

Production Order: 500000303890



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:	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  Kitting Devices	<p>Kitting Devices Perform Order Kitting, Load Minor Mandrels, Dry Extrusions, and Cut FEP Record Time Extrusions Enter Dryer (Initial/Time/Date): <u>KPO2 15:30am 05Feb24</u> Record Time Extrusions First Exit Dryer (Initial/Time/Date): <u>KPO2 11:00am 06Feb24</u> Record Dryer Shelf #: <u>N/A</u></p> <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</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</td> <td>PC</td> <td>500</td> <td><u>0000290560</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	PC	500	<u>0000293119</u>	<u>500</u>					<u>N/A</u>	<u>N/A</u>	MM1536-01	B	PC	500	<u>0000290560</u>	<u>500</u>	N/A	N/A <i>04 Feb 2024</i>	<i>DKW</i>
Component Number	Req'd Rev Rev Used	UOM	Qty.	Batch No.	Actual Qty Used																								
MM0179-01	D	PC	500	<u>0000293119</u>	<u>500</u>																								
				<u>N/A</u>	<u>N/A</u>																								
MM1536-01	B	PC	500	<u>0000290560</u>	<u>500</u>																								

Notes: DA 2564, 2484.

N/A

N/A

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Opr No.	Planned WorkCenter Description	Operation Details					Comp. Qty.	Scrap Qty & Desc.	Date Comp.	Initials
MP N/A		RM0158-01	E	<u>E</u>	PC	200	<u>N/A</u> <u>81054</u>	<u>N/A</u> <u>200</u>		
		1000-1153-01	A	<u>A</u>	PC	594	<u>N/A</u> <u>87892</u> <u>87840</u> <u>87893</u>	<u>N/A</u> <u>200</u> <u>200</u> <u>200</u>		
		1000-2053-01	A	<u>A</u>	PC	500	<u>0000287543</u>	<u>500</u>		
		MM1537-02	A	<u>A</u>	PC	500	<u>000288401</u>	<u>500</u>		
		TL0167-02	E	<u>E</u>	PC	70	<u>N/A</u>	<u>Bulk</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>			

Notes:

N/A

N/A

N/A

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<i>N/A</i>	141967-01	02	<u>02</u>	PC	500	<u>85794</u>	<u>519</u>				
	RM7349-02	C	<u>C</u>	PC	543	<u>82861</u>	<u>500</u>	<u>N/A</u>			
	RM7348-01	C	<u>C</u>	PC	500	<u>84587</u>	<u>500</u>	<u>N/A</u>			
	RM4001-01	B	<u>B</u>	PC	125	<u>82468</u> <u>82803</u> <u>N/A</u>	<u>100</u>	<u>N/A</u>			
	RM0607-01	D	<u>D</u>	PC	56	<u>① 74662</u> <u>N/A</u> <u>74663</u>	<u>N/A</u>	<u>70</u>	<u>N/A</u>	<u>N/A</u>	<u>N/A</u>
	RM0498-01	C	<u>C</u>	PC	500	<u>0000287616</u>	<u>482</u>	<u>N/A</u>			
	RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>	<u>N/A</u>			
	RM0009-04	I	<u>I</u>	PC	1	<u>88992</u>	<u>Bulk</u>				

Notes:

N/A

N/A

N/A

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N/A	N/A	MM1538-01	A	<u>A</u>	PC	500	<u>N/A</u>	<u>Bulk</u>		
							<u>0000290562</u>	<u>500</u>		
		MM1537-01	A	<u>A</u>	PC	1000	<u>N/A</u>	<u>N/A</u>		
							<u>0000290561</u>	<u>1060</u>		
		MM0177-01	C	<u>C</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000284208</u>	<u>500</u>		
		MM0180-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000282490</u>	<u>479</u>		
							<u>0000257865</u>	<u>100</u>		
		MM0178-01	E	<u>E</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000276174</u>	<u>500</u>		
		MM0176-01	D	<u>D</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000288413</u>	<u>500</u>		
		MM0074-01	G	<u>G</u>	PC	500	<u>N/A</u>	<u>N/A</u>		
							<u>0000300399</u>	<u>522</u>		
							<u>N/A</u>	<u>N/A</u>		

