

# Production Order: 500000294023



Production Order Document  
Production Order Qty: 500

PC  
Sheet: 1 of 1

## Material: SA0155-01 Rev F

Material Type: ZFRT Description: Edwards Flex Shaft Commander 155885  
 Production Version: 7987  
 Plant / Business Unit: 1213 / AC5

Order Type: ZSTD

Project Phase:

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	KITTING3  Kitting Devices    Kitting Devices	<p>Kitting Devices                      Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>XC31 7:40AM 03JAN24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>XC31 9:30AM 03JAN24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	03JAN24	KL27

Notes: DA2484, 2564

N/A

N/A

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DAm68 05JAN24

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## Material: SA0155-01 Rev F

Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP	MP	RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u> <u>81054</u> <u>58497</u>	<u>N/A</u> <u>100</u> <u>25</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>86518</u> / <u>86519</u> <u>86520</u> / <u>86521</u>	<u>100/200</u> <u>200/100</u>		
		1000-2053-01	A	<u>F</u>	PC	500	<u>0000268040</u>	<u>518</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>N/A</u> <u>0006276175</u>	<u>0500 N/A</u> <u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>
							<u>N/A</u>		<u>N/A</u>	<u>N/A</u>

Notes:

N/AN/AN/A

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Opr No.	Planned WorkCenter Description	Operation Details						Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	141967-01	02	02	PC	500	80349/81188 82898/82899	41/2770			
		RM7349-02	C	C	PC	543	82331/82332 84800	225/217	335/150		
		RM7348-01	C	C	PC	500	78684 82881	50	300		
		RM4001-01	B	B	PC	125	082094 n/a 82818	n/a	03436		
		RM0607-01	D	D	PC	56	71863 n/a	145	n/a		
		RM0498-01	C	C	PC	500	0000287518 n/a	500	n/a		
		RM0009-04	I	I	PC	1	82971 n/a	Bulk	n/a	n/a	n/a
		RM0009-04	I	I	PC	1	82971	Bulk			

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	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000271052</u>	<u>N/A</u>	<u>Bulk</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000281413</u>	<u>N/A</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>0000278966</u>	<u>N/A</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>0000275691</u>	<u>N/A</u>	<u>N/A</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>0000271050</u>	<u>N/A</u>	<u>N/A</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>0000281411</u>	<u>N/A</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>0000286925</u>	<u>517</u>	<u>N/A</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
MA 100	n/a CATASY01 Catheter Assembly 1  	n/a Line Clearance Perform Line Clearance and Heat Gun Setting  Line Clearance Confirmation Reqd(Milestone )	n/a  500	n/a 0	04Jun24 V078	n/a
MA 150	CATHSY01 Catheter Assembly 1  	Major and Minor Mandrel Assembly  Major and Minor Mandrel Assembly	500	0	04Jun24 CL30 SH23 JY90 RN21 AF54 PM96	
<b>Notes:</b>						
MA						
MA						
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
NP	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	04 Jan 24	CP32 NY35 AL34 VP62
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	04 Jan 24	AS31 V078 MY50 SX11
Notes:						
N/A						
MA						
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 Reqd(Milestone )		N/A	N/A N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1  Insert Cut Hypo Tube  Insert Cut Hypo Tube  Confirmation Reqd(Milestone )	Insert Cut Hypo Tube	500	0	04Jan24	Gs22 8H23 0V39 LM46
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	04Jan24	ST96 SH85 VV25 CY97

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					
N/A	 Confirmation Reqd(Milestone)		N/A	N/A	N/A	N/A
400	<b>CATASY01</b> Catheter Assembly 1  Reflow		500	0	SX60 SY47 NK62 AX05 AF54 PM96 Out Jan 24	
450	<b>CATASY01</b> Catheter	FEP Removal	500	0	SJ90 AF54 PM96 Out Jan 24	

Notes:

N/A

N/A

N/A

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Opn No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1  					
MP	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 Material Consumed: Part #: 1006-1153-0 Batch #: 86519 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	492	OF - HII EW - II (8) 04/24	P66 LT35 PP40 TD45 LL61 VCO9 CB81 SX11	
MP	In-process Inspection and Rework					
	Confirmation Reqd(Milestone )					
MP	N/A	N/A	N/A	N/A	N/A	N/A
<b>Notes:</b>						

