

Production Order: 500000306363



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  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>1002 11:15am 08Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>Am 18 6:30 am 11Feb24</u> Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	07 FEB 24	SH 70

Notes: DA 2484, 2564

v/a

n/a

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
<i>MJ N/A</i>	RM0158-01	E	<u>E</u>	PC	200	<u>88018</u>	<u>N/A</u>	<u>N/A</u>		
	1000-1153-01	A	<u>A</u>	PC	594	<u>89544</u> <u>89545</u> <u>89546</u>	<u>N/A</u>	<u>200</u> <u>200</u> <u>200</u>		
	1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>N/A</u>	<u>500</u>		
	MM1537-02	A	<u>A</u>	PC	500	<u>000290571</u>	<u>N/A</u>	<u>500</u>	<i>N/A</i>	<i>N/A</i>
	TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
	TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
	TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
								<u>Bulk</u>		

Notes:

*N/A**N/A**N/A*

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		141967-01	02	<u>02</u>	PC	500	<u>87435</u>	<u>500</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82869</u>	<u>543</u>	<u>N/A</u>		
		RM7348-01	C	<u>C</u>	PC	500	^{XC31} 12FEB24 <u>8158T 88536</u>	<u>500</u>	<u>N/A</u>		
		RM4001-01	B	<u>B</u>	PC	125	<u>89429</u>	<u>100</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		RM0607-01	D	<u>8</u>	PC	56	<u>78849</u>	<u>33</u>	<u>N/A</u>	<u>N/A</u>	
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287648</u>	<u>488</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>			

Notes:

N/A

N/A

N/A

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N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>Bulk</u>	<u>500</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>1,120</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A N/A</u>
		MM0180-01	E	<u>E</u>	PC	500	<u>0000287541</u>	<u>500</u>	<u>N/A</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000290565</u>	<u>500</u>	<u>N/A</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>500</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000300400</u>	<u>516</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	12Fe ^b 2 ^u	CB58
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	12Fe ^b 2 ^u	CD19 SD34 YK40 SN67

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	500	0	12 Feb 24	M450 MC17
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	12 Feb 24	AJ65 PY67
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 Confirmation Reqd(Milestone)	Insert Cut Hypo Tube	500	0	12Feb24	PZ22 Q110
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	12Feb24	CX63 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	 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	12 Feb 24	CD19 RL47 AL67 SN67
450	CATASY01 Catheter	FEP Removal	500	0	12 Feb 24	J292 SN67
Notes:						
N/A						
N/A						
N/A						

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	Assembly 1 					
N/A	FEP Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 89546 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A		490	EW-1H VD-11 OF-1 EW-1 OF-1 (10)	12 Feb 24 10	LS46 VCOA B160 AR02 TA36 DY29 PH59 CB81
N/A	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
MA 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)	479	IB-111 MAH-111 DL-44 ⑪	12 Feb 24	LH45 TRN MH1D CD19 TRN MH1D PT09 YK95 FB01 AX82 RS23
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	479	0	12 Feb 24	MH1D PT09 VA96 AX82

