

Production Order: 500000297259



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:	7988		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 	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>AM685:415pm 21 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>GS85 1:25pm 22 Jan 24</u> Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table><thead><tr><th>Component Number</th><th>Req'd Rev Rev Used</th><th>UOM</th><th>Qty.</th><th>Batch No.</th><th>Actual Qty Used</th></tr></thead><tbody><tr><td>1000-2053-01</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0000278880</u></td><td><u>540</u></td></tr><tr><td>MM1537-02</td><td>A <u>A</u></td><td>PC</td><td>500</td><td><u>0600288401</u></td><td><u>500</u></td></tr></tbody></table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>540</u>	MM1537-02	A <u>A</u>	PC	500	<u>0600288401</u>	<u>500</u>	N/A	N/A	U5024 DICOV
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																		
1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>540</u>																		
MM1537-02	A <u>A</u>	PC	500	<u>0600288401</u>	<u>500</u>																		

Notes: DA 2484, 2564

N/A

N/A

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NP N/A	RM0158-01	E	E	PC	200	N/A	N/A			
						58407	150			
	TL0167-02	E	E	PC	70	N/A	N/A			
						N/A	Bulk			
	TL0165-05	J	J	PC	5	N/A	Bulk			
						N/A	Bulk			
	TL0165-03	J	J	PC	5	N/A	Bulk	N/A	N/A	N/A
						N/A	Bulk			
NP N/A	141967-01	02	02	PC	500	85501	487			
						85500	35			
	RM7349-02	C	C	PC	543	82729	600			
						N/A	N/A			
	RM7348-01	C	C	PC	500	78690	500			
						N/A	N/A			

Notes:

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
n/a	n/a	RM4001-01	B	<u>B</u>	PC	125	<u>82456</u>	200			
		RM0607-01	D	<u>P</u>	PC	56	<u>① 74662</u> N/A	N/A			
		RM0498-01	C	<u>C</u>	PC	500	<u>000287641</u>	<u>500</u>			
		RM0362-01	E	<u>E</u>	PC	594	<u>80231</u>	<u>600</u>			
		RM0009-04	I	<u>+</u>	PC	1	<u>82971</u>	<u>Bulk</u>			
		RM0009-04	I	<u>-</u>	PC	1	<u>82971</u>	<u>Bulk</u>	n/a	n/a	n/a
		MM1538-01	A	<u>A</u>	PC	500	<u>000278970</u>	<u>500</u>			
		MM1537-01	A	<u>A</u>	PC	1000	<u>000284209</u>	<u>1080</u>			

Notes:

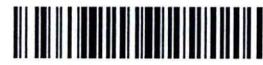
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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MA MA	MM1536-01	B	<u>B</u>	PC	500	<u>000281412</u>	<u>500</u>				
						<u>000271063</u>	<u>40</u>				
	MM0180-01	E	<u>E</u>	PC	500	<u>000282490</u>	<u>400</u>				
						<u>000282489</u>	<u>100</u>				
	MM0179-01	D	<u>D</u>	PC	500	<u>000276172</u>	<u>500</u>				
						<u>000272345</u>	<u>40</u>				
	MM0178-01	E	<u>E</u>	PC	500	<u>000276174</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
						<u>000271050</u>	<u>80</u>				
	MM0177-01	C	<u>C</u>	PC	500	<u>000284708</u>	<u>500</u>				
						<u>000252923</u>	<u>40</u>				
	MM0176-01	D	<u>D</u>	PC	500	<u>000281411</u>	<u>500</u>				
						<u>000271036</u>	<u>40</u>				
	MM0074-01	G	<u>G</u>	PC	500	<u>000295126</u>	<u>519</u>				
						<u>000285406</u>	<u>28</u>				

Notes:

N/A

N/A

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Cpr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MA	MA	MA	MA	MA	MA	MA
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting Line Clearance Confirmation Reqd(Milestone)	500	0 23 Jan 24	KLES5	
150	CATASY01 Catheter Assembly 1 Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0 23 Jan 24	Ax 05 AF54 NK62 CL30 Y014 ZM 96 AF54	

Notes:

MA
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MA

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Confirmation Reqd(Milestone)	n/a	n/a	n/a	n/a	n/a
200	CATASY01 Catheter Assembly 1 	Loading Braid Stock	500	0	23 Jan 24	AL34 EO CY97 ST96 NY35
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	23 Jan 24	VPC2 CY97 AS31 DX35

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
	Trim Braid Wire at Proximal End N/A Confirmation Req'd(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 Req'd(Milestone)	Insert Cut Hypo Tube	500	0	23 Jan 24 23 Jan 24	MYS0 LM46 CP32 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	23 Jan 24 23 Jan 24	WV25 LM46 D105 V078

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 <i>MA</i> Confirmation Reqd(Milestone)	<i>n/a</i>	<i>n/a</i>	<i>n/a</i>	<i>n/a</i>	<i>n/a</i>
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	<i>Reflow</i>	500	0	<i>23 Jan 24</i>	<i>RN27</i> <i>AF54</i> <i>NK62</i> <i>SY47</i> <i>SH85</i> <i>CL30</i> <i>TRN1078</i> <i>pm96</i> <i>AB54</i>
450	CATASY01 Catheter	<i>FEP Removal</i>	500	0	<i>23 Jan 24</i>	<i>AF54</i> <i>JY90</i> <i>SH85</i> <i>pm96</i>
Notes:						
<i>MA</i>						
<i>MA</i>						
<i>n/a</i>						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 					
MA	FEP Removal	N/A	N/A	N/A	N/A	N/A
	Confirmation Reqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000153-01 Batch #: 87654 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	488	EW-111 VD-1 FM-1 23 Jan 2024 EW-11 DF-11 12		V291 P66 TD45 CB81 LL61 VC09
MA	In-process Inspection and Rework					
	Confirmation Reqd(Milestone)					
MA	N/A	N/A	N/A	N/A	N/A	N/A
Notes:						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	488	0 235 am ~	235 am ~	GS22 CL05 PH59 FBO1 VA96
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	480	EH-1 DL- 1111 MAH-111 ⑧	235 am ~ 235 am ~	SV46 DX95 PH59 FBO1 VA96

Notes:

N/A

N/A

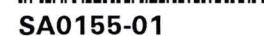
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP	Reqd(Milestone)	MA	MA	MA	MA	MA
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink Loading Heat Shrink Confirmation Reqd(Milestone)	480	0 <i>23 Jan 24</i>	<i>23 Jan 24</i>	ML38 D429 PH59 FBO RS23
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: <u>0521</u> Cal Due: <u>31 May 24</u> TMI: <u>2083C</u> Cal Due: <u>31 May 24</u> TMI: <u>0386</u> Cal Due: <u>31 May 24</u> TMI: <u>0936A</u> Cal Due: <u>31 May 24</u>	480	0 <i>23 Jan 24</i>	<i>23 Jan 24</i>	ML38 STR48 HV36 RS23

Notes:

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials																														
M8	Confirmation Reqd(Milestone)	NA	NA	NA	NA	NA																														
750	CATASY01 Catheter Assembly 1 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <table> <tr> <td>Part #:</td> <td>Rm4001-01</td> <td>Batch #:</td> <td>52456</td> <td>Qty:</td> <td>12</td> </tr> <tr> <td>Part #:</td> <td>NA</td> <td>Batch #:</td> <td>NA</td> <td>Qty:</td> <td>NA</td> </tr> <tr> <td>Part #:</td> <td>NA</td> <td>Batch #:</td> <td>NA</td> <td>Qty:</td> <td>NA</td> </tr> <tr> <td>Part #:</td> <td>NA</td> <td>Batch #:</td> <td>NA</td> <td>Qty:</td> <td>NA</td> </tr> <tr> <td>Part #:</td> <td>NA</td> <td>Batch #:</td> <td>NA</td> <td>Qty:</td> <td>NA</td> </tr> </table>	Part #:	Rm4001-01	Batch #:	52456	Qty:	12	Part #:	NA	Batch #:	NA	Qty:	NA	Part #:	NA	Batch #:	NA	Qty:	NA	Part #:	NA	Batch #:	NA	Qty:	NA	Part #:	NA	Batch #:	NA	Qty:	NA	480	O 23Jan24	ML60 mm02 STX48 Hv36	
Part #:	Rm4001-01	Batch #:	52456	Qty:	12																															
Part #:	NA	Batch #:	NA	Qty:	NA																															
Part #:	NA	Batch #:	NA	Qty:	NA																															
Part #:	NA	Batch #:	NA	Qty:	NA																															
Part #:	NA	Batch #:	NA	Qty:	NA																															
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	478	ARD-11 (2) 23Jan24	SG88 SS52 SSH44																															

