Production Order: 500000297999

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: 7988

Project Phase:

Plant / Business Unit: 1213 / AC5

Opr 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): GS857:00AM 24 Jan 24 Record Time Extrusions First Exit Dryer (Initial/Time/Date): XC31 11:30pm 25JAN24 Record Dryer Shelf #: N/A	N/A	N/A	25JAN24	SH70

Component Number	Req'd Rev	Used Rev	UOM	Qty.	Batch No.	Actual Qty Used
1000-2053-01	A	A	PC	500	0000278380	500
					N/A	N/A
MM1537-02	A	A	PC	500	0000288401	500

Notes: DA2484, 2564
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	N/A				
		RM0158-01	E	E	PC	200	58497	200				
							N/A	N/A				
		TL0167-02	E	E	PC	70	N/A	Bulk				
							N/A	Bulk				
		TL0165-05	J	J	PC	5	N/A	Bulk				
							N/A	Bulk				
N/A	N/A	TL0165-03	J	J	PC	5	N/A	Bulk	N/A	N/A	29Jan24	KPaz
							N/A	Bulk				
		141967-01	02	02	PC	500	85793	525				
							N/A	N/A				
		RM7349-02	C	C	PC	543	82834 82836 82856	200 300 100				
		RM7348-01	C	C	PC	500	85428	500				
							N/A	N/A				

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	N/A	RM4001-01	B	B	PC	125	82469	200	N/A	N/A	N/A	N/A
							N/A	N/A				
		RM0607-01	D	D	PC	56	74663	109				
							N/A	N/A				
		RM0498-01	C	C	PC	500	0000275492	500				
							N/A	N/A				
		RM0362-01	E	E	PC	594	80236	600				
							N/A	N/A				
		RM0009-04	I	I	PC	1	79168	Bulk				
							N/A	Bulk				
		RM0009-04	I	I	PC	1	79168	Bulk				
							N/A	Bulk				
		MM1538-01	A	A	PC	500	0000278970	500				
							N/A	N/A				
		MM1537-01	A	A	PC	1000	0000284209	1000				

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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				
		MM1536-01	B	B	PC	500	000028l412	500				
							N/A	N/A				
		MM0180-01	E	E	PC	500	0000287541	500				
							N/A	N/A				
		MM0179-01	D	D	PC	500	0000276172	500				
							N/A	N/A				
N/A	N/A	MM0178-01	E	E	PC	500	0000276174	500	N/A	N/A	N/A	N/A
							N/A	N/A				
		MM0177-01	C	C	PC	500	0000284208	500				
							N/A	N/A				
		MM0176-01	D	D	PC	500	000028l411	500				
							N/A	N/A				
		MM0074-01	G	G	PC	500	0000293933	520				
							N/A	N/A				

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	26Jan24	V078 CB58
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly .	500	0	26Jan24	CL30 JY90 SD34 YK40

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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	26Jan24	CL05 YO4 GD19 MY50
250	CATASY01 Catheter Assembly 1	Trim Braid Wire at Proximal End .	500	0	26Jan24	eP52 DX35 PY67 AL34

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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	26Jan24	SH23 GS22 AIGS SCID
350	CATASY01 Catheter Assembly 1	Load Tubing .	500	0	26Jan24	ST96 BD64 RL47

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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	26Jan24	SY47 V078 SN67 AL67 AM47
450	CATASY01 Catheter	FEP Removal .	500	0	26Jan24	SY85 AM47

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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 #: 1000-1153-01 Batch #: 87654 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 Part #: N/A Batch #: N/A Qty: N/A	489	EW-III 11 OF-1 DS-1 DW-1 (11)	26Jan24	VL91 R66 JD45 LS46 LLG1 AR02
N/A	N/A	N/A	N/A	N/A	N/A	N/A

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

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CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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
550	CATASY01 Catheter Assembly 1 Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel .	489	0	26Jan24	PP40 LH45 TRM MH10 PH59
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly .	489	0	26Jan24	HT72 ML60 KT47 PH59

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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 .	489	0	26Jan24	SV46 PTQ9 LH45
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: 2083C Cal Due: 31May24 TMI: 0936A Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 0521 Cal Due: 31May24	489	0	26Jan24	PH59

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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 #: RM4001-01 Batch #: 82469 Qty: N/A Part #: RM0607-01 Batch #: 74663 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	487	EH-11 (2)	26Jan24	DY29
800	CATASY01 Catheter Assembly 1	Major Mandrel Removal .	485	ACD-11 (2)	26Jan24	PL22 YK140 BD64

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	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. pass 2. pass 3. pass 4. pass 5. pass	485	0	27 Jan 24	DLOT
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	N/A	N/A	N/A

