

Production Order: 500000302934



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 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP *① Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KP02 11:00am 03Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>AL71 5:00pm 03Feb24</u> <u>AL71 10:30 Am 04Feb24</u> Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table border="1"> <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 D</td> <td>PC</td> <td>500</td> <td><u>0000293119</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 B</td> <td>PC</td> <td>500</td> <td><u>0000290560</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 D	PC	500	<u>0000293119</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B B	PC	500	<u>0000290560</u>	<u>500</u>	N/A <i>02Feb24</i>	N/A <i>KP02</i>
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																							
MM0179-01	D D	PC	500	<u>0000293119</u>	<u>500</u>																							
				<u>N/A</u>	<u>N/A</u>																							
MM1536-01	B B	PC	500	<u>0000290560</u>	<u>500</u>																							

Notes: ① Incorrect entry AL71 03Feb24
N/A

DA 2564, 2484

Date Printed: 02/02/2024 / 10:21:46

Page: 1 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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>81054</u>	<u>N/A</u>	<u>N/A</u>			
		1000-1153-01	A	<u>A</u>	PC	594	<u>87670</u>	<u>N/A</u>	<u>200</u>			
							<u>87671</u>		<u>200</u>			
							<u>87672</u>		<u>200</u>			
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>		<u>500</u>			
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u>		<u>500</u>			
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>		<u>N/A</u>			
		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>			
Notes:												
<u>N/A</u>												
<u>N/A</u>												
<u>N/A</u>												

Date Printed: 02/02/2024 / 10:21:46

Page: 2 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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
<i>N/A</i>	<i>N/A</i>	141967-01	02	<u>02</u>	PC	500	<u>85502</u>	<u>512</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82859</u>	<u>565</u>			
		RM7348-01	C	<u>C</u>	PC	500	<u>82879</u>	<u>150</u>			
		RM4001-01	B	<u>B</u>	PC	125	<u>88505</u>	<u>450</u>			
		RM0607-01	D	<u>D</u>	PC	56	<u>82460</u>	<u>100</u>			
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287645</u> <u>0000287644</u> <u>0000287646</u>	<u>379</u> <u>50</u> <u>53</u>	<i>N/A</i>	<i>N/A</i>	<i>N/A</i>
		RM0009-04	I	<u>I</u>	PC	1	<u>79170</u>	<u>Bulk</u>			
		RM0009-04	I	<u>I</u>	PC	1	<u>79170</u>	<u>Bulk</u>			

Notes:

*N/A**N/A**N/A*

Date Printed: 02/02/2024 / 10:21:46

Page: 3 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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	0000290562	N/A	Bulk		
		MM1537-01	A	A	PC	1000	0000290561	N/A	N/A		
		MM0177-01	C	C	PC	500	0000284208	N/A	N/A		
		MM0180-01	E	E	PC	500	0000295774	N/A	N/A	N/A	N/A
		MM0178-01	E	E	PC	500	0000276174	N/A	N/A	N/A	N/A
		MM0176-01	D	D	PC	500	0000288413	N/A	N/A		
		MM0074-01	G	G	PC	500	0000300398	44			
							0000297038	105			

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 4 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting Line Clearance Confirmation Reqd(Milestone)	500	0	05Feb24	KL95
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	0	05Feb24	SNC07 JCG2 pm46 AFSF CD ① NK62

Notes:

N/A
N/A
N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 5 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



① NK62 05 Feb 24

Production Order: 500000302934



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	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock Loading Braid Stock Confirmation Reqd(Milestone)	500	0	05Feb24	PY87 VPC2 SXII
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	05Feb24	RL47 MY50 LMUB

Notes:

N/A
N/A
N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 6 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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	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	05Feb24	ALY2 P222 MLub
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	05Feb24	AL67 AIG5 CD19 UV25 C497 SK11W
Notes:		N/A N/A N/A				

Date Printed: 02/02/2024 / 10:21:46

Page: 7 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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 Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	DY29 TPN SXII
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	05Feb24	SN67 CD19 PM96 APS4 NK62
450	CATASY01 Catheter	FEP Removal	500	0	05Feb24	JC92 AM47 PM96 APS4

