

Production Order: 500000300505



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: 7988
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  Kitting Devices	Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>Xe31 4:30PM 29JAN24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP2 11:30am 30Jan24</u> Record Dryer Shelf #: <u>N/A</u>				KL27

Notes: DA 2564, 2484

N/A
N/A

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Opn No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MF <i>N/A</i>		RM0158-01	E	<u>E</u>	PC	200	<u>0000271063</u> <u>58497</u>	<u>40</u> <u>181</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>N/A</u> <u>79170</u>	<u>N/A</u> <u>Bulk</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>N/A</u> <u>79170</u>	<u>N/A</u> <u>Bulk</u>		
		MM1538-01	A	<u>A</u>	PC	500	<u>0000278970</u> <u>N/A</u>	<u>500</u> <u>N/A</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000284209</u> <u>N/A</u>	<u>1120</u> <u>N/A</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278880</u> <u>0000287548</u>	<u>400</u> <u>100</u>	<i>N/A</i>	<i>N/A</i>
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u> <u>N/A</u>	<u>500</u> <u>N/A</u>		
							<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
		TL0167-02	E	<u>E</u>	PC	70	N/A	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	N/A	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	N/A	Bulk			
		141967-01	02	<u>D2</u>	PC	500	85502	466			
		RM7349-02	C	<u>C</u>	PC	543	82899 82835 82837 82848	100 100 200 280			
MIP	N/A	RM7348-01	C	<u>C</u>	PC	500	82874 82886	N/A 600	N/A	N/A	N/A
		RM4001-01	B	<u>B</u>	PC	125	82458	200			
		RM0607-01	D	<u>D</u>	PC	56	71863	100			

Notes:

N/A
N/A
N/A

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④ KFO2 31 Jan 24

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	RM0498-01	C	<u>C</u>	PC	500	① <u>0000275492</u> <u>0000275492</u> <u>0000287642</u>	N/A 133 86			
	RM0362-01	E	<u>E</u>	PC	594	<u>0000287643</u> <u>78865</u> <u>78867</u> <u>80231</u>	263 357 90 190			
	MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	500			
	MM0180-01	E	<u>E</u>	PC	500	<u>0000278966</u>	20			
	MM0178-01	E	<u>E</u>	PC	500	<u>0000282490</u> <u>N/A</u>	500 N/A		<u>N/A</u>	<u>N/A</u>
	MM0176-01	D	<u>D</u>	PC	500	<u>0000276174</u> <u>N/A</u>	500 N/A		<u>N/A</u>	<u>N/A</u>
	MM0074-01	G	<u>G</u>	PC	500	<u>0000288413</u> <u>N/A</u> <u>0000292834</u> <u>0000292833</u>	500 N/A 523 40			

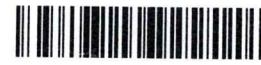
Notes:

N/AN/AN/A

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① KP02 31 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	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	30Jan24	KL95
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly 	Major and Minor Mandrel Assembly	500	0	30Jan24	AX05 NK62 pn 96 CL30 V078

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
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock Loading Braid Stock Confirmation Reqd(Milestone)	500	0	30Jan24 AL341 MY50 ST96 DX35	
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	①30Jan24 30Jan24 VP62 CY97 AS 31 ny 35	
Notes:						
N/A						
N/A						
N/A						

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① MV18 30Jan24

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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 Confirmation Reqd(Milestone)	Insert Cut Hypo Tube	500	O 30Jan24	je SK11 LM46 CP32 GS22	N/A
350	CATASY01 Catheter Assembly 1	Load Tubing	500	O 30Jan24	VV25 LM46 CL05	N/A
Notes:						
N/A						
N/A						
N/A						