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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 )	492	0	04/Jan/24	CLO5 SR46 RS23 FB01 AL34 PH59
600	CATASY01  Catheter Assembly 1    Distal Tip Assembly  Distal Tip Assembly  Confirmation	Distal Tip Assembly	476	IDB-11 DL-44111 MAH-1111 (16)	04/Jan/24	MM02 ML38 RS23 VA96 FBO) KT47

Notes:

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP	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	476	0	04 Jun 24	VPA6 FBO1 KT207
700	CATASY01 Catheter Assembly 1  Tipping	Tipping Record Tipping Oven Information: TMI: 0936A Cal Due: 31 may 24 TMI: 2083C Cal Due: 31 may 24 TMI: 0386 Cal Due: 31 may 24 TMI: 0521 Cal Due: 31 may 24	476	0	04 Jun 24	STR48

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	N/A
750	CATASY01 Catheter Assembly 1  	Tip Inspection/ Flash Removal Material Consumed: Part #: <u>204001-01</u> Batch #: <u>82094</u> Qty: <u>15</u> Part #: <u>204007-01</u> Batch #: <u>71843</u> Qty: <u>10</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u>	476	0	out Jan 24	Hv36 STX48 PHn9
800	CATASY01 Catheter Assembly 1  	Major Mandrel Removal	468	ACD-HH 111 ⑧	out Jan 24 SS44 SS52	
Notes:						
N/A						
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
	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  Confirmation Reqd(Milestone )	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>	468	0	① 04Jan24 04Jan24	SS52 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	① 04Jan24	n/a
Notes:						
<i>n/a</i>						
<i>n/a</i>						

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(1) PY46 04Jan24

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**Material: SA0155-01 Rev E**

**Notes:**

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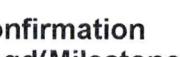
SA0155-01

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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	 Quality Inspection & Review Confirmation Reqd(Milestone )	TMI: N/A Cal Due: N/A Record DIM02 Go/No-Go Gage Information: TMI: 0691 Cal Due: 30sep25 TMI: 0692 Cal Due: 30sep25 Record DIM02 Inspection Results N = 54: Pass: 54 Fail: 0	367	DIS(SP) HHT DIS-HHT HHT HHT STR-HHT HHT HHT	04Jan24	k155 1936 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: 1056 Cal Due: 31may24 Record Length Gage Information: TMI: 0889 Cal Due: 30sep24 Record Calibrated Ruler Information: TMI: 10629 Cal Due: 30sep24	327	LT-HHT HHT HHT HHT HHT HHT HHT HHT	04Jan24	SSH44 KL67

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	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	302	SCR - III (TT) Del - III (TT) PM - II (TT) DL - III DIS - III BP - III WK - I  <i>05 Jan 24</i>	25	XN26 SVU3
1100	CATASY01  Catheter Assembly 1    Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <i>Am68 05 JAN 24</i>	N/A	N/A	N/A	N/A
Notes:						
<i>N/A</i>						
<i>N/A</i>						
<i>N/A</i>						