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

Material: SA0155-01 Rev F

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

Opr No.	Planned Work Center 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: 31MAY2024 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 #: 1000-1153-01 Batch #: 87654 Qty: N/A Part #: RM0158-01 Batch #: 58497 Qty: N/A Part #: RM4001-01 Batch #: 82469 Qty: N/A Part #: RM0607-01 Batch #: 74663 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	461	DEL-~~HH~~SP FM-~~HH~~(TT) DL-~~HH~~(TT) EW-111 DIS-111 EH-111 24	27Jan24	PY46 MC11 KX54 DL07
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: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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	Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: N/A Cal Due: N/A Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30Sep2025 TMI: 0692 Cal Due: 30Sep2025 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	454	DIS-111 STR-11 7	27Jan24	RVW
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: 31MAY2024 Record Length Gage Information: TMI: 0889D Cal Due: 30Sep2024 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30Sep2024	450	DAL-111 LT-1 4	27Jan24	RVW CB58

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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
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	427	Del-1111 SCR-111 DL-11 DIS-11 DNT-11 EW-11 BP-11 SKV-11 FL-1 CRK-1 Mex-1 VD-1 (23)	29Jan24	SV43 XN26
1100	CATASY01 Catheter Assembly 1 Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): KPD2 29Jan24	N/A	N/A	29Jan24	KPD2

Notes: N/A
N/A
N/A

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

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
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	427	0	29 Jan 24	APW

Notes: N/A APW 29 Jan 24

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

CREGANNA MEDICAL is part of TE connectivity

Production Order: 500000297999

Material: SA0155-01 Rev F

Production Order Document
Production Order Qty: 500 PC

Batch Number:	0000297999
By:	AP10
Date:	29 Jan 24

Reviewed By: RBZ9
Date: 30JAN24

Notes: N/A AP10 29 Jan 24

Date Printed: 23.01.2024 / 19:46:14

SA0155-01

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Extend to 30Jan2024 J238 12/9/23
Extend to 19Feb2024 J238 1/16/2024

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DEVIATION AUTHORIZATION NUMBER: 2484

*See attached email extension to 24SEP23 TSD 24AUG23

Extend to 22Nov2023 J238 10/18/23

Extend to 21Dec2023 J238 11/27/2023

DEVIATION AUTHORIZATION FORM Extend to 23Oct2023 J238 21Sep23

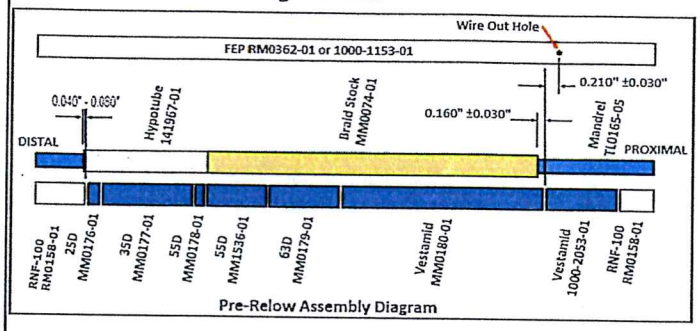
Requestor Name: Udhesh Kapadnis

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.



Pre-Relow Assembly Diagram

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.

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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:

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.

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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~~ ① fixture for inspection. (See image 1)

① MM1536-01 typo correction TS12 10AUG23

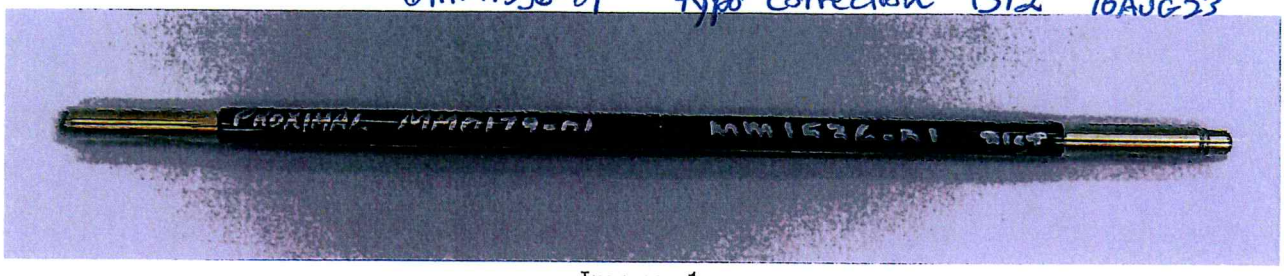

Image- 1

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)

