Production Order: 500000307854

Material: SA0155-01 Rev F

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

Material Type: ZFRT

Description: Edwards Flex Shaft Commander 155885

Order Type: ZSTD

Production Version: 7987

Project Phase:

Plant / Business Unit: 1213 / AC5

Oprn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3 Kitting Devices Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): XC31 7:40AM 19FEB24 Record Time Extrusions First Exit Dryer (Initial/Time/Date): XC31 7:40AM ~~PLOT~~ (1) ~~XC31~~ 20FEB24 Record Dryer Shelf #: N/A (1) XC31 20FEB24	N/A	N/A	19FEB24	XC31

Component Number	Req'd Rev	Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
MM0179-01	D	D	PC	500	0000293119	500
					N/A	N/A
MM1536-01	B	B	PC	500	0000290560	500

Notes: ~~DA-284~~ (1) DA2484, 2564

N/A

N/A

Date Printed: 02/16/2024 / 01:07:57

(1) V078 20 Feb 24

SA0155-01

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Production Order: 500000307854

Material: SA0155-01 Rev F

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

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	N/A
		RM0158-01	E	E	PC	200	88018	118				
							N/A	N/A				
		1000-1153-01	A	A	PC	594	① ~~8~~ 90170 90166 90168 90171	100 62 200 213				
		1000-2053-01	A	A	PC	500	~~90170~~ N/A XC31 21FEB24 0000295725	500				
							N/A	N/A				
		MM1537-02	A	A	PC	500	0000290571	500				
							N/A	N/A				
		TL0167-02	E	① ~~E~~ N/A	PC	70	N/A	Bulk				
							N/A	Bulk				
		TL0165-05	J	J	PC	5	N/A	Bulk				
							N/A	Bulk				
		TL0165-03	J	J	PC	5	N/A	Bulk				
							N/A	Bulk				

Notes:
N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

① Error Correct Batch #. BV57 16FEB24

① ~~① 16FEB24 BV57~~

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

Material: SA0155-01 Rev F

Production Order Document
Production Order Qty: 500 PC
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Opr No.	Planned Work Center	Operation Details							Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		141967-01	02	02	PC	500	87435	507				
							N/A	N/A				
		RM7349-02	C	C	PC	543	90040	500				
							N/A	N/A				
		RM7348-01	C	C	PC	500	85677	600				
							N/A	N/A				
		RM4001-01	B	B	PC	125	89583	100				
						X c31 21 FEB24	~~89603~~ N/A	N/A				
N/A	N/A	RM0607-01	D	D	PC	56	78322	27				
							N/A	N/A				
		RM0498-01	C	C	PC	500	0000275493	44	N/A	N/A	N/A	N/A
							0000287649	292				
							0000287650	49				
							0000301684	100				
		RM0009-04	I	I	PC	1	88993	Bulk				
							N/A	Bulk				
		RM0009-04	I	I	PC	1	88993	Bulk				

Notes:

N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

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Production Order: 500000307854

Material: SA0155-01 Rev F

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

Opr No.	Planned WorkCenter Description	Operation Details							Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
							N/A	Bulk				
		MM1538-01	A	A	PC	500	0000290562	500				
							N/A	N/A				
		MM1537-01	A	A	PC	1000	① ~~00000~~ N/A 0000294701	N/A				
							① ~~0000294701~~	1,000				
N/A	N/A	MM0177-01	C	C	PC	500	0000294697	500				
							N/A	N/A				
		MM0180-01	E	E	PC	500	0000295774	500				
							N/A	N/A	N/A	N/A	N/A	N/A
		MM0178-01	E	E	PC	500	0000290565	500				
							N/A	N/A				
		MM0176-01	D	D	PC	500	0000288413	500				
							N/A	N/A				
		MM0074-01	G	G	PC	500	0000303766	525				
							N/A	N/A				

Notes:

N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

① Error correct
Batch # 0000294701
BV57 16FEB24

~~16FEB24 BV57~~

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

Material: SA0155-01 Rev F

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

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 Confirmation Reqd(Milestone)	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	0 ~~0~~ 2 21Feb24	V078
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly .	500	0	21Feb24	SY47 V078 JY90 PM TG

