

Production Order: 500000296056



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 Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KP02 5:15am 17 Jan 24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 7:45am 18 Jan 24</u> Record Dryer Shelf #: <u>N/A</u>									
	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	N/A	N/A	16Jan24	TPde	
	1000-2053-01	A <u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>	<u>N/A</u>	<u>N/A</u>			
	MM1537-02	A <u>A</u>	PC	500	<u>0000274175</u>	<u>500</u>					

Notes: DA 2484, 2564

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	RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u> <u>50497</u>	<u>N/A</u> <u>139</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u> <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>N/A</u> <u>Bulk</u>		
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u> <u>N/A</u>	<u>N/A</u> <u>Bulk</u>		
		141967-01	02	<u>02</u>	PC	500	<u>N/A</u> <u>85550</u>	<u>510</u> <u>N/A</u>	<u>N/A</u> <u>N/A</u>	<u>N/A</u>
		RM7349-02	C	<u>C</u>	PC	543	<u>N/A</u> <u>82851</u>	<u>N/A</u> <u>200</u>		
		RM7348-01	C	<u>C</u>	PC	500	<u>82852</u> <u>78689</u> <u>78640</u>	<u>307</u> <u>500</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	RM4001-01	B	<u>B</u>	PC	125	<u>82453</u>	<u>100</u>		
		RM0607-01	D	<u>D</u>	PC	56	<u>74662</u>	<u>N/A</u>		
		RM0498-01	C	<u>C</u>	PC	500	<u>0000275491</u>	<u>400</u>		
							<u>0000275490</u>	<u>112</u>		
		RM0362-01	E	<u>E</u>	PC	594	<u>80240</u>	<u>517</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>82971</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>82971</u>	<u>Bulk</u>		
		MM1538-01	A	<u>A</u>	PC	500	<u>0006278970</u>	<u>500</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>0006284209</u>	<u>1,000</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
N/A	N/A	MM1536-01	B	<u>B</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0179-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		MM0176-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>N/A</u>	<u>N/A</u>		

Notes:

N/A

N/A

N/A

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Opri 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 Line Clearance Confirmation Reqd(Milestone)	500	O	① 19 Jan 24 18 Jan 24	KL95
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly Major and Minor Mandrel Assembly	500	O	① 17 Jan 24 18 Jan 24	NF62 AF54 CL30 JY90
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
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	① 14 Jun 24 18 Jun 24	MY50 VP62 ST96 Y014
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End	Trim Braid Wire at Proximal End	500	0	① 14 Jun 24 18 Jun 24	PL34 SK11 AS31 NY35

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	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	① 19Jan24 18Jun24	LMU6 Sx11 cp32 V078
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	⑥ 19Jan24 18Jun24	W25 C497 C105 V078
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
N/A	Load Tubing Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	① 19Jan24 BJun24 pm96 SY47 SH85	NK62 RN27 AX05
450	CATASY01 Catheter	FEP Removal	500	0	① 19Jan24 18Jun24	pm96 SG88
Notes:						
N/A						
N/A						
N/A						

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Opi No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 N/A 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 #: 1000-1153-0 Batch #: 87455 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		493	OF - 11 EW - 1111 DL-1 18Jan24 7	LL61 CB81 VC09 VLA1 HJ0024 18Jan24 SR46 T266 TD45	
N/A	N/A	N/A N/A 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)	Remove Heat Shrink & Mandrel	493	0	① 19Jan24 PH59 PP40 GS22	VAG6 DV39 RS23
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Distal Tip Assembly Confirmation	Distal Tip Assembly	485	DL - II MTH - II IDB - II MTS - II ⑧	① 19Jan24 PH59 ML60	VAG6 FRO)

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
NIA	Reqd(Milestone)	NIA	NIA	NIA	NIA	NIA
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	485	O	P446 TPN D429 18Jan24 ML38 MVTB	
700	CATASY01 Catheter Assembly 1 Tipping	Tipping Record Tipping Oven Information: TMI: 09964 Cal Due: 31may24 TMI: 2083C Cal Due: 31may24 TMI: 0386 Cal Due: 31may24 TMI: 0521 Cal Due: 31may24	485	O	STX48 Hv36 19Jan24 18Jan24 ML38	

Notes:

NIA
NIA
NIA

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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 	<p>Tip Inspection/ Flash Removal Material Consumed:</p> <p>Part #: RM4001-01 Batch #: 82453 Qty: 5 Part #: RM4007-01 Batch #: 74462 Qty: 8 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</p> <p>Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)</p>	485	0	(1) 18Jan24 18Jan24	STX48 Hv36 mmoz DX35
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	478	0 ACD-HH11 (7)	18Jan24 18Jan24 18Jan24	SS44 SS52 XL91 AB9

