

# Production Order: 500000301827



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 Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KD2 7:50am 30 JAN 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XC3 10:20am 30 JAN 24</u> Record Dryer Shelf #: <u>N/A</u>	N/A	N/A	01 JAN 24	BV57
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used
	MM0179-01	D <u>D</u>	PC	500	0000294700	500 <u>N/A</u> <u>N/A</u>
	MM1536-01	B <u>B</u>	PC	500	0000281412	500

Notes: DA2484, 2564

N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 1 of 18



SA0155-01

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# Production Order: 500000301827



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

## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>88018</u>	<u>N/A</u>	<u>N/A</u>	<u>150</u>	
		1000-1153-01	A	<u>A</u>	PC	594	<u>88619</u> <u>88622</u> <u>88623</u>	<u>N/A</u>	<u>N/A</u>	<u>200</u> <u>200</u> <u>194</u>	
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	N/A N/A
		MM1537-02	A	<u>A</u>	PC	500	<u>XC31</u> <u>31JAN24</u> <u>00002884</u> <u>0000288401</u> <u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>500</u>	
		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>N/A</u>	<u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>N/A</u>	<u>Bulk</u>		
								<u>N/A</u>	<u>Bulk</u>		

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 2 of 18



SA0155-01

CREGANNA  
MEDICAL  
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# Production Order: 500000301827



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

## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	141967-01	02	02	PC	500	88399	516			
		RM7349-02	C	C	PC	543	82865	N/A			
		RM7348-01	C	C	PC	500	82889 82886	458			
		RM4001-01	B	B	PC	125	82458	300			
		RM0607-01	D	D	PC	56	83127 X(3) 31JAN24 78848 N/A	150	N/A	N/A	N/A
		RM0498-01	C	C	PC	500	74662 0000287643	100			
		RM0009-04	I	I	PC	1	N/A 79170	983			
		RM0009-04	I	I	PC	1	N/A 79170	66			
								Bulk			

Notes:

N/A  
N/A  
N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 3 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000301827



Production Order Document  
Production Order Qty: 500  
PC

Sheet: 1 of 1

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	A	PC	500	N/A	Bulk			
		MM1537-01	A	A	PC	1000	0000278970	500			
		MM0177-01	C	C	PC	500	N/A	N/A			
		MM0180-01	E	E	PC	500	0000284708	500			
		MM0178-01	E	E	PC	500	0000295774	500			
		MM0176-01	D	D	PC	500	0000282490	29			
		MM0074-01	G	G	PC	500	0000276174	500			

Notes:

N/A  
N/A  
N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 4 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000301827**



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

**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
M0	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	31Jan24	V078
	Line Clearance					
	Confirmation Reqd(Milestone )					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	31Jan24	Sy47 JY90 AX05 pm96
	Major and Minor Mandrel Assembly					
Notes:						N/A
						N/A
						N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 5 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



Production Order: 500000301827



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
200	CATASY01  Catheter Assembly 1  	Loading Braid Stock  Loading Braid Stock  Confirmation Reqd(Milestone )	500	O  315cm <sup>2</sup>	ep32 ny35 AL34	
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	O  315cm <sup>2</sup>	CLOS DX35 MV50 CMUB	

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 6 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



**Production Order: 500000301827**



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Trim Braid Wire at Proximal End  NP Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
300	CATASY01  Catheter Assembly 1    Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	Insert Cut Hypo Tube	500	0	315 cu <sup>24</sup>	SH23 AS31 VRGL DV34
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	315 cu <sup>24</sup>	ST96 GS22 VV25 CY97

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 7 of 18



SA0155-01

CREGANNA MEDICAL  
is part of



Production Order: 500000301827



Production Order Document  
Production Order Qty: 500  
PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Load Tubing  NP Confirmation Reqd(Milestone )		N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone )	Reflow	500	0 31J <sup>cm24</sup>	CL30 V078 NR62	
450	CATASY01 Catheter	FEP Removal	500	0 31J <sup>cm24</sup>	SHS5 PM96	

