

# Production Order: 500000294402



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 Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>K02 5:20am 08 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XCS 10:20pm 08 JAN 24</u> Record Dryer Shelf #: <u>N/A</u>				
	Kitting Devices	Component Number Req'd Rev UOM Qty. Batch No. Actual Qty Used				
		MM0179-01 D D PC 500 <u>000276172</u> 500				
				<u>N/A</u>	<u>08Jan24</u>	<u>DFOO</u>
		MM1536-01 B B PC 500 <u>000281412</u> 500				

Notes: DA2484, 2564

N/A

N/A

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N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u>	<u>N/A</u>		
							<u>58497</u>	<u>200</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u>	<u>N/A</u>		
							<u>87010</u>	<u>200</u>		
							<u>86799</u>	<u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>86788</u>	<u>200</u>		
							<u>0000278880</u>	<u>400</u>		
							<u>0000268040</u>	<u>130</u>	<u>N/A</u>	<u>N/A</u>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000276175</u>	<u>500</u>		
							<u>N/A</u>	<u>N/A</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</u>		
							<u>N/A</u>	<u>Bulk</u>		
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>		
							<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

N/A

N/A

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N/A	N/A	141967-01	02	02	PC	500	82999	511		
		RM7349-02	C	C	PC	543	82566	N/A		
		RM7348-01	C	C	PC	500	78688	551		
		RM4001-01	B	B	PC	125	82433	N/A	N/A	N/A
		RM0607-01	D	D	PC	56	74662	200	N/A	N/A
		RM0498-01	C	C	PC	500	0000287519	60	N/A	N/A
		RM0009-04	I	I	PC	1	82971	500		
		RM0009-04	I	I	PC	1	82971	N/A		

### Notes:

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① GS85 10 Jan 24

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>N/A</u>	<u>Bulk</u>		
							<u>0000271052</u>	<u>500</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>N/A</u>	<u>N/A</u>		
							<u>0000381413</u>	<u>1000</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000278966</u>	<u>500</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000352489</u>	<u>400</u>	<u>N/A</u>	<u>N/A</u>
		MM0178-01	E	<u>E</u>	PC	500	<u>0000275691</u>	<u>100</u>		
							<u>0000276174</u>	<u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000281411</u>	<u>500</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000286928</u>	<u>520</u>		
							<u>N/A</u>	<u>N/A</u>		

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
P/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	500	0	09Jan24	V078
	Line Clearance					
	Confirmation Reqd(Milestone )					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	09Jan24	AS31 J790 pm96 NK62
	Major and Minor Mandrel Assembly					
<b>Notes:</b>						
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
P/A	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
200	CATASY01  Catheter Assembly 1  	Loading Braid Stock	500	0	09Jan24	y014 CL05 VP62 SX11
	Loading Braid Stock					-
	Confirmation Reqd(Milestone )					-
250	CATASY01  Catheter Assembly 1  	Trim Braid Wire at Proximal End	500	0	09Jan24	CP32 NY35 PL34 CY97
<b>Notes:</b>						
N/A						
N/A						
N/A						

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P/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	09Jan24	SH23 GS22 MU50 LM46
350	CATASY01  Catheter Assembly 1	Load Tubing	500	0	09Jan24	ST96 NY35 V078 W125 DV39

**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
	 Load Tubing  Confirmation Reqd(Milestone)	P/A	P/A	P/A	P/A	P/A
400	<b>CATASY01</b> Catheter Assembly 1  Reflow  Confirmation Reqd(Milestone)		500	0	Jan 24 ST 85 NY 35 V 078 PM 96 RN 27	
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	Jan 24 SE 88 PM 96	

**Notes:**

N/A  
N/A  
P/A

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	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 #: 100-1153-0 Batch #: 87010 Qty: 10 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	480	OF - HHT HHT 1111 EW - HHT 1 (20)	07Jan24 HT72 num02 TD45 LL61 CB81 TA36	P66
		N/A	N/A	N/A	N/A	N/A
	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
550	CATASY01  Catheter Assembly 1  	Remove Heat Shrink & Mandrel	480	0	(1) 09Jan24	LL61 RS23 AX 82
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly    Distal Tip Assembly  Confirmation	Distal Tip Assembly	471	MATT - 444 OF - 11 DL - 11  (9)	09Jan24	VA96 RS23 AX82

