

# Production Order: 500000307856



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
		Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
50	KITTING3  Kitting Devices  	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>XC31 5:30AM 19FEB24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XC31 9:20AM 21FEB24</u> Record Dryer Shelf #: <u>N/A</u>									
		MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>18FEB24</u>	<u>DKW</u>
		MM1536-01	B <u>B</u>	PC	500	<u>0000290560</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>		

Notes: DA2484, 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	RM0158-01	E	<u>E</u>	PC	200	<u>81054</u>	<u>N/A</u>	<u>200</u>			
		A	<u>A</u>	PC	594	<u>88446</u> <u>88445</u> <u>88444</u>	<u>N/A</u>	<u>200</u> <u>200</u> <u>200</u>			
		A	<u>A</u>	PC	500	<u>000282543</u>	<u>N/A</u>	<u>500</u>			
		A	<u>A</u>	PC	500	<u>000290571</u>	<u>N/A</u>	<u>500</u>			
		E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>			
		J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>			
		J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>MA</u>
						<u>N/A</u>	<u>N/A</u>	<u>Bulk</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	141967-01	02	02	PC	500	86568	505				
	RM7349-02	C	C	PC	543	83334	521				
	RM7348-01	C	C	PC	500	88492	450				
	RM4001-01	B	B	PC	125	82822	200				
	RM0607-01	D	D	PC	56	74662	2152	N/A	N/A	N/A	N/A
	RM0498-01	C	C	PC	500	①5000307856 0000287652 ②00003078 N/A	2191 N/A				
	RM0009-04	I	I	PC	1	88993	Bulk				
	RM0009-04	I	I	PC	1	88993	Bulk				

### Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
N/A  N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000290562</u>	<u>Bulk</u>	<u>500</u>			
	MM1537-01	A	<u>A</u>	PC	1000	<u>0000294701</u>	<u>N/A</u>	<u>1,060</u>			
	MM0177-01	C	<u>C</u>	PC	500	<u>0000294697</u>	<u>N/A</u>	<u>5500</u>			
	MM0180-01	E	<u>E</u>	PC	500	<u>0000294374</u>	<u>N/A</u>	<u>400</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
	MM0178-01	E	<u>E</u>	PC	500	<u>0000287501</u>	<u>N/A</u>	<u>100</u>			
	MM0176-01	D	<u>D</u>	PC	500	<u>0000288413</u>	<u>N/A</u>	<u>500</u>			
	MM0074-01	G	<u>G</u>	PC	500	<u>0000306625</u>	<u>N/A</u>	<u>519</u>			
							<u>N/A</u>	<u>N/A</u>			

### Notes:

N/A

N/A

N/A

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**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MA	MA	MA	MA	MA	MA	MA
100	CATASY01  Catheter Assembly 1  	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	22 Feb 24	V078
150	CATASY01  Catheter Assembly 1    Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	22 Feb 24	V078 AS31 JY90 PM 96

**Notes:**

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**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone )	MIA	MIA	MIA	MIA	MIA
200	CATASY01  Catheter Assembly 1  	Loading Braid Stock	500	0	22 Feb 2024	CLOS Y014
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	22 Feb 2024	ST96 DX35
<b>Notes:</b>		MIA				
		MIA				
		MIA				

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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 )		MA	MA	N/A	N/A
300	CATASY01  Catheter Assembly 1    Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	Insert Cut Hypo Tube	500	0	22 Feb 24	SHZ3 GS22
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	22 Feb 24	CP32 SY47

**Notes:**

MA  
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N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Load Tubing Confirmation Rreqd(Milestone )		MA	MA	MA	MA
400	<b>CATASY01</b> Catheter Assembly 1  Reflow Confirmation Rreqd(Milestone )	Reflow	500	0	22 Feb 2024	SH85 SX60 PM96
450	<b>CATASY01</b> Catheter	FEP Removal	100	0	22 Feb 2024	JY90 PM96
<b>Notes:</b>						
MA						
MA						
MA						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Cty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1  FEP Removal  Confirmation Reqd(Milestone )		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 #: 1000-1153-01 Batch #: 88445 Qty: 10 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 Part #: N/A Batch #: N/A Qty: N/A	493	EW-LH1 DF-1 ⑦	V291 P60 LL61 VC09 CB81	
			N/A	N/A	N/A	N/A
			N/A	N/A	N/A	N/A
			N/A	N/A	N/A	N/A
			N/A	N/A	N/A	N/A

