

Production Order: 500000301826



Production Order Document
Production Order Qty: 500

PC

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Material: SA0155-01 Rev F

Material Type:	ZFRT	Description: Edwards Flex Shaft Commander 155885	Order Type: ZSTD
Production Version:	7987		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>GS85 5:30pm</u> <u>28 Jun 24</u></p> <p>Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KDZ 11:15am</u> <u>29 Jun 24</u></p> <p>Record Dryer Shelf #: <u>N/A</u></p> <hr/> <table border="1"> <thead> <tr> <th>Component Number</th> <th>Req'd Rev Rev</th> <th>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</td> <td><u>D</u></td> <td>PC</td> <td>500</td> <td><u>0000276172</u></td> <td><u>520</u></td> </tr> <tr> <td>MM1536-01</td> <td>B</td> <td><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>0000276172</u>	<u>520</u>	MM1536-01	B	<u>B</u>	PC	500	<u>0000281412</u>	<u>500</u>	N/A	N/A	27Jun24 DKos
Component Number	Req'd Rev Rev	Used	UOM	Qty.	Batch No.	Actual Qty Used																				
MM0179-01	D	<u>D</u>	PC	500	<u>0000276172</u>	<u>520</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	<u>0000271063</u>	<u>40</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>58497</u> <u>N/A</u> <u>87659</u> <u>87658</u> <u>87666</u> <u>87895</u>	<u>150</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000278880</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>0000288401</u>	<u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		TL0165-05	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>
		TL0165-03	J	<u>J</u>	PC	5	<u>N/A</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>
							<u>N/A</u>	<u>Bulk</u>		

Notes:

N/A

N/A

N/A

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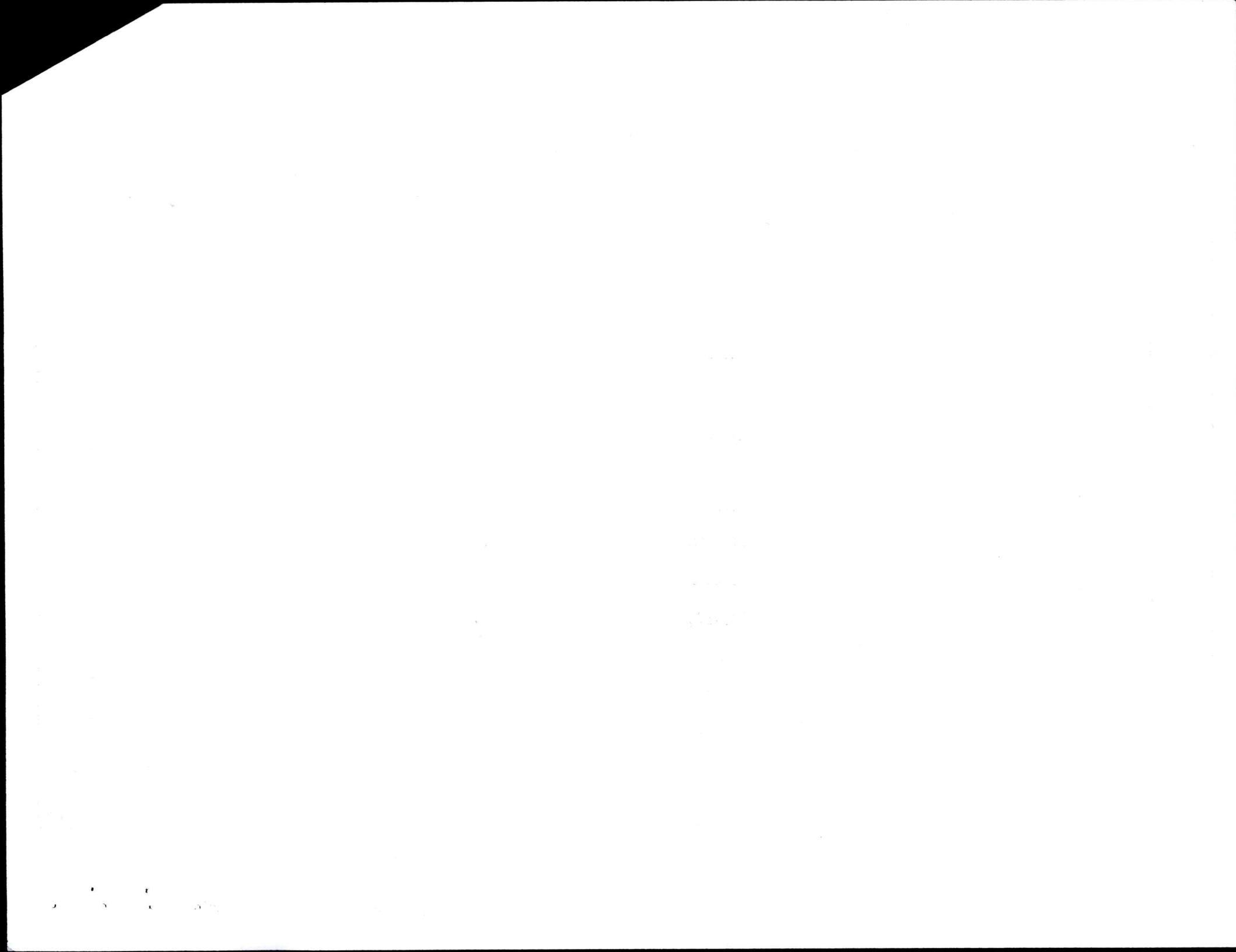
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		141967-01	02	<u>02</u>	PC	500	<u>85502</u> <u>85501</u> <u>85793</u>	<u>450</u> <u>25</u> <u>32</u>			
		RM7349-02	C	<u>C</u>	PC	543	<u>82837</u>	<u>500</u>	<u>N/A</u>		
		RM7348-01	C	<u>C</u>	PC	500	<u>82886</u>	<u>500</u>	<u>N/A</u>		
		RM4001-01	B	<u>B</u>	PC	125	<u>82454</u> <u>82457</u>	<u>100</u> <u>100</u>	<u>N/A</u>		
		RM0607-01	D	<u>D</u>	PC	56	<u>74662</u>	<u>100</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		RM0498-01	C	<u>C</u>	PC	500	<u>0000287643</u>	<u>500</u>	<u>N/A</u>		
		RM0009-04	I	<u>I</u>	PC	1	<u>79169</u>	<u>Bulk</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
		RM0009-04	I	<u>I</u>	PC	1	<u>79169</u>	<u>Bulk</u>			

