

Production Order: 500000066050



Fusiontron UAE U.A.E. JSC
PC Sheet: 1 of 1

Material: SA0254-06 Rev G

Material Type: ZFRT
 Production Version: 8000
 Plant / Business Unit: 1213 / AC5

Description: Printed Shaft 144C Prox End Color
 B CMDR

Order Type: ZSTD

Project Phase:

Opn No.	Planned WorkCenter Description	Operation Details			Initials
		Comp. Qty.	Scrap Qty & Desc.	Date Comp.	
50	CATASY04 Catheter Assembly 4	Prepare Materials MPI0398 Rev. <u>U</u>			
	Count: Yes	Line Clearance MPI0230 Rev. <u>E</u>			
		By: <u>CL</u>	Date: <u>09 Jan 21</u>		
	Prepare Materials				
	Confirmation Rreqd(Milestone)				
100	CATASY04 Catheter	Straighten First Jacket MPI0398 Rev. <u>U</u>			

Notes: DA 1738 DA 1787

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Opn No.	Planned Work Center Description	Operation Details						Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initials
		Component Number	Req'd Rev	Rev Used	UOM	Qty.	Batch No.				
MM0187-01	E	<u>E</u>	<u>PC</u>		1	<u>0000062288</u>	<u>500</u>	<u>500</u>		<u>09 Jan 21</u>	<u>SP</u>
MM0189-01	D	<u>D</u>	<u>PC</u>		500	<u>000064995</u>	<u>100</u>	<u>400</u>		<u>09 Jan 21</u>	<u>SP</u>

Notes:	N/A

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Opn No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		Component	Req'd Rev	Rev Used	UOM	Qty.	Batch No.				
200	CATASY04 Catheter Assembly 4 	Strain Relief Reflow MPI0398 Rev. <u>U</u> Temp = 420°F 5°F Air Flow = 60 SCFH			PC	500	<u>0000058371</u>	<u>N/A</u>	09 Jan 21	<i>BK</i> <i>SC</i> <i>SP</i> <i>MJ</i> <i>AO</i>	
	Strain Relief Reflow	Component	Req'd Rev	Rev Used	UOM	Qty.	Batch No.	Actual Qty Used			
	Confirmation Reqd(Milestone)	MM0527-01	B	<u>3</u>	PC	500	<u>0000058371</u>	<u>500</u>	<u>N/A</u>		
		RM0096-01	F	<u>F</u>	PC	125	<u>27976</u>	<u>180</u>	<u>N/A</u>		
250	CATASY04 Catheter Assembly 4 	Position Tubing For Reflow MPI0398 Rev. <u>U</u>			PC	188	<u>0</u>	09 Jan 21	<i>AP</i>		
		Component	Req'd Rev	Rev Used	UOM	Qty.	Batch	Actual			
	Notes:										

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Opt. No.	Planned WorkCenter Description	Operation Details						Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initials
		Number	Rev	Used	No.	Qty Used					
	Position Tubing for Reflow	MM0186-00	D	D	PC	500	208-061101	500			
		MM0523-03	C	C	PC	500	0000059871	500			
		MM0524-01	B	B	PC	500	0000058676	500			
		MM0530-01	B	B	PC	500	0000057812	500			
		RM7586-02	D	D	PC	500	25632	260			
		RM8745-01	B	B	PC	500	27613	240			
		MM0185-01	I	I	PC	500	0000058372	200			

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Op No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initiator
		A	PC	500	00000060069	500				
	MM1540-01	A	PC	500	00000060069	500	N/A			
	MM1539-01	A	PC	500	00000060061	500	N/A			
	RM016101-MED	F	F	PC	46	N/A				
					26704	100				
300	CATASY04	Reflow	MPI0398 Rev. L		79	0	option 21	Vb/J		
	Catheter Assembly 4				417	0	option 24	MS		
		Reflow								
350	CATASY04	Skive Heat Shrink	MPI0398 Rev. Y		250	0	11 Jan 21	JK		
	Catheter Assembly 4				246	0	11 Jan 21	Pry		
		Notes:								