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	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	471	0	07Jan24	V96 A+Z2 DV39
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: 038C Cal Due: 31 may 24 TMI: 0521 Cal Due: 31 may 24 Tipping	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31 may 24 TMI: 2083C Cal Due: 31 may 24 TMI: 038C Cal Due: 31 may 24 TMI: 0521 Cal Due: 31 may 24	471	0	07Jan24	STX48 Hv36

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  	<b>Tip Inspection/ Flash Removal</b> <b>Material Consumed:</b> Part #: RM4001-01 Batch #: 82433 Qty: 10 Part #: RM060701 Batch #: 74662 Qty: 5 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	471	0	09Jan24	STX48 Hv36
800	CATASY01  Catheter Assembly 1  	Major Mandrel Removal	462	ACD -HHH 1111 ⑨	09Jan24	SSW4 SS52

Notes:

N/A

N/A

N/A

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## Material: SA0155-01 Rev F

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	Major Mandrel Removal  N/A  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>	459	SKV-III	09.Jan24	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	N/A	SHox PP40 ML46
Notes:						
N/A						
N/A						
N/A						

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	<b>Quality Inspection &amp; Review</b>  <b>Confirmation Reqd(Milestone )</b> <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>31 May 24</u> 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>1000-1153-01</u> Batch #: <u>87010</u> Qty: <u>11</u> Part #: <u>RM0607-01</u> Batch #: <u>74662</u> Qty: <u>9</u> Part #: <u>RM4001-01</u> Batch #: <u>82433</u> Qty: <u>15</u> Part #: <u>RM0158-01</u> Batch #: <u>58497</u> Qty: <u>11</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> </p>	428	MAR-THI BW-1 #5US-1 EN-THI WK-1 DEL-THI DIS-THI DL-THI #10S-111	<i>KT47</i> <i>P146</i> <i>09Jan24</i>	
950	<b>QUALITY1</b> <b>Quality Inspection &amp; Review</b>	<p>Quality Inspection &amp; 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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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: 30 Sep 25 TMI: 0692 Cal Due: 30 Sep 25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	382	DIS(SP) HHH DE(ET) HHHHH DIS-HHH HHH HHH HHH 11	09Jan24	0521 Y936
1000	 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: 31 May 24 Record Length Gage Information: TMI: 0889D Cal Due: 30 Sep 24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30 Sep 24	337	LT. HHH HHH HHH HHH HHH HHH HHH HHH HHH	09Jan24	0521 Y936

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    Quality Inspection & Review  Confirmation Reqd(Milestone )	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	SCR-111 SKV-111 Dis-11 Mar-11 DISC-11 FL-1 EH-1 Mex-1 VD-1 DL-1  <i>3/5</i>  <i>(22)</i>	10Jan24	SV43
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>GS 85</u> <u>10Jan 24</u>	N/A	N/A	10Jan24	GS 85
Notes:						
<i>N/A</i>						
<i>N/A</i>						

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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	315	0	10 Jun 24	BA71

**Notes:**

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Batch Number: 0000294402

By: BA71

Date: 10 Jan 24

Reviewed By:

RB29

Date:

12 JAN 24

Notes:

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**Requestor Name:** Udhesh Kapadnis

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

revision to 24 SEP 23  
1562  
24 AUG 23  
23 OCT 2023

**DEVIATION AUTHORIZATION FORM** Effective to 23 Oct 2023

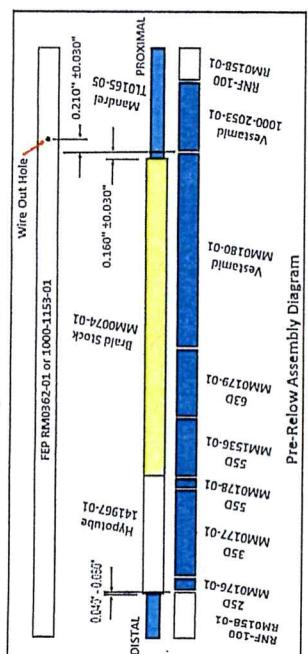
Requestor Name: Udhesh Kapadnis		
Document Number Affected	Revision	L
3107610		

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.