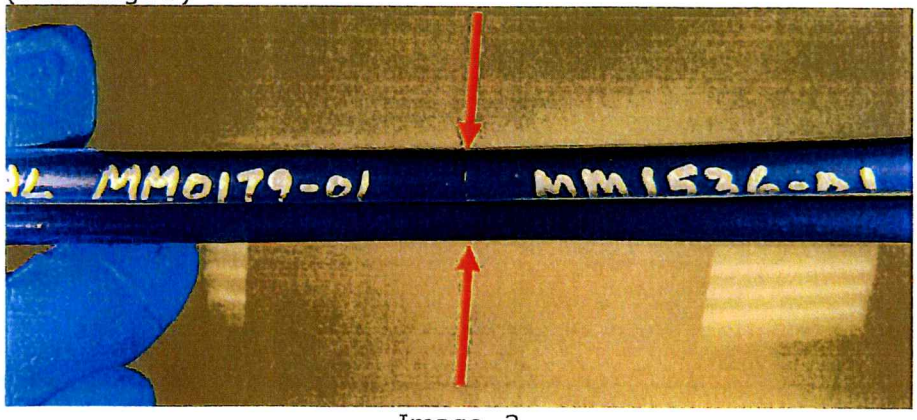

Image- 3

- 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)

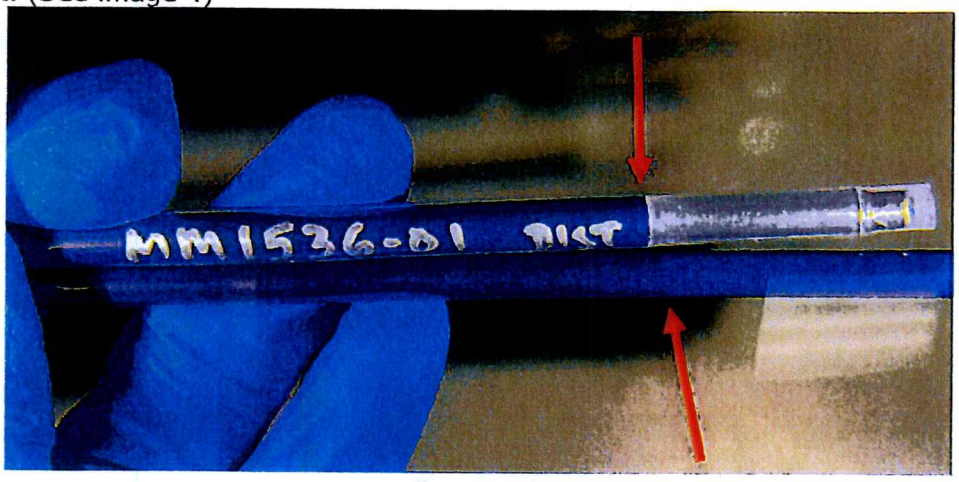

Image- 4

- 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.