Notes:

Date Printed: 01/30/2024 / 00:30:08

Page: 8 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



## Production Order: 500000301827



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

Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 					
	FEP Removal 		N/A	N/A	N/A	N/A
	Confirmation Reqd(Milestone )					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: <u>1000-115-01</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>1000-1153-01</u> Batch #: <u>88728</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>	491	EW-1 EW-HK11 OF -1 (9)	31 Jan 24 V291 PP40 TD45 LL61 TA36 CB81	
	In-process Inspection and Rework 					
	Confirmation Reqd(Milestone )					
	N/A N/A	N/A	N/A	N/A	N/A	N/A
Notes:						

Date Printed: 01/30/2024 / 00:30:08 (1) mutg 30 Jun 24

Page: 9 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



# Production Order: 500000301827



Production Order Document  
Production Order Qty: 500  
PC

Sheet: 1 of 1

## 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  Remove Heat Shrink & Mandrel  Confirmation Reqd(Milestone )	491	0  315 cu <sup>24</sup>	31 Jan 24	ML60 AT39 PY46 TRV DT29 VA96 FBO) AX82 RS23
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Confirmation	Distal Tip Assembly	472	MAH - HTT.11 DL - HTT HTT 1	31 Jan 24	ML60 VA96 FBO) AX82

Notes:

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Date Printed: 01/30/2024 / 00:30:08

Page: 10 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of



# Production Order: 500000301827



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

## Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
650	CATASY01  Catheter Assembly 1  	Loading Heat Shrink	472	0	31Jan24	ML38 VA96 F B01 AX82
	Loading Heat Shrink					
	Confirmation Reqd(Milestone )					
700	CATASY01  Catheter Assembly 1  	Tipping Record Tipping Oven Information: TMI: <u>0521</u> Cal Due: <u>31 May 24</u> TMI: <u>2083C</u> Cal Due: <u>31 May 24</u> TMI: <u>0386</u> Cal Due: <u>31 May 24</u> TMI: <u>0936A</u> Cal Due: <u>31 May 24</u>	472	0	31Jan24	ML38 STX48
	Tipping					

Notes:

N/A  
N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 11 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of





Material: SA0155-01 Rev F

PC  
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 Material Consumed: Part #: <u>P4001-01</u> Batch #: <u>82458</u> Qty: <u>10</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> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	472	0	31Jan24	STX48 PHN9 KT47
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	461	ACD-HH 1 (11)	31Jan24	SS44 SS52
Notes:						
N/A						
N/A						
N/A						

Date Printed: 01/30/2024 / 00:30:08

Page: 12 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

**Production Order: 500000301827**



Production Order Document  
Production Order Qty: 500  
PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Major Mandrel Removal  Confirmation Reqd(Milestone )  N/A	N/A	N/A	N/A		N/A
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	31Jan24	SS52 ML65 TRN KL67
900	QUALITY1  Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	MV33 ML46 SH04
Notes:						
N/A N/A N/A						

Date Printed: 01/30/2024 / 00:30:08

Page: 13 of 18



SA0155-01

CREGANNA MEDICAL  
is part of



## Production Order: 500000301827

Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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 24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>RMD001-01</u> Batch #: <u>82458</u> Qty: <u>20</u></p> <p>Part #: <u>1000-1153-01</u> Batch #: <u>88619</u> Qty: <u>15</u></p> <p>Part #: <u>RMD001-01</u> Batch #: <u>78848</u> Qty: <u>12</u></p> <p>Part #: <u>RMD058-01</u> Batch #: <u>88018</u> Qty: <u>10</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	① 421 418 417③	DIS-144 44T-LH11 MAP-144 111 EH-1 DEC-144 11 EM-11 #6WS-111 WK-11 #70S-11 #9LIS-1 #10S-1	31Jan24	P146 DY29 KL55 XL91
950	QUALITY1  Quality Inspection & Review	<p>Quality Inspection &amp; Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: ① <u>N/A</u> ② <u>Cal Due: 2024-01-01</u> ①</p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A  
N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 14 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