Notes:

N/A

N/A
N/A

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	N/A	N/A	N/A	N/A	N/A	N/A
100	CATASY01 Catheter Assembly 1  Line Clearance Confirmation Rreqd(Milestone)	Line Clearance Perform Line Clearance and Heat Gun Setting	500	0	06 Feb 24	KL95
150	CATASY01 Catheter Assembly 1  Major and Minor Mandrel Assembly	Major and Minor Mandrel Assembly	500	0	06 Feb 24	Pm96 AX05 NK62 AF54 CL30 Y014 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	500	0	06Feb24	MY50 SX0 ST96 DX35
	Loading Braid Stock					
	Confirmation Reqd(Milestone)					
250	CATASY01 Catheter Assembly 1 	Trim Braid Wire at Proximal End	500	0	06Feb24	LM46 CY97 C105 V078
Notes:						
N/A						
N/A						
N/A						

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	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	06Feb24 VRG2 DV39 GS31 GS22	VV25 CP32 GS22
350	CATASY01 Catheter Assembly 1	Load Tubing	500	0	06Feb24	VV25 CP32 GS22
Notes:						
N/A						
N/A						
N/A						

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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
	 Load Tubing Confirmation Reqd(Milestone)	N/A				
400	CATASY01 Catheter Assembly 1 Reflow Confirmation Reqd(Milestone)		500	0	06Feb24	Pm96 Ax05 NKbZ AF54 SY47 SK85
450	CATASY01 Catheter	FEP Removal	500	0	06Feb24	Pm96 AF54 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
	Assembly 1 FEP Removal N/A 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 #: 87893 Qty: N/A Part #: N/A Batch #: N/A Qty: N/A	485	OF-1 VD-1 EW-1111 II DF-111 PS-1 15	LL61 VC09 MM02 VR91 P266 TD45 06 Feb 24	LL61 VC09 MM02 VR91 P266 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 Rreqd(Milestone)	485	0	06Feb24	VAG6 Yg36
600	CATASY01 Catheter Assembly 1 	Distal Tip Assembly	480	MTH - 1 DL - 111 MAS - 1 07Feb24 (5)	07Feb24	FRO1 ML60 SV46 VAG6

Notes:

N/A
N/A
N/A

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N/A	Reqd(Milestone)	N/A	N/A	N/A	N/A	N/A
650	CATASY01 Catheter Assembly 1 	Loading Heat Shrink	480	0	06Feb24	ML38
	Loading Heat Shrink					
	Confirmation Reqd(Milestone)					
700	CATASY01 Catheter Assembly 1 	Tipping Record Tipping Oven Information: TMI: 0521 Cal Due: 31May24 TMI: 2083C Cal Due: 31May24 TMI: 0386 Cal Due: 31May24 TMI: 0936A Cal Due: 31May24	480	0	06Feb24	ML38
	Tipping					STX48
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
750	CATASY01 Catheter Assembly 1 	<p>Tip Inspection/ Flash Removal</p> <p>Material Consumed:</p> <p>Part #: RMH001-01 Batch #: 82468 Qty: N/A</p> <p>Part #: RM007-01 Batch #: 74662 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	479	①	wk-1 06Feb24	MU78 STX48 Hv36
800	CATASY01 Catheter Assembly 1 	Major Mandrel Removal	473 469	① ACD-III III ⑥ ①	06Feb24	XL91 SG88

Notes:

N/A
N/A
N/A

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① PM 4607 Feb 24

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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	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. <u>passed</u> 2. <u>passed</u> 3. <u>passed</u> 4. <u>passed</u> 5. <u>passed</u>	469	0	07 Feb 24	KL67 ML65 SS52
900	QUALITY1 Quality Inspection & Review	Quality Inspection and Review Perform Quality Inspection per QIP Document #3107610 Record Data in SAP ROS	0 46	N/A	N/A	SHay HT72 ML65 MV33

Notes:

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OPY46 07 Feb 24

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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: 0700-01 Cal Due: 31 May 24</p> <p>TMI: N/A Cal Due: N/A</p> <p>Material Consumed:</p> <p>Part #: Pn4001-01 Batch #: S2468 Qty: 16</p> <p>Part #: 10001153-01 Batch #: 87892 Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p> <p>Part #: N/A Batch #: N/A Qty: N/A</p>	421	EW-1P1 DEL-HH1 ACD-11 MAR-HH111 DIS-HHHTT HH1111 #105-11 #709-1 EM-1 DL-1 EH-11 #905-111	07 Feb 24	XLA1 KL67 MLGS PY46 K155 KT27
950	QUALITY1 Quality Inspection & Review	<p>Quality Inspection & Review Borescope Inspection Record Inspection Data in SAP ROS Record Tip Gage Information:</p> <p>TMI: 50713B Cal Due: 12 Apr 24</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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Opr No.	Planned WorkCenter Description	Operation Details	Comp Qty.	Scrap Qty & Desc.	Date Comp.	Initials
N/A	 Quality Inspection & Review  Confirmation Reqd(Milestone)	<p>TMI: <u>50317</u> Cal Due: <u>31 Aug 24</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>	366	DIS(SP)HH DIS - HH HH HH HH HH STR - LXX <u>35</u>	07 Feb 24	XL91 KL67 ML65 0821
1000	 QUALITY1 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>0889D</u> Cal Due: <u>30 Sep 24</u> Record Calibrated Ruler Information: TMI: <u>0629</u> Cal Due: <u>30 Sep 24</u></p>	369	LT - HH HH HH 11 <u>17</u>	07 Feb 24	XL91 KL67 ML65 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
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	3M5	SCR-JH1(TT) Del-11 (TT) FM-11 (TT) SCR-111 VD-111 DNT-11 SKV-11 FL-1 DIS-1 EW-1 FM-1	07 Feb 24 24	YK95 5V43
1100	CATASY01 Catheter Assembly 1  Line Closure	Line Closure Perform Line Closure Settle materials issued to production order (Initials/Date): KPO2 07 Feb 24	N/A	N/A	07 Feb 24	KPO2
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	345	O 09 Feb 24	AP10 09 Feb 24	AP10

Notes:

N/A AP10 09 Feb 24 /

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Batch Number: 0000303890

By: AP10

Date: 09 Feb 24

Reviewed By:

RB29

Date:

09 Feb 24

Notes:

N/A AP10 09 Feb 24

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1AP10 09 Feb 24 SA0155-01

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Beta → 2023-07-28 11:57:23
Ex-els → 19F0-2023-07-28 11:57:23
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Extend to 2023-08-15 11:57:23
Beta → 2023-08-15 11:57:23

DEVIATION AUTHORIZATION NUMBER: 2484
* See attached email extension to 2484-
TS12
24AUG23
Extend to 2023-08-15 11:57:23
DEVIAITON AUTHORIZATION FORM End to 23072023 11:57:23

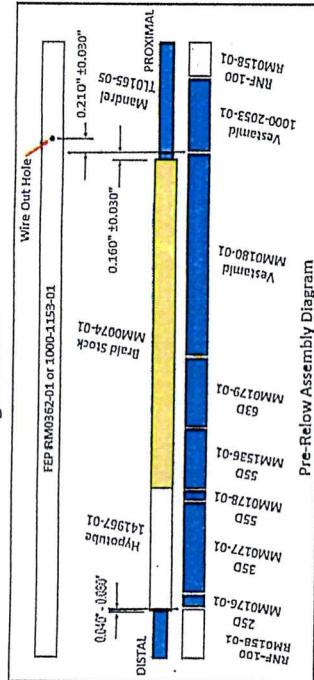
CONTROLLED COPY

Requestor Name: Udhesh Kapadnis

Document Number Affected	Revision
3107610	L

Deviation From:

QIP3107610, Section 8.0 Inspection Requirements
(Supplemental Visual Inspection) OP 1050:
Current QIP3107610 does not state to inspect for the
correct extrusion configuration.



