

Production Order: 500000292878



Production Order Document
Production Order Qty: 500

PC

Sheet: 1 of 1

Material: SA0254-06 Rev G

Material Type:	ZFRT	Description: Printed Shaft 144C Prox End Color B CMDR	Order Type: ZSTD
Production Version:	7999		Project Phase:
Plant / Business Unit:	1213 / AC5		

Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
50	CATASY04 Catheter Assembly 4 Count: Yes  Prepare Materials MPI0398 Rev. AH Line Clearance MPI0230 Rev. F By: MW28 Date: 03 Jan 24 ① 03 Jan 24		500	0	② 04 Jan 24 MW28 04 Jan 24	MW28
100	CATASY04 Straighten First Jacket MPI0398 Rev. AH		N/A	N/A	N/A	N/A

Notes: DA 2581

N/A

N/A

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① MW28 03 Jan 24

② N45 04 Jan 24



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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty	Scrap Qty & Desc.	Date Comp.	Initials
	Catheter Assembly 4 N/A										BK05
	Straighten First Jacket	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	500	0	0451324	
		1000-1190-01	A A	FT	2708.350	0000289940	3,108.350				
	Confirmation Reqd(Milestone)					N/A	N/A				
150	CATASY04 Catheter Assembly 4 Positioning Braid Over First Jacket Confirmation Reqd(Milestone)	Positioning Braid Over First Jacket MPI0398 Rev. AH Record Braid Pic Count for 15 parts below: Braid Production Lot No: 0000286483 1. <u>40</u> 2. <u>40</u> 3. <u>40</u> 4. <u>40</u> 5. <u>40</u> 6. <u>40</u> 7. <u>40</u> 8. <u>40</u> 9. <u>40</u> 10. <u>40</u> 11. <u>40</u> 12. <u>40</u> 13. <u>40</u> 14. <u>40</u> 15. <u>40</u> If more than braid production lot is used for The build, record the braid pic count for 15 parts for the second braid production lot below. Enter N/A if only one braid production lot is used for the build.						500	0	0451324	M4341 M471 (TRN) NT35 CX32 SF35 SP43 VV84 VJ06

Notes:

N/A

N/A

N/A

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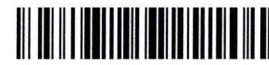
Notes:

N/A

N/A

NIA

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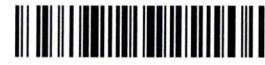
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Opr No.	Planned WorkCenter Description	Operation Details						Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Strain Relief Reflow Confirmation Reqd(Milestone)	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used				
		RM0096-01	F F	PC	167	82176	166				
						N/A	N/A				
		MM0527-01	C C	PC	500	0000276169	500				
						N/A	N/A				
250	CATASY04 Catheter Assembly 4 Position Tubing for Reflow	Position Tubing For Reflow MPI0398 Rev. AH	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	500	O	MY34 CX32 SF35 SP63 VJ06
			MM0186-00	D D	PC	500	0000282491	500			
							N/A	N/A			
			MM0523-03	C C	PC	500	0000276167	500			
							N/A	N/A			
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	N/A	MM0524-01	B	<u>B</u>	PC	500	<u>0000281416</u>	<u>500</u>	<u>N/A</u>		
		MM0530-01	B	<u>B</u>	PC	500	<u>0000276170</u>	<u>500</u>	<u>N/A</u>		
		RM7586-02	D	<u>D</u>	PC	500	<u>84450,83839</u>	<u>250,8</u>	<u>85002,83420</u>	<u>250,4</u>	
		MM0185-01	I	<u>I</u>	PC	500	<u>0000281409</u>	<u>500</u>	<u>N/A</u>		
		MM1539-01	A	<u>A</u>	PC	500	<u>0000278969</u>	<u>500</u>	<u>N/A</u>		
		TL5909-01	B	<u>N/A</u>	PC	5	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>		
		RM016101-MED	F	<u>F</u>	PC	125	<u>82407</u>	<u>125</u>	<u>N/A</u>		
		MM1540-01	B	<u>B</u>	PC	500	<u>0000278958</u>	<u>500</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
N/A	N/A	N/A	N/A	N/A	N/A	N/A
300	CATASY04 Catheter Assembly 4 	Reflow MPI0398 Rev. AH Temp = 415°F (+/- 15 °F) Speed = 4.5 in/min (+/- 0.5 in/min)	500	O	OK Jan 24	EE65
	Reflow	Component Number Req'd Rev Rev Used UOM Qty. Batch No. Actual Qty Used 1000-1154-01 A A PC 500 86410, 86407 100, 100 86486, 86488 100, 100 86485 100				
350	CATASY04 Catheter Assembly 4 	Skive Heat Shrink MPI0398 Rev. AH	500	O	TE 04Jan24	AN000 Mlob
	Skive Heat					

