

# Production Order: 500000066206



Production Order Document  
Production Order Qty: 500  
PC  
Sheet: 1 of 1

## Material: SA0254-06 Rev G

Material Type: ZFRT      Description: Printed Shaft 144C Prox End Color  
Production Version: 8000      B CMDR  
Plant / Business Unit: 1213 / AC5

Order Type: ZSTD

Project Phase:

Opn No.	Planned WorkCenter Description	Operation Details			
		Comp. Qty.	Scrap Qty & Desc.	Date Comp	Initials
50	CATASY04 Catheter Assembly 4	500	0	12 Jan 21	LY
	Count: Yes				
	By: LY	Date: 12 Jan 21			
	Prepare Materials				
	Confirmation Rqrd(Milestone )				N/A
100	CATASY04 Catheter	Straighten First Jacket	MP10398 Rev. Y		

Notes: DA: 1738, DATA 1787 DA 1787

DA#

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22 Feb 21 CL

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SA0254-06

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Material: SA0254-06 Rev G



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### Notes:

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A standard linear barcode is positioned vertically on the left side of the page. To its right, the number '600254 06' is printed vertically, corresponding to the barcode's data.

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14 TANZIL

CU 14 Jan 21

## Operation Details

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initials
		Qty.	UOM	Qty.	UOM	Qty.	UOM				
200	CATASY04 Catheter Assembly 4 	Strain Relief Reflow MPI0398 Rev. <u>1A</u> Temp = 420°F 5°F Air Flow = 60 SCFH  Strain Relief Reflow Confirmation Rreq(Milestone )	N/A	N/A	N/A	N/A	N/A	500	0	13Jan21	AY
250	CATASY04 Catheter Assembly 4 	Position Tubing For Reflow MPI0398 Rev. <u>1A</u>	500	0	500	PC	500	0000058674	500	13Jan21	SC BK SR

**Notes:**

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Material: SA0254-06 Rev G

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Opn No.	Planned Work Center Description	Operation Details						Comp. Qty. Qty.	Scrap & Desc.	Date Comp.	Initials
		Number	Rev	Used	No.	Qty Used					
	Position Tubing for Reflow	MM0186-00	D	<u>D</u>	PC	500	<u>P08 - 061101</u>	<u>500</u>			
		MM0523-03	C	<u>C</u>	PC	500	<u>0000059871</u>	<u>500</u>			
		MM0524-01	B	<u>B</u>	PC	500	<u>0000058676</u>	<u>500</u>			
		MM0530-01	B	<u>B</u>	PC	500	<u>0000059060</u>	<u>500</u>			
		RM7586-02	D	<u>D</u>	PC	500	<u>25469</u>	<u>2500</u>			
		RM8745-01	B	<u>B</u>	PC	500	<u>25632</u>	<u>250</u>			
		MM0185-01	I	<u>I</u>	PC	500	<u>0000061042</u>	<u>500</u>			

Notes:

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CV 13 Jan 21

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Opn No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		Opn No.	WorkCenter	Tool	PC	Qty	Opn No.				
	MM1540-01 A	A	△	PC	500	00000600069	500				
	MM1539-01 A	A	△	PC	500	0000061041	500				
	RM016101-MED	F	△	PC	46	26089	160				
300	CATASY04 Catheter Assembly 4	Reflow	MPI0398 Rev. △					500	0	13Jan21	KS VNT
		Temp = 415°F (+/- 15 °F)									
		Speed = 4.5 in/min (+/- 0.5 in/min)									
		Reflow									
350	CATASY04 Catheter Assembly 4	Skive Heat Shrink	MPI0398 Rev. △					500	0	13Jan21	PMY
		Notes:									

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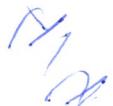
14Jan21 CL

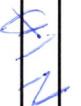
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Opn No.	Planned Work Center Description	Operation Details			
		Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initials
400	CATASY04  Skive Heat Shrink 	4 89	6 EW 4 Disc 1 DF	13 Jan 21	Puy
450	CATASY04  Catheter Assembly 4 Count: Yes  FM5104693 In Process Inspection 	4 380 109	0 0	13 Jan 21 14 Jan 21	Puy YK