Deviation To:

This DA allows addition inspection for correct assembly of
extrusion material MM0179-01 and MM1536-01 during
performing QIP3107610, Section 8.0 Inspection
Requirements (Supplemental Visual Inspection) OP 1050.
See instructions attached to this DA.

Justification: Recently it has been found that operators are incorrectly assembling MM0179-01 and MM1536-01. The event documents in NC-26390, and NC-26426. Only few of experienced inspectors can detect finished unit that contains incorrect extrusion configuration, and inexperienced inspectors may not which potential non-conformance unit sent to customer. Interim correction action has been implemented at OP 250, 300, 350 to detect unit built with out of oriented extrusions. This DA is adding another layer of inspection at final QC inspection to avoid incorrect assembly defects.

Part Number Affected	Revision
SA0155-01	H
Start Date: 26 Jul 2023	End Date: 25 Aug 2023

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 FMEAs Yes No Validations Yes No Details (if any): N/A

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

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

Training Required: Yes No If no, explain:

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

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① UK55, 23JW 2023

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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)

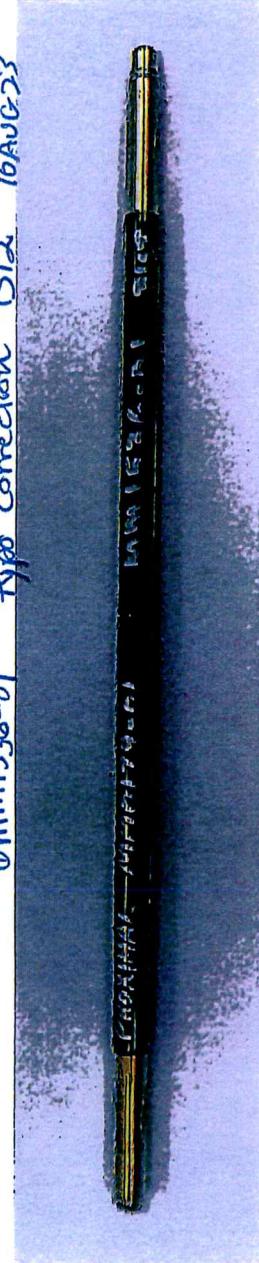


Image- 1

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)

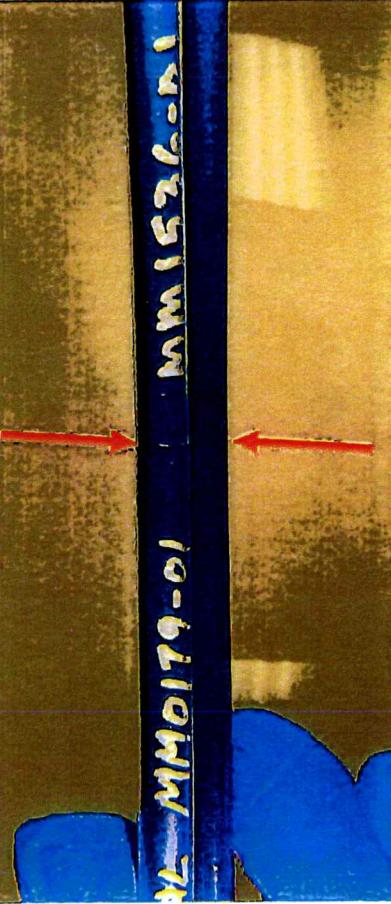


Image- 3

- 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)