Notes:

NA

NA

NA

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
M15	Major Mandrel Removal Confirmation Reqd(Milestone)		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. pass 2. pass 3. pass 4. pass 5. pass	478	0 23 cm 24		Y936 SS52
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	0	EH-1 EW-1 (2) 22 cm 24		M165 HT72
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
MPS	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: N/A Cal Due: N/A TMI: N/A Cal Due: N/A Material Consumed: Part #: PNH00L01 Batch #: 82456 Qty: 18 Part #: 1000-1153-01 Batch #: 74662(1) Qty: N/A Part #: B00607-01 Batch #: 74662 Qty: 6 Part #: 1000-1153-01 Batch #: 87656 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A (OPY 4623 Jan 24)</p>	457	EH-11 WK-1111 Dis-2H11 EW-11 #103-1 #6W-1 De2-11 (19)	23 Jan 24	KL67 KT217 D429
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/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
N/A	 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>10691</u> Cal Due: <u>30 SEP 25</u> TMI: <u>10692</u> Cal Due: <u>30 SEP 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u>	438	Str - 111 WT - H ① DIS - H ④ H ④ H ④ I (SP) ⑯	23 Jan 24	NY35 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>31 MAY 24</u> Record Length Gage Information: TMI: <u>0884 D</u> Cal Due: <u>30 SEP 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 SEP 24</u>	413	LT - H H H H H H H H H H H H H ⑯	23 Jan 24	KL67 SSH44

Notes:

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

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⑯ PY46 23 Jan 24

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N/A	N/A	N/A	N/A	N/A	N/A	N/A
1050	QUALITY1 Quality Inspection & Review 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS 	378	<ul style="list-style-type: none"> • SCR-1H (TT) • FM - II (TT) • DEL - K (TT) • STN - 4H • DL - HHI • VD - I • SCR - IIII • EW - I • DNT - I • FM - I • FB - II • BP - I • AB - I • DISC - I • PBC - I (35)	23Jan24	SV43 XN26
1100	CATASY01 Catheter Assembly 1 	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02 24Jan24</u>	N/A	N/A	24Jan24	KP02
Notes:						
N/A						
N/A						
N/A						

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1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	0 500 378	0	25Jan24	M/28

Notes:

N/A

N/A

N/A

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01/28/25 Jan 24

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Batch Number: 0000297259

By: M/28

Date: 25 Jan 24

Reviewed By:

RB29

Date:

26 JAN 24

Notes:

N/A

N/A

N/A

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

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① UK55, 23JW 2023



is part of

DA
2484
①
DA
2468

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 correction TS12 10AUG23

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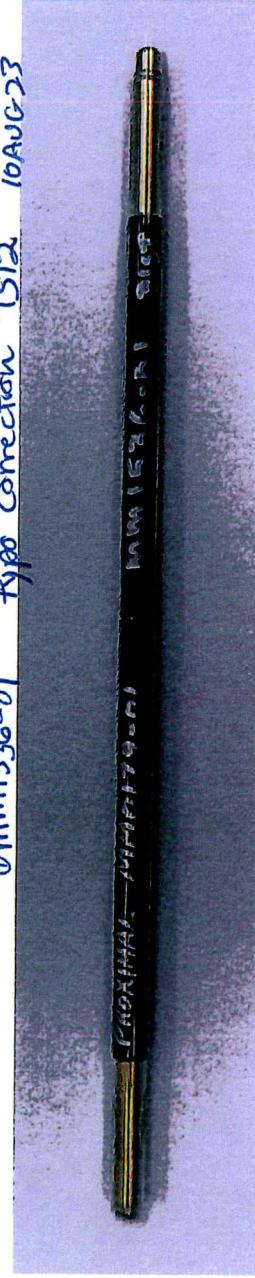


