

Production Order: 500000294401



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

Material Type:	ZFRT	Description: Edwards Flex Shaft Commander 155885	Order Type: ZSTD
Production Version:	7987		Project Phase:
Plant / Business Unit:	1213 / AC5		

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials																							
50	KITTING3 Kitting Devices  Kitting Devices	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>AM 685:10 PM 07 Jan 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 11:00 AM 08 Jan 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev Used</th> <th>UOM</th> <th>Qty.</th> <th>Batch No.</th> <th>Actual Qty Used</th> </tr> </thead> <tbody> <tr> <td>MM0179-01</td> <td>D <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000271051</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>N/A</u></td> <td><u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000271063</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000271051</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000271063</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u> <i>07Jan24</i>	<i>DKW</i>
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																								
MM0179-01	D <u>D</u>	PC	500	<u>0000271051</u>	<u>500</u>																								
				<u>N/A</u>	<u>N/A</u>																								
MM1536-01	B <u>B</u>	PC	500	<u>0000271063</u>	<u>500</u>																								

Notes: DA 2484, 2564

N/A

N/A

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<i>N/A</i>		RM0158-01	E	<u>E</u>	PC	200	<u>58497</u>	<u>150</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>86782</u> <u>86787</u> <u>86786</u> <u>86521</u>	<u>200</u> <u>200</u> <u>100</u> <u>100</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000276175</u>	<u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<i>N/A</i>	<i>N/A</i>
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>Bulk</u>		

Notes:

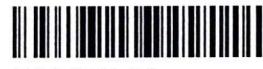
N/A

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		141967-01	02	02	PC	500	82899	525			
							N/A	N/A			
		RM7349-02	C	C	PC	543	82565	560			
							N/A	N/A			
		RM7348-01	C	C	PC	500	78687	① 500 700			
							N/A	N/A			
		RM4001-01	B	B	PC	125	82432	200			
							N/A	N/A			
		RM0607-01	D	D	PC	56	74662	① 60 100			
							71863	① 92 52			
		RM0498-01	C	C	PC	500	0000287519	492			
							N/A	N/A			
		RM0009-04	I	I	PC	1	82971	Bulk			
							N/A	Bulk			
		RM0009-04	I	I	PC	1	82971	Bulk			

Notes:

N/A

N/A

N/A

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① GS85 09 Jan 24

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N/A	MM1538-01	A	<u>A</u>	PC	500	N/A	Bulk			
						0000271052	500			
						N/A	N/A			
		MM1537-01	A	<u>A</u>	PC	1000	0000281413	620		
						0000273843	500			
		MM0177-01	C	<u>C</u>	PC	500	0000278966	500		
						N/A	N/A			
		MM0180-01	E	<u>E</u>	PC	500	0000282489	575		
						N/A	N/A			
	MM0178-01	E	<u>E</u>	PC	500	0000271050	500	N/A	N/A	N/A
						N/A	N/A			
	MM0176-01	D	<u>D</u>	PC	500	0000281411	500			
						0000271036	40			
	MM0074-01	G	<u>G</u>	PC	500	0000291636	519			
						0000286923	30			

Notes:

N/A

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	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	08Jan24	KL95
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	08Jan24	NK62 pm96 AX05 V078 Y014

Notes:

N/A

N/A

N/A

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N/A	Confirmation Reqd(Milestone)	N/A	① 500 N/A	0 N/A	08Jan24 N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	08Jan24	AL34 MY50 5X11 ny35 ST96
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	08Jan24	CY97 CL05 AS31

Notes:

N/A

N/A

N/A

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① mm02 08Jan24

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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 Insert Cut Hypo Tube Confirmation Reqd(Milestone)	500	0	08Jan24	VQ62 LM46 SH23 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	08Jan24	VV25 LM46 CP32 NY35
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 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	08Jun24	RN27 PM96 JY35 SH85 V078 P66
450	CATASY01 Catheter	FEP Removal	500	0	08Jan24	PM96 JY90
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
	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 #: 100-1153-01 Batch #: 87108 Qty: 16 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	483	OF - 1111 BRF - 144 ① EW - 11 EN - HHHII OF - H - ① MAS - 1 17	08-Jan-24	LL61 VC09 DX35 R68 mm02 TD45
	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						
N/A						
N/A						
N/A						