Notes:
N/A
N/A
N/A

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SA0155-01

QPYHG 21Feb 24

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

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Production Order Document
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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	21Feb24	cp22 ~~C~~ ① DX35
250	CATASY01 Catheter Assembly 1	Trim Braid Wire at Proximal End .	500	0	21Feb24	CL05 ny35

Notes:

N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

SA0155-01

① PY46 22 Feb 24

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Production Order: 500000307854

Material: SA0155-01 Rev F

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

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	21Feb24	3H23 QS31
350	CATASY01 Catheter Assembly 1	Load Tubing .	500	0	21Feb24	ST96 GS22

Notes:
N/A
N/A
N/A

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CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

Material: SA0155-01 Rev F

Production Order Document
Production Order Qty: 500 PC
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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	21Feb24	SX60 SA85 PM96
450	CATASY01 Catheter	FEP Removal .	500	0	21Feb24	TREV R66 JY90 AT39 PM96

Notes:
N/A
N/A
N/A

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Production Order: 500000307854

Material: SA0155-01 Rev F

Production Order Document
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Sheet: 1 of 1

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	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 #: 1080-1153-0 Batch #: 90168 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	479	EW- HH HH LH WT-1 OF-1111 SCK-1 (21)	21 Feb 24	RGG YZ91 IL61 CB81
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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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 .	477	MAH-1 DL-1 (2)	21Feb24	MCB AX82 RS23 FB01 D429
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly .	477	0	21Feb24	ML60 PH59 FB01

Notes:
N/A
N/A
N/A

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Production Order: 500000307854

Material: SA0155-01 Rev F

Production Order Document
Production Order Qty: 500 PC

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 Confirmation Reqd(Milestone)	Loading Heat Shrink .	475	DU-11 (2)	21Feb24	MM02 PH59 AX82 FB01
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 2083C Cal Due: 31May24 TMI: 0936A Cal Due: 31May24	475	0	21Feb24	MV78 STX48 HV36 AX82

Notes: N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

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Production Order: 500000307854

Material: SA0155-01 Rev F

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

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 #: Pm1001-01 Batch #: 89583 Qty: 12 Part #: Pm0607-01 Batch #: 87322 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	470	EH-IIII (5)	21 Feb 24	PP40 STX48 HV36
800	CATASY01 Catheter Assembly 1	Major Mandrel Removal .	457	ACD-IIII IIII III (13)	21 Feb 24	KT26 SSHH

Notes: N/A
N/A
N/A

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Production Order: 500000307854

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Production Order Document
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
NA	Major Mandrel Removal Confirmation Reqd(Milestone)	NA	NA	NA	NA	NA
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. passed 2. passed 3. passed 4. passed 5. passed	455	SKV-11 (2)	21Feb24	MLGS SSSZ
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	NA	NA	NA	SHOY MV33 HT72

Notes: NA NA NA

Date Printed: 02/16/2024 / 01:07:57

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Production Order: 500000307854

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Production Order Document
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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)	Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: 0700-01 Cal Due: 31May24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: Bu400L-0 Batch #: 89583 Qty: 16 Part #: 1000-1153-01 Batch #: 90166 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	415	WK-卌 ll #105-lll EW-卌 #905-l Fm-llll Del-ll Dis-llll #905-l #705-卌 DL-ll EH-l #546-llll MAR-l (40)	24Feb25	TRN my28 K155 P446 KT47
950	QUALITY1 Quality Inspection & Review	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:	N/A	N/A	N/A	N/A

Notes: N/A

N/A

N/A

Date Printed: 02/16/2024 / 01:07:57

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

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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: N/A Cal Due: N/A Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30 Sep 25 TMI: 0692 Cal Due: 30 Sep 25 Record DIM02 Inspection Results N = 54: Pass: 50 Fail: 0	409	DIS-LH (CSP) (6)	21Feb24	1936
1000	QUALITY1 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: 1056 Cal Due: 31 May 24 Record Length Gage Information: TMI: 0559D Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 Sep 24	405	LT-111 (4)	21Feb24	1936 SG88 SS44

Notes:
N/A
N/A
N/A

Date Printed: 02/16/2024 / 01:07:57

SA0155-01

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Production Order: 500000307854