Date Printed: 01/03/2024 / 09:38:14

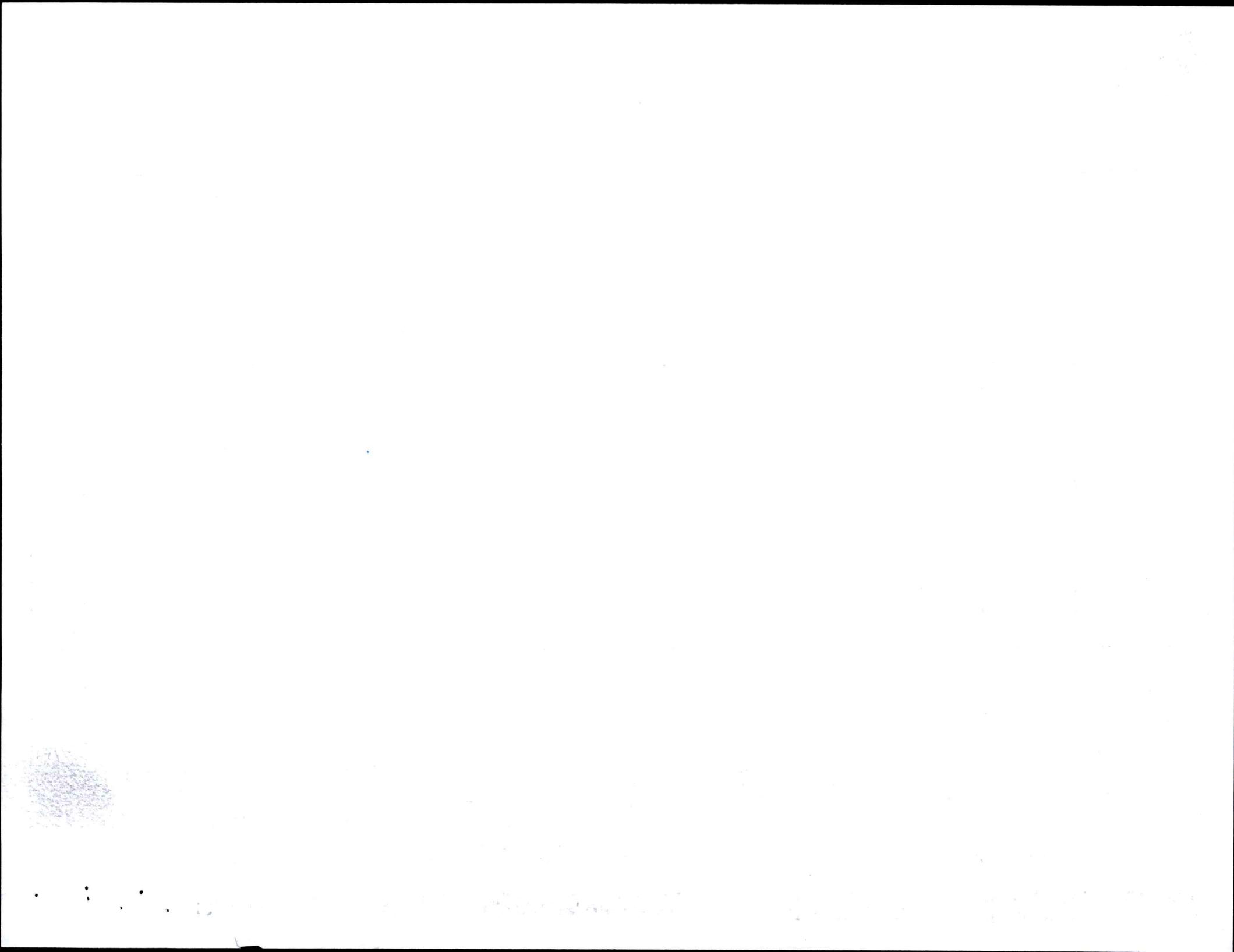
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
1100	Confirmation Reqd(Milestone )	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1  Packing assembly    Package  Confirmation Reqd(Milestone )	Package Package, Label, and Ship Finished Parts	302	0	05 Jan 24	BATI

Notes:

N  
N  
N

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**Material: SA0155-01 Rev F**

Batch Number: 0000294013

By: BA71

Date: 05 Jan 24

Reviewed By:

RB29

Date:

05 JAN 24

Notes:

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CREGANNA MEDICAL

**CONTROL**

**GANNA MEDICAL** is part of **Expend to 2023** **DEVIATION A**

**=TE**

**CONTROLLED COPY** DEVIATION AUTHORIZATION NUMBER: 2484  
\* See attached email extension to 24

**AUTHORIZATION FORM** Extended to **23 OCT 2023** **24 AUG 2023** **1512** **See attached email extension to 24 SEP 2023**

Requestor Name: Udhesh Kapadnis

Requestor Name: Udhesh Kapadnis	Document Number Affected	Revision
	3107610	L

Part Number Affected	Revision	
SA0155-01	H	
Start Date:	End Date:	Lot Number:
26 Jul 2023	25 Aug 2023	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 <input type="checkbox"/> 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.	

<b>Corrective Action Required:</b>	<input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
<b>If no, explain:</b> 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.	

① UK55, 23JW 2023



## 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 T512 10AUG23**



Image- 1

### Step 1:

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



Image- 2

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

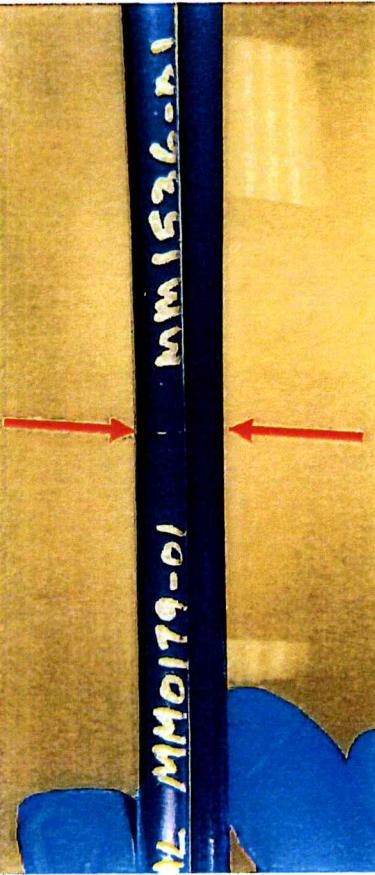


Image- 3

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

## **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)

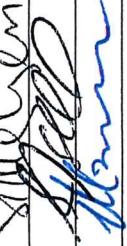
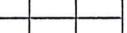
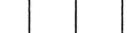