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Vb/J option 21

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Opn No.	Planned WorkCenter Description	Operation Details			
		Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initiator
400	CATASY04 Skive Heat Shrink	248	2EW	11Jan21	YK
450	CATASY04 Catheter Assembly 4 Count: Yes In Process Inspection	245	1EW	11Jan21	Pxy
	In-Process Inspection (Visual Inspection) MPI0398 Rev. U FM5104693 (Rework if needed. Use FM5104983)				
	Anneal Shaft MPI0398 Rev. U FM5104692	248	0	11Jan21	YK
	Anneal Shaft	245	0	11Jan21	Pxy

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PA

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Opn No.	Planned WorkCenter Description	Operation Details					
		Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials		
500	CATASY04 Catheter Assembly 4 	81 393	900 fail 14 to offat 10 opfail	11 Jan 21	CKW		
	Leak Test/Prox Cut/Ring Gage-Dim 13/21 		NY(
550	CATASY04 Catheter Assembly 4 	81 393	0 0	11 Jan 21	CKW		
	Distal Cut MPI0398 Rev. Y Line Closure MPI0230 Rev. E By: <u>MU</u> Date: <u>11 Jan 21</u>						
600	PADPRIN1 Pad Print Count: Yes 	474	0	12 Jan 21	PK		
	Pad Print Set Up MPI0276 Rev. D Line Clearance MPI0230 Rev. E						
	Notes:	N/A					

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connectively

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Opn No.	Planned WorkCenter Description	Operation Details	
	Pad Print Setup	By: <u>PK</u>	Date: <u>12 Jan 21</u>
		<p>TM10503 (circle TM1 used) Cliché - TL0525 Ink # RM7407-01 Thinner - RM7408-01 Hardener - RM7409-01 Customized Measuring Equipment - Caliper Inspection Gauge TM10843 Setup Rod # TL0815 Program - #10 Ink Viscosity (REF) -5 to 6 Pad - TL0545 or equivalent Fence - TL0538 Drying Oven - TM10643 Drying Racks-TL0531, TL0532</p> <p>N/A</p>	<p>TM10735 Cliché - TL0567 Ink - RM7407-01 Thinner - RM7408-01 Hardener - RM7409-01 Customized Measuring Equipment - Caliper Inspection Gauge TM10843 Setup Rod # TL0815 Program - #10 Ink Viscosity (REF) -5 to 6 Pad - TL0545 or equivalent Fence - TL0569 Drying Oven - TM10643 Drying Racks-TL0531, TL0532</p> <p>N/A</p>

Notes:	<u>N/A</u>

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Opn No.	Planned WorkCenter Description	Operation Details						Initials
		Comp. Qty	Scrap Qty & Desc.	City	Date Comp.	Comp. Qty	Comp. Qty	
650	PADPRIN1 Pad Print 	Verification MPI0276 Rev. <u>D</u> Section 15.0				474	0	12/Jan/21 PK

Notes:

V/A

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Opn No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
		B	B	L	0.005	TP53072	0.005				
700	PADPRIN1	RM7408-01	B	B	L	N/A	N/A				
		RM7409-01	B	B	L	0.010	26764	0.010			
						N/A	N/A				
750	PADPRIN1	Pad Print	Prepare Surface for Ink	MP10276 Rev. D	Section 15.5	Polynit wipes	474	0	12 Jan 21	PK	
						99% IPA					
			Prepare Surface for Ink								

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Opn No.	Planned WorkCenter Description		Operation Details			
			Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initiates
800	PADPRIN1 Pad Print 	In-Process Inspection and Rework MPI0276 Rev. <u>D</u> Section 30.0 Polynit Wipes 99% IPA Mag Light	474	0	12 Jun 21	PK
850	PADPRIN1 Pad Print 	Curing Oven MPI0340 Rev. <u>B</u> Section 35.0 Curing Oven Parts sit for 8 hours minimum after curing oven Confirmation Reqd(Milestone)	474	0	12 Jun 21	KUT
900	PADPRIN1 Pad Print	Transfer Parts to Production MPI0276 Rev. <u>D</u> Section 40.0	474	0	13 Jun 21	PK
Notes:						