Image- 1

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)

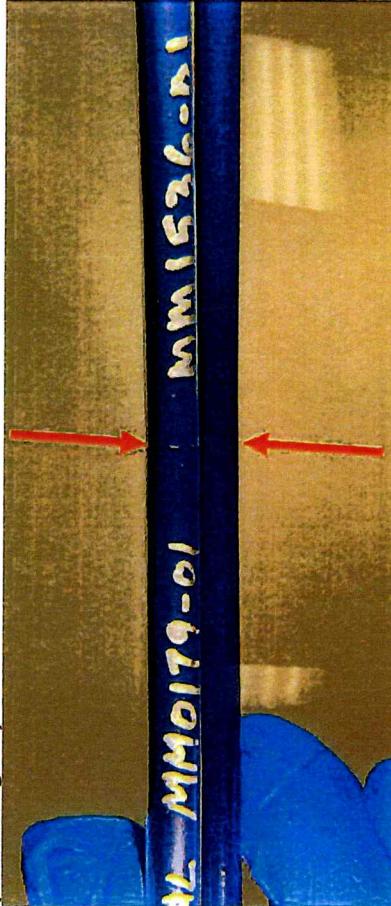
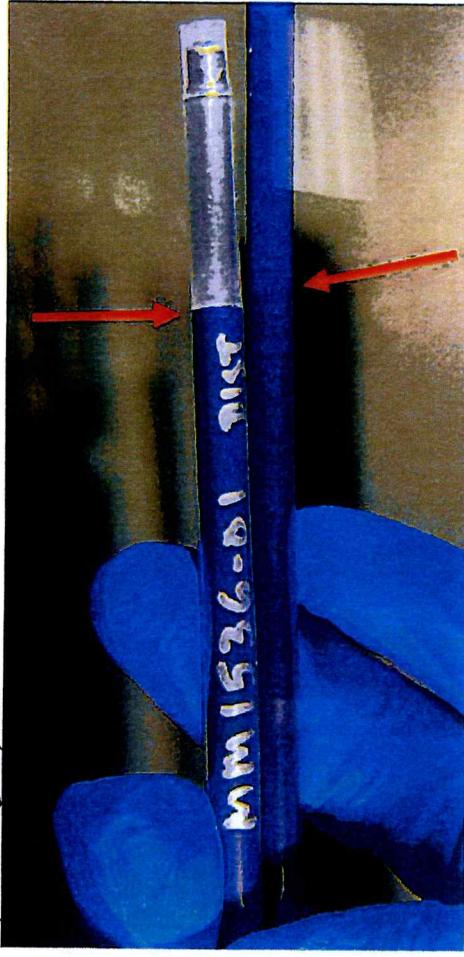


Image- 3

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

Image - 5

Entered to HENNAH 0208 1/15/2023
Entered to 13 FEB 2024 0228 1/15/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

CREGANNA
MEDICAL
is part of



DEVIATION AUTHORIZATION FORM

Requestor Name:	Krishna Selvaraj		
Document Number Affected	Revision	Revision	Date
Doc # 3005206 (MPI0238)	BP	H	16 Nov 2023
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	Lot Number:	N/A
SA0155-01	H		
Start Date:	End Date:		
16 Nov 23	15 DEC 23		
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# 500000 297259