Image- 4

- 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

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## DEVIATION AUTHORIZATION FORM

Requestor Name:	Krishna Selvaraj		
Document Number Affected	Revision		
Doc #3005206 (MPI0238)	BP		
Deviation From:	<b>Deviation To:</b> Doc # <b>3005206 (Flex Commander MPI0238):</b> <b>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>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.		
Part Number Affected	Revision		
SA0155-01	H		
Start Date:	End Date:	Lot Number:	
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			
Corrective Action Required:	<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.			
Training Required:	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<b>If no, explain:</b> 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# 500000294023

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	9:38pm	430	Sy47	03Jan24	9:50pm	415	Sy47	03Jan24	16
Tm10942	44	10:10pm	429	SX60	03Jan24	10:22pm	415	Sy47	03Jan24	16
Tm10942	44	10:35pm	429	Sy47	03Jan24	10:47pm	415	Sy47	03Jan24	16
Tm10942	44	11:38pm	430	SX60	03Jan24	11:50pm	415	SX60	03Jan24	16
Tm10942	44	12:11AM	429	SX60	04Jan24	12:23AM	415	Sy47	04Jan24	16
Tm10942	44	<del>12:58</del> 12:48AM	429	Sy47	04Jan24	1:00AM	415	Sy47	04Jan24	16
Tm10942	44	1:29AM	430	SX60	04Jan24	1:41AM	415	Sy47	04Jan24	16
Tm10942	44	1:51AM	428	Sy47	04Jan24	2:03AM	415	SIA07	04Jan24	16
Tm10942	44	5:30am	430	AX05	04Jan24	5:42am	415	AX05	04Jan24	16
Tm10942	44	5:59am	430	AX05	04Jan24	6:11am	415	AX05	04Jan24	16
Tm10942	44	6:22am	428	AX05	04Jan24	6:34am	415	AX05	04Jan24	16
Tm10942	44	6:50am	430	KL95	04Jan24	7:02AM	415	AX05	04Jan24	16

(1) Sy47 04Jan24



Document No: 5105589

FM5104665 Rev: C

**Document Type: Manufacturing Form**

## Title: SA0155-01 Reflow Log Sheet Form

**PRODUCTION ORDER#** 500000294023

OP 400

① KCL95 04 Jan 24



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

PRODUCTION ORDER# 500000294023

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	9:24pm	429	SX60	03Jan24	9:36pm	415	SY47	03Jan24	16
Tm10745	44	9:55pm	429	SY47	03Jan24	10:07pm	415	SY47	03Jan24	16
Tm10745	44	10:54pm	430	SY47	03Jan24	11:06pm	415	SX60	03Jan24	16
Tm10745	44	11:56pm	430	SX60	03Jan24	12:08AM	415	SY47	04Jan24	16
Tm10745	44	12:29AM	429	SY47	04Jan24	12:41AM	415	SY47	04Jan24	16
Tm10745	44	1:18AM	430	SY47	04Jan24	1:30AM	415	SY47	04Jan24	16
Tm10745	44	1:40AM	428	SX60	04Jan24	1:52AM	415	SY47	04Jan24	16
Tm10745	44	5:10am	430	AX05	04Jan24	5:22am	415	AX05	04Jan24	16
Tm10745	44	5:28am	427	AX05	04Jan24	5:40am	415	AX05	04Jan24	16
Tm10745	44	5:50am	429	AX05	04Jan24	6:02am	415	AX05	04Jan24	16
Tm10745	44	6:10am	428	AX05	04Jan24	6:22am	415	AX05	04Jan24	16
Tm10745	44	6:30am	427	AX05	04Jan24	6:42am	415	AX05	04Jan24	16