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① ATB9 08-Jan-24

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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 Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	483	0	08 Jan 24	MV78 SV46
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	465	MAS-III EH-1 MIS-III SKV-1 ID-1 18	08 Jan 24	DX35

Notes:

N/A

N/A

N/A

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N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	465	0	08Jan24	ML38
	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> Tipping	465	0	08Jan24	ML38
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	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 # RM4001-01 Batch #: 82432 Qty: 7 Part # RM0607-01 Batch #: 74662 Qty: 5 Part # RM0158-01 Batch #: 58497 Qty: 2 Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	① 465 439 ① 465	0	08Jan24	HT72
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	① ACD-11 H63	ACD-11	08Jan24	5G88 TRN AT39 S44
Notes: N/A N/A N/A						

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(1) mm02 08 Jan24

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	Major Mandrel Removal Confirmation Reqd(Milestone) N/A	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>PASS</u> 2. <u>PASS</u> 3. <u>PASS</u> 4. <u>PASS</u> 5. <u>PASS</u>	462	SKV-1 (1)	09.Jan.23	M LG5 SS52
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	09.Jan.24	S Hox MV33 PP40 ML46
Notes:						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Quality Inspection & Review  Confirmation Reqd(Milestone) <i>(n/a)</i>	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31MAY24</u></p> <p>TMI: <u>n/a</u> Cal Due: <u>n/a</u> TMI: <u>n/a</u> Cal Due: <u>n/a</u> Material Consumed: Part #: <u>Pm4001-01</u> Batch #: <u>82432</u> Qty: <u>16</u> Part #: <u>1000-1153-01</u> Batch #: <u>86782</u> Qty: <u>12</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> </p>	443	MAR-1111 DEL-1 ACD-1 DS-1 #LOS-1 Dis-1111 EW-111 EH-1 #SUS-11 #6w-1 (19)	<i>09Jan24</i> <i>KL67</i> <i>DY29</i> <i>KT47</i> <i>PY46</i> <i>k155</i>	
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>n/a</u> Cal Due: <u>n/a</u> Record Caliper Information:</p>	<i>n/a</i>	<i>n/a</i>	<i>n/a</i>	<i>n/a</i>

Notes:

n/a

n/a

n/a

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N/A	 Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: <u>✓/A</u> Cal Due: <u>✓/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</u> Cal Due: <u>30 Sep 25</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	378	DIS-QP-IHT MAS-1 STR-LHT-IHT 111 DIS-IHT-IHT-IHT IHT-IHT-IHT IHT-IHT-IHT 1 (65)	04 Jan 24	YB36 KL67
1000	 Quality Inspection & Review Confirmation Reqd(Milestone)	Quality Inspection & Review Leak Test Record Inspection Data in SAP ROS Record Leak Tester Information: TMI: <u>1056</u> Cal Due: <u>31 MAY 24</u> Record Length Gage Information: TMI: <u>0889 D</u> Cal Due: <u>30 SEP 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u>	353	OAL-1 LT - IHT-IHT IHT-IHT DCL-1 DL-1 EW-11 (25)	04 Jan 24	KL67 SSH44

Notes:

N/A
N/A
N/A

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N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS Quality Inspection & Review Confirmation Reqd(Milestone)	N/A	324 29	YK95 SV43 10Jan24	YK95
1100	CATASY01 Catheter Assembly 1 	Line Closure Perform Line Closure Settle materials issued to production order (Initial/Date): GS85 09 Jan 24	N/A	N/A	09 Jan 24 GS85	GS85
Notes:						
N/A						
N/A						
N/A						

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1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	324	0 <i>12 Jan 24</i>	<i>AP10</i>	

Notes:*N/A AP10 12 Jan 24*

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Batch Number: 0000294401

By: AP10

Date: 12 Jan 24

Reviewed By:

RB29

Date:

12 JAN 24

Notes:

N/A AP10 12 Jan 24

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Extend to 22 Nov 2023 328 10/22/23
to 20 Dec 2023 328 10/22/23 DEVIATION A

Requestor Name: Uddhesh Kanadnis

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: 2484
See attached email extension to 2484