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	2:18pm	430	NK62	22Jan24	2:30pm	415	NK62	22Jan24	12
Tm10745	44	3:11 pm	430	NK62	22Jan24	3:23pm	415	NK62	22Jan24	10
Tm10745	44	4:34pm	430	SH85	22Jan24	4:46pm	415	SH85	22Jan24	16
Tm10745	44	5:19pm	429	SH85	22Jan24	5:31pm	415	SH85	22Jan24	16
Tm10745	44	6:24pm	430	SH85	22Jan24	6:36pm	415	SH85	22Jan24	16
Tm10745	44	6:57pm	428	SH85	22Jan24	7:09pm	415	SH85	22Jan24	16
Tm10745	44	7:42pm	430	SH85	22Jan24	7:54pm	415	SH85	22Jan24	16
Tm10745	44	9:00 pm	430	SH85	22Jan24	9:12pm	415	SH85	22Jan24	16
Tm10745	44	9:45pm	430	V078	22Jan24	9:57pm	415	Sy47	22Jan24	16
Tm10745	44	10:45pm	430	V078	22Jan24	10:57pm	415	Sy47	22Jan24	16
Tm10745	44	11:57pm	429	Sy47	22Jan24	12:09Am	415	Sy47	23Jan24	16
Tm10745	44	12:25AM	429	Sy47	23Jan24	12:37Am	415	Sy47	23Jan24	16



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

PRODUCTION ORDER# 50000029725-9

OP 400

① TA 36 24 Jan 24



500000297259

PRODUCTION ORDER# 50000297259①

Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	3:10pm	430	0521	22Jan24	3:22pm	415	0521	22Jan24	9
Tm10942	44	4:25pm	430	Sy47	22Jan24	4:37pm	415	Sy47	22Jan24	16
Tm10942	44	4:58pm	430	SH85	22Jan24	5:18pm	415	SH85	22Jan24	16
Tm10942	44	5:35pm	430	V078	22Jan24	5:47pm	415	SH85	22Jan24	12
Tm10942	44	6:44pm	430	SH85	22Jan24	6:56pm	415	SH85	22Jan24	16
Tm10942	44	7:28pm	430	SH85	22Jan24	7:40pm	415	SH85	22Jan24	16
Tm10942	44	7:56pm	428	SH85	22Jan24	8:10pm	415	FV50	22Jan24	16
Tm10942	44	9:20pm	430	Sy47	22Jan24	9:32pm	415	Sy47	22Jan24	16
Tm10942	44	10:20pm	430	Sy47	22Jan24	10:32pm	415	Sy47	22Jan24	16
Tm10942	44	11:25pm	430	Sy47	22Jan24	11:37pm	415	Sy47	22Jan24	15
Tm10942	44	12:55AM	430	V078	23Jan24	1:07AM	415	V078	23Jan24	16
Tm10942	44	1:34AM	430	SH85	23Jan24	1:46AM	415	SH85	23Jan24	16

① V078 22Jan24



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

PRODUCTION ORDER# 500000297259

OP 400



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

PO #: 50000297259

OP #: 500 Shift #: 2nd

Total Parts Reworked:		24	
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		14
MP	Micropores	n/a	n/a
SCR	Scratch	///	3
SKV	Skive Marks	n/a	n/a
VD	Voids		7
n/a	n/a	n/a	n/a
Inspected By (Sign and Date):		Vanneej Lor 22 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 #: 50000297259 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>18</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	///	<u>3</u>
EH	Exposed Hypotube	///	<u>5</u>
EW	Exposed Wire	/// //	<u>7</u>
MP	Micropores		<u>0</u>
SCR	Scratch		<u>0</u>
SKV	Skive Marks	///	<u>5</u>
VD	Voids		<u>0</u>
<u>N/A</u>	<u>N/A</u>		<u>0</u>

Inspected By (Sign and Date): Aug 22 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 #: 500000297259OP #: 500 Shift #: 2^{nd.}

Total Parts Reworked:		6	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	NIA	NIA
EH	Exposed Hypotube	NIA	NIA
EW	Exposed Wire		3
MP	Micropores	NIA	NIA
SCR	Scratch	NIA	NIA
SKV	Skive Marks	NIA	NIA
VD	Voids		3
NIA	NIA	NIA	NIA
Inspected By (Sign and Date):		MM02	22Jan24

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 #: 500000291259 OP #: 500 Shift #: 1st

Total Parts Reworked:		46	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		11
EW	Exposed Wire		27
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks		1
VD	Voids		7
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

LL61, BC81, VC09 ① 23 Jan 24
24 Jan

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):

LL61 23 Jan 24



Document No: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000297259 OP #: 750 Shift #: 1st

Total Parts Reworked:		129	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		33
DIM07 US / WC	DIM07 Undersized (Window Closed)		19
EH	Exposed Hypotube		35
N/A	Glue, stopper		42
Inspected By (Sign and Date):		Hv 36 23 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000297259

OP #: 750 Shift #: 2nd.