① XL91 31Jan24

② TMI: 50713B Cal Due: 12 Apr 24 XL91 31 Jan 24

③ KL67 31Jan24



## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review   Confirmation Reqd(Milestone)	TMI: <u>044-50317</u> Cal Due: <u>044</u> 31Aug24 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>	380	STR-111 DIS-14444 1H1 1 WK-11  DIS(SP)144 DEL(GT)14444	31Jun24	PT46 XL91 KL69
1000	 QUALITY1   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>31may24</u> Record Length Gage Information: TMI: <u>08890</u> Cal Due: <u>30SEP24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30SEP24</u>	359	LT-14444 1H1 1M1	31Jan24	SS44 XL91 KL69

Notes:

N/A

N/A

N/A

Date Printed: 01/30/2024 / 00:30:08

Page: 15 of 18



SA0155-01

CREGANNA  
MEDICAL  
is part of

① XL91 31 Jan 24

# Production Order: 500000301827



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

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	<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	325	SCR-HH-HH SKV-III FM-III FB-III DIS-II VD-III GNII-①  GNII-1 STN-1 BP-1 DEL-1 HRA-①  EH-1 EW-1 CRK-1 34 Mar-1	31Jan24	SV43 XN26
1100	<b>CATASY01</b> Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): <u>XCS1</u> <u>31JAN24</u>	N/A	N/A	31JAN24	XCS1
<b>Notes:</b> N/A N/A N/A						

Date Printed: 01/30/2024 / 00:30:08

Page: 16 of 18



SA0155-01

① XN26 31Jan24  
**CREGANNA MEDICAL**  
 is part of



Production Order: 500000301827



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

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	325	0 02 Feb 24	AP10 02 Feb 24	ABCO

Notes:

MAP N/A AP10 02 Feb 24

Date Printed: 01/30/2024 / 00:30:08

AP10 02 Feb 24  
Page: 17 of 18



SA0155-01

CREGANNA MEDICAL  
is part of



**Production Order: 500000301827**



Production Order Document  
Production Order Qty: 500

PC

Sheet: 1 of 1

**Material: SA0155-01 Rev F**

Batch Number: 000301827

By: AP10

Date: 02 Feb 24

Reviewed By:

RB29

Date:

02 feb 24

Notes:

N/A AP10 02 Feb 24

Date Printed: 01/30/2024 / 00:30:08

Page: 18 of 18



SA0155-01

CREGANNA  
MEDICAL  
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Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 JUL 2023
Mgr. Manufacturing Engineering	Jake Stanisowski		25 JUL 2023
Mgr. Operations	Matthew Benson		25 JUL 2023

FM0002.RevF Deviation Authorization

**CONTROLLED COPY**

① UK55, 23JW 2023



DA DA 2484  
2468. ①

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

### Group Training Record

#### Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and MM1536-02 fixture for inspection. (See image 1)  
**① MM1536-01 type connection TS12 10AUG23**