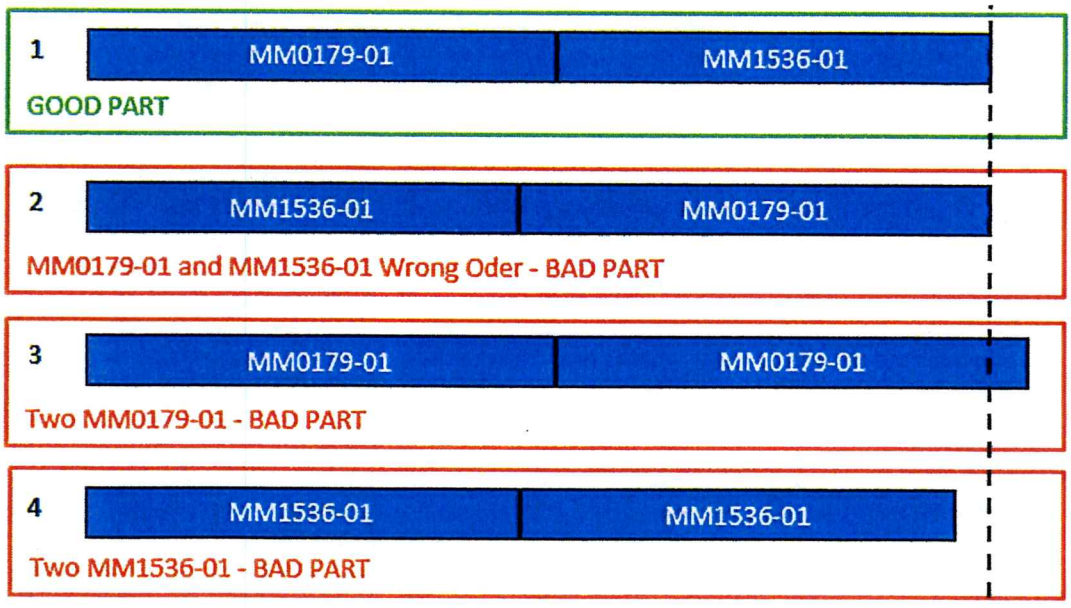

Image – 5

Extend to 14Jan2024 J228 12/12/2023
Extend to 13Feb2024 J228 1/9/2024

CREGANNA MEDICAL is part of TE

CONTROLLED COPY **DEVIATION AUTHORIZATION NUMBER: DA2564**

DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj

Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP

Deviation From:	Deviation To:
Doc #3005206 (Flex Commander MPI0238): OPER850.11: Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.	**Doc #3005206 (Flex Commander MPI0238): OPER850.11:** Using a laser micrometer **at OPER900 (TMI0700-01)**, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.

Justification:

TMI0602 lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable.

TMI0700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified to inspect Dim 6 per ES0647: Laser micrometer equivalency test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.

Part Number Affected	Revision
SA0155-01	H

Start Date:	End Date:	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# 500000297999

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	12:30 AM	430	JY47	26 Jan 24	12:42 AM	415	JY47	26 Jan24	16
TM10745	44	1:07 AM	428	SH85	26 Jan 24	1:19 AM	415	SH85	26 Jan 24	16
TM10745	44	1:20 AM	429	VO78	26 Jan 24	1:32 AM	415	VO78	26 Jan 24	16
TM10745	44	6:50 AM	430	AM47	26 JAN 24	7:02 AM	415	AM47	26 JAN 24	16
TM10745	44	7:20 am	430	OS21	26 Jan 24	7:32 am	415	OS21	26 Jan 24	16
TM10745	44	7:49 AM	430	SN67	26 Jan 24	8:01 AM	415	SN67	26 Jan 24	16
TM10745	44	8:20 am	430	OS21	26 Jan 24	8:32 am	415	OS21	26 Jan 24	16
TM10745	44	9:35 am	430	OS21	26 Jan 24	9:47 am	415	OS21	26 Jan 24	16
TM10745	44	10:10 am	430	OS21	26 Jan 24	10:22 am	415	OS21	26 Jan 24	16
TM10745	44	10:50 am	430	OS21	26 Jan 24	11:02 am	415	OS21	26 Jan 24	16
TM10745	44	11:22 am	430	RV16	26 Jan 24	11:34 am ① ~~11:34 am~~ 12:07 PM ~~12:07 AM~~	415 ① ~~415~~ ② 415	RV16	26 Jan 24 ① ~~26 Jan 24~~	16
TM10745	44	11:55 AM	430	AL67	26 Jan 24			AL67	26 Jan 24	16

① CB58 26Jan24 ② 6155 29Jan24

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PRODUCTION ORDER# 500000297999

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM0745	44	1:10pm	430	OS 21	26Jan24	1:22pm	415	OS 21	26Jan24	11
TM0745	44	1:48pm	430	OS 21	26Jan24	2:00pm	415	OS 21	26Jan24	16
TM0745	44	2:25pm	430	OS 21	26Jan24	2:37pm	415	OS 2	26Jan24	16
TM0745	44	2:48pm	430	OS 21	26Jan24	3:00pm	415	OS 21	26Jan24	14
					N/A					
					OS 21 26Jan24					

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PRODUCTION ORDER# 500000297999

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:50AM	430	SY47	26Jan24	1:02AM	415	SY47	26Jan24	16
TM10942	44	1:20Am	429	SH85	26Jan24	1:32Am	415	SH85	26Jan24	16
TM10942	44	1:55Am	430	SH85	26Jan24	2:07Am	415	V078	26Jan24	16
TM10942	44	6:35am	430	OS21	26Jan24	6:47am	415	OS21	26Jan24	16
TM10942	44	7:05am	430	OS21	26Jan24	7:17am	415	OS21	26Jan24	16
TM10942	44	7:35Am	430	SN67	26Jan24	7:47Am	415	SN67	26Jan24	16
TM10942	44	8:05am	429	OS21	26Jan24	8:17am	415	OS21	26Jan24	16
TM10942	44	8:35am	430	OS21	26Jan24	8:47am	415	OS21	26Jan24	16
TM10942	44	9:55am	430	OS21	26Jan24	10:17am	415	OS21	26Jan24	16
TM10942	44	10:25am	430	OS21	26Jan24	10:37am	415	OS21	26Jan24	16
TM10942	44	11:10am	430	OS21	26Jan24	11:22am	415	OS21	26Jan24	16
TM10942	44	11:40AM	430	CD19	26Jan24	11:52AM	415	CD19	26Jan24	16