Wire Out Hole 

FEP RM#0362-01 or 1006-1153-01



## 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

A<sup>•</sup>

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

Revision

	H
Lot Number:	N/A

### Part Number Affected

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SA0155-01

工

Lat Numbaw

26 JUL 2023 25 AUG 2023

N/A

Digital Accounts - 1

**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

לענין הרכבת נסיעות

### **Corrective Action Required:** Yes

**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

卷之三

① UK55, 23JW 2023



DA | DA | 2484  
2468

## 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 ~~MM1536-02~~ fixture for inspection. (See image 1)  
**① MM01536-01 type connection 512 10AUG23**

### CONTROLLED COPY



Image- 1

### Step 1:

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



Image- 2

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

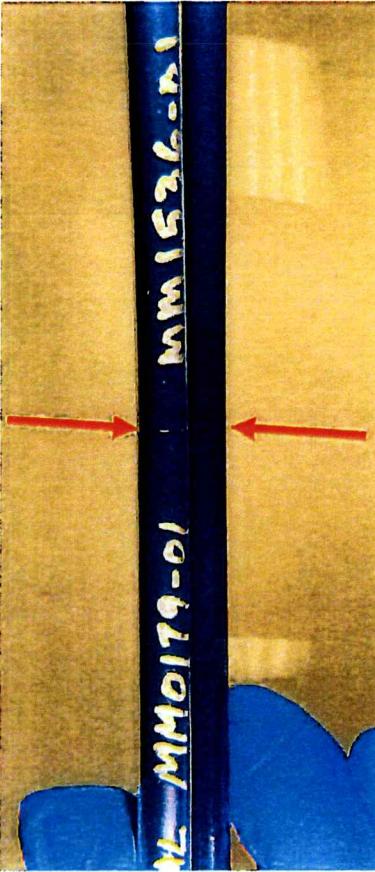


Image- 3

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

## **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)

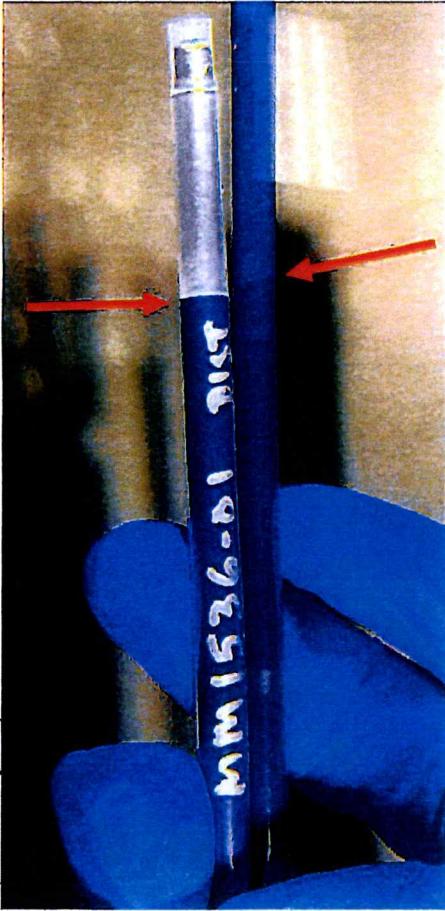


Image- 4

- 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.

<b>1</b>	<b>MM0179-01</b>	<b>MM1536-01</b>
<b>GOOD PART</b>		
<b>2</b>	<b>MM1536-01</b>	<b>MM0179-01</b>
		<b>MM0179-01 and MM1536-01 Wrong Order - BAD PART</b>
<b>3</b>	<b>MM0179-01</b>	<b>MM0179-01</b>
		<b>Two MM0179-01 - BAD PART</b>
<b>4</b>	<b>MM1536-01</b>	<b>MM1536-01</b>
		<b>Two MM1536-01 - BAD PART</b>

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**



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## DEVIATION AUTHORIZATION FORM