Notes:



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Puy 13 Jan 21

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Opr No.	Planned WorkCenter Description	Operation Details			Date Comp.	Initials
		Comp. Qty	Scrap Qty & Desc.	Day:		
500	CATASY04 Catheter Assembly 4 	Leak Test/Prox Cut/Ring Gage-Dim 13/21 MPI0398 Rev. <u>U</u> FM5104694 FM5104695  (Rework if needed - Use FM5104983)	257 220	8 Fail 300 Fail 400	13 Jan 21 14 Jan 21	NYL XX NT
550	CATASY04 Catheter Assembly 4 	Distal Cut MPI0398 Rev. <u>U</u> Line Closure MPI0230 Rev. <u>E</u> By: <u>NT</u> Date: <u>14 Jan 21</u>	257 220	0 0	13 Jan 21 14 Jan 21	NYL NT
600	PADPRIN1 Pad Print Count: Yes 	Pad Print Set Up MPI0276 Rev. <u>D</u> Line Clearance MPI0230 Rev. <u>E</u>	277 477	0	14 Jan 21	KUT

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Opn No.	Planned Work Center Description	Operation Details		
Opn No.	Planned Work Center Description	Comp. Qty	Scrap Qty & Desc.	Date Comp.
Pad Print Setup	By: <u>KUT</u> Date: <u>14 Jan 21</u>	<p>TM10503 (circle TM1 used) <u>TM10735</u> Cliché - TL0525 Cliché - TL0567 Ink # RM7407-01 Ink - RM7407-01 Thinner - RM7408-01 Thinner - RM7408-01 Hardener - RM7409-01 Hardener - RM7409-01 Customized Measuring Equipment - Caliper Inspection Gauge TM10843 Setup Rod # TL0815 Program - #10 Ink Viscosity (REF) -5 to 6 Pad - TL0545 or equivalent Fence - TL0538 Drying Oven - TM10643 Drying Racks-TL0531, TL0532</p> <p>N/A</p>		

Notes:	<u>N/A</u>

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Op. No.	Planned WorkCenter Description	Operation Details					
		Comp. Qty	Scrap Qty & Desc.	Date Comp.	UnitRate	Unit Rate	Unit Rate
650	PADPRIN1 Pad Print 	Verification MPI0276 Rev. D Section 15.0		477	O	1470m21	1470m21
		Verification					
		Component Number	Req'd Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
RM7407-01	B	B	L	0.050	TP25658	0.040	N/A
		Notes:					

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Opr No.	Planned Work Center Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		B	B	L	0.005	TP55374	0.005				
	RM7408-01										
	RM7409-01										
700	PADPRIN1 Pad Print	Prepare Surface for Ink MPI0276 Rev. <u>D</u> Section 15.5 Polynit wipes 99% IPA					477	0	14Jan21	KWJ	
750	PADPRIN1 Pad Print	Print Parts MPI0276 Rev. <u>D</u> Section 20.0 Inspection gauge TM10843					477	0	14Jan21	KWJ	

Notes:	N/A
	210

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Opn No.	Planned WorkCenter Description		Operation Details			
			Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initiator
800	PADPRIN1 Pad Print 	In-Process Inspection and Rework MPI0276 Rev. D Section 30.0 Polynit Wipes 99% IPA Mag Light  In-process Inspection and Rework	477	0	14Jan21	KUT
850	PADPRIN1 Pad Print 	Curing Oven MPI0340 Rev. B Section 35.0  Curing Oven for 120 +30/-15 minutes Parts sit for 8 hours minimum after curing oven  Curing Oven Confirmation Reqd(Milestone )	477	0	14Jan21	KUT
900	PADPRIN1 Pad Print 	Transfer Parts to Production MPI0276 Rev. D Section 40.0				
		Notes:				