#### CONTROLLED COPY

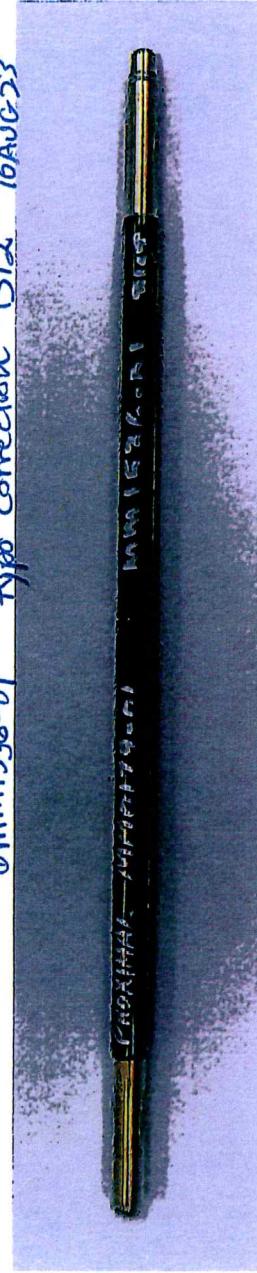


Image- 1

#### 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)

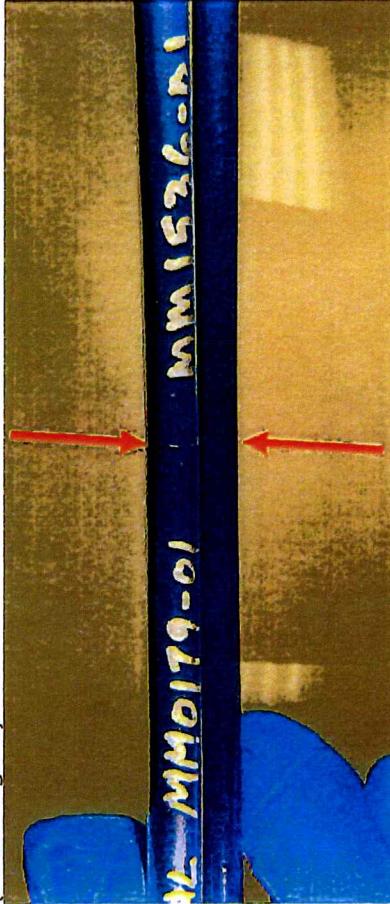
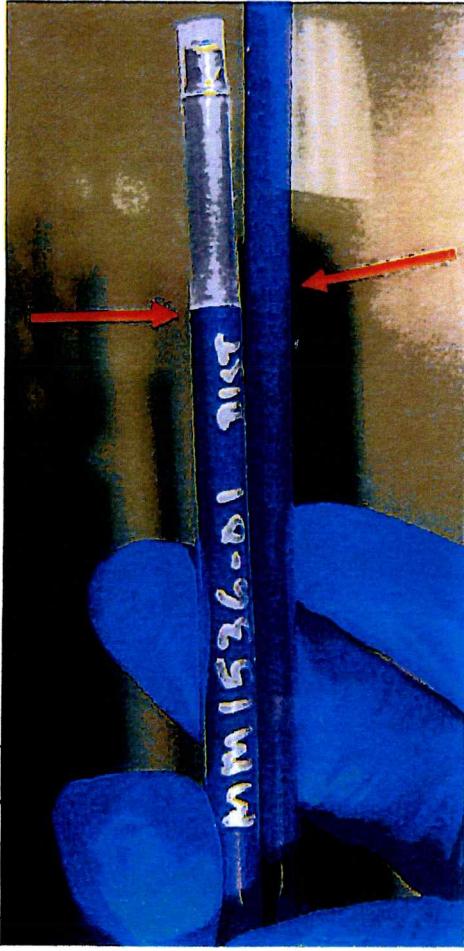


Image- 3

- 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.

<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	MM0179-01 <b>Two MM0179-01 - BAD PART</b>
<b>4</b>	MM1536-01	MM1536-01 <b>Two MM1536-01 - BAD PART</b>

Image - 5

Entered to Hansel T208 11/16/2023  
Entered to 13 Feb 2024 T208 1/9/2024

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## DEVIATION AUTHORIZATION FORM

Requestor Name:	Krishna Selvaraj		
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
Doc #3005206 (Flex Commander MPI0238): <b>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.	Doc #3005206 (Flex Commander MPI0238): <b>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.		
<b>Justification:</b> 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	
<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 checked="" type="checkbox"/> Yes <input 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			
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# 500000301827

