DEV NUMBER:	ORIGINATOR:	DATE:
DEV25-0015	**Roberto Guzmán**	17-Jan-25

RAIN BIRD

DEVIATION FORM (DRAWING)

FORM#233813-01 REV: R

BUSINESS UNIT (SBU and PLANT) W/ PRIMARY DESIGN CONTRO		SHEET:
025 OTY	> > > LND	1 OF 1

DMR# (IF APPLICABLE):

DEVIATION TYPE: NEW ☑ EXTENSION ☐ OF DEV#:

TOP-LEVEL SKU P/N(S) AND MODEL NUMBER(S):
MUF-SPK4S, MUF-SPK4SX, UXB360SPYK, UXB360, UXB360025

EFFECTIVITY DATE:	EXPIRATION DATE:
17-Jan-25	18-Apr-25

PROJECT NAME OR NO. (OPTIONAL):

AFFECTED MFG PLANTS (WHERE USED):

005 LAM ☐	013S STL ☐	025 OTY ☑	041 NOG ☑
008 BUY ☐	019 AZU ☐	028 TUC ☐	047 TUC ☐
013E EEX ☐	020MX NMD ☐	026 ELG ☐	CHINA ☐

REASON FOR DEVIATION:

Conditionally approval of QAP1000 for P/N 180514, mold 45021 @ Nogales Molding Facility, accepting described conditions and the recomended deviated allowances:
1. 0.452" + 0.001" / -0.002" CPK 0.60 PPK 0.60 proposing 0.452" + 0.002" / -0.002" CPK 1.43 PPK 1.42
2. 0.466" + 0.002" / - 0.001" CPK 0.31 PPK 0.30 proposing 0.466" + 0.002" / - 0.003" CPK 2.30 PPK 2.17
3. 0.122" + 0.002" - 0.000" CPK 0.24 PPK 0.24 proposing 0.122" + 0.002" - 0.002" CPK 1.20 PPK 1.21, the limit of this was not open to the 1.33 requirement due to it being a critical dimension that the stackup would only allow it to work to the proposed dimension.
4. Note 6 Max flash appendage to be 0005" high X 0.005" thick, Max detected @ 0.0105" height. proposed Note 6 Max flash appendage to be 00012" high X 0.005" thick
Be aware that we don't have material available and need to build units to cover backloged order.

RISK ASSESSMENT/ CORRECTIVE ACTION PLAN (NAMES & DATES)/ COMMITMENT:

Risk assessment:
Low. Flow rate, distribution pattern and leakage at closed position were verified in Arimex. Results were satisfactory, functional testing was conducted in Arimex on January, 2025 (PCO 29463).
Corrective action plan:
1.Built Safety stock of 8 to cover the repaire time. Amauri Ruiz 1/28/25
2.Mold will be transported to PA to assess the dimensions that were not meeting the specification.- 1 week César Rodríguez 2/4/25
3.Assessment and metal analysis to elaborate a plan to adjust/fabricate components.-4 weeks César Rodríguez 3/4/25
4.Fitting on adjusted components and dry run.- 1 week César Rodríguez 3/11/25
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6.Transportation to Nogales.- 1 week César Rodríguez 3/25/25
7.Validation of repaired mold will be completed by RB Nogales César Rodríguez 4/9/25

DRAWING NUMBER:	DRAWING REVISION:	DEVIATION REVISION:	DRAWING TITLE/ PART DESCRIPTION:	VENDOR:
180514	D	D2	UMBRELLA 360, BUBBLER	RB NOGALES

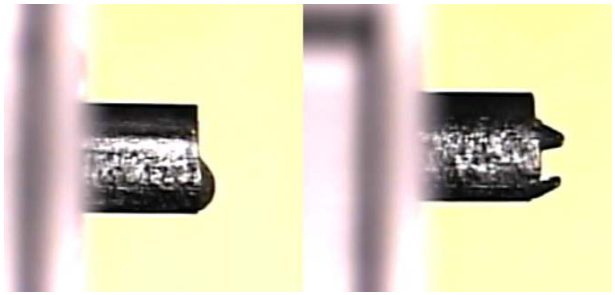
DESCRIPTION OF DEVIATION (IS/WAS CONDITION AND DRAWING ZONE FOR EACH PART NO. OR ATTACH REDLINE PRINTS):

F3 → **IS**: DIA .466 +.002/-.003; **WAS**: DIA .466 +.002/- .001

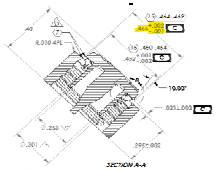
F3 → **IS:** .452 +/- .002; **WAS** DIA .452 +.001/- .002

D7 → **IS**: DIA .122 +.002/- .001; **WAS**: DIA .122 +.002/- .000

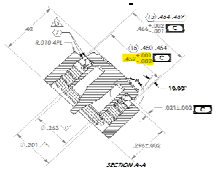
Note 6 → **IS**: MAX FLASH APPENDAGE TO BE .012 HIGH; **WAS**: MAX FLASH APPENDAGE TO BE .005 HIGH



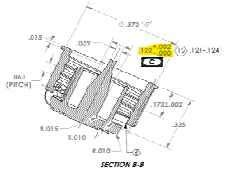
F3



F3



D7



Note 6 6. MAX FLASH APPENDAGE TO BE .005 HIGH X .005 THICK.