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	Shrink	N/A	N/A	N/A	N/A	N/A
400	CATASY04 Catheter Assembly 4 Count: Yes 	In-Process Inspection (Visual Inspection) MPI0398 Rev. AH FM5104693 (Rework if needed. Use FM5104983)	475	EW LH MH WH DF LH AB II	04Jan24	AN00 M66
		Component Number Req'd Rev Rev Used	UOM	Qty.	Batch No. Actual Qty Used	
		1000-1154-01 A A	PC	5	84047 5 N/A	
450	CATASY04 Catheter Assembly 4 	Anneal Shaft MPI0398 Rev. AH FM5104692	475	0	04Jan24	AN00 M66
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	Anneal Shaft	N/A	N/A	N/A	N/A	N/A
500	CATASY04 Catheter Assembly 4 	Leak Test/Prox Cut/Ring Gage-Dim 13/21 MPI0398 Rev. <u>AH</u> FM5104694 FM5104695 Leak Test/Prox Cut/Ring Gage-Dim 13/21 (Rework if needed - Use FM5104983)	470	LT-III ODB-11 04 Jan 24 04 Jan 24	SP86 VX41 04 Jan 24 04 Jan 24	SP86 VX41 04 Jan 24 04 Jan 24
550	CATASY04 Catheter Assembly 4 	Distal Cut MPI0398 Rev. <u>AH</u> Line Closure MPI0230 Rev. <u>F</u> By: <u>SP86</u> Date: <u>04 Jan 24</u>	470	0	04 Jan 24 04 Jan 24 04 Jan 24	VX41
600	PADPRIN1 Pad Print 	Pad Print Set Up MPI0276 Rev. <u>F</u>	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	Count: Yes Pad Print Setup	Line Clearance MPI0230 Rev. <u>F</u> By: <u>LV04 TRN</u> Date: <u>04JAN24</u> <u>GL42</u> TMI0503 (circle TMI used) Cliché - TL0525 Ink # RM7407-01 Thinner - RM7408-01 Hardener - RM7409-01 Customized Measuring Equipment - Caliper Inspection Gauge TMI0843 Setup Rod # TL0815 Program - #10 Ink Viscosity (REF) -5 to 6 Pad - TL0545 or equivalent Fence - TL0538 Drying Oven - TMI0643 Drying Racks-TL0531, TL0532 TMI0735 Cliché - TL0567 Ink - RM7407-01 Thinner - RM7408-01 Hardener - RM7409-01 Customized Measuring Equipment - Caliper Inspection Gauge TMI0843 Setup Rod # TL0815 Program - #10 Ink Viscosity (REF) -5 to 6 Pad - TL0545 or equivalent Fence - TL0569 Drying Oven - TMI0643 Drying Racks-TL0531, TL0532	470	0	04JAN24	LV04 TRN GL42