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	12:05AM	430	SH85	31Jan24	12:17AM	415	SH85	31Jan24	16
Tm10745	44	12:30AM	429	V078	31Jan24	12:42PM	415	V078	31Jan24	16
Tm10745	44	12:53AM	428	V078	31Jan24	1:05 AM	415	CL30	31Jan24	16
Tm10745	44	1:30AM	429	V078	31Jan24	1:42AM	415	V078	31Jan24	16
Tm10745	44	1:50AM	430	SG88	31Jan24	2:02AM	415	SG88	31Jan24	16
Tm10745	44	5:35AM	430	NK62	31Jan24	5:47AM	415	NK62	31Jan24	16
Tm10745	44	6:00AM	430	OS21	31Jan24	6:12AM	415	OS21	31Jan24	16
Tm10745	44	6:25AM	429	OS21	31Jan24	6:37AM	④44415	OS21	31Jan24	16
Tm10745	44	7:00AM	429	NK62	31Jan24	7:12AM	415	NK62	31Jan24	16
① Tm10745	44	8:50AM	N/A KLS5 81Jan24	AX05	31Jan24	9:00AM	415	AX05	31Jan24	
Tm10745	44	7:50am	430	AX05	31Jan24	8:02am	415	AX05	31Jan24	16
Tm10745	44	8:20am	430	AX05	31Jan24	8:32am	415	AX05	31Jan24	16

① NK62 31Jan24

① AX05 31Jan24



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

## Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000301827

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	8:45am	428	AX05	31Jan24	8:57am	415	AX05	31Jan24	16
TM10745	44	9:10am	429	AX05	31Jan24	9:22am	415	AX05	31Jan24	16
TM10745	44	9:27am	430	KL95	31Jan24	9:39am	415	KL95	31Jan24	16
TM10745	44	10:20am	430	TA36	31Jan24	10:32am	415	TA36	31Jan24	16
TM10745	44	11:15am	430	OS21	31Jan24	11:27am	415	OS21	31Jan24	10
				N/A						
				OS21	31Jan	24				



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

PRODUCTION ORDER# 500000301827

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	11:50pm	430	V078	30Jan24	12:02Am	415	V078	31Jan24	16
Tm10942	44	12:19Am	430	V078	31Jan24	12:31Am	415	V078	31Jan24	16
Tm10942	44	1:10Am	429	V078	31Jan24	1:22Am	415	V078	31Jan24	16
Tm10942	44	1:40Am	428	V078	31Jan24	1:52Am	415	SG88	31Jan24	16
Tm10942	44	5:17Am	430	NK62	31Jan24	5:29am	415	NK62	31Jan24	16
Tm10942	44	5:50am	430	NK62	31Jan24	6:02am	415	NK62	31Jan24	16
Tm10942	44	6:20am	429	NK62	31Jan24	6:32am	415	NK62	31Jan24	16
Tm10942	44	7:40am	430	AX05	31Jan24	7:52am	415	AX05	31Jan24	16
Tm10942	44	8:10am	430	AX05	31Jan24	8:22am	415	AX05	31Jan24	16
Tm10942	44	8:33am	428	AX05	31Jan24	8:45am	415	AX05	31Jan24	16
Tm10942	44	8:55am	427	AX05	31Jan24	9:07am	415	AX05	31Jan24	16
Tm10942	44	9:30am	430	AX05	31Jan24	9:42am	415	AX05	31Jan24	16



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

PRODUCTION ORDER# 500000301827

OP 400

00521 31 Jan 24



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

PO #: 500000301827

OP #: 500 Shift #: 2nd

Total Parts Reworked:		15	
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		8
MP	Micropores	n/a	n/a
SCR	Scratch	//	2
SKV	Skive Marks	n/a	n/a
VD	Voids		5
n/a	n/a	n/a	n/a

