

Production Order: 500000300507



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</p> <p>Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP</p> <p>Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>XCS1 7:30PM 30 JAN 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KP02 11:30AM 31 Jan 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p>	N/A	N/A	30 JAN 24	SA 70																								
		<table border="1"> <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>MM0179-01</td> <td>D <u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000293119</u></td> <td><u>500</u></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td><u>N/A</u></td> <td><u>N/A</u></td> </tr> <tr> <td>MM1536-01</td> <td>B <u>B</u></td> <td>PC</td> <td>500</td> <td><u>0000281412</u></td> <td><u>500</u></td> </tr> </tbody> </table>	Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used	MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>				
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																									
MM0179-01	D <u>D</u>	PC	500	<u>0000293119</u>	<u>500</u>																									
				<u>N/A</u>	<u>N/A</u>																									
MM1536-01	B <u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>																									

Notes: DA 2484, 2564

N/A
N/A

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N/A	N/A	RM0158-01	E	<u>E</u>	PC	200	303AN24 3470 58497	N/A N/A 150			
		RM0009-04	I	<u>I</u>	PC	1	79170	Bulk			
		RM0009-04	I	<u>I</u>	PC	1	N/A	Bulk			
		MM1538-01	A	<u>A</u>	PC	500	0000290562	500	N/A	N/A	N/A
		MM1537-01	A	<u>A</u>	PC	1000	0000290561	1,000	N/A		
		1000-2053-01	A	<u>A</u>	PC	500	0000287543	500	N/A		
		MM1537-02	A	<u>A</u>	PC	500	0000288401	500	N/A		

Notes:

N/A

N/A

N/A

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N/A	N/A	TL0167-02	E	<u>E</u>	PC	70	N/A N/A	Bulk			
		TL0165-05	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		TL0165-03	J	<u>J</u>	PC	5	N/A N/A	Bulk			
		141967-01	02	<u>02</u>	PC	500	85793 N/A	506 N/A			
		RM7349-02	C	<u>C</u>	PC	543	82860 82835	456 86	N/A	N/A	N/A
		RM7348-01	C	<u>C</u>	PC	500	85428 N/A	500 N/A			
		RM4001-01	B	<u>B</u>	PC	125	82471 N/A	100 N/A			
		RM0607-01	D	<u>D</u>	PC	56	78848	100			

Notes:

N/A
N/A
N/A

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N/A	N/A	RM0498-01	C	<u>C</u>	PC	500	0000287644	N/A	485	
		RM0362-01	E	<u>E</u>	PC	594	85874	N/A	600	
		MM0177-01	C	<u>C</u>	PC	500	0000284208	N/A	500	N/A N/A N/A N/A
		MM0180-01	E	<u>E</u>	PC	500	0000287541	N/A	500	
		MM0178-01	E	<u>E</u>	PC	500	0000276174	N/A	500	
		MM0176-01	D	<u>D</u>	PC	500	0000288413	N/A	500	
		MM0074-01	G	<u>G</u>	PC	500	0000295169	N/A	522	

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	P/A	P/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	01Feb24	V078
	Line Clearance Confirmation Rreqd(Milestone)					
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	01 Feb 24	SV47 JY90 PM96
	Major and Minor Mandrel Assembly					
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
P/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	01Feb24	CLOS-DX35
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	01Feb24	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 Insert Cut Hypo Tube Confirmation Reqd(Milestone)	500	0	01Feb24 ST96	S423
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	01Feb24 GS22	CP22
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	 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	ef ① 01Feb24	CL30 V078
450	CATASY01 Catheter	FEP Removal	500	0	01Feb24	Y014 pm96

Notes:

N/A

N/A

N/A

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① KL95 01Feb24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Assembly 1 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 Confirmation Reqd(Milestone)	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-01 Batch #: 88747 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	485	EW-HH11 OF-HH11 01 Feb 24 (15)	D66 VL91 LL61 TA36 CB81	
		N/A	N/A	N/A	N/A	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
550	CATASY01 Catheter Assembly 1 	Remove Heat Shrink & Mandrel Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	475	MAP-1 D2-4XX1 " MATH-1 (10)	01Feb'24	PH99 FBO1 AK82 RS23 VA96 Y936
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	475	0	01Feb'24	PH99 FBO1 AK82 VA96