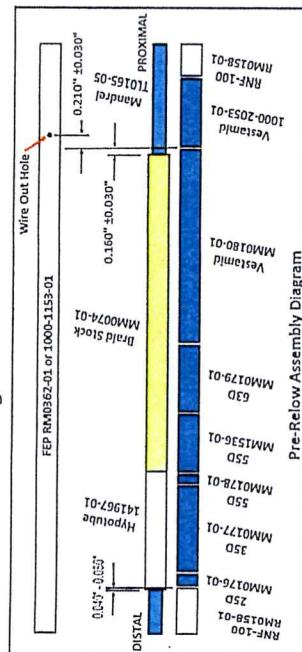
DEVIATION AUTHORIZATION FORM Enters to >3000 to 3003 3008
2008 1008 1003

Requestor Name: Udhesh Kapadnis		
Document Number Affected	3107610	Revision L

Deviation From:

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

Wire Out Hole



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.

are incorrectly assembling MM0179-01 and MM1536-01. A few of experienced inspectors can detect finished unit that ed inspectors may not which potential non-conformance implemented at OP 250, 300, 350 to detect unit built with of inspection at final QC inspection to avoid incorrect

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 units 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

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:	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> 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.	

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:**

① UK55, 23JW 2023

①	DA	2484 2468
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Group Training Record

Description/Objectives of Training:

DA- Inspection at final QC, Op#1050.

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and MM1536-01 fixture for inspection. (See image 1)
① MM1536-01 type connection TS12 10AUG-23

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Image- 1

Step 1:

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



Image- 2

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

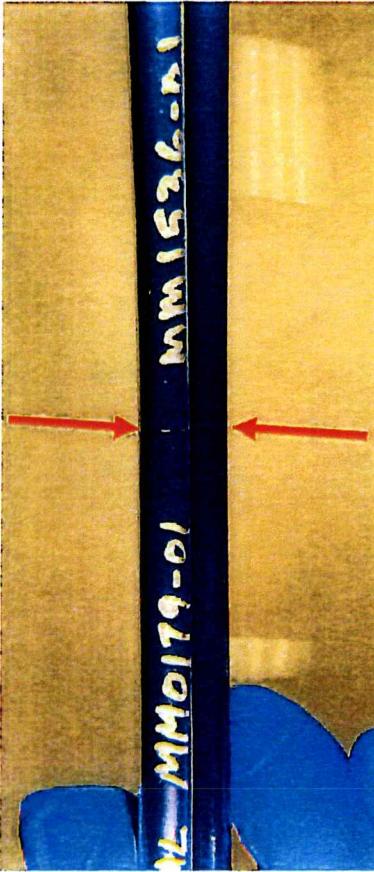


Image- 3

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

CONTROLLED COPY

Step 2:

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

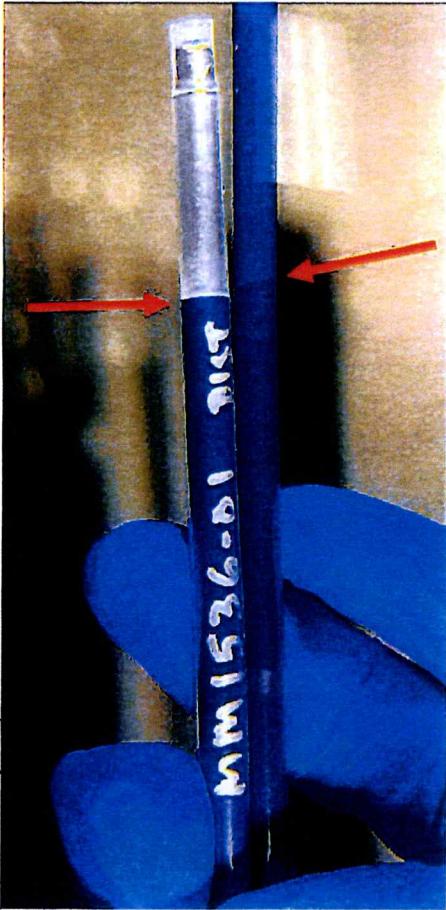


Image- 4

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

1	MM0179-01 GOOD PART	MM1536-01
2	MM1536-01	MM0179-01
MM0179-01 and MM1536-01 Wrong Order - BAD PART		
3	MM0179-01	MM0179-01 Two MM0179-01 - BAD PART
4	MM1536-01	MM1536-01 Two MM1536-01 - BAD PART