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 WO4 04 JAN 24				
650	PADPRIN1 Pad Print  Verification	Verification MPI0276 Rev. <u>F</u> Section 15.0	470	0	04JAN24 LW04 TRN GL42	

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	RM7408-01	B	<u>B</u>	L	0.005	<u>66780</u>	<u>0.005</u>	<u>N/A</u>	<u>N/A</u>	
		RM7409-01	B	<u>B</u>	L	0.010	<u>85169</u>	<u>0.010</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
700	PADPRIN1 Pad Print 	Prepare Surface for Ink MPI0276 Rev. <u>F</u> Section 15.5 Polynit wipes 99% IPA						470	0	04JAN24	LW04 TRN GL42
750	PADPRIN1 Pad Print 	Print Parts MPI0276 Rev. <u>F</u> Section 20.0 Inspection gauge TMI0843						470	0	04JAN24	LW04 TRN GL42
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
800	PADPRIN1 Pad Print 	In-Process Inspection and Rework MPI0276 Rev. <u>F</u> Section 30.0 Polynit Wipes 99% IPA Mag Light In-process Inspection and Rework	470	0	04JAN24	LV04 TRN GL42
850	PADPRIN1 Pad Print Curing Oven MPI0340 Rev. <u>B</u> Section 35.0 Curing oven for 120 +30/-15 minutes Parts sit for 8 hours minimum after curing oven Lot Completion time: <u>8:09 AM</u> By: <u>PK15</u> Date: <u>05 Jan 24</u> Confirmation Reqd(Milestone)		175 295	0	04JAN24 05Jan24	LV04 TRN GL42 PK15
900	PADPRIN1 Pad Print 	Transfer Parts to Quality MPI0276 Rev. <u>F</u> Section 40.0	N/A 470	N/A 0	05JAN24	N/A LV04 TRN GL42

Notes:

N/A

N/A

N/A

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①LV04 05jan24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Transfer parts to QA Confirmation Reqd(Milestone)	Transfer Parts to Line Time: <u>6:15 PM</u> By: <u>LV04 TRN</u> Date: <u>05JAN24</u> <u>GL42</u>	470	0	05JAN24	LV04 TRN GL42
950	PADPRIN1 Pad Print Count: Yes 	Cleaning MPI0276 Rev. <u>F</u> Section 50.0 Line Clearance <u>F</u> MPI0230 Rev. <u> </u> By: <u>LV04 TRN</u> Date: <u>05JAN24</u> <u>GL42</u>	470	0	05JAN24	LV04 TRN GL42
1050	QUALITY1	Required Inspection	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																				
1050	<p>Quality Inspection & Review</p>  <p>Quality Inspection & Review</p> <p>Confirmation Reqd(Milestone)</p>	<p>Perform Quality Inspection per QIP Document #3107613</p> <p>Record Data in SAP Inspection Plan</p>	1 436	<p>19-SL/GNG 4-FB 13-SL/GNG 9-SCR 4-PRT 1-FM 1-EW 1-FIB 1-EO</p>	06JAN24	<p>my28 LT03 AJ74 J001 SB08 LT03</p>																				
1070	<p>CATASY04</p> <p>Catheter Assembly 4</p>  <p>Rework MPI0398 Rev. <u>N/A</u></p> <p>Rework Process</p> <p>Confirmation</p>	<p>Rework MPI0398 Rev. <u>N/A</u></p> <p>Material consumed</p> <table> <tr> <td>Material _____</td> <td>Batch <u>N/A</u></td> <td>Rev _____</td> <td>Qty _____</td> </tr> <tr> <td>Material _____</td> <td>Batch _____</td> <td>Rev _____</td> <td>Qty _____</td> </tr> <tr> <td>Material _____</td> <td>Batch _____</td> <td>Rev _____</td> <td>Qty _____</td> </tr> <tr> <td>Material _____</td> <td>Batch _____</td> <td>Rev _____</td> <td>Qty _____</td> </tr> <tr> <td>Material _____</td> <td>Batch _____</td> <td>Rev _____</td> <td>Qty _____</td> </tr> </table>	Material _____	Batch <u>N/A</u>	Rev _____	Qty _____	Material _____	Batch _____	Rev _____	Qty _____	Material _____	Batch _____	Rev _____	Qty _____	Material _____	Batch _____	Rev _____	Qty _____	Material _____	Batch _____	Rev _____	Qty _____	436	0	06JAN24	LT03
Material _____	Batch <u>N/A</u>	Rev _____	Qty _____																							
Material _____	Batch _____	Rev _____	Qty _____																							
Material _____	Batch _____	Rev _____	Qty _____																							
Material _____	Batch _____	Rev _____	Qty _____																							
Material _____	Batch _____	Rev _____	Qty _____																							