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

PRODUCTION ORDER# 508000297999

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:36PM	429	KL45	26JAN24	12:48PM	415	KL45	26JAN24	11
TM10942	44	1:30PM	430	0521	26Jan24	1:42PM	415	0521	26Jan24	16
TM10942	44	2:03PM	430	SD34	26Jan24	2:15PM	415	SD34	26Jan24	16
TM10942	44	2:35PM	430	0521	26Jan24	2:47PM	415	0521	26Jan24	16
					N/A					
					0521	26Jan24				

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

PO #: 5000000297999 **OP #: 500** **Shift #:** 3rd

Total Parts Reworked:		162	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
AB	Air Bubbles	11	2
EH	Exposed Hypotube	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸	45
EW	Exposed Wire	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸	90
MP	Micropores	N/A	N/A
SCR	Scratch	𝍸	5
SKV	Skive Marks	𝍸 111	8
VD	Voids	𝍸 𝍸 11	12
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		LL61.2546.	26Jan24

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 #: 5000002979999 OP #: 500 Shift #: 2nd

Total Parts Reworked:		3	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	1	1
EW	Exposed Wire	11	2
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
N/A	N/A	N/A	0
Inspected By (Sign and Date):		[signature] 25 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 #: 5000029799 **OP #: 750** **Shift #:** 3 st

Total Parts Reworked:		90	
Router Code	**Defect Failure Mode**	**Reworkable Defects (Tally)**	**Total Defects**
DIM07 OS / WO	DIM07 Oversized (Window Open)	𝍸 𝍸 𝍸 𝍸	20
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸	50
N/A	Glue stopper	𝍸 𝍸 𝍸	20
Inspected By (Sign and Date):		D429 · 26 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): ☒

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

PRODUCTION ORDER# 500000297999

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	7:14AM	190°F	PL22	26Jan24	8:24AM	190°F	PL22	26Jan24	27
TM102036	N/A	7:55AM	190°F	PL22	26Jan24	9:05AM	190°F	PL22	26Jan24	45
TM10409	N/A	8:34AM	190°F	PL22	26Jan24	9:44AM	190°F	PL22	26Jan24	42
TM12036	N/A	9:32AM	190°F	YKHO	26Jan24	10:42AM	190°F	YK40	26Jan24	25
TM10409	N/A	10:08AM	190°F	YK40	26Jan24	11:18AM	190°F	YK40	26Jan24	41
TM12036	N/A	10:44AM	190°F	YK40	26Jan24	11:54AM	190°F	YK40	26Jan24	28
TM10409	N/A	11:56AM	190°F	YK40	26Jan24	1:06PM	190°F	YK40	26Jan24	55
TM10409	N/A	1:10PM	190°F	BD64	26Jan24	2:20PM	190°F	BD64	26Jan24	31
TM12036	N/A	1:50PM	190°F	BD64	26Jan24	3:10PM	190°F	BD64	26Jan24	30
TM10409	N/A	3:05PM	190°F	BD64	26Jan24	4:15PM	190°F	BD64	26Jan24	71
TM10409	N/A	4:25PM	190°F	BD64	26Jan24	5:35PM	190°F	BD64	26Jan24	27
TM10409	N/A	4:50AM	190°F	KL45	27JAN24	6:00AM	190°F	KL45	27JAN24	63
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

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

PO #: 5000002979999 OP #: 900 Shift #: 3

Total Parts Reworked:		135	
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 I	61
MP	Micropores	𝍸 𝍸 III	13
SCR	Scratch	𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 𝍸 II	82
SKV	Skive Marks	𝍸 I	6
VD	Voids	𝍸 𝍸 𝍸 𝍸 𝍸 I	26
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized	𝍸 𝍸 III	13
DIM06 OS	DIM06 OD Oversized	𝍸 I	6
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		D207 MC17 KX54 26Jan24	

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	30.43	25.37	26.93	36.52	27.09	32.29	28.79	22.23	30.15	27.83	28.763	3.9233774	4.378	11.5864539	8.542	PASS
Seg B	78.96	80.27	76.73	69.89	70.44	72.12	78.95	74.3	77.39	66.34	74.539	4.6705043	3.981	55.9457226	8.542	PASS
Seg C	73.09	77.29	77.11	76.1	86.13	83.1	86.59	83.64	76.5	85.64	80.519	4.9875945	2.911	66.0001124	8.542	PASS

EDW Commander Flex - Bend and Tensile Strength Testing

LOT #: 500000297999
Date: 29JAN2024
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.