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Opn No.	Planned WorkCenter Description	Operation Details				
		Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initiator	
	Transfer Parts to Line				KUT	
	Time: <u>11:30pm</u> By: <u>KUT</u> Date: <u>15 Jan 21</u>	477	0	15Jan21	KUT	
Transfer parts to Production	Confirmation Rreqd(Milestone)					
950	PADPRIN1	Cleaning MPI0276 Rev. <u>D</u> Section 50.0				
	Pad Print					
	Count: Yes					
		Line Clearance MPI0230 Rev. <u>B</u>				
	Cleaning					
	Confirmation Rreqd(Milestone)					
1000	CATASY04	In-Process Dimensional Inspection			NIA	

Notes:	<u>✓/A</u>
	<u>D/A</u>

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## Material: SA0254-06 Rev G

Opn No.	Planned WorkCenter Description	Operation Details					
		Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initiates		
Catheter Assembly 4	MPI0398 Rev. <u>11</u> FM5104662 FM5104696	474	30P Fail	23Jan21	CKY PNT N-1		
In-Process Dimensional Inspection	(No Rework can be done at this OP)  Line Closure MPI0230 Rev. <u>E</u>  By: <u>Ping</u> Date: <u>23 Jan 21</u>				#1809-52 PRT - 33 TT - 10 SCR - 4 CEN - 3 VD - 1 FM - 1	370	20Feb21 AP
1050	QUALITY1						
	Quality Inspection & Review						
	Quality Inspection & Review						
	Confirmation Req'd(Milestone )						
	Notes:						

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Production Order: 500000066206

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A standard linear barcode consisting of vertical black bars of varying widths on a white background.

AA0254-06  
AP20FEb21



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Opn No.	Planned WorkCenter Description	Operation Details					
		Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials	Comments	
	Confirmation Rreqd(Milestone )				MM		
1100	PACKINT1	Packing Instructions SPI0087 REV. H			310	0	

Notes:	NA

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Production Order Qty: 500  
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Sheet: 1 of 1

**Material:** SA0254-06 Rev G

Batch Number:	0000066206
By:	YT
Date:	23 Feb 21

Reviewed By:	<i>Murder</i>
Date:	23 Feb 21

Notes:	<i>N/A</i>

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PRODUCTION ORDER# 5000066206

## OPER 400.0

### In-Process Inspection

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/ Date
Using a magnification light, visually inspect the entire length of the shafts.	N/A	100%	2.85x Mag. Light	500	0	0	PNY 13 Jan 2021
Metallic Foreign Material: No embedded metallic and foreign material is allowed along the length of the shaft.	N/A	100%	2.85x Mag. Light	500	0	0	
All other Foreign Material:			Tappi Chart and 2.85x Mag. Light	496	4		
Particle Size Area: mm <sup>2</sup>	Acceptable Limits per Part	See Table					
< 0.05 mm <sup>2</sup>	No Limit						
0.05 mm <sup>2</sup> ≤ Area < 0.25 mm <sup>2</sup>	3						
0.25 mm <sup>2</sup> ≤ Area < 0.80 mm <sup>2</sup>	2						
0.80 mm <sup>2</sup> ≤ Area ≤ 1.5 mm <sup>2</sup>	1						
> 1.5 mm <sup>2</sup>	0						
No surface damage to the shafts such as voids pits or cuts. (interior surface of distal end not included)	N/A	100%	2.85x Mag. Light	496	0	0	
No bumps, lumps, or protrusions along the shaft that will compromise the OD. Verify all protrusions to make sure the OD is still within specification.	N/A	100%	2.85x Mag. Light	496	0	0	
No flat spots, kinks, delamination, gaps between material transitions and material transitions should not exhibit cracking, no exposed or apparent braid.	N/A	100%	2.85x Mag. Light	489	7	7	
Verify all ODs along the entire length of shaft are within specification according to print/drawing requirements.	See QA Inspection Requirement	100%	See QA Inspection Equipment	489	0	0	PNY 13 Jan 2021

PNY 13 Jan 2021



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Document No: FM5104983  
Rev: B  
Document Type: Manufacturing Form  
Title: SA0254 Cause of Rework Form