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**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01  Catheter Assembly 1    Remove Heat Shrink & Mandrel  Confirmation Reqd(Milestone )	Remove Heat Shrink & Mandrel	480	MAH-14T1 DL-14T1 (13)	22 Feb 24	SR46 ML78 AX82 PH59 RS23
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Confirmation	Distal Tip Assembly	480	0	22 Feb 24	PP40 ML60 AX82 PH59 DM29

Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
NP	Reqd(Milestone )	MA	MA	MA	MA	MA
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink	480	0 22 Feb 24	AT39 4X82 DY29	
700	CATASY01  Catheter Assembly 1    Tipping	Tipping Record Tipping Oven Information: TMI: 0386 Cal Due: 31 May 24 TMI: 0521 Cal Due: 31 May 24 TMI: 2083C Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	480	0 22 Feb 24	AT39 STX48 Hv36	

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials																													
	Confirmation Reqd(Milestone )		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 #:</td> <td>204001-01</td> <td>Batch #:</td> <td>82822</td> <td>Qty:</td> <td>10</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> <tr> <td>Part #:</td> <td>N/A</td> <td>Batch #:</td> <td>N/A</td> <td>Qty:</td> <td>N/A</td> </tr> </table> <p>Tip Inspection/ Flash Removal</p> <p>Confirmation Reqd(Milestone )</p>	Part #:	204001-01	Batch #:	82822	Qty:	10	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	Part #:	N/A	Batch #:	N/A	Qty:	N/A	473	EH-111 #705-111 22 Feb 2024 (1)	M662 STX48 Hv36
Part #:	204001-01	Batch #:	82822	Qty:	10																														
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																														
Part #:	N/A	Batch #:	N/A	Qty:	N/A																														
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	461	ACD-11111 11 (12)	22 Feb 2024 KT26 SSHH SS52																														

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
	Major Mandrel Removal  MA Confirmation Reqd(Milestone )		MA	MA MS	MA	MA
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. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	461	0	22 Feb 2024	SS52
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	MA	MA	MA	MA
Notes:		MA MA MA				

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MPT	Quality Inspection & Review  Confirmation Reqd(Milestone )	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31 May 24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>Pn4001-01</u> Batch #: <u>82882</u> Qty: <u>18</u> Part #: <u>COD-1152-01</u> Batch #: <u>888446</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>   <u>(1) P22 P446 22 Feb 24</u> </p>	H36	#10s-1 SKU-11 ACD-1 Dis-4H111 Fm-11 EH-11 #5us-1 #70s-1 #60s-1 WK-1 EW-1111 DV-1 (25)	22 Feb 24	K156 TRN M428 P446
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>50713B</u> Cal Due: <u>12 APR 25</u> Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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Cpr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review   Confirmation Reqd(Milestone )	TMI: <u>0733</u> Cal Due: <u>30 APR 24</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 25</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	427	ST12-1111 DIS-444(SP) ①	22 Feb 24	K155
1000	 Quality Inspection & Review   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 24</u> Record Length Gage Information: TMI: <u>0889D</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u>	423	L7-1111 ③④	22 Feb 24	KT47

Notes:

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Cty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	<b>QUALITY1</b> Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone ) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	393	• EW-HH • TL-III • VD-III • DIS-III • FM-I • AB-1 • PBC-1 • GNII-1 • SCR-II (IT) • DL-HH III (IT)	22 Feb 24 (30)	SV43 XN26
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>An 68 23 Feb 24</u>		N/A	N/A	N/A

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	393	0	23 Feb 2024 AB10	

Notes:

N/A AB10 23 Feb 2024)

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Batch Number: 0000307856

By: ABW

Date: 23 Feb 24

Reviewed By:

RB29

Date:

23 Feb 24

Notes:

N/A ABW 23 Feb 24

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CREGANNA  
MEDICAL

**ANNA MEDICAL** is part of **TECHNICON**

### EXTEND TO SENSES -

Requestor Name: Udhesh Kanadnis  
Fees to ~~2000~~ 3200 ~~1/17/2023~~

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DEVIATION AUTHORIZATION NUMBER: 2484

**ZATION FORM** Efend to 23 Oct 2023  
See attached email extension to 24 SEP 2023  
T512  
24 AUG 23  
T523  
21 SEP 2023

CONTROLLED COPY

DEVIATION FORM Effective to 23 OCT 2023  
\*See attached email extension to 24 SEP 2023  
152  
24 AUG 23

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

### Deviation From:

QIP3107610, Section 8.0 Inspection Requirements  
(Supplemental Visual Inspection) OP 1050:  
Current QIP3107610 does not state to inspect for

*Caution*: The extrusion configuration shown in Figure 12-12 does not state to inspect for the correct extrusion configuration.

Requirements (Supplemental Visual Inspection) OP 1050.  
See instructions attached to this DA Form.