Notes:

N/A

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N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>0000278910</u>	<u>N/A</u>	<u>Bulk</u>	
		MM1537-01	A	<u>A</u>	PC	1000	<u>0000290561</u>	<u>N/A</u>	<u>500</u>	
		MM0177-01	C	<u>C</u>	PC	500	<u>0000284208</u>	<u>N/A</u>	<u>1000</u>	
		MM0180-01	E	<u>E</u>	PC	500	<u>0000282490</u>	<u>N/A</u>	<u>60</u>	
		MM0178-01	E	<u>E</u>	PC	500	<u>0000276174</u>	<u>N/A</u>	<u>500</u>	
		MM0176-01	D	<u>D</u>	PC	500	<u>0000238413</u>	<u>N/A</u>	<u>N/A</u>	
		MM0074-01	G	<u>G</u>	PC	500	<u>0000271036</u>	<u>N/A</u>	<u>40</u>	
							<u>0000295163</u>	<u>N/A</u>	<u>522</u>	

Notes:

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
100	CATASY01 Catheter Assembly 1 	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	29Jan24	KL95
150	CATASY01 Catheter Assembly 1 	Major and Minor Mandrel Assembly	500	0	29Jan24	NK62 PM96 Y614 SH23 CP32

Notes:

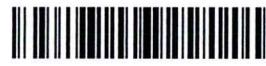
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
200	CATASY01 Catheter Assembly 1  Loading Braid Stock Confirmation Reqd(Milestone)	Loading Braid Stock	500	0	29 Jan 24	Vp62 SXII ny35 DX35 CP32
250	CATASY01 Catheter Assembly 1  Trim Braid Wire at Proximal End		500	0	29 Jan 24	LM46 SXII ST96 DX39