Notes:

N/A

NIA

N/A

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① WTB 06 JAN 24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1090	QUALITY1 Quality Inspection & Review  Quality Inspection & Review Confirmation Reqd(Milestone)	Required Inspection Perform Quality Inspection per QIP Document #3107613 Record Data in SAP Inspection Plan	436	O 06 JAN 24	LID3	
1100	PACKINT1 Packing assembly 	Packaging Instructions SPI0087 REV. O	436	O 08 JAN 24	PA10	

Notes:

N/A AP10 08 Jan 24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Packing Instructions					
	Confirmation Reqd(Milestone)	<i>WIA AP10 08 Jan 24</i>				

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Batch Number: 0000292878

By: AB10

Date: 08 Jan 24

Reviewed By:

RB29

Date:

08 JAH 24

Notes:

N/A AB10 08 Jan 24

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DEVIATION AUTHORIZATION FORM

Requestor Name:	Geoffrey Dybicz		
Document Number Affected		Revision	
3107613	I		

Deviation From: MIC # Test/Specification Dimensions Sampling Equipment US100585 Distal Segment without Braid GN 6 View perpendicular to table. Pass if braid ends in "Acceptable Braid" region. Fail if braid ends in "No Braid Area" or "Must Have Braid" region. Record Summary PASS/FAIL 2.0" ± 0.3" 200% TMI0724 + Fiber Optic Light.	Deviation To: MIC # Test/Specification Dimensions Sampling Equipment US100585 Distal Segment without Braid GN 6 View perpendicular to table. Pass if braid ends in "Acceptable Braid" region. Fail if braid ends in "No Braid Area" or "Must Have Braid" region. Record Summary PASS/FAIL 2.0" ± 0.3" 200% TMI0724 + Fiber Optic Light. A different inspector must perform the second round of inspections. The second inspector should only inspect parts that passed the first round of inspections. Use attached form to record the results of both inspections. Notify engineering immediately if the second inspector rejects any parts.
-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------	---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------

Justification: Edwards has initiated SCAR-001909 as a result of three escapes for GN6. They are now 100% inspecting for this feature, instead of AQL. In order to successfully close the SCAR, we need to eliminate any additional escapes. This deviation will be used to catch any potential escapes while permanent corrective actions are implemented.

Part Number Affected		Revision	
SA0254 - All Tabs		F	
Start Date:	End Date:	Lot Number:	
20Dec2023	31Jan2024	All Lots	

Risk Assessment:
Is there any potential risk(s) that may occur as a result of the proposed deviation including the following:
Control Plans Yes No FMEA's Yes No Validations Yes No Details (if any):

If yes to any of the above, what controls are being put in place to mitigate the risk

Corrective Action Required: Yes No **Change plan to follow for Document update**
If no, explain: *Tsi 21DEC23*

Training Required: Yes No **If no, explain:**

Title	Approval Name	Approval Signature	Date
Manager, Manufacturing Engineering	Jake Stanislowski		20 Dec 2023
Quality Manager	Jay Zabel		20 Dec 2023
Manager, Operations	Matthew Benson		20 Dec 2023

Deviation Authorization 2581 Secondary Inspection Record			
100% GNE Inspection #1	100% GNE Inspection #2	Inspector Initials	Date Completed
LTO3	SB08	LTO3	06 JAN 24
Inspector Initials	Date Completed	100% GNE Inspection #1	Time Completed
LTO3	06 JAN 24	100% GNE Inspection #2	11:00 AM
Units Passing	145+	Units Failed	457
Units Failed	13	Units Failed	0

Note: Notify engineering immediately if the second inspector rejects any units.