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①
30Jan24 MR78
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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			
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	N/A Reflow	500	0 30Jan24	N/A NK62 TA36 SY47 SK85	N/A
450	CATASY01 Catheter	FEP Removal	N/A			PM96 JY90
Notes:						
N/A						
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
	Assembly 1 		500	0	30Jan24	N/A
450	FEP Removal 	N/A				
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 In-process Inspection and Rework Material Consumed: Part #: 10000-1153-0 Batch #: 28728 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	In-process Inspection and Rework Material Consumed: Part #: 10000-1153-0 Batch #: 28728 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	0 483 471	EW- HT Fm - DF- 29	LL01 VC09 CB81 VL91 R66 HT72 TD415 30 Jan 24	LL01 VC09 CB81 VL91 R66 HT72 TD415
	N/A N/A Notes: N/A N/A N/A	N/A	N/A	N/A	N/A	N/A

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① Mv18 30Jan24

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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 Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel	471	0	30Jun24	FR01 RS23 Y936 CRN) MV78 PP40
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	466	(5)	30Jun24	DV39 ML60 ATB9

Notes:

N/A

N/A

N/A

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Material: SA0155-01 Rev E

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	4666	0	30 Jan 24	ML38
700	CATASY01 Catheter Assembly 1  Tipping	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31 May 24 TMI: 2093C Cal Due: 31 May 24 TMI: 0386 Cal Due: 31 May 24 TMI: 0936A Cal Due: 31 May 24	4666	0	30 Jan 24	ML38

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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
750	CATASY01 Catheter Assembly 1 	Tip Inspection/ Flash Removal Material Consumed: Part #: RMH001-01 Batch #: 82458 Qty: N/A Part #: PM007-01 Batch #: 71863 Qty: N/A Part #: PM0158-01 Batch #: 58497 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	464	EH-11 2	30 Jan 24	MM02 SV46
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	443	ACD-HHHHH HHHHH 21	30 Jan 24	XL91 SG88 SS44

Notes:

N/A

N/A

N/A

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Material: SA0155-01 Rev F

Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	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> Cut to Length Confirmation Reqd(Milestone)	442	SKV-1 ①	31JUN24 ES552	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	31JUN24 SHO4 ML4L P66 HT72	MV33
Notes:						
<i>N/A</i>						
<i>N/A</i>						
<i>N/A</i>						

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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)	<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: 31 may 24 TMI: MA Cal Due: MA TMI: MA Cal Due: MA Material Consumed: Part #: Pn401L01 Batch #: 82458 Qty: 18 Part #: 1000-1153-01 Batch #: 88728 Qty: N/A Part #: MA Batch #: MA Qty: N/A Part #: MA Batch #: MA Qty: N/A Part #: MA Batch #: MA Qty: N/A</p>	396	ACD-11 EW-111 DS-1 MAR-1HT 1HT LHT 1HT #6US-1HT #6OS-111 #7OS-111 #9US-1	31Jan24 KL67 PY46 DY29 K155 K125	
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: N/A Cal Due: N/A Record Caliper Information:</p>	N/A	N/P	N/A	N/A

Notes:

N/A

N/A

N/A

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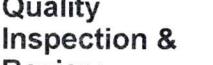
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Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: <u>N/A</u> Cal Due: <u>N/A</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>	373	DEL(GD)HHTH DIS(GP)HHT dis-1111 STR-1111	315~ (23)	Y936 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>31MAY24</u> Record Length Gage Information: TMI: <u>0889 D</u> Cal Due: <u>30SEP24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30SEP24</u>	370	LT-111		KL67

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
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	339	0	02 Feb 24 AP10	AP10 02 Feb 24

Notes:

N/A AP10 02 Feb 24

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Batch Number: 0000300505

By: AP10

Date: 02 Feb 24

Reviewed By:

RB29

Date:

02 feb 24

Notes:

N/A AP10 02 Feb 24

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Extend to 2023 DEVIATION A
Extend to 2023 DEVIATION A