<b>Requestor Name:</b> Krishna Selvaraj			
<b>Document Number Affected</b>	<b>Revision</b>		
Doc #3005206 (MPI0238)	BP		
<b>Deviation From:</b>  <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b>  Using a laser micrometer, check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.	<b>Deviation To:</b>  <b>Doc #3005206 (Flex Commander MPI0238): OPER850.11:</b>  Using a laser micrometer at <b>OPER900 (TMI0700-01)</b> , check the DIM06 outer diameter. Position the laser indicator as close to the distal edge as possible. Start the measurement, then slowly move the part through the laser micrometer until reaching the lower edge of the shoulder.		
<b>Justification:</b>  TMI0602 lasermic which is currently used in SA0155-01 Flex commander product at OPER850 for Dim 6 inspection has mechanical failure and confirmed as not usable.  TMI0700-01 lasermic is used at OPER900 for 100% inspection for Dim 1, Dim 6 and Dim 9. Since TMI0700-01 is already qualified to inspect Dim 6 per ES0647: Laser micrometer equivalency test, there is no additional risk in using TMI0700-01 for OPER850 Dim 6 inspection till TMI0602 issue is resolved.			
<b>Part Number Affected</b>	<b>Revision</b>		
SA0155-01	H		
<b>Start Date:</b>	<b>End Date:</b>	<b>Lot Number:</b>	
16 Nov 23	15 DEC 23	N/A	
<b>Risk Assessment:</b> Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No FMEA's <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Validations <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No Details (if any): N/A			
If yes to any of the above, what controls are being put in place to mitigate the risk – N/A			
<b>Corrective Action Required:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No			
<b>If no, explain:</b> This is a temporary change to use TMI0700-01. DA will be removed once the lasermic TMI0602 issues are resolved and accepted for usage.			
<b>Training Required:</b> <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <b>If no, explain:</b> N/A			
<b>Title</b>	<b>Approval Name</b>	<b>Approval Signature</b>	<b>Date</b>
Engineering Manager	Jake Stanislowski		16 Nov 2023
Quality Manager	Jay Zabel		16 Nov 2023
Operations Manager	Matthew Benson		16 Nov 2023



PRODUCTION ORDER# 500000294402

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	10:47pm	430	V078	08Jan24	10:59pm	415	V078	08Jan24	16
TM10942	44	11:45pm	430	V078	08Jan24	11:57pm	415	V078	08Jan24	16
TM10942	44	12:12Am	427	V078	09Jan24	12:24AM	415	V078	09Jan24	16
TM10942	44	12:45Am	429	SH85	09Jan24	12:57Am	415	SH85	09Jan24	16
TM10942	44	1:13Am	428	V078	09Jan24	1:25Am	415	V078	09Jan24	16
TM10942	44	1:43Am	430	V078	09Jan24	1:55Am	415	SH85	09Jan24	16
TM10942	44	5:35am	430	TA36	09Jan24	5:47am	415	TA36	09Jan24	15
TM10942	44	5:54am	430	PM96	09Jan24	6:06 AM	415	PM96	09Jan24	16
TM10942	44	6:20am	430	OS21	09Jan24	6:32am	415	OS21	09Jan24	16
TM10942	44	6:45am	430	OS21	09Jan24	6:57am	415	OS21	09Jan24	16
TM10942	44	7:40am	430	AX05	09Jan24	7:52am	415	AX05	09Jan24	16
TM10942	44	8:06am	428	AX05	09Jan24	8:28am	415	AX05	09Jan24	16



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

**PRODUCTION ORDER#** 500000294402

OP 400



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

PRODUCTION ORDER# 500000294402

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:30pm	430	V078	08Jan24	11:42 pm	415	V078	08Jan24	16
Tm10745	44	11:55pm	430	V078	08Jan24	12:07 Am	415	V078	09Jan24	16
Tm10745	44	12:30Am	428	V078	09Jan24	12:42 AM	415	V078	09Jan24	16
Tm10745	44	12:55AM	429	V078	09Jan24	1:07AM	415	V078	09Jan24	16
Tm10745	44	1:27AM	428	V078	09Jan24	1:39AM	415	V078	09Jan24	16
Tm10745	44	1:54Am	429	SH85	09Jan24	2:06Am	415	SH85	09Jan24	9
Tm10745	44	5:40AM	430	PM 96	09Jan24	5:52AM	415	PM 96	09Jan24	16
Tm10745	44	6:05am	430	0521	09Jan24	6:17am	415	0521	09Jan24	16
Tm10745	44	6:52am	430	0521	09Jan24	6:44am	415	0521	09Jan24	16
Tm10745	44	7:00am	430	0521	09Jan24	7:12am	415	0521	09Jan24	16
Tm10745	44	7:50am	430	AX 05	09Jan24	8:02am	415	AX 05	09Jan24	16
Tm10745	44	8:25am	430	AX 05	09Jan24	8:37am	415	AX 05	09Jan24	16



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

**PRODUCTION ORDER#** 500000 294402

OP 400



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

PO #: 50000294402 OP #: 500 Shift #: 2<sup>nd</sup>.