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	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	479	0	12Feb24	LH45 PT09 AY82
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: <u>69364</u> Cal Due: <u>31Mar24</u> TMI: <u>2083C</u> Cal Due: <u>31Mar24</u> TMI: <u>0386</u> Cal Due: <u>31Mar24</u> TMI: <u>0521</u> Cal Due: <u>31Mar24</u> Tipping	479	0	12Feb24	IC83 RS23
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 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <table> <tr> <td>Part #:<u>RM0607-01</u></td> <td>Batch #:<u>78849</u></td> <td>Qty: <u>N/A</u></td> </tr> <tr> <td>Part #:<u>RM4001-01</u></td> <td>Batch #:<u>89429</u></td> <td>Qty: <u>N/A</u></td> </tr> <tr> <td>Part #: <u>N/A</u></td> <td>Batch #: <u>N/A</u></td> <td>Qty: <u>N/A</u></td> </tr> <tr> <td>Part #: <u>N/A</u></td> <td>Batch #: <u>N/A</u></td> <td>Qty: <u>N/A</u></td> </tr> <tr> <td>Part #: <u>N/A</u></td> <td>Batch #: <u>N/A</u></td> <td>Qty: <u>N/A</u></td> </tr> </table> <p>Tip Inspection/ Flash Removal</p> <p>Confirmation Reqd(Milestone)</p>	Part #: <u>RM0607-01</u>	Batch #: <u>78849</u>	Qty: <u>N/A</u>	Part #: <u>RM4001-01</u>	Batch #: <u>89429</u>	Qty: <u>N/A</u>	Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>	Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>	Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>	477	EH-11 (2) 12Feb24	IC83 BG60 STX48 HV36
Part #: <u>RM0607-01</u>	Batch #: <u>78849</u>	Qty: <u>N/A</u>																		
Part #: <u>RM4001-01</u>	Batch #: <u>89429</u>	Qty: <u>N/A</u>																		
Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>																		
Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>																		
Part #: <u>N/A</u>	Batch #: <u>N/A</u>	Qty: <u>N/A</u>																		
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	474	ACD-1 (i) 12Feb24	YK40 SS44															

Notes:

N/A

N/A

N/A



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(i) PM46 12 Feb 24

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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>PASS</u> 2. <u>PASS</u> 3. <u>PASS</u> 4. <u>PASS</u> 5. <u>PASS</u>	476	0	12Feb24	AL42 TRN DL07 SS52
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

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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:</p> <p>TMI: <u>0700-01</u> Cal Due: <u>31 MAY 2024</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>RM0158-01</u> Batch #: <u>88018</u> Qty: <u>N/A</u></p> <p>Part #: <u>1000-1153-01</u> Batch #: <u>89545</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM4001-01</u> Batch #: <u>89429</u> Qty: <u>N/A</u></p> <p>Part #: <u>RM0607-01</u> Batch #: <u>78849</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	443	H905-1 DIS-4HT11 111 #5WS-11 MAR-4HT 1 BT-11 WK-4HT H905-1 EW-11 DEL-11 FM-11 ③③	12 Feb 2024	DX52 DL07 P146 DY29 PH59 6155
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A





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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	<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>	437	Dis-4H(SPD) (6)	12Feb24	A67
1000	QUALITY1  Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>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>0889D</u> Cal Due: <u>30Sep24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30Sep24</u></p>	423	LT-4H 4H (11) (14)	12Feb24	RJb

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	399	SCR-HFM (TT) DL - II (TT) DIS - III MAR - II MEX - III BP - I KNK - I VD - I DISC - I SKV - I 24	12Feb24	SV43 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): XC31 12FEB24	N/A	N/A	12FEB24	XC31
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	399	○	13 Feb 24	APC0

Notes:

N/A APC0 13 Feb 24

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Batch Number: 0000306363

By: AP10

Date: 13 Feb 24

Reviewed By:

RB29

Date:

13 Feb 24

Notes:

N/A AP10 13 Feb 24

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Batches to 2024 3228 11/6/23
Expiry to 19 Feb 2024 3228 11/6/23
IE

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Extend to 20 May 2023 3228 11/6/23

Requestor Name: Udhesh Kapadnis

DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 2484 STEPS
TS12
24 AUG 23 3228 11/6/23

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Document Number Affected	Revision
3107610	L

Deviation From:
QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050:
Current QIP3107610 does not state to inspect for the correct extrusion configuration.

Deviation To:
This DA allows addition inspection for correct assembly of extrusion material MM0179-01 and MM1536-01 during performing QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050.
See instructions attached to this DA.

Pre-Release Assembly Diagram:

Pre-Release Assembly Diagram

Justification: Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-26390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with out of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid incorrect assembly defects.