Notes:

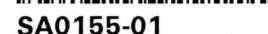
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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Trim Braid Wire at Proximal End Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
300	CATASY01 Catheter Assembly 1 	Insert Cut Hypo Tube	500	0	29Jan24	W25 DR39 AS31 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	29Jan24	M4490 C497 C105 SH23

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
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)	Reflow	500	0	29 Jan 24	TA36 Ax05 V078
450	CATASY01 Catheter	FEP Removal	500	0	29 Jan 24	PM 96 JY90 Y014

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
	Assembly 1 	N/A	N/A	N/A	N/A	N/A
	FEP Removal					
	Confirmation Rreqd(Milestone)					
500	CATASY01 Catheter Assembly 1 	In-process Inspection and Rework Material Consumed: Part #: 1000-1153-0 Batch #: 88728 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	491	EW-111 EH-1 OF-1 FM-1 SV-11 ⑨	UL61 VC09 T266 29 Jan 24	
	In-process Inspection and Rework					
	Confirmation Rreqd(Milestone)					
N/A	N/A	N/A	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
550	CATASY01 Catheter Assembly 1 Remove Heat Shrink & Mandrel Confirmation Reqd(Milestone)	Remove Heat Shrink & Mandrel	491	0	30 Jan 24	VPP96 F B01 RS23 Y936 (TRN) MV78 PY46 TRN D429
600	CATASY01 Catheter Assembly 1 Distal Tip Assembly Confirmation	Distal Tip Assembly	488	DL-L MAS-11 ③	30 Jan 24	F B01 SV46 HT72

Notes:

N/A
N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	488	0	30 Jun 24	ML38 VA96
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0386 Cal Due: 31may 24 TMI: 0521 Cal Due: 31may 24 TMI: 2083C Cal Due: 31may 24 TMI: 0936A Cal Due: 31may 24 Tipping	488	0	30 Jun 24	RS03 ML38 STR48
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
	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
750	CATASY01 Catheter Assembly 1  Tip Inspection/ Flash Removal Confirmation Reqd(Milestone)	Tip Inspection/ Flash Removal Material Consumed: Part #: <u>PM-0607-D</u> Batch #: <u>74662</u> Qty: <u>82454</u> Part #: <u>PM4001-D</u> Batch #: <u>82457</u> Qty: <u>74662</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>	488	0	30 Jan 24	STX48 mn02 Hv36
800	CATASY01 Catheter Assembly 1  Major Mandrel Removal		486	ACD-II (2)	30 Jan 24	SS52 XL91 SG88 SSH4

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
	Major Mandrel Removal Confirmation Reqd(Milestone)	N/A	N/A	N/A N/A	N/A	N/A
850	CATASY01 Catheter Assembly 1 	Cut to Length Record DIM05 gage result for the first 5 parts at the start of operation: 1. pass 2. pass 3. pass 4. Pass 5. pass	① 486 480	SKV-HH1 ⑥ 20) 24)	Y936 5550	
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	MV33
Notes:		N/A N/A N/A				

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① P46 30 Jan 24

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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) Re-Inspect after re-work. Required Inspection Visual/OD Inspection Record Inspection Data in SAP ROS Record Laser Micrometer Information: TMI: <u>0700-01</u> Cal Due: <u>31 may 24</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>P-N4001-01</u> Batch #: <u>82454</u> Qty: <u>16</u> Part #: <u>1000-1153-01</u> Batch #: <u>88728</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>	441	DEI-1 DIS-1 FM-1 ET-11 #10>-1 MAR-HH HH1 EW-HH11 #54-1111 Dis-HH11 TD-1 (29) DL-1 #90>-1 ADC-1	30 Jan 24	b155 P146	
950	QUALITY1 Quality Inspection & Review 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:		N/A	N/A	N/A	N/A

Notes:

N/A

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N/A

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	 Quality Inspection & Review Confirmation Reqd(Milestone)	<p>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>30 Sep 25</u> TMI: <u>0692</u> Cal Due: <u>30 Sep 25</u> Record DIM02 Inspection Results N = 54: Pass: <u>54</u> Fail: <u>0</u></p>	426	DIS-LHT(SP) LHT STR-LHT (15)	30 Jun 24	0521 SS44 TRW
1000	 Quality Inspection & Review Quality Inspection & Review Confirmation Reqd(Milestone)	<p>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>0890</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u></p>	426	0	30 Jun 24	SS44 WL61

Notes:

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	405	- DIS - IIII - SCR - MM (TT) - EW - II - VD - III - DL - IIII (TT) - BP - I - MAR - I (21)	30Jan24	SV43 XN26
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): <u>KP02 30Jan24</u>	N/A	N/A	30Jan24	KP02

Notes:

N/A

N/A

N/A

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1100	Confirmation Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
1150	PACKINT1 Packing assembly Package Confirmation Reqd(Milestone)	Package Package, Label, and Ship Finished Parts	405	0	31 Jan 24	BAJ

Notes:

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Batch Number: 0000301826

By: BAPT

Date: 31 Jan 24

Reviewed By:

RB29

Date:

02 feb 24

Notes:

H
N
M

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is part of



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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① UK55, 23JW 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 MM1536-02 fixture for inspection. (See image 1)
① MM01536-01 type connection TS12 10AUG23

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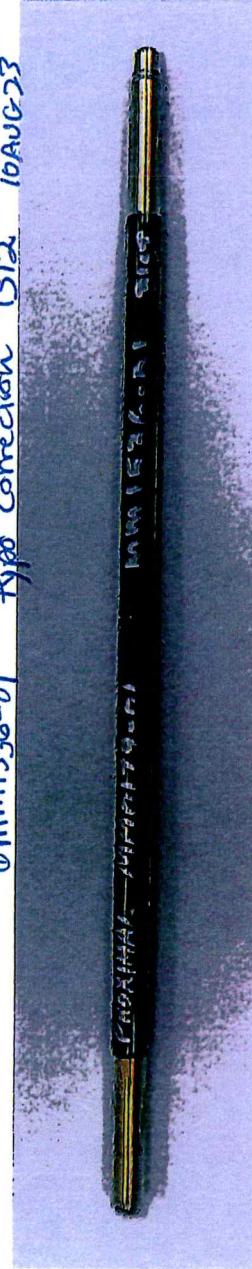


Image- 1

Step 1:

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



Image- 2

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

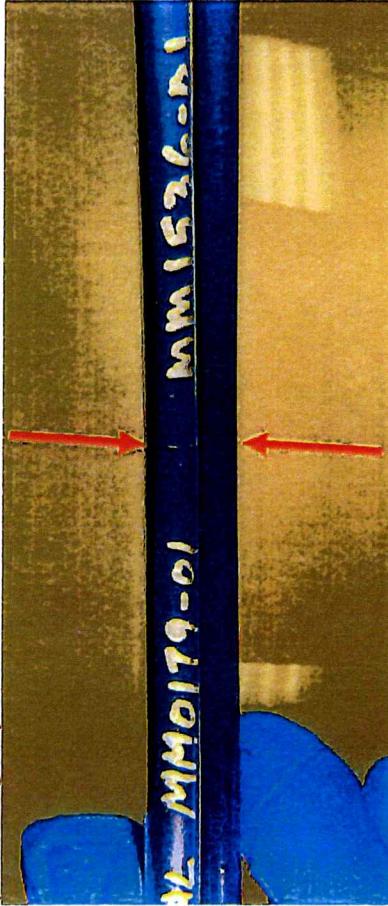
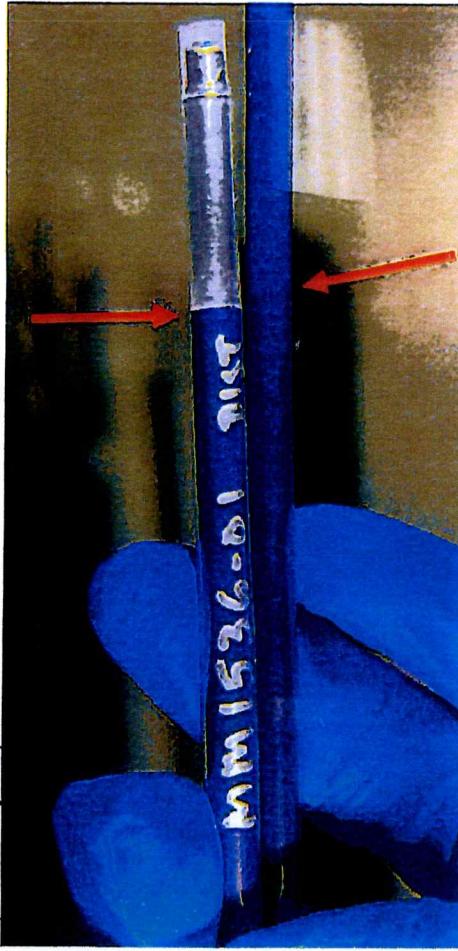