Material: SA0155-01 Rev F

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

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	380	SCR - IIII (TT) FM - III (TT) DL - II (TT) DEL - 1 DL - II EW - 1 VD - II SKV - III PBC - 1 DIS - IIII 25	21Feb24	SV43 XN26
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): XC31 21FEB24	N/A	N/A	21FEB24	XC31

Notes:	N/A
	N/A
	N/A

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SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
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	380	0	23Feb24	AP10

Notes: N/A AP10 23 Feb 24

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CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000307854

Material: SA0155-01 Rev F

Production Order Document
Production Order Qty: 500 PC

Batch Number:	500000307854
By:	ARO
Date:	23 Feb 24

Reviewed By:	RBZ9
Date:	23 Feb 24

Notes: N/A ARO 23 Feb 24

Date Printed: 02/16/2024 / 01:07:57

SA0155-01

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Extend to 20Jan2024 JZ28 11/14/23
Extend to 19Feb2024 JZ28 1/16/2024

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Extend to 22Nov2023 JZ28 10/10/2023

Extend to 21Dec2023 JZ28 11/17/2023

DEVIATION AUTHORIZATION NUMBER: 2484

*See attached email extension to 24SEP23 TSL 24AUG23

DEVIATION AUTHORIZATION FORM

Extend to 23Oct2023 JZ28 21Sep23

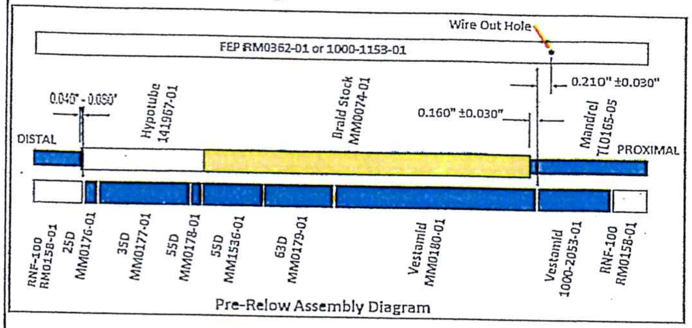
Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

Deviation From:

QIP3107610, Section 8.0 Inspection Requirements (Supplemental Visual Inspection) OP 1050:

Current QIP3107610 does not state to inspect for the correct extrusion configuration.



Deviation To:

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

Justification: Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-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	Revision
SA0155-01	H

Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

Risk Assessment:

Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:

Control Plans ☐ Yes ☒ No FMEA's ☐ Yes ☒ No Validations ☐ Yes ☒ No

Details (if any): N/A

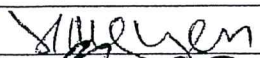
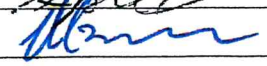
If yes to any of the above, what controls are being put in place to mitigate the risk.

Corrective Action Required: ☐ Yes ☒ No

If no, explain: 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:**

CONTROLLED COPY

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

① UK55, 23JW 2023

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DA	2484 ~~2468~~ ①

Group Training Record

Description/Objectives of Training:
DA- Inspection at final QC, Op#1050.

CONTROLLED COPY

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~~ ①MM1536-01 fixture for inspection. (See image 1) typo correction TS12 10AUG23

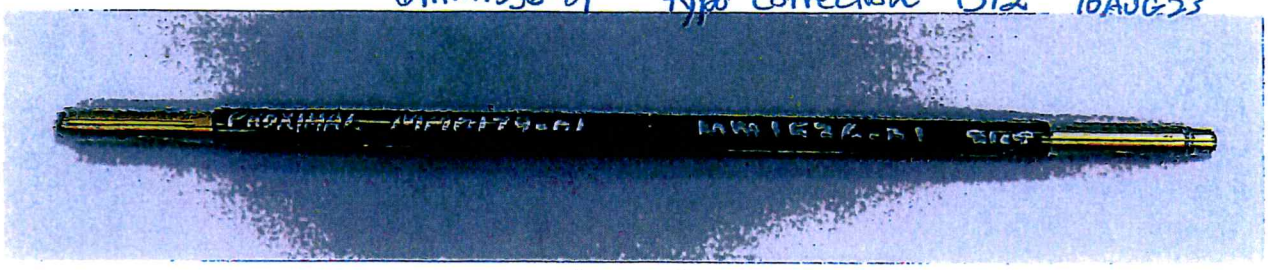

Image- 1

Step 1:

- Visually locate the MM0180-01 (Vestamid) transition to MM0179-01 on the completed part approximately 9.75" from the distal end using magnification light 2.25X minimum.
- Align the fixture MM0179-01 extrusion proximal end to the Vestamid transition on completed part. (See image 2)

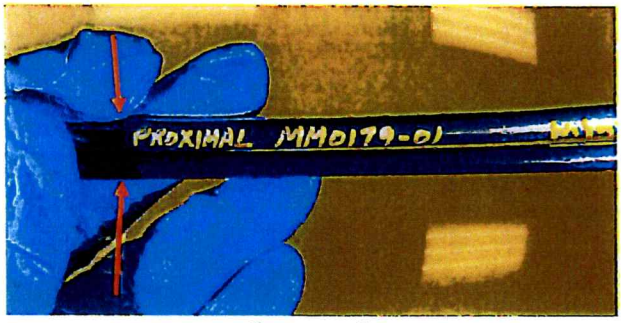

Image- 2

- Visually verify the MM0179-01 distal end of the fixture is approximately at the same location on the completed part. (See image 3)

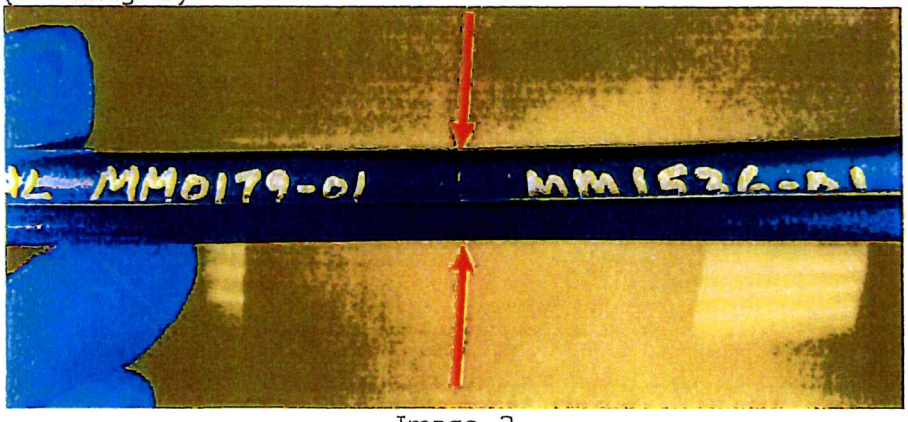

Image- 3

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, move to Step 2.

Step 2:

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

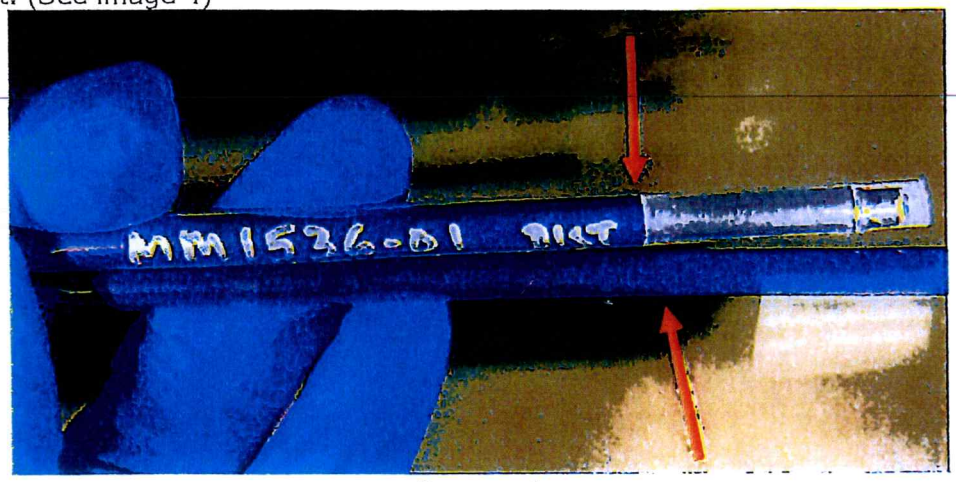

Image- 4

- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
- If the part transition is aligned, the part passes inspection.
- Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