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 8 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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 	N/A	N/A	N/A	N/A	N/A
	FEP Removal					
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-0 Batch #: 87670 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	481	EW-111 OF-144444 05 Feb 24 ①	L546 LL601 VC09 CB81 ② 1441 05 Feb 24 ③ 19	
	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
N/A	N/A	N/A	N/A	N/A	MA	N/A
Notes:						
N/A N/A N/A						

Date Printed: 02/02/2024 / 10:21:46

Page: 9 of 18



SA0155-01

0P446 05 Feb 24

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



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)	463	MAH-444 444 DL-44HII 05 Feb ²⁴ IS	05 Feb ²⁴	SCD0 RS23 FRO1 PT159 VA96 AX82
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	463	O	05 Feb ²⁴	B760 FB01 PT159 VA96 AX82

Notes:

NA

NA

NA

Date Printed: 02/02/2024 / 10:21:46

Page: 10 of 18



SA0155-01

CREGANNA
MEDICAL
is part of





Material: SA0155-01 Rev F

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	463	0	05 Feb 24	LH45 F80) PH59 VA96 AY82
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31 MAY 24 TMI: 2083C Cal Due: 31 MAY 24 TMI: 0386 Cal Due: 31 MAY 24 TMI: 0521 Cal Due: 31 MAY 24 Tipping	463	0	05 Feb 24	IC83 STR48 Hv36 RS23
Notes:						
N/A						
N/A						

Date Printed: 02/02/2024 / 10:21:46

Page: 11 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP	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 # <u>PW401-01</u> Batch #: <u>82460</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>	457	EH-4441 ⑥	05 Feb 24	IIC83 STX48 HV36
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		① 448 452	ACD-444 ACD-44 ⑤	05 Feb 24	CD19 SSW44

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 12 of 18



SA0155-01

① KL15 05 Feb 24

CREGANNA
MEDICAL
is part of



Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Major Mandrel Removal NP Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1 	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>	0	452	05Feb24	S552 ML65
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	S H04 MV33 ML46

Notes:

N/A
N/A
N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 13 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



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: TMI: 0700-01 Cal Due: 31may24 TMI: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: 2024001-01 Batch #: 81460 Qty: 15 Part #: 1000-1153-01 Batch #: 87670 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</p>	394	ACD-1 DEL-144 HHT-111 DIS-144-144 HHT-111 Fn-11 #703-111 #7603-111 #H54S-111 wk-11 MAR-111 #905-111 #908-1	05Feb24	PY46 KL55 KT47 XL91 KL61
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: A1A00 Cal Due: 24A ② 12 APR 24 Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 14 of 18

① TMI: 50113B KL67 05Feb24

② KL67 05Feb24



SA0155-01

CREGANNA
MEDICAL
is part of



Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Quality Inspection & Review Confirmation Reqd(Milestone)	TMI: <u>0691</u> Cal Due: <u>31AUG24</u> 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>	300	DIS-144(SP) 44 STR-11 DIS-1 WK-1	05FEB24	0521 XL91 KL67
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: <u>1056</u> Cal Due: <u>31AUG24</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>	363	L-144 HHT HHT 11	05FEB24	SS44 XL91 KL67

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

(1) TMI: 50317 KL67 05 Feb 24
(2) KL67 05 Feb 24

Page: 15 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



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	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	339	SCR - 144 (11 GT) FM - 11 (11) DIS - 111 VD - 144 / FB - 1 KNK - 1 FM - 1 FB - 1 ②4	05 Feb 24	SV43 X0 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP2</u> <u>06 Feb 24</u>	N/A	N/A	06 Feb 24	KP02
Notes:						
N/A						
N/A						
N/A						

Date Printed: 02/02/2024 / 10:21:46

Page: 16 of 18



SA0155-01

① XN26 05 Feb 24

CREGANNA
MEDICAL
is part of

Production Order: 500000302934



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	351	0	06Feb26 mmu7	

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 17 of 18



SA0155-01

CREGANNA
MEDICAL
is part of



Production Order: 500000302934



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0155-01 Rev F

Batch Number: 0000302934

By: mm47

Date: 06feb24

Reviewed By:

RB29

Date:

06feb24

Notes:

N/A

N/A

N/A

Date Printed: 02/02/2024 / 10:21:46

Page: 18 of 18



SA0155-01

CREGANNA
MEDICAL
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Entered to **HENNAH 3228 1215003**
Entered to **13 Feb 2024 3228 1/4/2024**

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj			
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	Deviation To:		
<p>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</p> <p>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.</p>	<p>Doc #3005206 (Flex Commander MPI0238): OPER900 (TMI0700-01):</p> <p>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.</p>		
Justification:			
<p>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.</p> <p>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.</p>			
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:		
16 Nov 23	15 DEC 23		
Lot Number:	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

Batches to 2024-2208 U/A/B3
Excess to 19 Feb 2024 2208 1/16/23 2024
CREGANNA MEDICAL is part of



Extends to 22 Nov 2023 2208 1/16/23 2024
Batches to 2023-2208 1/16/23 2024

DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 24SEPS3
TSIS
24AUG23
23Oct2023 2208 1/16/23 2024

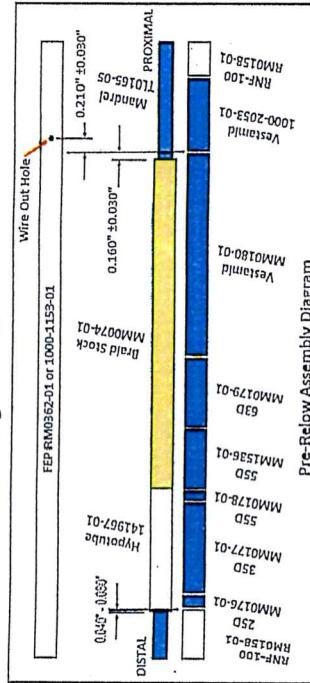
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Requestor Name: Udhesh Kapadnis

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: 26 Jul 2023 **End Date:** 25 Aug 2023 **Lot Number:** 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 FMEAs 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.	<input checked="" type="checkbox"/>	<input type="checkbox"/>

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 Stanislawski		25 Jul 2023
Mgr. Operations	Matthew Benson		25 Jul 2023

FM0002.RevF

Deviation Authorization

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①. UK55, 23JW 2023

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DA | 2484
DA | 2468
①

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)
①MM0179-01 **MM1536-01** **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)

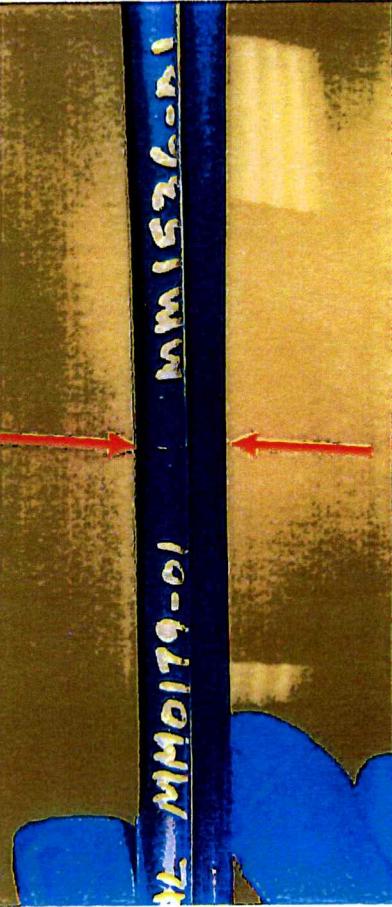


Image- 3

- 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)