Total Parts Reworked:		13	
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		12
MP	Micropores	N/A	N/A
SCR	Scratch		1
SKV	Skive Marks	N/A	N/A
VD	Voids	N/A	N/A
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 #: 50000294402 OP #: 500 Shift #: 2

Total Parts Reworked:		6	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire	///	5
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):** Craig 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.

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



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

PO #: 500000294402 OP #: 500 Shift #: 2

Total Parts Reworked:		10	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	11	2
EW	Exposed Wire	1111	7
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids	1	1
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		HT72 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000294402 OP #: 500 Shift #: 1<sup>st</sup>

Total Parts Reworked:		211	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		47
EW	Exposed Wire		143
MP	Micropores	N/A	N/A
SCR	Scratch		1
SKV	Skive Marks		6
VD	Voids		24
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Dy 26, LL61, CB81, TA36, VC09	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.

Data Uploaded for Engineering Review (Check):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000294402

OP #: 750 Shift #: 1st

Total Parts Reworked:		108	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		17
DIM07 US / WC	DIM07 Undersized (Window Closed)		21
EH	Exposed Hypotube		35
N/A	Glue , stopper		35
Inspected By (Sign and Date):		STX 48	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):

**PRODUCTION ORDER#** 500000 294402

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	6:20 AM	190°F	KLSS	09 Jan 24	7:30 am	190°F	KLSS	09 Jan 24	61
Tm10409	N/A	7:35 am	190°F	SSH4	09 Jan 24	8:45 am	190°F	SSH4	09 Jan 24	35
Tm12036	N/A	8:20am	190°F	SSH4	09 Jan 24	9:30am	190°F	SSH4	09 Jan 24	40
Tm10409	N/A	8:40am	190°F	KLSS	09 Jan 24	9:50 am	190°F	KLSS	09 Jan 24	34
Tm12036	N/A	9:35 am	190°F	SSH4	09 Jan 24	10:45am	190°F	SSH4	09 Jan 24	41
Tm10409	N/A	9:55 am	190°F	SSH4	09 Jan 24	11:05am	190°F	SSH4	09 Jan 24	25
Tm10409	N/A	11:20am	190°F	SSH4	09 Jan 24	12:30pm	190°F	KL95	09 Jan 24	36
Tm12036	N/A	12:10PM	190°F	SSS2	09 Jan 24	1:20PM	190°F	SSS2	09 Jan 24	43
Tm10409	N/A	12:40PM	190°F	OS21	09 Jan 24	1:50PM	190°F	OS21	09 Jan 24	54
Tm12036	N/A	1:25pm	190°F	KL95	09 Jan 24	2:35pm	190°F	KL95	09 Jan 24	93
				N/A	KL95	09 Jan 24				

① SS 44 09 Jan 24



**PO #:** 50000029 4402

**OP #: 900 Shift #: 157**

Document No: 6102619

Rev: B

**Document Type: Manufacturing Form**

## **Title: SA0155-01 Dimensional/Visual Rework Form**

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

P-146 09 Jan 23 09 Jan 24

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

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023

PO #: 500000294402OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	
EH	Exposed Hypotube	PP40 09 Jan 24	
EW	Exposed Wire		8
MP	Micropores	N/A	N/A
SCR	Scratch		7
SKV	Skive Marks	N/A	N/A
VD	Voids	/	1
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized	N/A PP40 09 Jan 24	
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		PP40 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 #: 500000294402OP #: 900 Shift #: 2nd

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		29	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	0
EH	Exposed Hypotube		3
EW	Exposed Wire		6
MP	Micropores	NA	0
SCR	Scratch		23
SKV	Skive Marks	NA	0
VD	Voids		2
DIM01 US	DIM01 OD Undersized	NA	0
DIM06 US	DIM06 OD Undersized		1
DIM06 OS	DIM06 OD Oversized		2
DIM09 US	DIM09 OD Undersized	NA	0
Inspected By (Sign and Date):		See H. Meil 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):

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	28.43	25.47	22.23	24.88	26.09	25.41	27.78	26.29	26.03	26.57	25.918	1.6839227	4.378	18.5457866	8.542	PASS
Seg B	59.36	59.6	61.32	57.85	63.37	58.99	59.3	60.91	62.98	62.1	60.578	1.8432809	3.981	53.2398988	8.542	PASS
Seg C	76.81	75.6	74.79	76.74	76.04	77.41	77.81	77.42	75.47	75.16	76.325	1.0562118	2.911	73.2503675	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 #: 500000294402

Date: 10JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24


10Jan24