PRODUCTION ORDER# 15000000-66206

## **Attachment B: Cause of Rework.**

OPER 400.0

Date	Initial	AB (Prox)	AB (Distal)	DF	DS	EW	FM	Disc	SCR	SKV	VD
13 Jan 21	pny	o	8	o	o	o	2 2	o	o	o	o

## **Attachment B: Cause of Rework**

OPER 500-0

Date	Initial	Dim 13 (Go Gauge)	Dim 21 (Go gauge)
14 Jan 21	VC	0	56 N/A



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Document No: FM5104692

Rev: B

Rev. E Document Type: Manufacturing Form  
Title: SA0254 Annealing Oven Log Form

PRODUCTION ORDER# 50000066206

OPER 450.0

## Annealing Log Sheet



PRODUCTION ORDER# 500000066906

**OPER 500.0**

**▲13 & ▲21 Max OD Gauge Check for the manufacturing lot PRIOR TO AND AFTER Inspection**

Before & After Inspecting Parts	Dimension ## Gauge Check  (Ex. TMI###XX TMI0748AC or TMI0747AD)	Initials	Date	Time
Before	Dimension 13	TMI 0748AN MW	13 Jan 21	10:05 pm
Before	Dimension 21	TMI 0747A MW	13 Jan 21	10:05 pm
After	Dimension 13	TMI 0748 AN CL	14 Jan 21	2:00 pm
After	Dimension 21	TMI 0747 U CL	14 Jan 21	2:00 pm

PRODUCTION ORDER# 4420450000066206

22 Feb 21 CL

**OPER 500.0**

**Pressure Decay Testing**

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
<b>Air Leak Test GN 15</b>	N/A	100%	Issac Pressure Decay Tester	TMI 0797B	489	0	NT 14 Jan 21
<b>Outer Diameter ▲ 13 MAX OD at Pad Printed Area</b>	0.145" +0.002"/- 0.004" (≤0.147")	100%	Ring Gauge TM10748 or equivalent	TMI 0748AN	477	12	NT 14 Jan 21
<b>Outer Diameter ▲ 21 MAX OD</b> Drop Go Gauge from proximal end of shaft. Pass if ring stops at stop sleeve shoulder. Fail if gauge stops above or falls past stop sleeve shoulder.	0.157" ± 0.003" (≤0.160")	100%	Ring Gauge TM10747 or equivalent	TMI 0747U	477	0	NT 14 Jan 21

22 Feb 21 CL

PRODUCTION ORDER# 442045cccc662c6

**OP 1000.0 ▲ 13, ▲ 21 Max OD Gauge Check for the manufacturing lot PRIOR TO AND AFTER Inspection**

Before & After Inspecting Parts	Dimension ## Gauge Check	TMI###XX (Ex. TMI0748AC or TMI0747AD)	Initials	Date	Time
Before	Dimension 13				
		TMI 0746 AM	CL	21 Jan 21	6:20 AM
Before	Dimension 21				
		TMI 0747 TR	CL	21 Jan 21	6:20 AM
After	Dimension 13	TMI 0748 AM	CL	21 Jan 21	6:20 AM
After	Dimension 21	TMI 0747 TR	CL	21 Jan 21	8:40 AM

PRODUCTION ORDER# OP 1000.0 22 Feb 21 CL

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
<b>Outer Diameter ▲13 MAX OD at Pad Printed Area</b>	0.145" +0.002"/-0.004" (≤0.147")	100%	Ring Gauge TMI0748 or equivalent	TMI / 0748 #1	474	3	Cky 21 Jan 21
<b>Outer Diameter ▲21 MAX OD</b>	0.157" ± 0.003" (≤0.160")	100%	Ring Gauge TMI0747 or equivalent	TMI / 0747 T	474	0	Cky 21 Jan 21
<b>Outer Diameter ▲22 MAX OD</b>	0.142" ± 0.002" (0.140"-0.144")	100%	Ring Gauges TMI0967, or equivalent	TMI / 0967	474	0	Cky 21 Jan 21
<b>Outer Diameter ▲2 MIN OD</b>	0.142" ± 0.002" (0.140"-0.144")	100%	Ring Gauges TMI0968, or equivalent	TMI / 0968	474	0	Cky 21 Jan 21
<b>Outer Diameter ▲8 MAX OD</b>	0.140" ± 0.002" (0.138"-0.142")	100%	Two Axis Laser Micrometer	TMI / 50049	474	0	Pay 23 Jan 21
<b>Outer Diameter ▲8 MIN OD</b>	0.140" ± 0.002" (0.138"-0.142")	100%	Two Axis Laser Micrometer	TMI / 50049	474	0	Pay 23 Jan 21