Image - 5

Title	Approval Name	Approval Signature	Date
Mgr. Quality Engineering	Hai Nguyen		25 Jul 2023
Mgr. Manufacturing Engineering	Jake Stanislawski		25 Jul 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF

Deviation Authorization

CONTROLLED COPY

DEVIATION AUTHORIZATION FORM

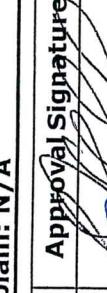
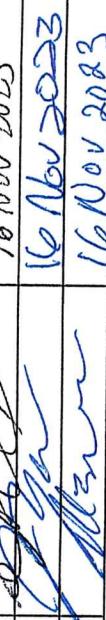
Requestor Name: Krishna Selvaraj

Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	
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.	
Deviation To:	
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.

TM10700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TM10700-01 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 <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			
Corrective Action Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> 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: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> 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

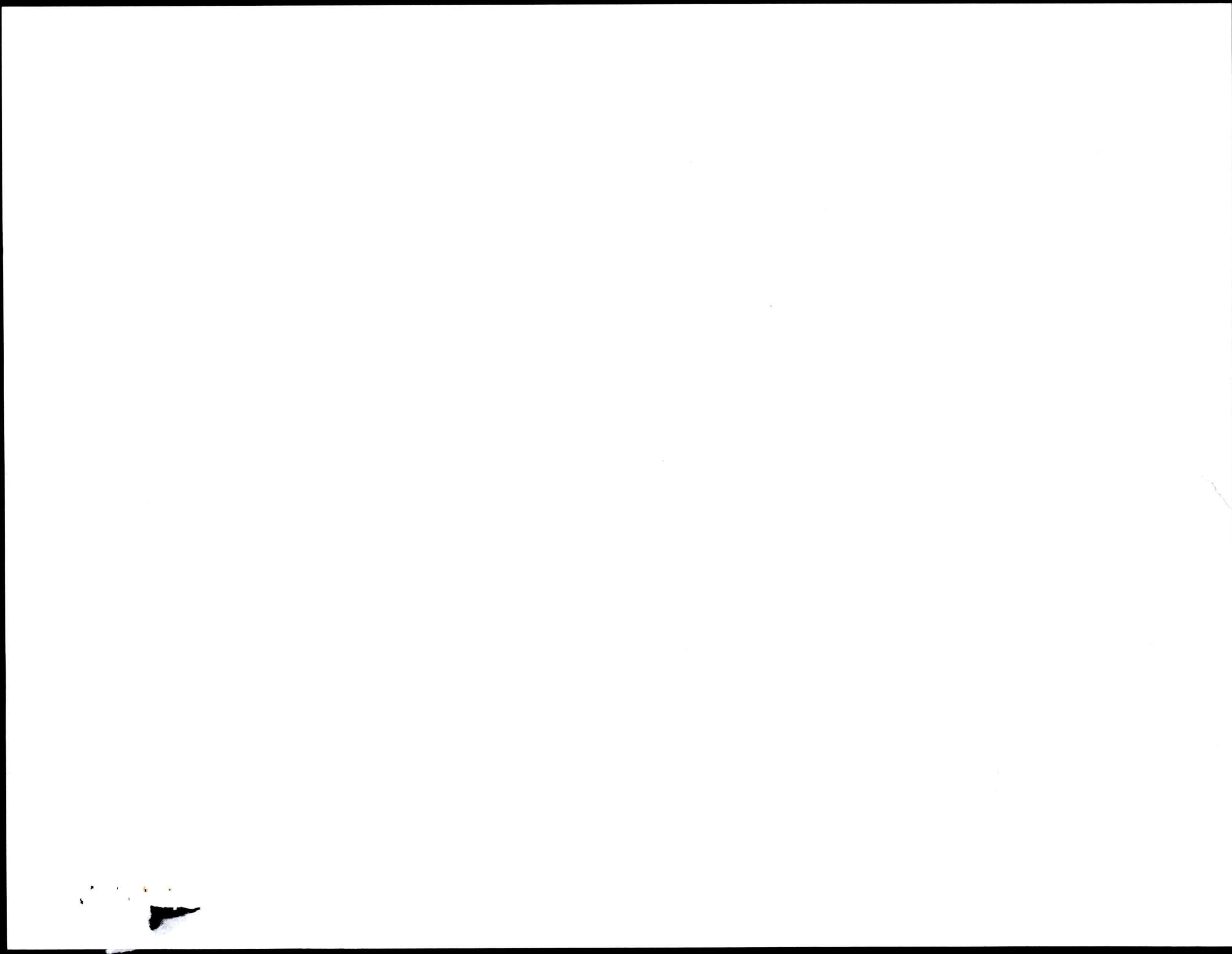


Document No: 5105589
FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000294401

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	11:50am	430	TA36	08Jan24	12:02pm	415	TA36	08Jan24	16
Tm10942	44	12:10PM	430	OS21	08Jan24	12:22PM	415	OS21	08Jan24	16
Tm10942	44	1:25PM	430	AX05	08Jan24	1:37PM	415	AX05	08Jan24	16
Tm10942	44	1:55PM	430	AX05	08Jan24	2:07PM	415	AX05	08Jan24	16
Tm10942	44	2:35pm	430	TA36	08Jan24	2:42pm	415	TA36	08Jan24	16
Tm10942	44	2:55PM	428	AX05	08Jan24	3:07PM	415	AX05	08Jan24	16
Tm10942	44	3:13PM	426	AX05	08Jan24	3:25PM	415	AX05	08Jan24	9
Tm10942	44	4:39pm	430	JY90	08Jan24	4:51pm	415	JY90	08Jan24	16
Tm10942	44	5:23pm	430	V078	08Jan24	5:35PM	415	V078	08Jan24	16
Tm10942	44	6:24pm	430	V078	08Jan24	6:36pm	415	V078	08Jan24	16
Tm10942	44	6:47pm	430	V078	08Jan24	6:59pm	415	V078	08Jan24	16
Tm10942	44	7:20pm	428	SH85	08Jan24	7:32pm	415	SH85	08Jan24	16