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty	Scrap Qty	Date Comp.	Initiator
			Qty.	& Desc.		
		Transfer Parts to Line Time: <u>7:00 AM</u> By: <u>PK</u> Date: <u>13 Jan 21</u>				
	N/A	Transfer parts to Production Confirmation Rreqd(Milestone)				
950	PADPRIN1	Cleaning MPI0276 Rev. <u>D</u> Section 50.0 Count: Yes Line Clearance MPI0230 Rev. <u>E</u> By: <u>PK</u> Date: <u>12 Jan 21</u>	474	0	12 Jan 21	PK
		Cleaning Confirmation Rreqd(Milestone)				
1000	CATASY04	In-Process Dimensional Inspection				
		Notes: <u>N/A</u>				

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Op No.	Planned WorkCenter Description	Operation Details					
		Comp. Qty	Scrap Qty & Desc.	Date Comp.	Initiator	Comments	Op No.
	Catheter Assembly 4	MPI0398 Rev. <u>11</u> FM5104662 FM5104696 (No Rework can be done at this OP)	90 441 321	240D Fail 39 DB FAI	15 Jan 21	WT	
	In-Process Dimensional Inspection	Line Closure MPI0230 Rev. <u>E</u> By: <u>WT</u> Date: <u>14 Jan 21</u>					
1050	QUALITY1	Required Inspection Perform Quality Inspection per QIP Document #3107613 Record Data in SAP Inspection Plan		10-77 860000000000000000 2- Sy/over 370D-05- 276 PRT-21 18 Feb 21 SCR-7 DS - 3 Disc- 2 SFM-1 EW - 1 SKV - 1		AP	
		Quality Inspection & Review					
		Quality Inspection & Review					
		Confirmation Rreqd(Milestone)					

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AP 18 FEB 21
AB 18 FEB 21
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Opn No.	Planned Work Center Description	Operation Details					
		Comp. Qty	Scrap Qty	Qty Desc.	Date Comp.	Initials	
1070	CATASY04 Catheter Assembly 4	Rework MPI0398 Rev. U	Material consumed NAK	Batch NAK	Rev NAK Qty NAK		
			Material NAK	Batch NAK	Rev NAK Qty NAK		
			Material NAK	Batch NAK	Rev NAK Qty NAK		
			Material NAK	Batch NAK	Rev NAK Qty NAK		
			Material NAK	Batch NAK	Rev NAK Qty NAK		
1090	QUALITY1	Required Inspection Perform Quality Inspection per QIP Document #3107613 Record Data in SAP Inspection Plan		276 0	18Feb21 AP		
	Quality Inspection & Review						
	Quality Inspection & Review						
	Notes:						

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Opn Nr.	Planned WorkCenter Description	Operation Details			
		Comp. City:	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone)				
1100	PACKINT1 Packing assembly	Packaging Instructions SPI0087 REV. <u>H</u>	0 16 21 140021 ES		

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Batch Number: 0000066050

By: FJ

Date: 18 Feb 21

Reviewed By:

Date: 18 Feb 21

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Attachment B: Cause of Rework.

OPER 400.0

Date	Initial	AB (Prox)	AB (Distal)	DF	DS	EW	FM	Disc	SCR	SKV	VD
11 Jun 21	YK	/	//	○	○	2	4	○	9	○	○
11 Jun 21	Pny	○	6	○	○	○	2	○	○	○	○
							N/A				