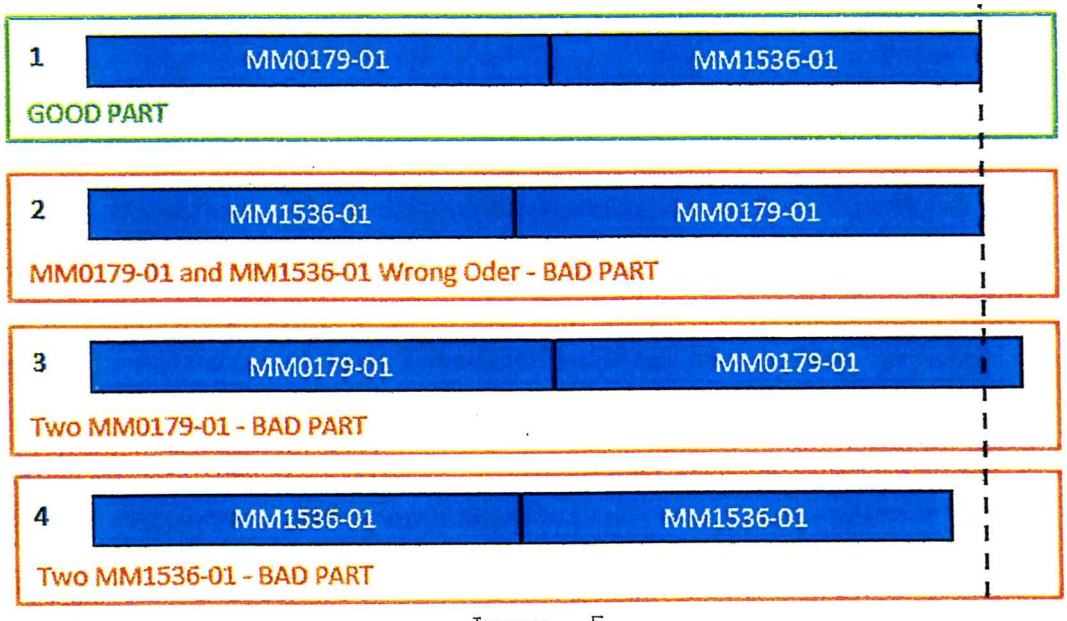

Image – 5

Extend to 14Jan2024 J238 12/11/2023
Extend to 13Feb2024 J238 1/9/2024

CREGANNA MEDICAL is part of TE

CONTROLLED COPY

DEVIATION AUTHORIZATION NUMBER: DA2564

Extend to 12Mar2024 J238 2/13/2024

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:	Lot Number:
16 Nov 23	15 DEC 23	N/A

Risk Assessment:

Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:

Control Plans ☐ 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 – N/A

Corrective Action Required: ☐ Yes ☒ 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: ☒ Yes ☐ 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# 500000307854

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	9:15pm	430	SH85	20Feb24	9:27Pm	415	SH85	20Feb24	16
TM10745	44	9:40pm	429	SX60	20Feb24	9:52Pm	415	SH85	20feb24	16
~~TM10745~~ TM10745 ①	44	10:16pm	429	SX60	20feb24	10:28pm	415	SX60	20feb24	16
TM10745	44	10:40pm	429	SX60	20feb24	10:52pm	415	SX60	20feb24	16
TM10745	44	11:05PM	429	AT39	20Feb24	11:17pm	415	SX60	20Feb24	16
TM10745	44	11:55pm	429	SX60	20feb24	12:07Am	415	SX60	21feb24	16
TM10745	44	12:25Am	429	SX60	21feb24	12:37Am	415	SY47	21Feb24	16
TM10745	44	1:00Am	430	SY90	21Feb24	1:12Am	415	SY47	21Feb24	16
TM10745	44	1:24Am	430	SG88	21Feb24	1:36Am	415	SG88	21Feb24	16
TM10745	44	1:57Am	428	SX60	21feb24	2:09Am	415	V078	21Feb24	14
TM10745	44	5:35am	430	TA36	21Feb24	5:47am	415	TA36	21feb24	16
TM10745	44	6:00am	430	TA36	21feb24	6:12am	415	TA36	21feb24	16