Part Number Affected	End Date:	Revision
SA0155-01	25 Aug 2023	H

Start Date:	Lot Number:
26 Jul 2023	N/A

Risk Assessment:
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:
Control Plans Yes No FMEA's 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:
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	

If no, explain: No corrective action is required for this event as there are no changes to the current process, consumption of material, or how the product is produced. This added inspection guidelines are to avoid incorrect extrusion assembly defects.

Training Required: Yes No **If no, explain:**

Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 Jul 2023
Mgr. Manufacturing Engineering	Jake Stanislawski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF

Deviation Authorization

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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.

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)

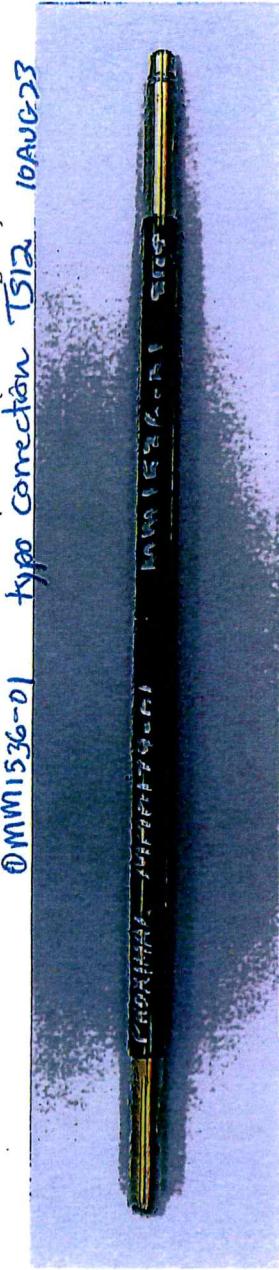


Image- 1

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)

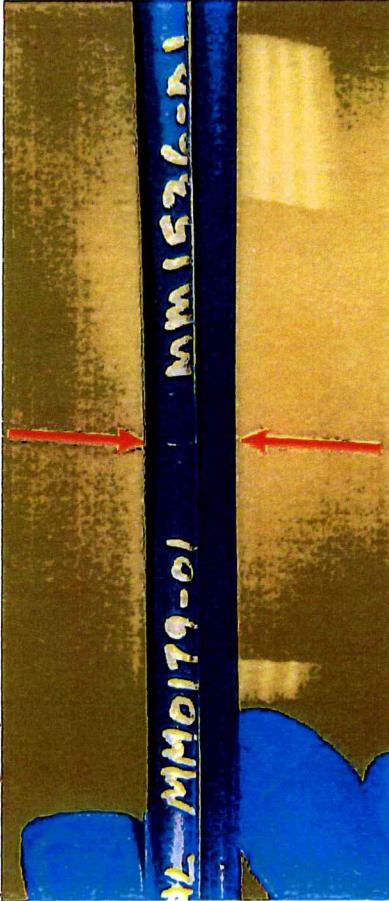


Image- 3

- 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)

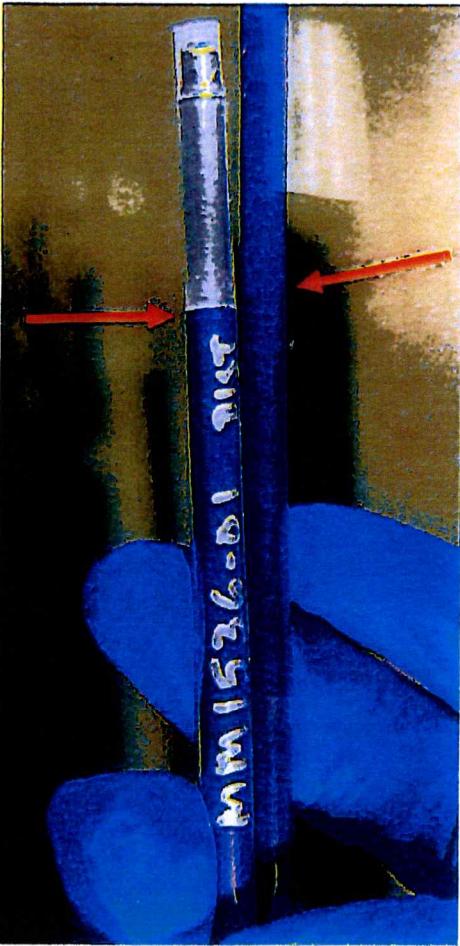


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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

Edited to Hans 3228 12/12/2023
Edited to Hans 3228 13 Feb 2024 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:

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.