Attachment B: Cause of Rework

OPER 500.0

Date	Initial	Dim 13 (Go Gauge)	Dim 21 (Go gauge)
11 Jun 21	Pny, MCL	○	146

66050

PRODUCTION ORDER#

OPER 400.0

In-Process Inspection

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
Using a magnification light, visually inspect the entire length of the shafts.	N/A	100%	2.85x Mag. Light		496	0	PMY 11 Jan 21
Metallic Foreign Material: No embedded metallic and foreign material is allowed along the length of the shaft.	N/A	100%	2.85x Mag. Light		496	0	
All other Foreign Material:							
Particle Size Area: mm ²	Acceptable Limits per Part	See Table	100%	Tappi Chart and 2.85x Mag. Light	496	0	
< 0.05 mm ²	No Limit						
0.05 mm ² ≤ Area < 0.25 mm ²	3						
0.25 mm ² ≤ Area < 0.80 mm ²	2						
0.80 mm ² ≤ Area ≤ 1.5 mm ²	1						
> 1.5 mm ²	0						
No surface damage to the shafts such as voids pits or cuts. (interior surface of distal end not included)	N/A	100%	2.85x Mag. Light		496	0	
No bumps, lumps, or, protrusions along the shaft that will compromise the OD. Verify all protrusions to make sure the OD is still within specification.	N/A	100%	2.85x Mag. Light		496	0	
No flat spots, kinks, delamination, gaps between material transitions and material transitions should not exhibit cracking, no exposed or apparent braid.	N/A	100%	2.85x Mag. Light		493	3	
Verify all ODs along the entire length of shaft are within specification according to print/drawing requirements.	See QA Inspection Requirement	100%	See QA Inspection Equipment		493	0	PMY 11 Jan 21



Document No: FM5104694

Rev: B

Document Type: Manufacturing Form

Title: SA0254 Max OD Gauge Check Form

PRODUCTION ORDER# 5000000000

OPER 500.0 ▲13 & ▲21 Max OD Gauge Check for the manufacturing lot PRIOR TO AND AFTER Inspection

Before & After Inspecting Parts	Dimension ## Gauge Check	TMI####XX (Ex. TMI0748AC or TMI0747AD)	Initials	Date	Time
Before	Dimension 13	TMI 0748 AN	CL	11 Jan 21	12:10 PM
Before	Dimension 21	TMI 0747 U	CL	11 Jan 21	12:10 PM
After	Dimension 13	TMI 0748 AN	LJ	11 Jan 21	12:25 AM
After	Dimension 21	TMI 0747 U	LJ	11 Jan 21	12:25 AM

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OPER 500.0 Pressure Decay Testing						
Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail
Air Leak Test GN 15	N/A	100%	Issac Pressure Decay Tester	TM10797	493	0
Outer Diameter ▲13 MAX OD at Pad Printed Area	$0.145" +0.002"/-$ $0.004"$ ($\leq 0.147"$)	100%	Ring Gauge TM10748 or equivalent	TM10748	474	14
Outer Diameter ▲21 MAX OD	$0.157" \pm 0.003"$ ($\leq 0.160"$)	100%	Ring Gauge TM10747 or equivalent	TM10747	474	0



PRODUCTION ORDER# 66050

OP 1000.0 ▲ 13, ▲ 21 Max OD Gauge Check for the manufacturing lot PRIOR TO AND AFTER Inspection

Before & After Inspecting Parts	Dimension ## Gauge Check	TMI###XX (Ex. TMI0748AC or TMI0747AD)	Initials	Date	Time
Before	Dimension 13			15 Jan 21	11:10 AM
		TMI 0748 AM	CL	15 Jan 21	12:10 PM
Before	Dimension 21			15 Jan 21	11:10 AM
		TMI 0747 u	CL	15 Jan 21	12:10 PM
After	Dimension 13			16 Jan 21	6:40 AM
		TMI 0748 AM	CL		
After	Dimension 21			16 Jan 21	6:40 AM
		TMI 0747 T	CL		

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OP 1000.0

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
Outer Diameter ▲3 MAX OD at Pad Printed Area	0.145" +0.002"/-0.004" (≤0.147")	100%	Ring Gauge TMI0748 or equivalent	TMI 0748A97	474	0	cky 15 Jan 21
Outer Diameter ▲21 MAX OD	0.157" ± 0.003" (≤0.160")	100%	Ring Gauge TMI0747 or equivalent	TMI 0747A97	468	4	cky 15 Jan 21
Outer Diameter ▲2 MAX OD	0.142" ± 0.002" (0.140"-0.144")	100%	Ring Gauges TMI0967, or equivalent	TMI 0967A97	445	23	cky 15 Jan 21
Outer Diameter ▲2 MIN OD	0.142" ± 0.002" (0.140"-0.144")	100%	Ring Gauges TMI0968, or equivalent	TMI 0968A97	445	0	cky 15 Jan 21
Outer Diameter ▲18 MAX OD	0.140" ± 0.002" (0.138"-0.142")	100%	Two Axis Laser Micrometer	TMI 50049	415	30	WT 15 Jan 21
Outer Diameter ▲18 MIN OD	0.140" ± 0.002" (0.138"-0.142")	100%	Two Axis Laser Micrometer	TMI 50049	415	0	WT 15 Jan 21