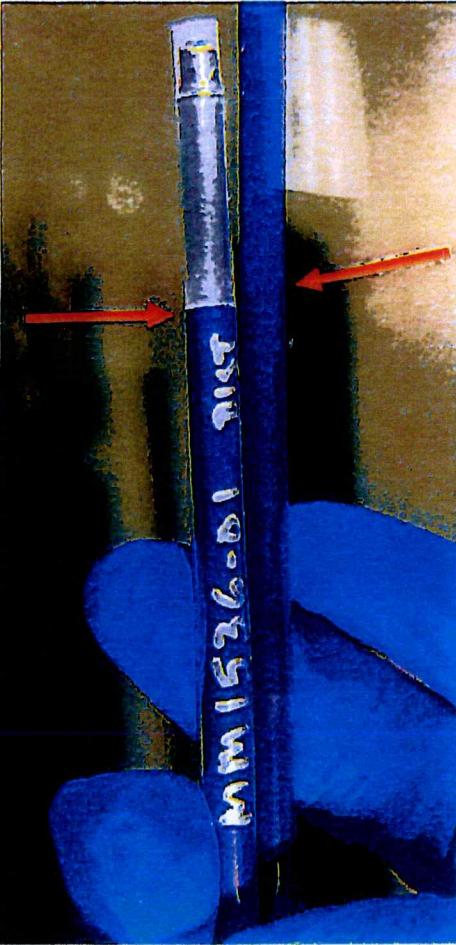


Image- 4

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
2	MM1536-01 MM0179-01 and MM1536-01 Wrong Order - BAD PART
3	MM0179-01 Two MM0179-01 - BAD PART
4	MM1536-01 Two MM1536-01 - BAD PART

Image - 5

Entered to Hansa 5228 12/15/2023

Entered to 13 Feb 2024 5228 1/1/2024

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 FMEAs <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# 500000305890

OP 400

① SH&5 06 Feb 24



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

PRODUCTION ORDER# 500000303890

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10942	44	12:10pm	430	0521	06 Feb 24	12:22pm	415	0521	06 Feb 24	16
Tm10942	44	1:25pm	430	TA36	06 Feb 24	1:37pm	415	TA36	06 Feb 24	16
Tm10942	44	2:15pm	430	TA36	06 Feb 24	2:27pm	415	TA36	06 Feb 24	16
Tm10942	44	2:50pm	430	AX05	06 Feb 24	3:02pm	415	AX05	06 Feb 24	16
Tm10942	44	5:00pm	430	V078	06 Feb 24	5:12pm	415	V078	06 Feb 24	16
Tm10942	44	6:38pm	430	SH85	06 Feb 24	6:45pm	415	SH85	06 Feb 24	16
Tm10942	44	7:00pm	429	JY90	06 Feb 24	7:12pm	415	JY90	06 Feb 24	16
Tm10942	44	7:23pm	427	SH85	06 Feb 24	7:35pm	415	SH85	06 Feb 24	16
Tm10942	44	7:50pm	430	CL30	06 Feb 24	8:02pm	415	SH85	06 Feb 24	16
Tm10942	44	9:08pm	430	V078	06 Feb 24	9:20pm	415	V078	06 Feb 24	16
Tm10942	44	9:40pm	430	V078	06 Feb 24	9:52pm	415	V078	06 Feb 24	16
Tm10942	44	10:12pm	430	V078	06 Feb 24	10:24pm	415	Sy47	06 Feb 24	16

① SH85 06 Feb 24

① SH85 07 Feb 24

② 06 Feb 24

② SH85 06 Feb 24



Document No: 5105589

FM5104665 Rev: C

Document Type: Manufacturing Form

Title: SA0155-01 Reflow Log Sheet Form

PRODUCTION ORDER# 500000303890

OP 400



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

PRODUCTION ORDER# 500000303890

OP 400

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
Tm10745	44	11:45am	430	0521	06 Feb 24	11:57am	415	0521	06 Feb 24	16
Tm10745	44	12:30pm	430	0521	06 Feb 24	12:42pm	415	0521	06 Feb 24	16
Tm10745	44	1:40 pm	430	TA36	06 Feb 24	1:52pm	415	TA36	06 Feb 24	16
Tm10745	44	2:30pm	430	AX05	06 Feb 24	2:42pm	415	AX05	06 Feb 24	16
Tm10745	44	2:59 pm	430	AX05	06 Feb 24	3:11 pm	415	AX05	06 Feb 24	7
Tm10745	44	5:21pm	430	SH85	06 Feb 24	5:33pm	415	CL30	06 Feb 24	16
Tm10745	44	6:20pm	430	CL30	06 Feb 24	6:32pm	415	CL30	06 Feb 24	16
Tm10745	44	6:45pm	430	CL30	06 Feb 24	6:57pm	415	CL30	06 Feb 24	16
Tm10745	44	7:08pm	428	SH85	06 Feb 24	7:20pm	415	SH85	06 Feb 24	16
Tm10745	44	7:33pm	428	SH85	06 Feb 24	7:45pm	415	SH85	06 Feb 24	16
Tm10745	44	7:59pm	428	SH85	06 Feb 24	8:11pm	415	SH85	06 Feb 24	16
Tm10745	44	9:22pm	430	Sy47	06 Feb 24	9:34pm	415	Sy47	06 Feb 24	16



Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000303890OP #: 500Shift #: 1ST**Total Parts Reworked:**24

Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire		18
MP	Micropores	N/A	N/A
SCR	Scratch	N/A	N/A
SKV	Skive Marks	N/A	N/A
VD	Voids		2
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		<u>VC 09 , LL61 06 Feb 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: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 500000303890OP #: 500 Shift #: 2nd**Total Parts Reworked:**45

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		23
MP	Micropores	N/A	N/A
SCR	Scratch		4
SKV	Skive Marks	//	2
VD	Voids		13
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		<u>Vamseej Lor 06 Feb 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): 2



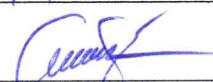
Document No: 5106073

Rev: E

Document Type: Manufacturing Form

Title: SA0155-01 Visual Rework Form

PO #: 50000303890OP #: 500 Shift #: 2

Total Parts Reworked:		40	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube		10
EW	Exposed Wire		27
MP	Micropores	N/A	0
SCR	Scratch	N/A	0
SKV	Skive Marks	/	1
VD	Voids		7
N/A	N/A	N/A	0
Inspected By (Sign and Date):		 06 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.

Data Uploaded for Engineering Review (Check):



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

PO #: 500000303890 OP #: 500 Shift #: 2nd

Total Parts Reworked:		<u>35</u>	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube		4
EW	Exposed Wire	 	30
MP	Micropores	N/A	N/A
SCR	Scratch		3
SKV	Skive Marks	N/A	N/A
VD	Voids		5
N/A	N/A	N/A	N/A

Inspected By (Sign and Date):

mm02

06Feb24

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 #: 50000303890OP #: 750 Shift #: 1st

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		12	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)		6
DIM07 US / WC	DIM07 Undersized (Window Closed)		1
EH	Exposed Hypotube		1
N/A	Glue - stepper		4
Inspected By (Sign and Date):		STX 48	07 Feb 24 08 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.

①

STX 48 07 Feb 24

Data Uploaded for Engineering Review (Check):



PO #: 500000303890

OP #: 750 Shift #: 2nd

Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

Total Parts Reworked:		27	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	 	24
DIM07 US / WC	DIM07 Undersized (Window Closed)	N/A	N/A
EH	Exposed Hypotube		3
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		SV46 06 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):



Document No: 6102646

Rev: A

Document Type: Manufacturing Form

Title: SA0155-01 Tipping Rework Form

PO #: 500000303890

OP #: 750 Shift #: 2

Total Parts Reworked:		59	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
DIM07 OS / WO	DIM07 Oversized (Window Open)	H H H	22
DIM07 US / WC	DIM07 Undersized (Window Closed)	X X	24
EH	Exposed Hypotube		13
N/A	N/A	N/A	N/A
Inspected By (Sign and Date):		MV78 06 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# 500000303890