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

PRODUCTION ORDER# 50000294401

OP 400



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

PRODUCTION ORDER# 500000294401

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	11:35AM	430	PM 96	08Jan24	11:47 AM	415	PM 96	08Jan24	16
TM10745	44	11:55 AM	428	PM 96	08Jan24	12:07 PM	415	PM 96	08Jan24	16
TM10745	44	12:25PM	430	OS 21	08Jan24	12:37PM	415	OS 21	08Jan24	16
TM10745	44	1:35PM	430	AX05	08Jan24	1:47PM	415	AX05	08Jan24	16
TM10745	44	2:10PM	430	AX05	08Jan24	2:22PM	415	AX05	08Jan24	18
TM10745	44	2:50PM	430	AX05	08Jan24	3:02PM	415	AX05	08Jan24	14
TM10745	44	4:22PM	430	SH85	08Jan24	4:34PM	415	SH85	08Jan24	16
TM10745	44	4:55pm	430	JY90	08Jan24	5:07 pm	415	V078	08Jan24	16
TM10745	44	5:10pm	430	V078	08Jan24	5:22 pm	415	V078	08Jan24	16
TM10745	44	6:39pm	430	V078	08Jan24	6:51pm	415	V078	08Jan24	16
TM10745	44	7:07PM	429	V078	08Jan24	7:19pm	415	V078	08Jan24	16
TM10745	44	7:32pm	430	V078	08Jan24	7:44pm	415	V078	08Jan24	16



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

PRODUCTION ORDER# 50000294401

OP 400



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

PO #: 500000294401 OP #: 500 Shift #: 2nd

Total Parts Reworked:		68	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		3
EW	Exposed Wire		45
MP	Micropores	N/A	N/A
SCR	Scratch		6
SKV	Skive Marks		1
VD	Voids		17
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	08Jan24

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 #: 500000294401 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>28</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>N/A</u>
EH	Exposed Hypotube	<u> </u>	<u>2</u>
EW	Exposed Wire	<u> </u>	<u>21</u>
MP	Micropores	<u>N/A</u>	<u>N/A</u>
SCR	Scratch	<u> </u>	<u>3</u>
SKV	Skive Marks	<u>N/A</u>	<u>N/A</u>
VD	Voids	<u> </u>	<u>2</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
Inspected By (Sign and Date):		<u>HT72 08 Jan 24</u>	