Notes:

N/A

N/A

N/A

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(1) V078 18Jan24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	XLA1 TRN VL91
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>	411	Sku-1 ①	18Jan24	SS52 Y936
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	N/A	Dis - II (SP) SCR - II (SP) #90511 ① #90512 ② #90511	N/A	Sf6d HT72 ML65

Notes:

N/A

N/A

N/A

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① M165 18Jan24
② ML65 18Jan24

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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:</p> <p>TMI: <u>0700-01</u> Cal Due: <u>31 May 24</u></p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Material Consumed:</p> <p>Part #: <u>RMO158-01</u> Batch #: <u>58497</u> Qty: <u>6</u></p> <p>Part #: <u>RN4001-01</u> Batch #: <u>82453</u> Qty: <u>5</u></p> <p>Part #: <u>RMO107-01</u> Batch #: <u>74662</u> Qty: <u>8</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p> <p>Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u></p>	452	<p>B54-1 DC1-1 D15-1 W6-1 #705-111 EH-11 DS-111 MAR-111 #945-1</p> <p>(25)</p>	18 Jun 24	b155 KT211 XL91 KL67
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: <u>N/A</u> Cal Due: <u>N/A</u></p> <p>Record Caliper Information:</p>	N/A	N/A	N/A	N/A

Notes:

N/A

N/A

N/A

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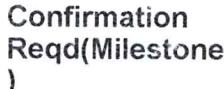
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Obr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record DIM02 Go/No-Go Gage Information: TMI: <u>0691</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>	436	STR-11 DEL-III DIS-UM UN MAR-1 16	18Jan24	k155 XL91 KL67
1000	QUALITY1  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>0889D</u> Cal Due: <u>30Sep24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30Sep24</u>	424	LT-++① UN UN II 12	18Jan24	LL61 XL91 KL67

Notes:

N/A

N/A

N/A

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① MVTB 18 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  Quality Inspection & Review Confirmation Reqd(Milestone) 	Required Inspection Visual Final Inspection Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS		3/14 50	Del - III (TT) SCR - III (TT) FM - II (TT) SKV - III III DL - III III Del - IIII VD - III II EW - IIII SC12 - II FL - I CRK - II FB - I BP - I GNII - I	19 Jan 24 SV43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>Am 68</u> ⁽¹⁾ <u>19 Jan 24</u> / <u>19 Jan 24</u>	N/A	N/A	N/A	N/A (1) Am 68

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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
1150	PACKINT1 Packing assembly  Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	374	0	19 Jan 24	(BA71)

Notes:

N
N
N

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Material: SA0155-01 Rev F

Batch Number: 0000296057p

By: BA71

Date: 19 Jan 24

Reviewed By:

AT78

Date:

19 Jan 24

Notes:

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OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM12036	N/A	12:10pm	190F	SSHH	18Jan24	1:20 pm	190F	KISS	18Jan24	48
TM10409	N/A	1:25pm	190F	SSHH	18Jan24	2:35pm	190F	SSHH	18Jan24	33
TM12036	N/A	1:55pm ^①	190F	SSHH	18Jan24	3:05pm	190F	SSHH	18Jan24	28
TM10409	N/A	2:30pm	190F	SSHH	18Jan24	3:40pm	190F	SSHH	18Jan24	40
TM10409	N/A	4:03PM	190F	XL91	18Jan24	4:03PM	190F	XL91	18Jan24	25 ^②
TM10409	N/A	4:03PM	190 F	XL91	18Jan24	5:13PM	190F	XL91	18Jan24	25
TM12036	N/A	4:42PM	190 F	XL91	18Jan24	5:52PM	190F	XL91	18Jan24	38
TM10409	N/A	5:20PM	190F	VL91	18Jan24	6:30PM	190F	VL91	18Jan24	44
TM10409	N/A	6:38PM	190F	VL91	18Jan24	7:48PM	190F	VL91	18Jan24	44
TM12036	N/A	7:20PM	190F	VL91	18Jan24	8:30PM	190F	VL91	18Jan24	56
TM10409	N/A	7:50PM	190F	AT39	18Jan24	9:02PM	190F	AT39	18Jan24	31
TM12036	N/A	8:31pm	190F	AT39	18Jan24	9:41pm	190F	AT39	18Jan24	53
TM10409	N/A	9:22pm	190F	SG88	18Jan24	10:32pm	190F	SG88	18Jan24	38