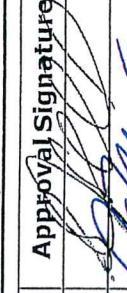
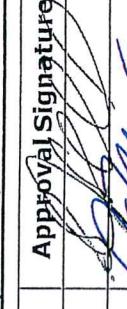
Doc #3005206 (Flex Commander MPI0238):
OPER850.11:

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		
SA0155-01	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 FMEAs <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



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

PRODUCTION ORDER# 500000 306363

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	7:23 AM	430	RL47	11 Feb 24	7:35 AM	415	RL47	11 Feb 24	16
TM10942	44	7:50 am	430	CB58	11 Feb 24	8:02 am	415	CB58	11 Feb 24	16
TM10942	44	8:20am	430	CB58	11 Feb 24	8:32am	415	CB58	11 Feb 24	16
TM10942	44	9:27AM	430	AL67	11 Feb 24	9:39AM	415	AL67	11 Feb 24	16
TM10942	44	9:54 AM	430	AL67	11 Feb 24	10:06 AM	415	AL67	11 Feb 24	16
TM10942	44	10:28AM	430	RL47	11 Feb 24	10:40AM	415	RL47	11 Feb 24	16
TM10942	44	10:53AM	430	SD34	11 Feb 24	11:05AM	415	SD34	11 Feb 24	16
TM10942	44	11:15am	430	CB58	11 Feb 24	11:27am	415	CB58	11 Feb 24	16
TM10942	44	11:40am	430	CB58	11 Feb 24	11:52am	415	CB58	11 Feb 24	16
TM10942	44	12:13pm	430	SN607	11 Feb 24	12:25pm	415	SN607	11 Feb 24	16
TM10942	44	1:32 PM	430	RL6	11 Feb 24	1:44 PM	415	RL6	11 Feb 24	16
TM10942	44	1:56pm	430	SD34	11 Feb 24	2:08pm	415	SD34	11 Feb 24	16

① SN607 + ②
11 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000 306363

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	7:11AM	430	AL67	11 Feb 24	7:23AM	415	AL67	11 Feb 24	16
TM10745	44	7:36AM	430	SNL67	11 Feb 24	7:48AM	415	SNL67	11 Feb 24	16
TM10745	44	8:05am	430	CB58	11 Feb 24	8:17am	415	CB58	11 Feb 24	16
TM10745	44	8:30am	430	CB58	11 Feb 24	8:42am	415	CB58	11 Feb 24	16
TM10745	44	9:02 AM	430	AL67	11 Feb 24	9:34 AM	415	AL67	11 Feb 24	16
TM10745	44	9:46 AM	430	RL47	11 Feb 24	9:58 AM	415	RL47	11 Feb 24	16
TM10745	44	10:12AM	430	SNL67	11 Feb 24	10:24AM	415	SNL67	11 Feb 24	16
TM10745	44	10:38AM	430	SNL67	11 Feb 24	10:58AM	415	SNL67	11 Feb 24	16
TM10745	44	11:20am	430	CB58	11 Feb 24	11:32am	415	CB58	11 Feb 24	16
TM10745	44	11:35am	430	CB58	11 Feb 24	11:47am	415	CB58	11 Feb 24	16
TM10745	44	11:55AM	430	AL67	11 Feb 24	12:07PM	415	AL67	11 Feb 24	16
TM10745	44	12:23PM	430	AL67	12:35 PM	415	AL67	11 Feb 24	16	