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This technical drawing illustrates a dental instrument assembly, specifically a Peri-Rootline Aspirator, Dissector, and Elevator. The drawing shows a central vertical shaft with various colored segments and associated dimensions:

- DISTAL:** A blue segment at the bottom.
- HYPOTUBE:** A white segment above the distal, labeled with dimension  $0.045^{\circ} \pm 0.003^{\circ}$ .
- MIDDLE:** A yellow segment above the hypotube, labeled with dimension  $0.160^{\circ} \pm 0.030^{\circ}$ .
- BUCKLE:** A white segment above the middle, labeled with dimension  $0.160^{\circ} \pm 0.030^{\circ}$ .
- BUCKLE:** A blue segment above the buckle, labeled with dimension  $0.160^{\circ} \pm 0.030^{\circ}$ .
- BUCKLE:** A white segment above the second buckle, labeled with dimension  $0.160^{\circ} \pm 0.030^{\circ}$ .
- PROXIMAL:** A blue segment at the top.

Dimensions are indicated by horizontal lines extending from the shaft to specific points on the drawing, such as  $0.045^{\circ} \pm 0.003^{\circ}$ ,  $0.160^{\circ} \pm 0.030^{\circ}$ , and  $0.210^{\circ} \pm 0.030^{\circ}$ . Part numbers are also present, including FEP-FRM0352-01 or 1000-115-01, MM00074-01, MMD0074-01, 63D, MM0178-01, 35D, MM0177-01, 141967-01, Hypotube, MM0176-01, 35D, MM0175-01, 25D, MM0174-01, RNP-F100, RM0176-01, MM0175-01, 35D, MM0177-01, 35D, MM0178-01, 63D, MM0179-01, RNP-F100, RM0180-01, Visetamid, 1000-2053-01, RNP-F100, RM0185-01, and RNP-F100.

**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

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

Dick Acaucca - 1

**KIWI ASSESSMENT**  
Is there a gap between what you expect and what you get?

Control Plans  Details (if any): N/A

If yes to any of the above what controls are being used:

卷之三

**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 data.

Ergonomics in Design 2000

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, Rev F

Deviation Authorization

**CONTROLLED COPY**

① UK55, 23JW 2023



is part of

TE	DA	2484
①		

## Group Training Record

### 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)  
① MM01536-01 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)

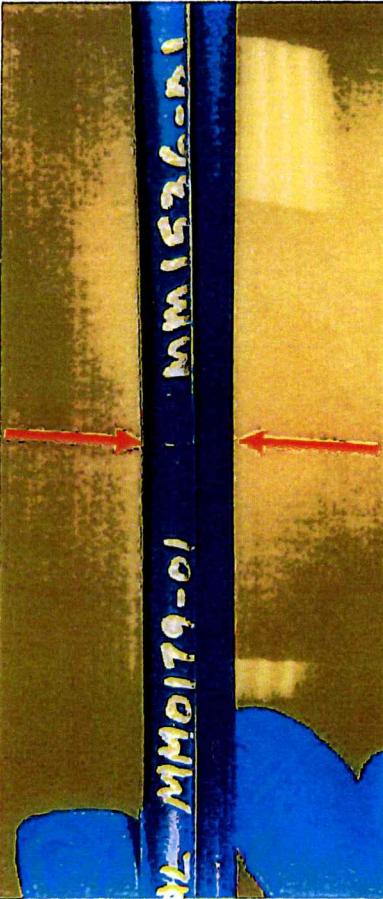


Image- 3

- 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.

## **CONTROLLED COPY**

### **Step 2:**

- Visually verify the MM1536-01 distal end of the fixture is approximately at the same location on the completed part. (See Image 4)

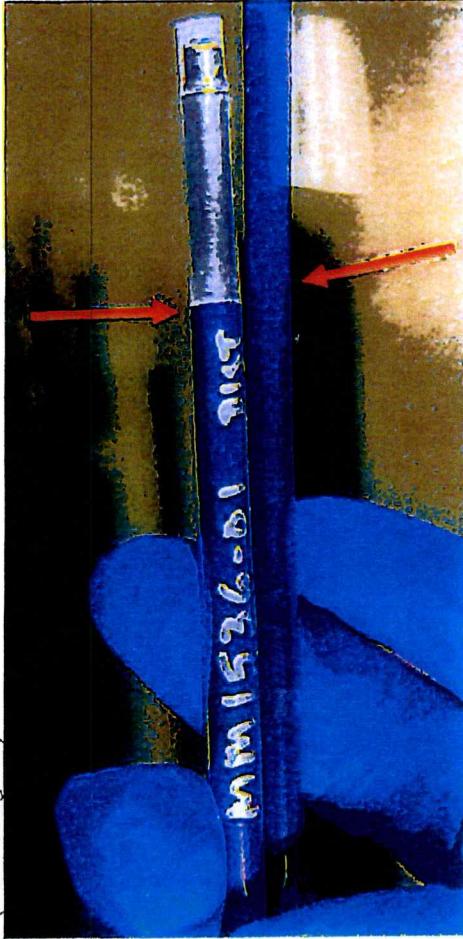


Image- 4

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

- If the part transition is aligned, the part passes inspection.

- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

<b>1</b>	MM0179-01 <b>GOOD PART</b>	MM1536-01
<b>2</b>	MM1536-01	MM0179-01 <b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>
<b>3</b>	MM0179-01 <b>Two MM0179-01 - BAD PART</b>	MM0179-01
<b>4</b>	MM1536-01 <b>Two MM1536-01 - BAD PART</b>	MM1536-01

Image - 5



Entered to MIM064 T228 11/1/2023  
 Entered to 13 February 2023 1/4/2024  
 DEVIATION AUTHORIZATION NUMBER: DA2564.  
 Entered to MIM064 T228 11/1/2023

## DEVIATION AUTHORIZATION FORM

<b>Requestor Name:</b> Krishna Selvaraj			
<b>Document Number Affected</b>	<b>Revision</b>		
Doc #3005206 (MPI0238)	BP		
<b>Deviation From:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b> Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.		<b>Deviation To:</b> <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b> Using a laser micrometer at <b>OPER900 (TMI0700-01)</b> , check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.	

**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.

<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b> Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No <b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> N/A			
<b>Title</b>	<b>Approval Name</b>	<b>Approval Signature</b>	<b>Date</b>
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#: 500000307856

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	9:59PM	429	SH85	21Feb24	10:11pm	415	SH85	21Feb24	16
Tm10745	44	10:42pm	430	SH85	21Feb24	10:54pm	415	SH85	21Feb24	16
Tm10745	44	11:55pm	430	SX60	21Feb24	12:07AM	415	SX60	22Feb24	16
Tm10745	44	12:23AM	429	Sy47	22Feb24	12:35AM	415	Sy47	22Feb24	16
Tm10745	44	12:51AM	429	SX60	22Feb24	1:03AM	415	Sy47	22Feb24	16
Tm10745	44	1:19AM	429	SX60	22Feb24	1:31AM	415	SX60	22Feb24	16
Tm10745	44	1:46AM	429	SX60	22Feb24	1:58AM	415	SX60	22Feb24	16
Tm10745	44	5:10AM	430	NK62	22Feb24	5:22AM	415	NK62	22Feb24	14
Tm10745	44	5:40AM	430	NK62	22Feb24	5:52AM	415	NK62	22Feb24	16
Tm10745	44	6:15AM	429	NK62	22Feb24	6:27AM	415	NK62	22Feb24	16
Tm10745	44	7:00AM	430	OS21	22Feb24	7:12AM	415	OS21	22Feb24	16
Tm10745	44	7:40am	430	AX05	22Feb24	7:52am	415	AX05	22Feb24	16



Document No: 5105589  
FM15104665 Rev: C  
Document Type: Manufacturing Form  
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000030785

OP 400



PRODUCTION ORDER# 500000307856

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	10:23pm	430	SH85	21 Feb 24	10:35pm	415	SH85	21 Feb 24	16
Tm10942	44	10:57pm	429	SH85	21 Feb 24	11:09pm	415	SX60	21 Feb 24	16
Tm10942	44	11:40pm	430	SX60	21 Feb 24	11:52pm	415	SX60	21 Feb 24	16
Tm10942	44	12:11am	429	SX60	22 Feb 24	12:23am	415	SY47	22 Feb 24	16
Tm10942	44	12:37am	428	SY47	22 Feb 24	12:49am	415	SY47	22 Feb 24	16
Tm10942	44	1:02am	430	SY47	22 Feb 24	1:14am	415	SY47	22 Feb 24	16
<del>N/A</del>	<del>44</del>	<del>1:16am</del>	<del>429</del>	<del>SX60</del>	<del>22 Feb 24</del>	<del>N/A</del>	<del>N/A</del>	<del>N/A</del>	<del>N/A</del>	<del>N/A</del>
Tm10942	44	1:31am	429	SY47	22 Feb 24	1:43am	415	SY47	22 Feb 24	16
Tm10942	44	1:59am	429	SX60	22 Feb 24	2:11am	415	V078	22 Feb 24	16
Tm10942	44	5:23am	430	NK62	22 Feb 24	5:35am	415	NK62	22 Feb 24	16
Tm10942	44	6:00am	429	NK62	22 Feb 24	6:12am	415	NK62	22 Feb 24	16
Tm10942	44	6:30am	430	OS21	22 Feb 24	6:42am	415	OS21	22 Feb 24	16