PRODUCTION ORDER# 1042050006626  
22-Feb-21 CL

Document No: FM5104696

Rev: B

Document Type: Manufacturing Form

Title: SA0254 In-Process Inspection Form

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
<b>Outer Diameter ▲13 AVG OD at Pad Printed Area</b>  Measure from distal end of material transition to stop sleeve shoulder  <b>NOTE:</b> Measure AVG OD and record results	0.145 +0.002"/-0.004" (0.141"-0.147")  100%	Two Axis Laser Micrometer	TM1 50049	474	0		PNY 23Jan21
<b>Outer Diameter ▲21 AVG OD</b>  Measure from stop sleeve shoulder to 4" distal of stop sleeve shoulder.  <b>NOTE:</b> Measure AVG OD and record results	0.157" ± 0.003" (0.154"-0.160")  100%	Two Axis Laser Micrometer	TM1 50049	474	0		PNY 23Jan21
<b>Outer Diameter ▲17 AVG OD</b>  Measure 4" distal the stop sleeve shoulder to the braid termination.  <b>NOTE:</b> Measure and Record results	0.157" ± 0.003" (0.154"-0.160")  100%	Two Axis Laser Micrometer	TM1 50049	474	0		PNY 23Jan21
<b>Outer Diameter ▲12 MAX OD</b>  Measure distally from the braid termination to the all the way distal end of the shaft.	0.142" ± 0.002" (0.140"-0.144")  100%	Two Axis Laser Micrometer	TM1 50049	474	0		PNY 23Jan21
<b>Outer Diameter ▲12 MIN OD</b>  Measure distally from the braid termination to the all the way distal end of the shaft.	0.142" ± 0.002" (0.140"-0.144")  100%	Two Axis Laser Micrometer	TM1 50049	474	0		PNY 23Jan21



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Document No: FM5104983

Rev: B Document Type: Manufacturing Form  
Title: SA0254 Cause of Rework Form

**PRODUCTION ORDER#** 1050-04 **OPER 1050-0**  
**DATE** 22 Feb 2011

Record total quantity reworked:

NA

Rework Performed by: NA Date: NA Rework Performed by: NA Date: NA

Re-Inspection Performed by: MH Date: NA

AK  
Kette

Status CURRENT Effective 10/27/2020

Title	Approval Name	Approval Signature	Date
Mfg Engineering manager	Renate Holahan	RENE HOLAHAN	09/08/2020
Quality Manager Ops	Steve Julte	STEVE JULTE	08/08/2020
No QDCC20	Mo Tucci	MO TUCCI	08/08/2020
Operations Manager	Match Opatz	Match Opatz	09/08/2020

Training Required:	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	If no, explain: N/A
--------------------	---	---------------------

Corrective Action Required:	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	If no, explain: Deviation talks about recording the variable data at a operation where we are already checking for the dimension.
-----------------------------	---	---

Risk Assessment:	If yes to any of the above, what controls are being put in place to mitigate the risk?	
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	Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:	

Part Number Affected	SH0254-04/05/06	Revision: 5
Start Date:	12/9/2020	End Date: 1/9/2021
Lot Number:	N/A	At Orginal

Justification:	As per the customer requirement we are starting to record the variable data for dimension 12 and 13 at "line dimension".	
Inspecction operation:	Inspecction operation	

Deviation From:	Currently at "line dimensional inspection operation" operators record the variable data for Dim 12 and Dim 13. 10 samples from each lot. Variable data using laser mic and ring gauges and do just check the dimension using laser mic and ring gauges and do not record any variable data.	
Deviation To:	Record the variable data for Dim 12 and Dim 13. 10 samples from each lot. Variable data recorded form to be filled by ops department ops lead to add to the excel file to monitor variable data behavior.	