① PY46 22 Feb 24 correction for SX60

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

PRODUCTION ORDER# 500000307854

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0745	44	6:35am	430	OS 21	21 Feb24	6:47am	415	OS 21	21 Feb24	16
TMI0745	44	7:40am	430	NK62	21 Feb24	7:52AM	415	NK62	21 Feb24	16
Tm10745	44	8:20am	430	TA36	21 feb 24	8:32am	415	TA36	21 FEB 24	16
Tm10745	44	8:35am	430	OS 21	21 Feb 24	8:47am	415	OS 21	21 Feb 24	6
					N/A					
					OS21 21 Feb 24					

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

PRODUCTION ORDER# 500000307854

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	9:03pm	430	SX60	20feb24	9:15pm	415	SX60	20feb24	16
TM10942	44	9:28pm	428	SH85	20Feb24	9:40pm	415	SH85	20Feb24	16
TM10942	44	9:57pm	430	SH85	20Feb24	10:09pm	415	SH85	20Feb24	16
TM10942	44	10:29pm	429	SH85	20Feb24	10:41pm	415	SH85	20Feb24	16
TM10942	44	10:55pm	①~~248~~428	SX60	20feb24	11:07pm	415	SX60	20feb24	16
TM10942	44	11:43pm	430	SY47	20Feb24	11:53pm	415	SY47	20Feb24	16
TM10942	44	12:16am	430	SX60	21feb24	12:28am	415	SX60	21Feb24	16
TM10942	44	12:40Am	428	SY47	21Feb24	12:52Am	415	SY47	21Feb24	16
TM10942	44	1:12Am	430	SY47	21Feb24	1:24Am	415	SY47	21Feb24	16
TM10942	44	1:44Am	429	SX60	21Feb24	1:56Am	415	V078	21Feb24	16
TM10942	44	5:20am	430	TA36	21Feb24	5:32am	415	TA36	21Feb24	16
TM10942	44	5:50am	430	TA36	21Feb24	6:02am	415	TA36	21Feb24	16

① SX60 20feb24

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

PRODUCTION ORDER# 500000307854

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	6:15am	430	TA36	21Feb24	6:27am	415	TA36	21Feb24	16
TM10942	44	7:00am	430	OS21	21Feb24	7:12am	415	OS21	21Feb24	16
TM10942	44	7:56 AM	430	PM96	21 Feb 24	8:08 AM	415	PM96	21 Feb 24	16
TM10942	44	8:30 am	430	TA36	21 FEB 24	8:42am	415	TA36	21 FEB 24	16
					N/A					
					OS21 21Feb24					

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

PO #: 5000003078 54 OP #: 500 Shift #: 2

Total Parts Reworked:		20	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	///	3
EW	Exposed Wire	~~HH~~ ~~HH~~ ~~HH~~ ///	18
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	//	2
N/A	N/A	N/A	0
Inspected By (Sign and Date):		[signature] 20 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 #: 500000307854 OP #: 500 Shift #: 2nd

Total Parts Reworked:		28	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
AB	Air Bubbles	ll	2
EH	Exposed Hypotube	N/A	N/A
EW	Exposed Wire	𝍸𝍸𝍸𝍸 ll	22
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	lll	3
VD	Voids	𝍸	5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Vanmeej Lor 20 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 #: 5000003078S4 OP #: 500 Shift #: 1

Total Parts Reworked:		98	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
AB	Air Bubbles	𝍸 𝍸 II	12
EH	Exposed Hypotube	𝍸 IIII	9
EW	Exposed Wire	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 IIII	69
MP	Micropores	N/A	N/A
SCR	Scratch	IIII	4
SKV	Skive Marks	I	I
VD	Voids	𝍸 IIII	9
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LL61, D429, CB81, TA36 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 5000003078 54 OP #: 750 Shift #: 2nd