Requestor Name: Udhesh Kapadnis

DEVIATION AUTHORIZATION NUMBER: 2484
X See attached email extension to 2484

negative
negative
negative
negative

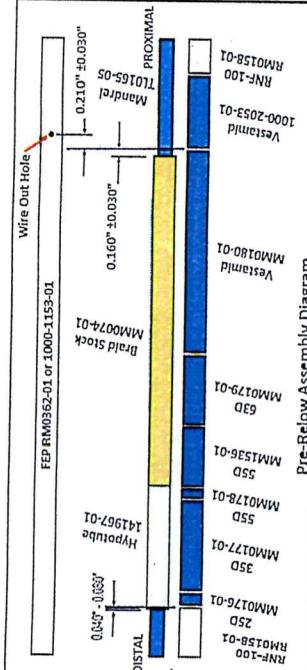
CONTROLLED COPY

Requestor Name: Udhesh Kapadnis

Requestor Name: Udhesh Kapadnis		Revision
Document Number Affected		
3107610	L	

Deviation From:

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



Deviation Test

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.

See instructions attached to this DA Form.

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

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Part Number Affected	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	N/A

卷之三

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

figures to any of the above.

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Corrective Action Required: Yes No

If no, explain: No corrective action is required for this event as there are no changes to the current process, consumption of material, or how the product is produced. This added inspection guidelines are to avoid incorrect extrusion assembly defects.

Training Required: Yes No

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

① UK55, 23JW 2023



DA	2484
2468	①

Description/Objectives of Training:
DA- Inspection at final QC, Op#1050.

Group Training Record

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)
①MM0179-01 type connection TS12 10AUG23

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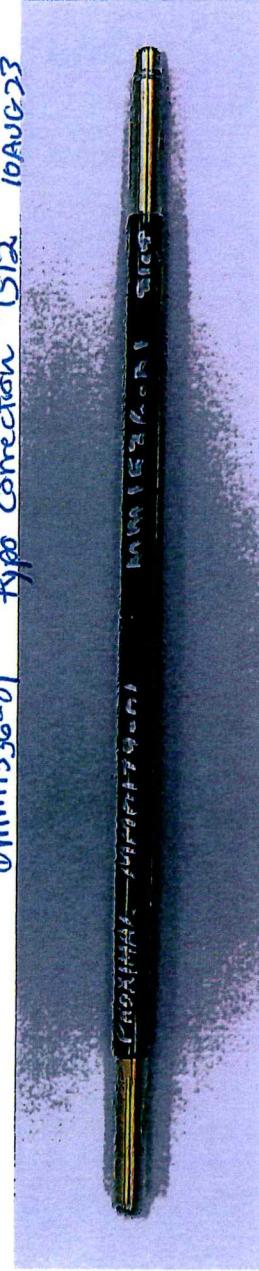


Image- 1

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)

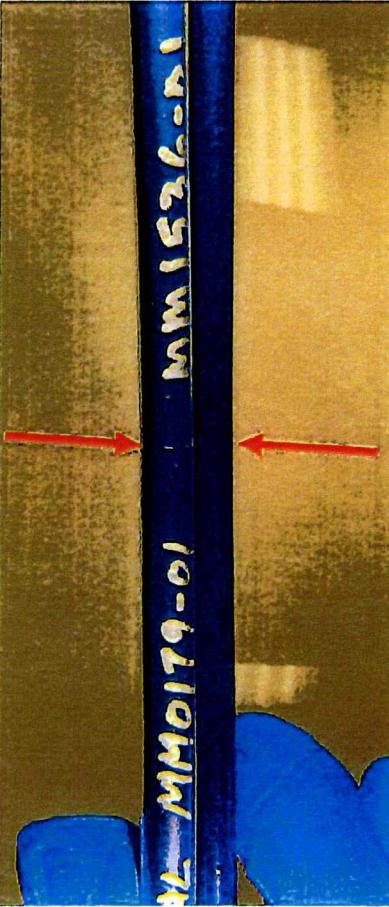


Image- 3

- 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.