① SX60 22 Feb 24



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

**PRODUCTION ORDER#:** 500000307856

OP 400



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

PO #: 50000307856 OP #: 500 Shift #: 2

Total Parts Reworked:		12	
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		10
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	/	1
VD	Voids	/	1
N/A	N/A	N/A	0

**Inspected By (Sign and Date):** *[Signature]* 21 Feb 24

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

**Data Uploaded for Engineering Review (Check):**



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

PO #: 50000307856 OP #: 500 Shift #: 2nd

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	//	2
EH	Exposed Hypotube	n/a	n/a
EW	Exposed Wire		7
MP	Micropores	n/a	n/a
SCR	Scratch	n/a	n/a
SKV	Skive Marks	//	2
VD	Voids		4
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Vannegi Lor 21 Feb 24	

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

Data Uploaded for Engineering Review (Check):



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

PO #: 500000307856 OP #: 500 Shift #: 1<sup>ST</sup>

Total Parts Reworked:		120	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		30
EW	Exposed Wire		77
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		1
VD	Voids		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		VC09, LL61, CB81	22 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):



PO #: 500000307856

OP #: 750 Shift #: 2<sup>nd</sup>

Document No: 6102646  
Rev: A  
Document Type: Manufacturing Form  
Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		13	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	///	3
DIM07 US / WC	DIM07 Undersized (Window Closed)	///	5
EH	Exposed Hypotube	///	5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mm02	21Feb24

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 #: 500000307856OP #: 750 Shift #: 1st

Document No: 6102646  
Rev: A  
Document Type: Manufacturing Form  
Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		89	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		17
DIM07 US / WC	DIM07 Undersized (Window Closed)		28
EH	Exposed Hypotube		12
N/A	Glue - stopper		32
Inspected By (Sign and Date):		STX 48	22 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):

PRODUCTION ORDER# 500000307856

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm12036	N/A	1:30AM	190°F	KT26	22Feb24	2:40 AM	190°F	AT39	22Feb24	34
Tm10409	N/A	5:30am	190°F	k155	22Feb24	6:40am	190°F	k155	22Feb24	55
Tm12036	N/A	6:00 am	190°F	k155	22Feb24	7:10am	190°F	k155	22Feb24	34
Tm10409	N/A	6:50 am	190°F	k155	22Feb24	8:00am	190°F	k155	22Feb24	35
Tm12036	N/A	7:40am	190°F	SS44	22Feb24	8:50am	190°F	SS44	22Feb24	32
Tm10409	N/A	8:10am	190°F	k155	22Feb24	9:20am	190°F	k155	22Feb24	32
Tm12036	N/A	9:00 am	190°F	k155	22Feb24	10:10 am	190°F	k155	22Feb24	36
Tm10409	N/A	9:25 am	190°F	k155	22Feb24	10:35 am	190°F	k155	22Feb24	30
Tm12036	N/A	10:05am	190°F	SS44	22Feb24	11:15am	190°F	SS44	22Feb24	49
Tm10409	N/A	11:15am	190°F	k155	22Feb24	12:25pm	190°F	k155	22Feb24	37
Tm12036	N/A	12:00pm	190°F	k155	22Feb24	1:10PM	190°F	k155	22Feb24	2737
Tm10409	N/A	12:30pm	190°F	k155	22Feb24	1:40 PM	190°F	k155	22Feb24	50
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① k155 22 Feb 24



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

PO #: 500000307856 OP #: 900 Shift #: 1ST

Total Parts Reworked:		86	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	1	1
EH	Exposed Hypotube		3
EW	Exposed Wire		26
MP	Micropores	N/A	N/A
SCR	Scratch		42
SKV	Skive Marks		4
VD	Voids		12
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		6155 KT 47	22 Fe 624

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	33.05	31.05	29.13	32.57	30.16	28.27	30.24	28.26	28.36	32.63	30.372	1.8883608	4.378	22.1047562	8.542	PASS
Seg B	68.65	82.44	81.22	70.87	71.94	68.13	68.54	68.75	76.32	80.86	73.772	5.8668386	3.981	50.4161154	8.542	PASS
Seg C	90.56	89.93	88.19	85.01	90.22	80.18	90.76	79.54	78.84	89.58	86.281	4.9595821	2.911	71.8436566	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 #: 500000307856

Date: 23FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24



23 FEB 2024