① SSHH 18 Jan 24

② XL91 18Jan24



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

PO #: 500000296056 **OP #:** 500 **Shift #:** 1st

Total Parts Reworked:		80	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		14
EW	Exposed Wire		46
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks		9
VD	Voids		17
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: 5105589
FM5104665 Rev: C
Document Type: Manufacturing Form
Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000296056

OP 400



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

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OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TMI0942	44	8:25 am	430	RN27	18Jan24	8:27 am	415	RN27	18Jan24	16
TMI0942	44	8:44am	426	KL95	18Jan24	8:56am	415	AX05	18Jan24	16
TMI0942	44	9:05am	427	AX05	18Jan24	9:17am	415	AX05	18Jan24	16
TMI0942	44	9:25am	428	AX05	18Jan24	9:37am	415	AX05	18Jan24	16
TMI0942	44	9:50am	430	AX05	18Jan24	10:02am	415	AX05	18Jan24	16
TMI0942	44	10:45am	430	AX05	18Jan24	10:57am	415	AX05	18Jan24	16
TMI0942	44	11:15am	430	AX05	18Jan24	11:25am	415	AX05	18Jan24	16
TMI0942	44	11:59am	430	AX05	18Jan24	12:11PM	415	AX05	18Jan24	16
TMI0942	44	12:32PM	430	AX05	18Jan24	12:44PM	415	AX05	18Jan24	16
TMI0942	44	1:50PM	430	AX05	18Jan24	2:02PM	415	AX05	18Jan24	16
TMI0942	44	2:25PM	430	AX05	18Jan24	2:37PM	415	AX05	18Jan24	16
TMI0942	44	2:50PM	430	AX05	18Jan24	3:02PM	415	AX05	18Jan24	16



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

PRODUCTION ORDER# 500000296056

OP 400



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

PRODUCTION ORDER# 500000296056

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	8:15am	426	AX05	18Jan24	8:27am	415	AX05	18Jan24	16
TM10745	44	8:35am	427	AX05	18Jan24	8:47am	415	AX05	18Jan24	16
TM10745	44	8:55am	426	AX05	18Jan24	9:07am	415	AX05	18Jan24	16
TM10745	44	9:15am	427	AX05	18Jan24	9:27am	415	AX05	18Jan24	16
TM10745	44	9:4am	430	AX05	18Jan24	9:52am	415	AX05	18Jan24	16
TM10745	44	10:59am	430	AX05	18Jan24	11:11am	415	AX05	18Jan24	16
TM10745	44	11:35am	430	AX05	18Jan24	11:47am	415	AX05	18Jan24	16
TM10745	44	11:56am	430	AX05	18Jan24	12:08pm	415	AX05	18Jan24	16
TM10745	44	12:20pm	430	AX05	18Jan24	12:32pm	415	AX05	18Jan24	16
TM10745	44	1:00pm	430	AX05	18Jan24	1:12pm	415	NK62	18Jan24	16
TM10745	44	2:05pm	430	AX05	18Jan24	2:17pm	415	AX05	18Jan24	16
TM10745	44	2:41pm	430	AX05	18Jan24	2:53pm	415	AX05	18Jan24	16



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

PO #: 500000296056 OP #: 500 Shift #: 2nd

Total Parts Reworked:		20	
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	1111111111	18
MP	Micropores	N/A	N/A
SCR	Scratch	1	1
SKV	Skive Marks	1	1
VD	Voids	N/A	N/A
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 18 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 #: 50000296056OP #: 500 Shift #: 2

Total Parts Reworked:		<u>24</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> </u>	<u>2</u>
EW	Exposed Wire	<u> </u>	<u>20</u>
MP	Micropores	<u>n/a</u>	<u>0</u>
SCR	Scratch	<u>n/a</u>	<u>0</u>
SKV	Skive Marks	<u> </u>	<u>6</u>
VD	Voids	<u> </u>	<u>1</u>
<u>n/a</u>	<u>n/a</u>	<u>n/a</u>	<u>0</u>
Inspected By (Sign and Date):		<u>Gupta</u>	<u>18 Jan 24</u>

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 #: 500000296056

OP #: 750 Shift #: 2

Total Parts Reworked:		(1+) 19	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	/	1
DIM07 US / WC	DIM07 Undersized (Window Closed)		4
EH	Exposed Hypotube		4
gd	① + glue damage		10
Inspected By (Sign and Date):		DX35 18 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):