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)

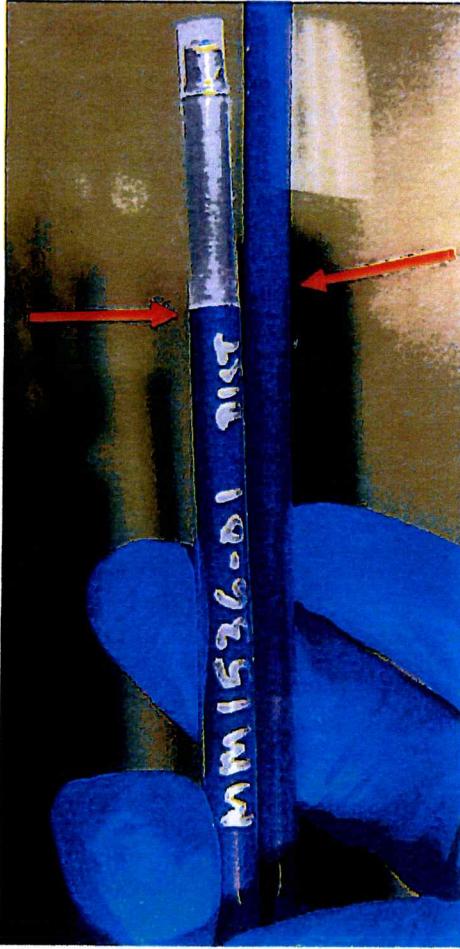


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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

Entered to Hansa 328 12/15/2023

Entered to 13 Flex 324 328 1/6/2024

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CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

DEVIATION AUTHORIZATION FORM

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

Justification:

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

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

Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
16 Nov 23	15 DEC 23	N/A	
Risk Assessment: Is there any potential risk(s) that may occur as a result of the proposed deviation including the following: Control Plans <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# 500000300505

OP 400

① V07830 Jan 24



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

PRODUCTION ORDER# 500000300505

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	12:25pm	430	0521	30Jan24	12:37pm	415	0521	30Jan24	16
TM10745	44	12:45PM	429	0521	30Jan24	12:57PM	415	0521	30Jan24	16
TM10745	44	1:50pm	430	0521	30Jan24	2:02PM	415	0521	30Jan24	16
TM10745	44	2:20pm	430	0521	30Jan24	2:42pm	415	0521	30Jan24	16
TM10745	44	4:23pm	430	SH85	30Jan24	4:35pm	415	SH85	30Jan24	16
TM10745	44	4:47pm	428	SH85	30Jan24	4:59pm	415	SH85	30Jan24	16
TM10745	44	5:35pm	429	V078	30Jan24	5:47PM	415	SA07	30Jan24	16
TM10745	44	6:24pm	430	CL30	30Jan24	6:36pm	415	SH85	30Jan24	16
TM10745	44	6:56pm	430	CL30	30Jan24	7:08pm	415	CL30	30Jan24	16
TM10745	44	7:25 pm	430	CL30	30Jan24	7:37pm	415	CL30	30Jan24	16
TM10745	44	7:49 pm	430	CL30	30Jan24	8:01pm	415	SH85	30Jan24	16
TM10745	44	9:23pm	430	V078	30Jan24	9:35PM	415	V078	30Jan24	16



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PRODUCTION ORDER# 500000300505

