shift #: 1st

Total Parts Reworked:		104	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		5
DIM07 US / WC	DIM07 Undersized (Window Closed)		26
EH	Exposed Hypotube		43
N/A	Glue , Stopper		30
Inspected By (Sign and Date):		Hv36 25 Jan 24	

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

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000297269OP #: 750 Shift #: 2

Total Parts Reworked:		5	
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)	N/A	N/A
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		HT72 25 Jan 24	

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

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 50000297269OP #: 750 Shift #: 2nd.

Total Parts Reworked:		13	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		8
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	25 Jan 24

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

Data Uploaded for Engineering Review (Check):

PRODUCTION ORDER# 500000297269

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI12036	N/A	7:45 AM	190°F	PM 96	25 Jan 24	8:55 AM	190°F	PM 96	25 Jan 24	30
TMI10409	N/A	8:20 AM	190°F	PM 96	25 Jan 24	9:30 AM	190°F	PM 96	25 Jan 24	34
TMI12036	N/A	9:00 AM	190°F	PM 96	25 Jan 24	10:10 AM	190°F	PM 96	25 Jan 24	34
TMI10409	N/A	9:30 AM	190°F	PM 96	25 Jan 24	10:40 AM	190°F	PM 96	25 Jan 24	34
TMI12036	N/A	10:10 am	190°F	0521	25 Jan 24	11:20am	190°F	SS44	25 Jan 24	41
TMI10409	N/A	11:30 am	190°F	SS44	25 Jan 24	12:40pm	190°F	SS44	25 Jan 24	38
TMI12036	N/A	11:50 am	190°F	K155	25 Jan 24	1:00 PM 1P ①	190°F	K155	25 Jan 24	32
TMI10409	N/A	12:35 PM	190°F	K155	25 Jan 24	1:45 PM	190°F	SS44	25 Jan 24	54
TMI10409	N/A	1:50 pm	190°F	SS44	25 Jan 24	3:00 PM	190°F	SS44	25 Jan 24	31
TMI12036	N/A	2:45 pm	190°F	SS44	25 Jan 24	3:55 PM	190°F	SS44	25 Jan 24	45
TMI10409	N/A	3:15 PM	190°F	K155	25 Jan 24	4:20 PM	190°F	K155	25 Jan 24	21
TMI10409	N/A	4:35 pm	190°F	SG88	25 Jan 24	5:45 PM	190°F	SG88	25 Jan 24	63
			N/A							
			SG88	25 Jan 24						

① K155 25 Jan 24



PO #: 500000297269

OP #: 900 Shift #: 1st

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	N/A
EH	Exposed Hypotube	11	2
EW	Exposed Wire		18
MP	Micropores		21
SCR	Scratch		30
SKV	Skive Marks	N/A	N/A
VD	Voids		5
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		6
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		KT 207 6155	25 Jan 24

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

Data Uploaded for Engineering Review (Check):



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

PO #: 50000297269 OP #: 900 Shift #: 2

Total Parts Reworked:		10	
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	N/A	0
MP	Micropores	N/A	0
SCR	Scratch		19
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
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):		 25 Jan 24	

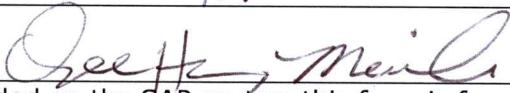
Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000297269 OP #: 900 Shift #: 2nd

Total Parts Reworked:		58	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		3
EW	Exposed Wire		6
MP	Micropores	N/A	0
SCR	Scratch		40
SKV	Skive Marks		3
VD	Voids		5
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		7
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):			25 Jan 24

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

Data Uploaded for Engineering Review (Check):

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	27.68	28.89	29.59	26.6	32.11	33.45	32.74	27.86	30.61	31.66	30.119	2.3516068	4.378	19.8236655	8.542	PASS
Seg B	69.26	28.3	74.54	72.12	73.16	73.45	72.61	73.08	64.68	77.1	67.83	14.276451	3.981	10.9954467	8.542	PASS
Seg C	75.63	80.15	86.37	78.37	88.15	82.23	84.7	84.72	80.36	75.51	81.619	4.3741042	2.911	68.8859826	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

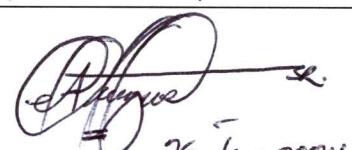
LOT #: 500000297269

Date: 26JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24



26 Jan 2024