Image- 3

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

Step 2:

- Visually verify the MM1536-01 distal end of the fixture is approximately at the same location on the completed part. (See image 4)



- Image- 4
- Scrap the part if the transition is not approximately aligned. Save the scrapped parts for Engineer review.
 - If the part transition is aligned, the part passes inspection.
 - Use Image 5 as a guide for GOOD and BAD extrusion transition alignment.

1	MM0179-01 GOOD PART	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

Entered to MINDRAY 3228 11/11/2023
Entered to 13 Feb 2024 3228 V6/04

CONTROLLED COPY DEVIATION AUTHORIZATION NUMBER: DA2564

CREGANNA
MEDICAL
is part of



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.

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# 50000030182

OP 400



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

PRODUCTION ORDER# 500000301826

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:30am	430	KL95	29Jan24	11:42am	415	KL95	29Jan24	16
Tm10745	44	12:05pm	430	NK62	29Jan24	12:17pm	415	NK62	29Jan24	16
Tm10745	44	1:15pm	430	AX05	29Jan24	1:27pm	415	AX05	29Jan24	16
Tm10745	44	1:45pm	430	AX05	29Jan24	1:57pm	415	AX05	29Jan24	16
Tm10745	44	2:05pm	426	AX05	29Jan24	2:17pm	415	AX05	29Jan24	16
Tm10745	44	2:35pm	429	AX05	29Jan24	2:47pm	415	AX05	29Jan24	16
Tm10745	44	3:05pm	429	AX05	29Jan24	3:17pm	415	AX05	29Jan24	16
Tm10745	44	4:43pm	430	JY90	29Jan24	4:55pm	415	JY90	29Jan24	16
Tm10745	44	5:05pm	430	V078	29Jan24	5:17pm	415	V078	29Jan24	16
Tm10745	44	6:21pm	430	V078	29Jan24	6:33pm	415	V078	29Jan24	16
Tm10745	44	7:10pm	430	V078	29Jan24	7:22pm	415	V078	29Jan24	16
Tm10745	44	7:45pm	428	V078	29Jan24	7:57pm	415	V078	29Jan24	16



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

PRODUCTION ORDER# 500000301826

OP 400

① VD7829 Jan 24



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

PRODUCTION ORDER# 500000301826

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10942	44	11:55 Am	430	NK62	29Jan24	12:07pm	415	NK62	29Jan24	16
TM10942	44	12:35PM	430	OS21	29Jan24	12:47pm	415	OS21	29Jan24	16
TM10942	44	1:31PM	430	AX05	29Jan24	1:43pm	415	AX05	29Jan24	16
TM10942	44	1:55PM	430	AX05	29Jan24	2:07pm	415	AX05	29Jan24	16
TM10942	44	2:15PM	428	AX05	29Jan24	2:27pm	415	AX05	29Jan24	16
TM10942	44	2:55pm	430	TN36	29Jan24	3:07pm	415	AX05	29Jan24	16
TM10942	44	4:24PM	430	JY90	29Jan24	4:36pm	415	JY90	29Jan24	16
TM10942	44	5:32PM	430	V078	29Jan24	5:44pm	415	V078	29Jan24	16
TM10942	44	6:23PM	430	V078	29Jan24	6:35pm	415	V078	29Jan24	16
TM10942	44	7:00PM	430	V078	29Jan24	7:12pm	415	JY90	29Jan24	16
TM10942	44	7:30PM	430	V078	29Jan24	7:42pm	415	V078	29Jan24	16
TM10942	44	8:05PM	428	V078	29Jan24	8:17pm	415	V078	29Jan24	16