Notes:

NA

NA

NA

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M8	Reqd(Milestone)		N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	475	0	01Fe ⁿ 24	PHF9 FR01 AX82 DY29
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: <u>0936A</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>0521</u> Cal Due: <u>31 may 24</u>	475	0	01Fe ⁿ 24	STX48 HV36 RS23
	Tipping					
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																													
NP	Confirmation Reqd(Milestone)		N/A	N/A	N/A	N/A																													
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <table> <tr><td>Part #:</td><td>Pn4001-01</td><td>Batch #:</td><td>82471</td><td>Qty:</td><td>10</td></tr> <tr><td>Part #:</td><td>Zn0607-01</td><td>Batch #:</td><td>78848</td><td>Qty:</td><td>5</td></tr> <tr><td>Part #:</td><td>N/A</td><td>Batch #:</td><td>N/A</td><td>Qty:</td><td>N/A</td></tr> <tr><td>Part #:</td><td>N/A</td><td>Batch #:</td><td>N/A</td><td>Qty:</td><td>N/A</td></tr> <tr><td>Part #:</td><td>N/A</td><td>Batch #:</td><td>N/A</td><td>Qty:</td><td>N/A</td></tr> </table>	Part #:	Pn4001-01	Batch #:	82471	Qty:	10	Part #:	Zn0607-01	Batch #:	78848	Qty:	5	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	475	0	01Feb24
Part #:	Pn4001-01	Batch #:	82471	Qty:	10																														
Part #:	Zn0607-01	Batch #:	78848	Qty:	5																														
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																														
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		456	ACD-14T4H 14T111 (19)	01Feb24	SS44 SS52 SS52																													

Notes:

N/A

N/A

N/A

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① SS52 01 Feb 24

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	Major Mandrel Removal 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>	454	DAL-1 SKV-1	01Feb24	SS52 KL67
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	N/A	SH04 ML46 MV33

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
	 Quality Inspection & Review Confirmation Reqd(Milestone) <i>N/A</i>	<p>Re-Inspect after re-work.</p> <p>Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31may24</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> TMI: <u>N/A</u> Cal Due: <u>N/A</u> Material Consumed: Part #: <u>Part4001-01</u> Batch #: <u>82471</u> Qty: <u>18</u> Part #: <u>4000-1153-01</u> Batch #: <u>88747</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> Part #: <u>N/A</u> Batch #: <u>N/A</u> Qty: <u>N/A</u> </p>	410	MAR-1H1111 DIS-4H11 DEC-4H DS-1 TD - #607-4H 1111 DL-11 #5U5-11 WK-1111 EW-11 OF - 1 #10S-1	01Feb24 P146 KT47 KL67 Y936	K155 P146 KT47 KL67 Y936
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information: TMI: <u>N/A</u> Cal Due: <u>N/A</u> Record Caliper Information:</p>	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
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	TMI: MA 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	398	STR - III DIS - III (CSP) DIS - II	01Feb24	0521 PY46 Y936 KL61
1000	 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: 06890 Cal Due: 30Sep24 Record Calibrated Ruler Information: TMI: 0629 Cal Due: 30sep24	384	LT - III III	01Feb24	KT419 Y936 KL61

Notes:

 N/A
 N/A
 N/A

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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	352	DIS - III MEX - III FM - III FB - I BP - I VD - I EW - II SCR - II SKV - III DL - I SCR - III III (TT) 36(1) 32	31 Feb 24	XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>XC31</u> <u>01 FEB 24</u>	N/A	N/A	01 FEB 24	XC31

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① XN26 01 Feb 24

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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	352	0 2 Feb 24 AP10	2 Feb 24 AP10	

Notes:

N/A AP10 02 Feb 24

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Batch Number: 0000300507

By: APW

Date: 02 Feb 24

Reviewed By:

RB29

Date:

02 feb 24

Notes:

N/A APW 02 Feb 24

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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

FM0002.RevF

Deviation Authorization

CONTROLLED COPY

① UK55, 23JU 2023



DA | 2484
DA | 2468 .
①

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

Group Training Record

Procedure:

- 100% inspection at Op#1050 per the instructions below.
- Inspect 1 part at a time.
- Inspection is focused on the correct MM0179-01 and MM1536-01 assembly.
- Use the example MM0179-01 and MM1536-01 fixture for inspection. (See image 1)
① MM0179-01 type connection TS12 10AUG23

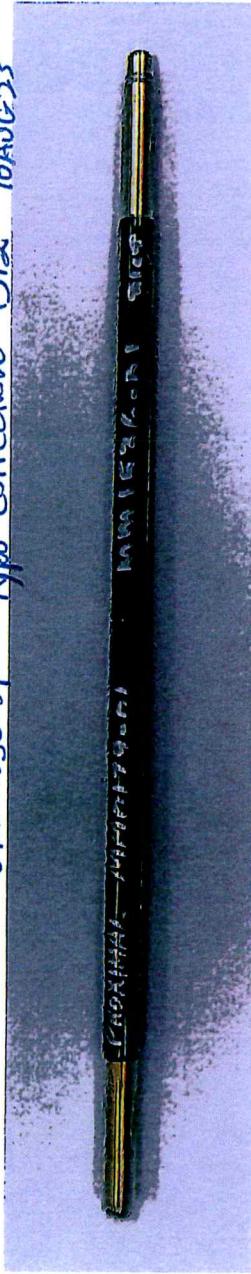


Image- 1

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)

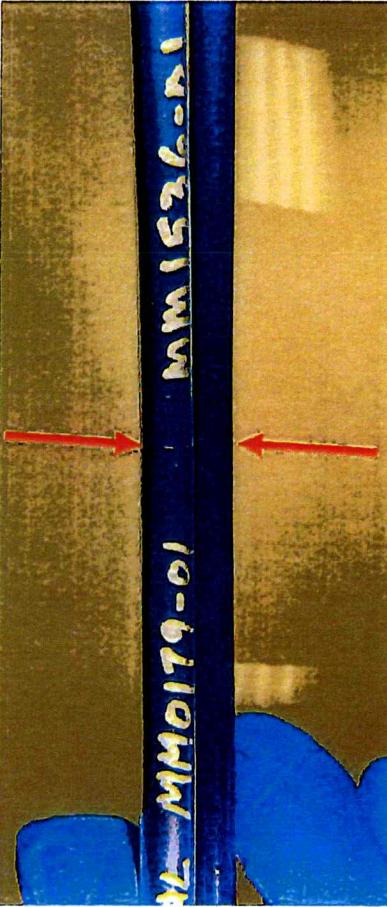


Image- 3

- 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.

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)

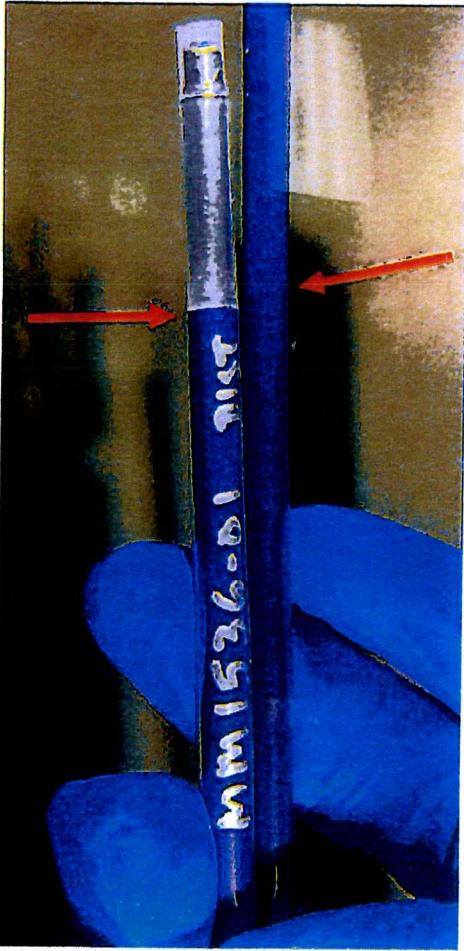


Image- 4
Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.