Total Parts Reworked:		7	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
DIM07 OS / WO	DIM07 Oversized (Window Open)	𝍸	5
DIM07 US / WC	DIM07 Undersized (Window Closed)	𝍸	2
EH	Exposed Hypotube	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		PP40 20 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000307854 OP #: 750 Shift #: 1st

Total Parts Reworked:		84	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
DIM07 OS / WO	DIM07 Oversized (Window Open)	𝍸 𝍸 𝍸 I	16
DIM07 US / WC	DIM07 Undersized (Window Closed)	𝍸	5
EH	Exposed Hypotube	𝍸 𝍸 𝍸 𝍸 I	21
N/A	Glue, Stopper	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 II	42
Inspected By (Sign and Date):		Hv36 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. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check): ☒

CREGANNA MEDICAL is part of TE connectivity

Document No: FM5104661
Rev: B
Document Type: Manufacturing Form
Title: SA0155-01 Annealing Log Sheet Form

PRODUCTION ORDER# 500000307854

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	11:40pm	190°F	KT26	20Feb24	12:50am	190°F	KT26	21Feb24	26
TM10409	N/A	12:14AM	190°F	KT26	21Feb24	1:24AM	190°F	KT26	21Feb24	33
TM12036	N/A	12:52AM	190°F	KT26	21Feb24	2:02AM	190°F	AT39	21Feb24	33
TM10409	N/A	4:25am	190°F	KI55	21Feb24	5:35 am	190°F	KI55	21Feb24	40
TM10409	N/A	5:40am	190°F	SS44	21 Feb 24	6:50 am	190°F	SS44	21 Feb 24	44
TM12036	N/A	6:40am	190°F	0521	21Feb 24	7:50AM	190°F	P146	21Feb24	60
TM10409	N/A	8:25Am	190°F	PM96	21Feb 24 ~~12 Feb24~~	9:35Am	190°F	PM96	21 Feb 24	52
TM12036	N/A	9:10 am	190°F	KI55	21Feb24	10:20am	190°F	KI55	21Feb24	53
TM10409	N/A	11:05 am	190°F	SS44	21 Feb 24	12:15 pm	190°F	SS44	21 Feb 24	46
TM12036	N/A	11:35am	190°F	KI55	21Feb24	12:45pm	190°F	KI55	21Feb24	30
TM10409	N/A	12:15pm	190°F	P146	21Feb24	1:25 pm	190°F	P146	21Feb24	40
		~~N/A~~ P146 21 Feb24								

OP146 21 Feb24

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

PO #: 5000000307854 **OP #: 900** **Shift #:** 2nd

Total Parts Reworked:		6	
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	||	2
MP	Micropores	N/A	0
SCR	Scratch	||||	4
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized	N/A SH 04 20 Feb 24	N/A PH 22 Feb 24
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		Lee H 20 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 #: 500000307854 OP #: 900 Shift #: 2

Total Parts Reworked:		12	
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	II	2
MP	Micropores	N/A	N/A
SCR	Scratch	~~IIII~~ II	12
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT 72 20 Feb 24	

N/A 20 Feb 24
HT 72

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 #: 5000003078 54 **OP #: 900** **Shift #:** 1st

Total Parts Reworked:		124	
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	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 1	51
MP	Micropores	N/A	N/A
SCR	Scratch	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸	>5
SKV	Skive Marks	N/A	N/A
VD	Voids	𝍸 𝍸 1	11
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	𝍸 𝍸 𝍸 11	17
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		P146, lk155, KT247 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. 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	35.93	33.94	32.98	25.93	29.59	29.97	28.38	28.35	27.58	29.05	30.17	3.129068	4.378	16.4709402	8.542	PASS
Seg B	68.66	68.98	68.2	68.79	72.67	65.35	68.86	75.12	77.22	78.48	71.233	4.3797693	3.981	53.7971385	8.542	PASS
Seg C	82.41	86.28	78.79	86.02	90.13	81.87	87.64	87.1	88.5	74.7	84.344	4.8244866	2.911	70.2999195	8.542	PASS

EDW Commander Flex - Bend and Tensile Strength Testing

LOT #: 500000307854
Date: 22FEB2024
Inspector Name: AUGUSTINE JAH
Equipment ID: TMI0311B
Cal Due Date: 27 OCT 24

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.