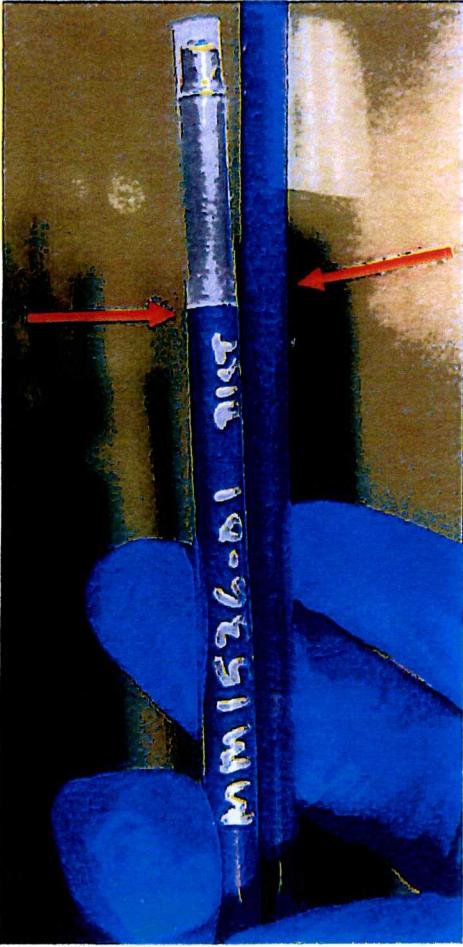


Image- 4

- 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.

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

Image - 5



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER#

500000302934

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	11:48am	430	cm99	04Feb24	12:00PM ^②	415	cm99	04Feb24	16
Tm10942	44	1:35pm	430	YK40	04 Feb 24	1:47pm	415	YK40	04 Feb 24	16
Tm10942	44	4:15pm	430	AL67	04 Feb 24	4:27pm	415	AL67	04 Feb 24	16
Tm10942	44	4:55pm	430	SN67	04Feb24	5:07pm	415	SN67	04Feb24	16
Tm10942	44	5:39pm	430	SN67	04Feb24	5:51pm	415	SN67	04Feb24	16
Tm10942	44	6:21pm	430	SN67	04Feb24	6:33pm	415	SN67	04Feb24	10
Tm10942	44	5:40AM	430	NK62	05Feb24	5:52AM	415	NK62	05Feb24	16
Tm10942	44	6:05AM	427	NK62	05Feb24	6:17AM	415	NK62	05Feb24	16
Tm10942	44	7:00am	430	OS21	05Feb24 ^①	7:12am	415	OS21	05Feb24	16
Tm10942	44	7:40am	430	KL95	05Feb24 ^②	7:52am	415	KL95	05Feb24	16
Tm10942	44	8:00am	429	OS21 ^①	05Feb24 ^③	8:12am	415	OS21	05Feb24	16
Tm10942	44	8:30am	430	OS21	05Feb24	8:42am	415	OS21	05Feb24	16

① 05 21 05 Feb 24

② 04 46 06 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000302934

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	12:09pm	430	YK40	04Feb24	12:21pm	415	YK10	04Feb24	16
Tm10745	44	12:28pm	430	cm99	04Feb24	12:40pm	415	cm99	04Feb24	16
Tm10745	44	2:15pm	430	YK40	04Feb24	2:27pm	415	YK40	04Feb24	16
Tm10745	44	2:50pm	430	SN47	04Feb24	3:02pm	415	SN47	04Feb24	16
Tm10745	44	6:07pm	430	CD19	04Feb24	6:19pm	415	CD19	04Feb24	16
Tm10745	44	5:20am	430	NK62	05Feb24	5:32am	415	NK62	05Feb24	16
Tm10745	44	5:55am	430	KL95	05Feb24	6:07am	415	KL95	05Feb24	16
Tm10745	44	6:30am	430	OS21	05Feb24	6:42am	415	OS21	05Feb24	16
Tm10745	44	7:48am	430	OS21	05Feb24	8:00am	415	OS21	05Feb24	16
Tm10745	44	8:15am	429	KL95	①NK62① 05Feb24	8:27am	415	KL95	05Feb24	16
Tm10745	44	8:45am	430	OS21	05Feb24	8:57am	415	OS21	05Feb24	16
Tm10745	44	9:16am	430	KL95	05Feb24	9:28am	415	KL95	05Feb24	16

①NK62 05 Feb 24



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

PO #: 50000 302934 OP #: 500 Shift #: 3

Total Parts Reworked:		10	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire	##	5
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks		1
VD	Voids		
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

LS46

04 Feb 24 04 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):

OP146 06 Feb 24

correction for LS46



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

PO #: 50000302934 OP #: 500 Shift #: 1st

Total Parts Reworked:

137

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u> </u>	<u>6</u>
EH	Exposed Hypotube	<u> </u> <u> </u> <u> </u> <u> </u> <u> </u>	<u>31</u>
EW	Exposed Wire	<u> </u> <u> </u>	<u>73</u>
MP	Micropores	<u>N/A</u>	<u>N/A</u>
SCR	Scratch	<u> </u>	<u>4</u>
SKV	Skive Marks	<u> </u>	<u>3</u>
VD	Voids	<u> </u> <u> </u> <u> </u> <u> </u>	<u>20</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
Inspected By (Sign and Date):		<u>CB81, LL61, VC09</u>	<u>05 Feb 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):

PO #: 50000302934OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		110	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		5
DIM07 US / WC	DIM07 Undersized (Window Closed)		22
EH	Exposed Hypotube		36
N/A	Glue - stopper		47
Inspected By (Sign and Date):		Hv36 05 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):

PRODUCTION ORDER# 500000302934

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	4:30am	190°F	K155	05Feb24	5:40am	190°F	SS44	05Feb24	33
Tm10409	N/A	6:10am	190°F	SS44	05Feb24	7:20am	190°F	SS44	05Feb24	47
Tm10409	N/A	7:30am	190°F	SS44	05Feb24	8:40am	190°F	SS44	05Feb24	35
Tm10236	N/A	8:05am	190°F	SS44	05Feb24	9:15am	190°F	SS44	05Feb24	35
Tm10409	N/A	8:45AM	190°F	SS44	05Feb24	9:55am	190°F	SS44	05Feb24	36
Tm10236	N/A	9:20 am	190°F	K155	05Feb24	10:30am	190°F	K155	05Feb24	32
Tm10409	N/A	10:10am	190°F	0521	05Feb24	11:20am	190°F	0521	05Feb24	44
Tm10409	N/A	11:20am	190°F	K155	05Feb24	12:30pm	190°F	K155	05Feb24	39
Tm10236	N/A	12:00pm	190°F	K155	05Feb24	1:10pm	190°F	K155	05Feb24	33
Tm10409	N/A	12:40PM	190°F	0521	05Feb24	1:50pm	190°F	KL95	05Feb24	37
Tm10409	N/A	1:50PM	① 190°F	KL95	05Feb24	3:00pm	190°F	KL95	05Feb24	38
Tm10236	N/A	2:30PM	190°F	KL95	05Feb24	3:40 pm	190°F	KL95	05Feb24	39 ① 43
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① KL95 05 Feb24



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000302934

OP #: 900 Shift #: 1st

Total Parts Reworked:		122	
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		22
MP	Micropores	n/a	n/a
SCR	Scratch	 	101
SKV	Skive Marks		1
VD	Voids		16
DIM01 US	DIM01 OD Undersized	n/a	n/a
DIM06 US	DIM06 OD Undersized		13
DIM06 OS	DIM06 OD Oversized	n/a	n/a
DIM09 US	DIM09 OD Undersized	n/a	n/a
Inspected By (Sign and Date):		P746 6/155 RTZ 05 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 #: 500000302934 OP #: 900 Shift #: 2nd

Total Parts Reworked:		56	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		2
EH	Exposed Hypotube	HTT	8
EW	Exposed Wire	HTT	7
MP	Micropores	N/A	0
SCR	Scratch	HTT HTT HTT LHT HTT HTT HTT HTT	42
SKV	Skive Marks		1
VD	Voids		3
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	HTT HTT	11
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		<i>Meilie</i>	05 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	27.45	28.76	28.06	28.31	28.38	26.92	27.99	27.62	28.47	28.7	28.066	0.5871248	4.378	25.4955675	8.542	PASS
Seg B	73.07	62.79	65.45	64.59	68.35	63.92	64.18	61.73	66.87	63.28	65.423	3.3132698	3.981	52.232873	8.542	PASS
Seg C	81.59	80.92	82.05	82.34	79.45	82.79	76.14	81.79	80.33	83.08	81.048	2.0508849	2.911	75.077874	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 #: 500000302934

Date: 06 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

06 Feb 24
J. M. S.