- 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

Edited to Hansh 3228 12/10/2023
 Edited to 13 Feb 2024 3228 Vqjksq
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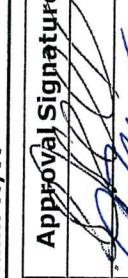
DEVIATION AUTHORIZATION FORM

Requestor Name: Krishna Selvaraj	
Document Number Affected	Revision
Doc #3005206 (MPI0238)	BP
Deviation From:	
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.	
Deviation To:	
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 checked="" type="checkbox"/> Yes <input 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# 500000300507

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10745	44	12:03AM	430	V078	01Feb24	12:15AM	415	CL30	01Feb24	16
TM10745	44	12:30AM	436	CL30	01Feb24	12:42AM	415	CL30	01Feb24	16
TM10745	44	12:57AM	430	CL30	01Feb24	1:09AM	415	CL30	01Feb24	16
TM10745	44	1:27AM	428	V078	01Feb24	1:39AM	415	CL30	01Feb24	16
TM10745	44	5:20am	430	NK62	01Feb24	5:32am	415	NK62	01Feb24	16
TM10745	44	6:00am	430	NK62	01Feb24	6:12am	415	NK62	01Feb24	16
TM10745	44	6:25am	430	OS21	01Feb24	6:37am	415	OS21	01Feb24	16
TM10745	44	7:00am	430	OS21	01Feb24	7:12am	415	OS21	01Feb24	16
TM10745	44	① 7:30am 8:01am	430	AX05	01Feb24	7:42am	415	AX05	01Feb24	16
TM10745	44	8:00am	430	AX05	01Feb24	8:12am	415	AX05	01Feb24	16
TM10745	44	8:25am	428	AX05	01Feb24	8:37am	415	AX05	01Feb24	16
TM10745	44	8:55am	430	AX05	01Feb24	9:07am	415	AX05	01Feb24	16

① AX05 01Feb24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 50000030050

OP 400



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

PRODUCTION ORDER# 500000300507

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	12:18Am	430	V078	01Feb 24	12:30AM	415	CL30	01Feb 24	16
TM10942	44	1:18Am	430	V078	01Feb 24	1:30AM	415	V078	01Feb 24	16
TM10942	44	1:51AM	430	CL30	01FEB 24	2:03AM	415	AT39	01Feb 24	16
TM10942	44	5:10am	430	NK62	01Feb24	5:22am	415	NK62	01Feb 24	16
TM10942	44	5:35am	430	NK62	01Feb 24	5:47am	415	NK62	01Feb 24	16
TM10942	44	6:10am	430	OS 21	01feb 24	6:22am	415	OS 21	01Feb 24	16
TM10942	44	6:45am	430	OS 21	01feb 24	6:57am	415	OS 21	01Feb 24	16
TM10942	44	7:10am	428	OS 21	01feb 24	7:22am	415	OS 21	01Feb 24	16
TM10942	44	7:50am	430	AX05	01Feb 24	8:02am	415	AX05	01Feb 24	16
TM10942	44	8:10am	426	AX05	01 Feb 24	8:22am	415	AX05	01Feb 24	16
TM10942	44	8:40am	427	AX05	01 Feb 24	8:52am	415	AX05	01Feb 24	16
TM10942	44	9:02am	428	AX05	01Feb 24	9:14am	415	AX05	01Feb 24	16



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

PRODUCTION ORDER# 500000300507

OP 400

① AX 05 01 Feb 24



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

PO #: 5000000300507 OP #: 500 Shift #: 1st

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 #: 500000300507 OP #: 500 Shift #: 2nd

Total Parts Reworked:		7	
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	///	4
MP	Micropores	N/A	N/A
SCR	Scratch	/	1
SKV	Skive Marks	N/A	N/A
VD	Voids	//	2
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		Vannmeeg Lor 31 Jan 24	

Note: Indicate tally marks in groups of 5. Scrap is to be recorded on the SAP router; this form is for reworked parts only.