① CB58 11 Feb 24

② AL67 11 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000306363

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	1:24 pm	430	RV16	11 Feb 24	1:36 pm	415	RV16	11 Feb 24	16
TM10745	44	1:42 pm	430	SD34	11 Feb 24	1:56 pm	415	SD34	11 Feb 24	16
TM10745	44	2:27 pm	430	PL22	11 Feb 24	2:39 pm	415	PL22	11 Feb 24	16
TM10745	44	3:18 pm	430	SD34	11 Feb 24	3:30 pm	415	SD34	11 Feb 24	14
TM10745	44	4:18 pm	430	cm99	11 Feb 24	4:30 pm	415	cm99	11 Feb 24	4

cm99 11 Feb 24

NSA

PO #: 500000306363OP #: 500 Shift #: 3

Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

Total Parts Reworked:

75

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		19
EW	Exposed Wire		45
MP	Micropores	N/A	N/A
SCR	Scratch		1
SKV	Skive Marks		4
VD	Voids		5
NA	N/A	NA	N/A

Inspected By (Sign and Date):

BI60 11 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.

Data Uploaded for Engineering Review (Check):

① P44613 Feb 24
correction for BI 60



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

PO #: SO0000306363 OP #: 500 Shift #: 3d

Total Parts Reworked:		<u>75</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>1</u>	<u>1</u>
EH	Exposed Hypotube	<u> </u>	<u>15</u>
EW	Exposed Wire	<u> </u> <u> </u>	<u>52</u>
MP	Micropores	<u>N/A</u>	<u>N/A</u>
SCR	Scratch	<u> </u>	<u>3</u>
SKV	Skive Marks	<u> </u>	<u>3</u>
VD	Voids	<u> </u>	<u>4</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>

Inspected By (Sign and Date):

AR02 13 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 #: 500000306363

OP #: 750 Shift #: 3

Total Parts Reworked:		58	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	1HT 1111	9
DIM07 US / WC	DIM07 Undersized (Window Closed)	NA	NA
EH	Exposed Hypotube	1HT 1HT 1HT 11	17
GD	glue damage	1HT 1HT 1HT 1HT 1HT 1HT 11	32
Inspected By (Sign and Date):		BZGO 11 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):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500 000306363 OP #: 750 Shift #: 3

Total Parts Reworked:		43	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		13
DIM07 US / WC	DIM07 Undersized (Window Closed)		12
EH	Exposed Hypotube		15
GD	Glue Damage		3
Inspected By (Sign and Date):		IC83	11FEB24

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):



PO #: 50000306363

OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		76	
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)		8
EH	Exposed Hypotube		10
N/A	Glue - Stopper		53
Inspected By (Sign and Date):		Hv36 12 Feb 24	

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

Data Uploaded for Engineering Review (Check):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000306363

OP #: 900 Shift #: 1st

Total Parts Reworked:		177		
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			27
MP	Micropores			N/A
SCR	Scratch		N/A	142
SKV	Skive Marks			2
VD	Voids			13
DIM01 US	DIM01 OD Undersized		N/A	N/A
DIM06 US	DIM06 OD Undersized			32
DIM06 OS	DIM06 OD Oversized		N/A	N/A
DIM09 US	DIM09 OD Undersized		N/A	N/A
Inspected By (Sign and Date):		P-146, D429, PM 59, V155		12 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	33.35	31.57	34.54	28.73	24.99	33.94	27.96	24.45	29.13	33.59	30.225	3.7213864	4.378	13.9327704	8.542	PASS
Seg B	80.17	77.14	71.38	67.35	79.44	73.62	75.74	74.77	80.28	67.96	74.785	4.7391004	3.981	55.9186415	8.542	PASS
Seg C	88.32	84.48	87.7	88.82	88.15	85.41	78.84	89.72	89.14	79.7	86.028	3.9179297	2.911	74.6229066	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 #: 500000306363

Date: 13FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24



SR.
13 FEB 2024