Inspections may not occur concurrently.

Note: The second round of inspections must be completed by a different inspector.

Note: 100% GNE inspection must be performed twice.

(1) LTO3 06 JAN 24

PRODUCTION ORDER# 5000000292878

Document No: FM5104693
Rev: C
Document Type: Manufacturing Form
Title: SA0254 In-Process Inspection Form

OPER 400.0

In-Process Inspection (Visual Inspection)

Test/Specification	Dimensions	Sample Plan	Equipment	TMI TL	# Pass	# Fail	Initial/Date												
Using a magnification light, visually inspect the entire length of the shafts.	N/A	100%	Inspect at a minimum of 2.85x magnification		500	0	M106 04Jan24												
Metallic Foreign Material: No embedded metallic and foreign material is allowed along the length of the shaft.	N/A	100%	Inspect at a minimum of 2.85x magnification		500	0													
All other Foreign Material:																			
<table border="1"> <thead> <tr> <th>Particle Size Area: mm²</th><th>Acceptable Limits per Part</th></tr> </thead> <tbody> <tr> <td>< 0.05 mm²</td><td>No Limit</td></tr> <tr> <td>0.05 mm² ≤ Area < 0.25 mm²</td><td>3</td></tr> <tr> <td>0.25 mm² ≤ Area < 0.80 mm²</td><td>2</td></tr> <tr> <td>0.80 mm² ≤ Area ≤ 1.5 mm²</td><td>1</td></tr> <tr> <td>> 1.5 mm²</td><td>0</td></tr> </tbody> </table>	Particle Size Area: mm ²	Acceptable Limits per Part	< 0.05 mm ²	No Limit	0.05 mm ² ≤ Area < 0.25 mm ²	3	0.25 mm ² ≤ Area < 0.80 mm ²	2	0.80 mm ² ≤ Area ≤ 1.5 mm ²	1	> 1.5 mm ²	0	See Table	100%	Use a calibrated Tappi Chart and Inspect at a minimum of 2.85x magnification		500	0	
Particle Size Area: mm ²	Acceptable Limits per Part																		
< 0.05 mm ²	No Limit																		
0.05 mm ² ≤ Area < 0.25 mm ²	3																		
0.25 mm ² ≤ Area < 0.80 mm ²	2																		
0.80 mm ² ≤ Area ≤ 1.5 mm ²	1																		
> 1.5 mm ²	0																		
No surface damage to the shafts such as voids pits or cuts. (interior surface of distal end not included)	N/A	100%	Inspect at a minimum of 2.85x magnification		500	0													
No bumps, lumps, or protrusions along the shaft that will compromise the OD. Verify all protrusions to make sure the OD is still within specification.	N/A	100%	Inspect at a minimum of 2.85x magnification		500	0													
No flat spots, kinks, delamination, gaps between material transitions and material transitions should not exhibit cracking, no exposed or apparent braid.	N/A	100%	Inspect at a minimum of 2.85x magnification		475	25													
Measured material overflow on proximal end of stop sleeve must be ≤0.02" (i.e., 0.2 mm ² dot on Tappi chart).	≤0.2 mm ²	100%	Use a calibrated Tappi Chart and Inspect at a minimum of 2.85x magnification	N/A	475	0	M106 04Jan24												

PRODUCTION ORDER# 500000292878

Attachment B: Cause of Rework.