① DX35 18 Jan 24
DX35 18 Jan 24

PO #: 500000296056OP #: 750 Shift #: 2nd

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

Total Parts Reworked:		23	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	III	13
DIM07 US / WC	DIM07 Undersized (Window Closed)		5
EH	Exposed Hypotube		5
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	18Jan24

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 #: 50000296056

OP #: 900 Shift #: J

Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

Total Parts Reworked:		69	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		5
EW	Exposed Wire		3
MP	Micropores	N/A	N/A
SCR	Scratch		64
SKV	Skive Marks	N/A	N/A
VD	Voids		3
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized	N/A HT72 18 Jan 24	
DIM09 US	DIM09 OD Undersized		
Inspected By (Sign and Date):		HT72 18 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):

- CONFIDENTIAL -

Page 1 of 1

Status CURRENT Effective 5/8/2023



PO #: 500000296056 OP #: 900 Shift #: 2nd

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

Total Parts Reworked:		65	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		5
EW	Exposed Wire		5
MP	Micropores	N/A	0
SCR	Scratch		48
SKV	Skive Marks		1
VD	Voids		5
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized		12
DIM06 OS	DIM06 OD Oversized		1
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H 18 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):

① UK55, 23 Jul 2023



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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 MM1536-01 fixture for inspection. (See image 1)
① MM0179-01 **② MM1536-01** **10AUG-23**

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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)

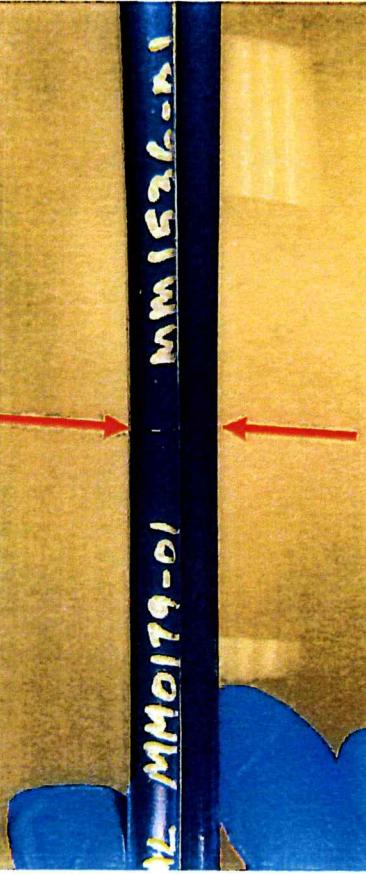


Image- 3

- 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.

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)

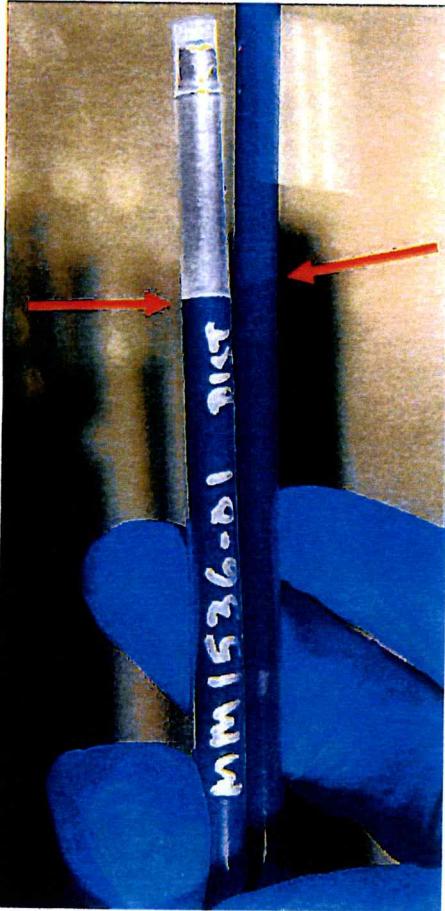


Image- 4

- 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.

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

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

Entered to Hansa 3228 12/15/2023
Entered to 13 February 3228 1/6/2024

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

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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

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	25.71	25.61	25.47	31	27.26	27.07	26.35	29.96	29.49	26.5	27.442	1.9913747	4.378	18.7237614	8.542	PASS
Seg B	60.35	57.8	60.18	59.57	55.55	62.39	59.03	64.04	59.62	65.91	60.444	3.0010746	3.981	48.4967219	8.542	PASS
Seg C	73.99	77.41	75.19	78.57	77.15	79.67	79.1	76.18	79.18	77.5	77.394	1.8455063	2.911	72.0217313	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 #: 500000296056

Date: 19JAN24

Inspector Name: Andrew Wipf

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24


19Jan24