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Document No: FM5104696

Rev: B

Document Type: Manufacturing Form
Title: SA0254 In-Process Inspection Form

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
Outer Diameter ▲3 AVG OD at Pad Printed Area Measure from distal end of material transition to stop sleeve shoulder NOTE: Measure AVG OD and record results	0.145 +0.002"/-0.004" (0.141"-0.147")	100%	Two Axis Laser Micrometer 50049	TM2 4/15	0	0	NT 15 Jan 21
Outer Diameter ▲21 AVG OD Measure from stop sleeve shoulder to 4" distal of stop sleeve shoulder. NOTE: Measure Avg OD and record results	0.157" ± 0.003" (0.154"-0.160")	100%	Two Axis Laser Micrometer 50049	TM2 4/15	0	0	NT 15 Jan 21
Outer Diameter ▲7 AVG OD Measure 4" distal the stop sleeve shoulder to the braid termination. NOTE: Measure and Record results	0.157" ± 0.003" (0.154"-0.160")	100%	Two Axis Laser Micrometer 50049	TM2 4/11	4	4	NT 15 Jan 21
Outer Diameter ▲2 MAX OD Measure distally from the braid termination to the all the way distal end of the shaft.	0.142" ± 0.002" (0.140"-0.144")	100%	Two Axis Laser Micrometer 50049	TM2 4/11	0	0	NT 15 Jan 21
Outer Diameter ▲2 MIN OD Measure distally from the braid termination to the all the way distal end of the shaft.	0.142" ± 0.002" (0.140"-0.144")	100%	Two Axis Laser Micrometer 50049	TM2 4/11	0	0	NT 15 Jan 21

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PRODUCTION ORDER#

OPER 1050.0

Date	Initial	AB	DISC	DF	DS	EW	FM	OD	SCR	SKV	VD	OTHER

Record total quantity reworked:

N/A

Quantity Passed after Rework:

N/A

Rework Performed by: N/A Date: N/A Rework Performed by: N/A Date: N/A

Re-Inspection Performed by: N/A Date: N/A

Operation Manager Quality Manager Ops mgmt Steve-Julie Mich Gpar Mo 10/22/2015	Match-Qpatz ① Hilary	19 DECEMBER 2015
Mfg Engineering manager Renate Holahan	APPROVAL SIGNATURE	Date
Title	APPROVAL NAME	APPROVAL SIGNATURE

Training Required:	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	If no, explain: N/A
--------------------	---	---------------------

If no, explain:	Deviation talks about recording the variable data at a operation where we are already checking for the dimension.
Corrective Action Required:	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No

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

Risk Assessment:	Excluded from QFEL21. At affected QFEL21				
Start Date:	End Date:	Lot Number:	1/9/2021	N/A	
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
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:					

Part Number Affected	Revision	SA0254 - 04/05/06
N/A		
51		

As per the customer requirement we are starting to record the variable data for dimension 12 and 13 at "inline dimensional inspection operation".		
Justification:		

Deviation From:	Currently at "inline dimensional inspection operation" operators record the variable data for Dim 12 and Dim 13. 10 samples from each lot. Variable data record form to be filled by ops just check the dimension using laser mic and ring gauges and do not record any variable data.
Deviation To:	Record the variable data for Dim 12 and Dim 13. 10 samples from each lot. Variable data record form to be filled by ops department ops lead to add to the excel file to monitor variable data behavior.