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 #: 500000294401 OP #: 500 Shift #: 2

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 #: 500000294401OP #: 750 Shift #: 2

Total Parts Reworked:		55	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	XXXX XXX XXX XXX XXX XXX	34
DIM07 US / WC	DIM07 Undersized (Window Closed)	XXX XXX XXX XXX	14
EH	Exposed Hypotube	XX II	7
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 08 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):

PRODUCTION ORDER# 500000294401

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	6:20pm	190°F	TRN AT39 SG88	08 Jan 24	7:30pm	190°F	TRN AT39 SG88	08 Jan 24	40
TM12036	N/A	7:00pm	190°F	TRN AT39 SG88	08 Jan 24	8:10pm	190°F	TRN AT39 SG88	08 Jan 24	47
TM10409	N/A	7:46pm	190°F	TRN AT39 SG88	08 Jan 24	8:56pm	190°F	TRN AT39 SG88	08 Jan 24	52
TM12036	N/A	8:11pm	190°F	AT39	08 Jan 24	9:21pm	190°F	AT39	08 Jan 24	27
TM10409	N/A	9:30pm	190°F	AT39	08 Jan 24	10:40pm	190°F	AT39	08 Jan 24	50
TM12036	N/A	10:09pm	190°F	AT39	08 Jan 24	11:10pm	190°F	AT39	08 Jan 24	42
TM10409	N/A	10:55pm	190°F	AT39	08 Jan 24	12:05AM	190°F	AT39	09 Jan 24	56
TM10409	N/A	12:06AM	190°F	AT39	09 Jan 24	1:16AM	190°F	AT39	09 Jan 24	38
TM10409	N/A	1:40AM	190°F	AT39	09 Jan 24	2:50AM	190°F	AT39	09 Jan 24	87
TM10409	N/A	5:15AM	190°F	SSH44	09 Jan 24	6:25am	190°F	SSH44	09 Jan 24	24
	N/A	SSH44	09 Jan 24							



PO #: 50000294401 OP #: 900 Shift #: 1st

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

Total Parts Reworked:		47	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		3
EW	Exposed Wire		22
MP	Micropores	N/A	N/A
SCR	Scratch		38
SKV	Skive Marks	N/A	N/A
VD	Voids		6
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		K155, KT217 0429 P# 46	09 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):

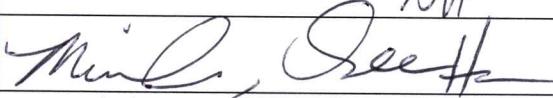
PO #: 500000294401OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		74	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	0
EH	Exposed Hypotube		5
EW	Exposed Wire		26
MP	Micropores	NA	0
SCR	Scratch		53
SKV	Skive Marks		2
VD	Voids		7
DIM01 US	DIM01 OD Undersized	NA	0
DIM06 US	DIM06 OD Undersized	NA	0
DIM06 OS	DIM06 OD Oversized	NA	0
DIM09 US	DIM09 OD Undersized	NA	0
Inspected By (Sign and Date):			08 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):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000294401

OP #: 900 Shift #: 2nd

Total Parts Reworked:		44	
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		17
MP	Micropores	N/A	N/A
SCR	Scratch		42
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized	N/A 09 Jan 24	
DIM06 US	DIM06 OD Undersized	PP40	
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		PP40 08 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):

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	26.18	26.74	27.58	25.55	26.61	25.13	27.96	31.63	25.63	29.6	27.261	2.031477	4.378	18.3671936	8.542	PASS
Seg B	64.54	62.48	65.32	60.72	67.21	59.05	62.94	58.19	62.06	62.66	62.517	2.755911	3.981	51.5457182	8.542	PASS
Seg C	80.05	76.78	77.61	72.47	77.87	81.36	76.92	75.51	77.1	76.22	77.189	2.4151855	2.911	70.1583949	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

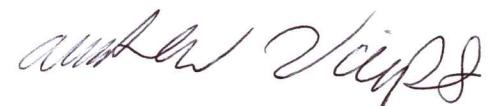
LOT #: 500000294401

Date: 11JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24


11 Jan 24