Data Uploaded for Engineering Review (Check):

PO #: 500000300507OP #: 500 Shift #: 2nd

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

Total Parts Reworked:		6	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	0
EH	Exposed Hypotube	/	1
EW	Exposed Wire		4
MP	Micropores	/	0
SCR	Scratch	/	0
SKV	Skive Marks	/	0
VD	Voids	/	1
N/A	N/A	/	0

Inspected By (Sign and Date): Amrit 31 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: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 50000300507OP #: 750 Shift #: 1st

Total Parts Reworked:		77	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		8
DIM07 US / WC	DIM07 Undersized (Window Closed)		12
EH	Exposed Hypotube		22
N/A	Glue , stopper		35
Inspected By (Sign and Date):		STR 48 01 Feb 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# 5001000300507

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10409	N/A	5:45am	190°F	SSHH	01Feb24	6:55am	190°F	SS44	01Feb24	33
Tm12036	N/A	6:30am	190°F	K155	01Feb24	7:40am	190°F	K155	01Feb24	39
Tm10409	N/A	7:50am	190°F	SSHH	01Feb24	9:00am	190°F	SSHH	01Feb24	42
Tm12036	N/A	8:15am	190°F	K155	01Feb24	9:25am	190°F	K155	01Feb24	30
Tm10409	N/A	8:50 am	190°F	K155	01Feb24	10:00 am	190°F	K155	01Feb24	31
Tm12036	N/A	9:40 am	190°F	K155	01Feb24	10:50am	190°F	K155	01Feb24	46
Tm10409	N/A	10:05am	190°F	0521	01Feb24	11:10 am	190°F	K155	01Feb24	29
Tm10409	N/A	11:25am	190°F	K155	01Feb24	12:30pm	190°F	K155	01Feb24	30
Tm10409	N/A	12:35pm	190°F	KL95	01Feb24	1:45pm	190°F	SS44	01Feb24	72
Tm12036	N/A	1:30pm	190°F	SSHH	01Feb24	2:40pm	190°F	SS44	01Feb24	31
Tm10409	N/A	2:10pm	190°F	SSHH	01Feb24	3:20pm	190°F	SS44	01Feb24	41
Tm12036	N/A	3:40pm	190°F	K155	01Feb24	4:50pm	190°F	K155	01Feb24	32
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A



PO #: 500000306507

OP #: 900 Shift #: 2nd

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

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

Data Uploaded for Engineering Review (Check):



PO #: 500000300507

OP #: 900 Shift #: C-5T

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

Total Parts Reworked:		90	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube		2
EW	Exposed Wire		5
MP	Micropores		37
SCR	Scratch		34
SKV	Skive Marks		2
VD	Voids		5
DIM01 US	DIM01 OD Undersized		N/A
DIM06 US	DIM06 OD Undersized		5
DIM06 OS	DIM06 OD Oversized		N/A
DIM09 US	DIM09 OD Undersized		N/A
Inspected By (Sign and Date):		K155, KT217 PY46	01 Feb 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

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	18.43	26.95	28.82	27.58	24.59	28.07	27.97	30.22	29.33	28.16	27.012	3.368672	4.378	12.2639539	8.542	PASS
Seg B	65.07	66.32	67.61	71.53	73.85	67.65	77.75	70.04	66.92	71.46	69.82	3.910149	3.981	54.2536961	8.542	PASS
Seg C	79.15	81.78	78.79	80.94	81.34	78.6	81.11	82.53	75.86	75.43	79.553	2.441621	2.911	72.4454418	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 #: 500000300507

Date: 02 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

02 Feb 24