OP 800

Oven #	Cycle #	Time In	Temp. In (Actual)	Initials	Date	Time Out	Temp. Out (Actual)	Initials	Date	Qty
TM10409	N/A	6:25pm	190°F	SG88	06 Feb 24	① 7:35PM +90F	190°F	SG88	06 Feb 24	40
TM12036	N/A	7:57pm	190°F	SG88	06 Feb 24	8:17pm	190°F	SG88	06 Feb 24	38
TM10409	N/A	7:42pm	190°F	SG88	06 Feb 24	8:52PM	190°F	SG88	06 Feb 24	34
TM12036	N/A	8:12PM	190°F	XL91	06 Feb 24	9:32pm	190°F	SG88	06 Feb 24	30
TM10409	N/A	9:42pm	190°F	SG88	06 Feb 24	10:52pm	190°F	SG88	06 Feb 24	45
TM12036	N/A	10:18pm	190°F	SG88	06 Feb 24	11:19pm	190°F	XL91	06 Feb 24	44
TM10409	N/A	10:53pm	190°F	SG88	06 Feb 24	12:03AM	190°F	SG88	07 Feb 24	40
TM12036	N/A	11:57pm	190°F	SG88	06 Feb 24	1:07AM	190°F	SG88	07 Feb 24	42
TM10409	N/A	1:04AM	190°F	SG88	07 Feb 24	2:14AM	190°F	V078	07 Feb 24	50
TM10409	N/A	4:30am	190°F	K155	07 Feb 24	5:40am	190°F	K155	07 Feb 24	41
TM10409	N/A	5:55am	190°F	SS44	07 Feb 24	7:05am	190°F	SS44	07 Feb 24	46
TM12036	N/A	6:20am	190°F	SS44	07 Feb 24	7:30am	190°F	SS44	07 Feb 24	19
N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A

① SG88 06 Feb 24



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

PO #: 50000303890 OP #: 900 Shift #: 2nd

Total Parts Reworked:		66	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	0
EH	Exposed Hypotube	N/A	0
EW	Exposed Wire		19
MP	Micropores	N/A	0
SCR	Scratch	/ / /	23
SKV	Skive Marks	N/A	0
VD	Voids	N/A	0
DIM01 US	DIM01 OD Undersized	N/A	0
DIM06 US	DIM06 OD Undersized	/ / /	15
DIM06 OS	DIM06 OD Oversized	N/A	0
DIM09 US	DIM09 OD Undersized	N/A	0
Inspected By (Sign and Date):		See H, PP40 06 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):



Document No: 6102619

Rev: B

Document Type: Manufacturing Form

Title: SA0155-01 Dimensional/Visual Rework Form

PO #: 500000303890 OP #: 900 Shift #: 2

Total Parts Reworked:		48	
Router Code	Defect Failure Mode	Reworkable Defects (Tally)	Total Defects
AB	Air Bubbles	N/A	N/A
EH	Exposed Hypotube	1	1
EW	Exposed Wire		23
MP	Micropores	N/A	N/A
SCR	Scratch		63
SKV	Skive Marks	N/A	N/A
VD	Voids		2
DIM01 US	DIM01 OD Undersized		
DIM06 US	DIM06 OD Undersized		
DIM06 OS	DIM06 OD Oversized	N/A 06 Feb 24	
DIM09 US	DIM09 OD Undersized	HT72	
Inspected By (Sign and Date):		HT72 06Feb24	

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):



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

PO #: 500000303890

OP #: 900 Shift #: 85 1st

PY4607 Feb 22

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

Data Uploaded for Engineering Review (Check):

Maximum Force Reached During Tensile Test (10 samples accepted from final inspection for each lot shall be selected and tensile tested)																
Sample # →	1	2	3	4	5	6	7	8	9	10	Avg	St Dev	K	Calculated Lower bound	Min Spec	Pass / Fail
Seg A	25.72	28.48	24.12	24.71	25.12	25.51	25.95	24.88	27.98	24.24	25.671	1.4770199	4.378	19.2046069	8.542	PASS
Seg B	70.2	59.69	58.36	60.02	61.26	65.35	70.23	66.35	62.28	60.23	63.397	4.3699327	3.981	46.0002977	8.542	PASS
Seg C	82.05	78.97	78.38	81.31	78.08	82.29	81.29	76.61	78.23	75.35	79.256	2.3783897	2.911	72.3325075	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 #: 500000303890

Date: 07 FEB 24

Inspector Name: LUKASU C. TSHISHIMBI

Equipment ID: TMI0311B

Cal Due Date: 27 OCT 24

07 Feb 24