OPER 400.0

Attachment B: Cause of Rework

OPER 500.0

Status CURRENT Effective 10/27/2020

① SP86 05 Jan 24

Document No: FM5104692
Rev: B
Document Type: Manufacturing Form
Title: SA0254 Annealing Oven Log Form

PRODUCTION ORDER# 500000 292878

OPER 450.0

Annealing Log Sheet

Document No: FM5104694
 Rev: B
 Document Type: Manufacturing Form
 Title: SA0254 Max OD Gauge Check Form

PRODUCTION ORDER# 50000292878

OPER 500.0 ▲13 & ▲21 Max OD Gauge Check for the manufacturing lot PRIOR TO AND AFTER Inspection

Before & After Inspecting Parts	Dimension ## Gauge Check	TMI#####XX (Ex. TMI0748AC or TMI0747AD)	Initials	Date	Time
Before	Dimension 13	TM10746AM	M/28	04 Jan 23 04 Jan 24	8:00 pm
Before	Dimension 21	TM10747X	M/28	04 Jan 23 04 Jan 24	8:00 pm
After	Dimension 13	TM10748AM	M/28	05 Jan 23 04 Jan 24	1:30 AM
After	Dimension 21	TM10747 X	M/28	05 Jan 23 04 Jan 24	1:30 AM

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PRODUCTION ORDER# 500000292878

OPER 500.0

Pressure Decay Testing

Test/Specification	Dimensions	Sample Plan	Equipment	TMI/TL	# Pass	# Fail	Initial/Date
Air Leak Test GN 15	N/A	100%	Issac Pressure Decay Tester	TMI07976	472	3	SP86 04 Jan 24 04 Jan 23 ①
Outer Diameter ▲ 13 MAX OD at Pad Printed Area Drop Go Gauge from proximal end of shaft. Pass if ring stops at stop sleeve shoulder. Fail if gauge stops above or falls past stop sleeve shoulder.	0.145" +0.002"/-0.004" (≤0.147")	100%	Ring Gauge TMI0748	TMI0748AM	470	2	SP86 04 Jan 24 04 Jan 23 ①
Outer Diameter ▲ 21 MAX OD Drop Go Gauge from stop sleeve shoulder. Pass if ring does not stop. Fail if ring stops less than 4" distal from stop sleeve shoulder.	0.157" ± 0.003" (≤0.160")	100%	Ring Gauge TMI0747	TMI0747X	470	0	SP86 04 Jan 24

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Document No: FM5104983
Rev: B
Document Type: Manufacturing Form
Title: SA0254 Cause of Rework Form

PRODUCTION ORDER# _____

OPER 1050.0

Date	Initial	AB	DISC	DF	DS	EW	FM	OD	SCR	SKV	VD	OTHER

Record total quantity reworked:

Quantity Passed after Rework:

Rework Performed by: _____ Date: _____ Rework Performed by: _____ Date: _____

Re-Inspection Performed by: _____ Date: _____

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be randomly 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	EDW Commander Balloon - Bend and Tensile Strength Testing
Seg 1	32.75	31.63	27.02	29.38	27.56	26.13	32.13	29.23	27.45	26.29	28.957	2.4705512	4.378	18.14092676	8.542	PASS	LOT #: 500000292878 Date: 08 JAN 2024 Inspector Name: KOCK YU LEE Equipment ID: TMI0311B Cal Due Date: 27 OCT 2024
Seg B	20.92	20.19	19.52	20.15	20.77	19.81	19.72	22.45	21.38	19.27	20.418	0.9738446	4.378	16.15450828	8.542	PASS	
Seg C	51.81	52.74	50.58	50.17	44.99	49.98	47.32	49.27	50.03	48.04	49.493	2.2419438	4.378	39.67776983	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 not being required for DA acceptance.

KINK TEST AND BEND TEST PERFORMED .

Kockyulee

08 JAN 24