**PRODUCTION ORDER#** 500000294023

OP 400

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



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

PO #: 500000294023

OP #: 500 Shift #: 2nd

Total Parts Reworked:		//	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	/
EH	Exposed Hypotube	PP40 03 Jan 24	/
EW	Exposed Wire	HHH HHH	/
MP	Micropores		/
SCR	Scratch	N/A	/
SKV	Skive Marks		/
VD	Voids	PP40 03 Jan 24	/
Inspected By (Sign and Date):		PP40 03 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 #: 50000 294023 OP #: 500 Shift #: 2

Total Parts Reworked:		<u>6</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>1</u>	<u>1</u>
EW	Exposed Wire	<u>   </u>	<u>5</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):		<u>Andy</u> 03 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 #: 500000 294023

OP #: 500 Shift #: 2

Total Parts Reworked:		13	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		5
EW	Exposed Wire		5
MP	Micropores	N/A	N/A
SCR	Scratch		3
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):		LT35 03 Jun 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 #:** 500000294023

**OP #:** 500    **Shift #:** 1<sup>st</sup>

Total Parts Reworked:		170	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		38
EW	Exposed Wire		113
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		7
VD	Voids		25
N/A	N/A	N/A	N/A

**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 #: 500000294023 OP #: 750 Shift #: 1st

Total Parts Reworked:		141	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		38
DIM07 US / WC	DIM07 Undersized (Window Closed)		20
EH	Exposed Hypotube		30
N/A	Glue, Stopper		53
Inspected By (Sign and Date):		Hv 36 04 Jan 24	

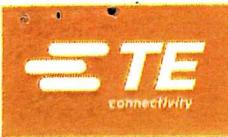
Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only. DIM01 OS, DIM09 OS, Foreign Material, and Cracks are not reworkable per MPI0238.

Data Uploaded for Engineering Review (Check):

PRODUCTION ORDER# 50000294023

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	5:40am	190F	SSHH	04Jan24	6:50am	190F	SSHH	04Jan24	31
TM12036	N/A	6:30am	190F	K155	04Jan24	7:40am	190F	K155	04Jan24	36
TM10409	N/A	7:40am	190 F	K155	04Jan24	8:50am	190 F	K155	04Jan24	27
TM12036	N/A	8:30am	190 F	K155	04Jan24	9:40 am	190 F	K155	04Jan24	36
TM10409	N/A	9:15am	190F	SSHH	04Jan24	10:25am	190F	SSHH	04Jan24	35
TM12036	N/A	9:40am	190 F	K155	04Jan24	10:50am	190 F	K155	04Jan24	31
TM10409	N/A	11:20am	190 F	K155	04Jan24	12:30pm	190 F	K155	04Jan24	39
TM12036	N/A	11:50am	190 F	K155	04Jan24	1:00 pm	190 F	K155	04Jan24	40
TM10409	N/A	12:30pm	190 F	K155	04Jan24	1:40PM	190 F	K155	04Jan24	67
TM12036	N/A	1:00 PM	190 F	K155	04Jan24	2:10PM	190 F	K155	04Jan24	40
TM10409	N/A	2:00PM	190F	OS21	04Jan24	3:10pm	190 F	OS21	04Jan24	86
				N/A						
				OS21	04Jan24					



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

PO #: 500000294023 OP #: 900 Shift #: 1st

Total Parts Reworked:		95	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		6
EW	Exposed Wire		8
MP	Micropores	N/A	N/A
SCR	Scratch		50
SKV	Skive Marks		5
VD	Voids		17
DIM01 US	DIM01 OD Undersized	N/A	N/A
DIM06 US	DIM06 OD Undersized		11
DIM06 OS	DIM06 OD Oversized	N/A	N/A
DIM09 US	DIM09 OD Undersized	N/A	N/A
Inspected By (Sign and Date):		le 155	04 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 #: 500000294023 OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		59	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		2
EW	Exposed Wire		14
MP	Micropores	N/A	0
SCR	Scratch		45
SKV	Skive Marks		5
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		6
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		<i>Scheher HT72, Maril</i>	04 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	25.44	23.05	28.17	28.35	30.37	28.85	31.35	28.79	26.88	29.37	28.062	2.4149157	4.378	17.4894991	8.542	PASS
Seg B	61.84	61.36	63.8	63.4	57.79	66.24	61.88	60.27	59.76	63.35	61.969	2.3845496	3.981	52.4761081	8.542	PASS
Seg C	80.31	78.41	79.22	78.83	79.98	77.34	78.29	75.42	79.12	79.15	78.607	1.4012062	2.911	74.5280887	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 #: 500000294023

Date: 05JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24 -


05Jan24