Document Number Affected	Revision	MP10398
N/A		

Requestor Name:	Govind Sharma
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DEVIATION AUTHORIZATION FORM

DEVIATION AUTHORIZATION NUMBER: DA1738



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Sample	Dim 12 (Max) $0.142'' +/0.002$	Dim 12 min $0.142'' +/-0.002$	N/A	Dim 13 Avg $0.145'' +0.002'' -0.004''$	Dim 13 Max $0.145'' +0.002'' -0.004''$	Test Description: Dim 12 and 13 variable data recording	Tested by: CKy	Lot Number: S00000066050	Part Number: SA0254-xx Q6
1	0.1429	0.1425	0.1450	0.1455	0.1461	0.1429	0.1424	0.1429	0.1424
2	0.1429	0.1424	0.1444	0.1451	0.1451	0.1429	0.1424	0.1429	0.1424
3	0.1421	0.1406	0.1447	0.1452	0.1452	0.1421	0.1406	0.1421	0.1406
4	0.1430	0.1420	0.1420	0.1452	0.1461	0.1430	0.1420	0.1430	0.1420
5	0.1428	0.1424	0.1424	0.1455	0.1461	0.1428	0.1424	0.1428	0.1424
6	0.1436	0.1425	0.1446	0.1455	0.1461	0.1436	0.1425	0.1436	0.1425
7	0.1417	0.1411	0.1455	0.1461	0.1461	0.1417	0.1411	0.1417	0.1411
8	0.1425	0.1418	0.1446	0.1454	0.1461	0.1425	0.1418	0.1425	0.1418
9	0.1426	0.1414	0.1445	0.1451	0.1461	0.1426	0.1414	0.1426	0.1414
10	0.1429	0.1424	0.1446	0.1456	0.1461	0.1429	0.1424	0.1429	0.1424
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TEST DATA SHEET

Requestor Name: Saroenu Chhum																			
Document Number Affected: 2100586																			
Revision: B																			
Deviation From: 100% Inspections at Final Inspection (Do not Require SmartSolve Notification to be issued).																			
<p>The following rules apply to these product families: If SmartSolve Notification is not required for any sum of scraps at final inspection: For products listed below, SmartSolve Notification is not required for any sum of scraps at final inspection: SA0286-01 & -02; SA0254-04, -05 & -06; SA0155-01</p> <p>There is a characteristic that is 100% inspected at Final Inspection, and this product is an Edwards product line there is a 35% allowance to scrap at final inspection.</p> <p>All lots undergo 100% visual inspection; therefore, there is no risk to the customer for lots released without documentation in the SmartSolve notification.</p>																			
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<p>Risk Assessment:</p> <p>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):</p> <p>If yes to any of the above, what controls are being put in place to mitigate the risk: N/A</p> <p>Corrective Action Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No</p> <p>If no, explain: No corrective action is required, SAP will address all lot manufactured in the new system.</p> <p>Training Required: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No If no, explain:</p>																			
<table border="1"> <tr> <td>Quality Director</td> <td>Jeff Pumper</td> <td>Approval Signature</td> <td>Date</td> </tr> <tr> <td>OPS Manager</td> <td>Zach Nelson</td> <td>Vivek Rangaswami PETRE</td> <td>15 JAN 2021</td> </tr> <tr> <td>Staff Engineer</td> <td></td> <td>WCU 15 JAN 2021</td> <td>15 JAN 2021</td> </tr> </table>				Quality Director	Jeff Pumper	Approval Signature	Date	OPS Manager	Zach Nelson	Vivek Rangaswami PETRE	15 JAN 2021	Staff Engineer		WCU 15 JAN 2021	15 JAN 2021				
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Maximum Force Reached During Tensile Test
 (10 samples accepted from final inspection for each lot shall be randomly 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	33.46	28.11	27.96	26.12	28.51	28.41	31.64	28	26.41	24.1	28.272	2.6674116	4.378	16.59407248	8.542	PASS
Seg B	21.84	21.56	22.26	22.16	24.68	21.62	22.84	21.74	23.75	25.23	22.768	1.3337316	4.378	16.92892302	8.542	PASS
Seg C	52.22	66.3	68.12	49.44	51.64	55.4	60.59	66.32	68.98	68.82	60.783	7.8973161	4.378	26.20855025	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 not being required for DA acceptance.

Kochyukov

21 JAN 21