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	12:35PM	430	0521	30Jan24	12:47PM	415	0521	30Jan24	16
Tm10942	44	1:25PM	430	Ax05	30Jan24	1:37PM	415	Ax05	30Jan24	16
Tm10942	44	2:10PM	430	Ax05	30Jan24	2:22PM	415	Ax05	30Jan24	16
Tm10942	44	2:40PM	430	0521	30Jan24	2:52PM	415	0521	30Jan24	16
Tm10942	44	3:00 PM	427	NK62	30Jan24	3:12PM	415	NK62	30Jan24	16
Tm10942	44	4:02PM	430	Sy47	30Jan24	4:14PM	415	Sy47	30Jan24	16
Tm10942	44	4:34PM	429	Sy47	30Jan24	4:46 PM	415	Sy47	30Jan24	16
Tm10942	44	5:06PM	429	SH85	30Jan24	5:18PM	415	SH85	30Jan24	16
Tm10942	44	6:34PM	430	SH85	30Jan24	6:46PM	415	SH85	30Jan24	16
Tm10942	44	7:10pm	430	SH85	30Jan24	7:22pm	415	SH85	30Jan24	16
Tm10942	44	7:36PM	427	SH85	30Jan24	7:48PM	415	SH85	30Jan24	16
Tm10942	44	7:59PM	427	SH85	30Jan24	8:11PM	415	V078	30Jan24	16



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

PO #: 50000300505

OP #: 500 Shift #: 2

Total Parts Reworked:		<u>14</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	<u>N/A</u>	<u>0</u>
EH	Exposed Hypotube	<u>HHII</u>	<u>7</u>
EW	Exposed Wire	<u>HHIII</u>	<u>8</u>
MP	Micropores	<u>N/A</u>	<u>0</u>
SCR	Scratch	<u>N/A</u>	<u>0</u>
SKV	Skive Marks	<u>N/A</u>	<u>0</u>
VD	Voids	<u>N/A</u>	<u>0</u>
<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>0</u>

Inspected By (Sign and Date):

Gus 30 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 #: 500000300505OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>39</u>	
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	///	5
SKV	Skive Marks	n/a	n/a
VD	Voids		8
n/a	n/a	n/a	n/a

Inspected By (Sign and Date): Vanneej Lor 30 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):

PO #: 500000300505OP #: 750 Shift #: 2nd.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		60	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		35
DIM07 US / WC	DIM07 Undersized (Window Closed)		3
EH	Exposed Hypotube		25
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mm02	30 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 #: 500000300505OP #: 750 Shift #: 2nd

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		33	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		20
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		8
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 30 Jan 23	

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# 500000300505

OP 800

① SG88 30 Jan 24

~~MAP R146 31 Jan 24~~



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

PO #: 50000300505 OP #: 900 Shift #: 2

Total Parts Reworked:		32	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire	11	2
MP	Micropores	N/A	0
SCR	Scratch		34
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	N/A	0
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		Candy	30 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 #: 500000300505 OP #: 900 Shift #: 2nd

Total Parts Reworked:		53	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NA	NA
EH	Exposed Hypotube		1
EW	Exposed Wire		2
MP	Micropores	NA	NA
SCR	Scratch		20
SKV	Skive Marks	NA	NA
VD	Voids		1
DIM01 US	DIM01 OD Undersized	NA	NA
DIM06 US	DIM06 OD Undersized		30
DIM06 OS	DIM06 OD Oversized	NA	NA
DIM09 US	DIM09 OD Undersized	NA	NA
Inspected By (Sign and Date):		Michael Seeth	30 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 #: 500000300505 OP #: 900 Shift #: 2

Total Parts Reworked:		16	
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	6
MP	Micropores	N/A	N/A
SCR	Scratch	1111111111	21
SKV	Skive Marks		
VD	Voids		
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized		
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT72 30 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): DJ



PO #: 500000300505

OP #: 900 Shift #: 1st

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.

Data Uploaded for Engineering Review (Check):

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023

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	28.87	30.19	31.75	29.26	27.18	24.72	28.39	27.88	32.07	30.35	29.066	2.1990968	4.378	19.4383543	8.542	PASS
Seg B	75.09	71.38	67.43	72.78	74.85	68.7	70.6	72.21	70.24	75.01	71.829	2.6730692	3.981	61.1875116	8.542	PASS
Seg C	84.64	85.23	80.63	84.78	78.88	69.15	85.15	86.49	86.47	84.51	82.593	5.3198978	2.911	67.1067776	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 #: 500000300505

Date: 31JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

31 JAN 2024