Document Number Affected	MP10398	Revision: U
Requestor Name:	Govind Sharma	

Requestor Name:	Govind Sharma	
-----------------	---------------	--

## DEVIATION AUTHORIZATION FORM



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Sample	Dim 12 (Max) 0.142" +/- 0.002	Dim 12 min 0.142" +/- 0.002	Dim 13 Avg 0.145" +0.002"-0.004"	Dim 13 Max 0.145" +0.002"-0.004"	Dim 12 and 13 variable data recording
1	0.1419	0.1419	NA	0.1449	0.1450
2	0.1418	0.1417	NA	0.1446	0.1453
3	0.1423	0.1416	NA	0.1442	0.1450
4	0.1417	0.1415	NA	0.1442	0.1452
5	0.1421	0.1415	NA	0.1434	0.1445
6	0.1421	0.1418	NA	0.1439	0.1453
7	0.1418	0.1415	NA	0.1445	0.1450
8	0.1419	0.1416	NA	0.1444	0.1452
9	0.1426	0.1423	NA	0.1435	0.1441
10	0.1424	0.1419	NA	0.1442	0.1448
11					
12					
13					
14					
15					
16					
17					
18					
19					
20					
21					
22					
23					
24					
25					
26					
27					
28					
29					
30					

Test Description: Dim 12 and 13 variable data recording

Part Number: SA0254-xx 06      Lot Number: 50000066206

Tested by: *PMT*

Date: 23 Jan 21

Tested by: *PMT*

## TEST DATA SHEET

*WKA2 Feb 21*

## DEVIATION AUTHORIZATION FORM

DEVIATION AUTHORIZATION NUMBER: DA1787

Requestor Name: Saroenu Chhum		Deviation Form:	
Document Number Affected	Revision	Deviation To:	100% Inspections at Final Inspection (Do not Require SmartSolve Notification to be issued).
2100586	B	SmartSolve Notification (Do not Require 100% Inspections at Final Inspection (Do not Require SmartSolve Notification to be issued)).	The following rules apply to these product families: If required for any sum of scraps at final inspection, there is a characteristic that is 100% inspected at final inspection, and this product is an Edwards product line there is a 35% allowance to scrap at final inspection.
Deviation From:		All lots undergo 100% visual inspection; therefore, there is no risk to the customer for lots released without documenting in the SmartSolve notification.	
Part Number Affected	Revision	Start Date:	SA0286-01 SA0286-02 SA0286-04 SA0254-05 SA0254-06 SA0155-01
		End Date:	15Jan2021 20286-01 & -02; SA0254-04, -05 & -06; SA0155-01
		Lot Number:	22Jan2021 N/A
<p><b>Risk Assessment:</b></p> <p>If yes to any of the above, what controls are being put in place to mitigate the risk: N/A</p> <p>Details (if any):</p> <p>Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:</p> <p>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</p> <p><b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No</p> <p>If no, explain:</p> <p>No correction is required, SAP will address all lot manufactured in the new system.</p> <p><b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No If no, explain:</p>			

**Maximum Force Reached During Tensile Test**  
 (10 samples accepted from final inspection for each lot shall be randomly 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
<b>Seg 1</b>	34.94	31.01	33.39	27.19	29.72	26.12	25.88	30.68	27.48	25.89	29.23	3.2437119	4.378	15.02902945	8.542	PASS
<b>Seg B</b>	23.18	22.5	20.87	22.14	23.34	20.95	21.56	22.78	20.55	21.61	21.948	0.992599	4.378	17.60257678	8.542	PASS
<b>Seg C</b>	47.71	66.11	51.46	50.08	67.52	49.68	47.94	46.44	46.88	51.67	52.549	7.7347232	4.378	18.68638173	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 not being required for DA acceptance.

*Kochyng Lee*

22 Feb 21