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

PO #: 500000301826 OP #: 500 Shift #: 1ST

Total Parts Reworked:

47

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles		1
EH	Exposed Hypotube	III	13
EW	Exposed Wire	SHT III	23
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks		1
VD	Voids	I	6
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

VC09, LL61, CB81 29 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 #: 50000301826

OP #: 500 Shift #: 2

Total Parts Reworked:		<u>30</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	/	1
EH	Exposed Hypotube	///	3
EW	Exposed Wire		24
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	N/A	0
VD	Voids	HH	5
N/A	N/A	N/A	0

Inspected By (Sign and Date):

Candy 29 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 #: 500000301826 OP #: 500 Shift #: 2nd.

Total Parts Reworked:		60	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	1	1
EH	Exposed Hypotube		5
EW	Exposed Wire		40
MP	Micropores	N/A	N/A
SCR	Scratch		2
SKV	Skive Marks	N/A	N/A
VD	Voids		15
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MM02	29 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 #: 500000301826OP #: 750 Shift #: 2nd.

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		73	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		27
DIM07 US / WC	DIM07 Undersized (Window Closed)		25
EH	Exposed Hypotube		21
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MV-78 11/10/2024 29 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# 500000301826

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	4:31pm	190°F	SG88	29 Jan 24	5:41pm	190°F	SG88	29 Jan 24	31
TM10409	N/A	5:50pm	189°F	SG88	29 Jan 24	7:00pm	190°F	SG88	29 Jan 24	51
TM10409	N/A	7:05pm	190°F	SG88	29 Jan 24	8:15pm	190°F	SG88	29 Jan 24	50
TM12036	N/A	7:28pm	190°F	SG88	29 Jan 24	8:38pm	190°F	SG88	29 Jan 24	33
TM10409	N/A	8:30PM	190°F	XL91	29 Jan 24	9:40 PM	190°F	① SG88 ② 9:40pm	29 Jan 24	31
TM12036	N/A	9:21pm	190°F	SG88	29 Jan 24	10:31pm	190°F	SG88	29 Jan 24	48
TM10409	N/A	10:21pm	190°F	SG88	29 Jan 24	11:31pm	190°F	SG88	29 Jan 24	46
TM10409	N/A	11:34pm	190°F	SG88	29 Jan 24	12:44AM	190°F	SG88	30 Jan 24	37
TM12036	N/A	12:37AM	190°F	SG88	③ 30 Jan 24 ④ 29 Jan 24	1:47AM	190°F	SG88	30 Jan 24	40
TM10409	N/A	4:20am	190°F	K155	30 Jan 24	5:30 am	190°F	K155	30 Jan 24	30
TM2036	N/A	5:20 am	190°F	K155	30 Jan 24	6:30 am	190°F	K155	30 Jan 24	37
TM10409	N/A	6:25 am	190°F	SS44	30 Jan 24	7:35am	190°F	SS44	30 Jan 24	① 5452
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① SG88 29 Jan 24

② SG88 29 Jan 24

① P44630 Jan 24



PO #: 500000301826

OP #: 900 Shift #: 1st

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):

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	31.08	31.57	27.75	29.32	19.47	30.55	25.96	27.74	24.54	31.14	27.912	3.790083	4.378	11.3190168	8.542	PASS
Seg B	75.09	72.64	70.94	74.99	66.24	77.61	68.93	68.83	70.9	74.5	72.067	3.5207324	3.981	58.0509643	8.542	PASS
Seg C	76.76	80.26	86.5	78.54	84.52	76.16	74.99	80.73	77.74	84.05	80.025	3.9052621	2.911	68.656782	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 #: 500000301826

Date: 31JAN2024

Inspector Name: AUGUSTINE JAH

Equipment ID: TMIO311B

Cal Due Date: 27 OCT 24



31 Jan 2024