**Inspected By (Sign and Date):** Nammej Lor 30 Jan 24

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

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



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

PO #: 500000301827

OP #: 500 Shift #: 1

Total Parts Reworked:		108	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		31
EW	Exposed Wire		84
MP	Micropores	N/A	N/A
SCR	Scratch		5
SKV	Skive Marks	N/A	N/A
VD	Voids		13
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		CB81, LL61, TA36	31 Jan 24

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

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000301827

OP #: 750 Shift #: 1st

Total Parts Reworked:		88	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	HHH	17
DIM07 US / WC	DIM07 Undersized (Window Closed)	HHH	7
EH	Exposed Hypotube	HHHHHHHHH	26
N/A	Glue , Stopper	HHHHHHHHHHHHHHHHH	① 3834
Inspected By (Sign and Date):		PH59, KT267	31 Jan 24

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

Data Uploaded for Engineering Review (Check):

① KT4701 Feb 24

PRODUCTION ORDER# 500000301 827

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tim10H09	N/A	6:00AM	190°F	SSH44	31Jan24	7:10am	190°F	SSH44	31Jan24	43
Tim10H09	N/A	7:30 am	190°F	KISS	31Jan24	8:40am	190°F	KISS	31Jan24	28
Tim10H09	N/A	8:15 am	190°F	SSH44	31Jan24	9:25am	190°F	KISS	31Jan24	32
Tim10H09	N/A	9:10am	190°F	SSH44	31Jan24	10:20am	190°F	SSH44	31Jan24	42
Tim12036	N/A	9:40AM	190°F	KISS	31Jan24	10:50am	190°F	KISS	31Jan24	32
Tim10H09	N/A	11:35AM	190°F	SSH44	31Jan24	12:45PM	190°F	SSH44	31Jan24	50
Tim12036	N/A	12:25 PM	190°F	SSH44	31Jan24	1:35PM	190°F	SSH44	31Jan24	50
Tim10H09	N/A	1:40PM	190°F	SSH44	31Jan24	2:50 PM	190°F	SSH44	31Jan24	35
Tim12036	N/A	2:05 pm	190°F	SSH44	31Jan24	3:15pm	190°F	SSH44	31Jan24	49
Tim10H09	N/A	2:55pm	190°F	SSH44	31Jan24	4:05PM	190°F	SSH44	31Jan24	53
Tim10H09	N/A	4:31PM	190°F	SG88	31Jan24	5:41pm	190°F	SG88	31Jan24	47
			N/A							
		SG88		31 Jan 24						

① SSH44 31Jan24

Status CURRENT Effective 5/8/2023



**PO #:** 500000301827

OP #: 900 Shift #: 1st

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

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):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023

PO #: 50000301827OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		45	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube		4
EW	Exposed Wire		2
MP	Micropores	N/A	0
SCR	Scratch		35
SKV	Skive Marks	N/A	0
VD	Voids	/	1
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		14
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Osee H 31 Jan 24	

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

Data Uploaded for Engineering Review (Check):



**PO #:** 500300301827

OP #: 900 Shift #: 2nd

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

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):**

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Page 1 of 1

Status CURRENT Effective 5/8/2023



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

PO #: 500000301827

OP #: 900 Shift #: 2

Total Parts Reworked:		14	
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	N/A	N/A
MP	Micropores	N/A	N/A
SCR	Scratch		13
SKV	Skive Marks	N/A	N/A
VD	Voids		4
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):		HT72 31Jan24	

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	31.47	31.11	23.54	22.79	26.05	27.8	29.47	30.21	27.31	30.25	28	3.0763398	4.378	14.5317843	8.542	PASS
Seg B	77.93	75.09	75.27	72.51	71.85	71.29	75.4	69.31	69.5	69.76	72.791	2.9814145	3.981	60.921989	8.542	PASS
Seg C	84.68	83.77	79.89	79.79	77.94	85.65	89.87	78.21	87.04	86.77	83.361	4.1551827	2.911	71.2652631	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 #: 500000301827

Date: 01FEB2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24



= 01 FEB 2024