Total Parts Reworked:		65	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		58
DIM07 US / WC	DIM07 Undersized (Window Closed)		1
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		mm02 22 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: 6102646
Rev: A
Document Type: Manufacturing Form
Title: SA0155-01 Tipping Rework Form

PO #: 500000 297259 OP #: 750 Shift #: 2nd

Total Parts Reworked:		32	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	HHH HHH HHH HHH HHH	25
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	0
EH	Exposed Hypotube	HHH //	7
N/A	N/A	N/A	0
Inspected By (Sign and Date):		M26023Jan24	

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# 500000297259

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	9:56PM	190°F	SG88	22 Jan 24	10:56pm	190°F	SG88	22 Jan 24	52
TM10409	N/A	10:40pm	190°F	SG88	22 Jan 24	11:50pm	190°F	SG88	22 Jan 24	38
TM10409	N/A	11:57pm	190°F	SG88	22 Jan 24	1:07AM	190°F	SG88	22 Jan 24	37
TM12036	N/A	12:43am	190°F	SG88	23 Jan 24	1:53AM	190°F	SG88	23 Jan 24	48
TM10409	N/A	1:19AM	190°F	SG88	23 Jan 24	2:29AM	190°F	SG88	23 Jan 24	45
TM10409	N/A	5:00am	190°F	SS44	23 Jan 24	6:10am	190°F	SS44	23 Jan 24	23
TM12036	N/A	5:25am	190°F	SS44	23 Jan 24	6:35am	190°F	SS44	23 Jan 24	48
TM10409	N/A	6:15 am	190°F	K155	23 Jan 24	7:25 am	190°F	K155	23 Jan 24	50
TM10409	N/A	7:20 am	190°F	K155	23 Jan 24	8:30am	190°F	K155	23 Jan 24	43
TM12036	N/A	8:00am	190°F	K155	23 Jan 24	9:10am	190°F	K155	23 Jan 24	30
TM10409	N/A	8:30 am	190°F	K155	23 Jan 24	9:40 am	190°F	K155	23 Jan 24	32
TM10409	N/A	9:30 am	190°F	K155	23 Jan 24	10:40am	190°F	K155	23 Jan 24	32
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
① SG88	23 Jan 24									

② K155 24 Jan 23



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

PO #: 500000297259 OP #: 900 Shift #: 2

Total Parts Reworked:		23	
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		2
MP	Micropores	N/A	N/A
SCR	Scratch		27
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		
DIM09 US	DIM09 OD Undersized	HT72 22 Jan 24	
Inspected By (Sign and Date):		HT72 22Jan24	

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 #: 50000297259 OP #: 900 Shift #: 2

Total Parts Reworked:		20	
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	1	1
MP	Micropores	N/A	0
SCR	Scratch		22
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):		 22 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 #: 500000297259

OP #: 900 Shift #: 1st

Total Parts Reworked:		68	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		2
EW	Exposed Wire		7
MP	Micropores	N/A	N/A
SCR	Scratch		25
SKV	Skive Marks	N/A	N/A
VD	Voids		8
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		33
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		K155, KT47 DY29 23 Jan 24 PY216	

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, DIM06 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

EDW Commander Flex

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	28.97	28.43	28.91	31.11	26.5	27.9	27.03	27	29.19	26.88	28.192	1.4192627	4.378	21.9784678	8.542	PASS
Seg B	60.65	62.39	62.18	59.68	61.36	60.63	63.03	62.45	61.59	64.07	61.803	1.2911756	3.981	56.6628299	8.542	PASS
Seg C	75.39	76.54	80.53	74.11	76.53	77.37	78.12	71.42	77.1	73.95	76.106	2.5316977	2.911	68.7362279	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 #: 500000297259

Date: 24JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

 24Jan24