APPROVALS (ALL REQUIRED):

QUALITY MGR. OR QUALITY ENG.
Indira Aragón / Ramiro Casas

MANUFACTURING ENGINEER
Claudia Anaya

Paul Dibene / Xavier Vela

BUYER OR BUYER/PLANNER
Adriana Romero / Amauri Ruiz

PLANT MANAGER
Jorge Bórquez

SBU PRODUCT MGR. OR SBU ENG. MGR
Paul Dailey

OTHER:
César Rodríguez, Juan Mexia, Marisol Arvizu, Jeff Cooper

QUALITY DIRECTOR (REQUIRED FOR BACK-TO-BACK DEVIATIONS)
Blanca Salas

Leal, Vanessa NOG 5033

Digitally signed by Leal, Vanessa NOG 5033
DN: cn=Leal, Vanessa NOG 5033, ou=Engineering, e=vleal@rainbird.com
Reason: I am the author of this document
Location:
Date: 2025-01-20 17:16:07:00

Guzman, Roberto OTY 4791

From: Guzman, Roberto OTY 4791
Sent: Friday, January 17, 2025 5:17 PM
To: Aragon, Indira OTY 4360; Casas, Ramiro OTY 4364; Anaya, Claudia OTY 4329; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Romero, Adriana OTY 4351; Ruiz, Amauri OTY 4374; Borquez, Jorge OTY 4398; Dailey, Paul SOPT; Rodriguez, Cesar Alberto NOG 5053; Mexia, Juan NOG 5089; Arvizu, Marisol NOG 5017; Cooper, Jeff SOPT 6563; Salas, Blanca LAM2 4020
Subject: DEV25-0015_ApproveQAP1000_180514_XeriBubblers
Attachments: DEV25-0015_ApproveQAP1000_180514_XeriBubblers.xlsx; PCO26463.pdf

Tracking:

Recipient	Delivery	Read	Response
Aragon, Indira OTY 4360	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 10:29 AM	Approve: 1/20/2025 10:31 AM
Casas, Ramiro OTY 4364	Delivered: 1/17/2025 5:17 PM		
Anaya, Claudia OTY 4329	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 7:32 AM	Approve: 1/20/2025 7:33 AM
Dibene, Paul OTY2 4687	Delivered: 1/17/2025 5:17 PM		
Vela, Xavier OTY 4377	Delivered: 1/17/2025 5:17 PM		Approve: 1/20/2025 7:42 AM
Romero, Adriana OTY 4351	Delivered: 1/17/2025 5:17 PM	Read: 1/17/2025 10:07 PM	Approve: 1/20/2025 7:04 AM
Ruiz, Amauri OTY 4374	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 11:01 AM	Approve: 1/20/2025 11:02 AM
Borquez, Jorge OTY 4398	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 10:59 AM	Approve: 1/20/2025 11:00 AM
Dailey, Paul SOPT	Delivered: 1/17/2025 5:17 PM		Approve: 1/20/2025 10:56 AM
Rodriguez, Cesar Alberto NOG 5053	Delivered: 1/17/2025 5:17 PM		Approve: 1/17/2025 5:24 PM
Mexia, Juan NOG 5089	Delivered: 1/17/2025 5:17 PM		Approve: 1/20/2025 2:30 PM
Arvizu, Marisol NOG 5017	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 8:41 AM	Approve: 1/20/2025 8:42 AM
Cooper, Jeff SOPT 6563	Delivered: 1/17/2025 5:17 PM	Read: 1/18/2025 7:22 AM	
Salas, Blanca LAM2 4020	Delivered: 1/17/2025 5:17 PM	Read: 1/20/2025 8:45 AM	Approve: 1/20/2025 2:19 PM

Good afternoon, team!

Please, review and approve the attached document at your earliest convenience. Use the voting buttons in the email.

DEV NUMBER:	ORIGINATOR:	DATE:
DEV25-0015	Roberto Guzmán	17-Jan-25

RAIN BIRD

DEVIATION FORM (DRAWING)

FORM#233813-01 REV: R

DMR# (IF APPLICABLE):	DEVIATION TYPE:	NEW ☑	EXTENSION ☐	OF DEV#:	FALSE

BUSINESS UNIT (SBU and PLANT) W/ PRIMARY DESIGN CONTRO: 025 OTY > > > LND

SHEET: 1 OF 1

TOP-LEVEL SKU P/N(S) AND MODEL NUMBER(S): MUF-SPK4S, MUF-SPK4SX, UXB360SPYK, UXB360, UXB360025

EFFECTIVITY DATE:	EXPIRATION DATE:
17-Jan-25	18-Apr-25

PROJECT NAME OR NO. (OPTIONAL):

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008 BUY ☐	019 AZU ☐	028 TUC ☐	047 TUC ☐
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REASON FOR DEVIATION:

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DRAWING NUMBER:	DRAWING REVISION:	DEVIATION REVISION:	DRAWING TITLE/ PART DESCRIPTION:	VENDOR:
180514	D	D2	UMBRELLA 360, BUBBLER	RB NOGALES

APPROVALS (ALL REQUIRED):

QUALITY MGR. OR QUALITY ENG.
Indira Aragón / Ramiro Casas

MANUFACTURING ENGINEER
Claudia Anaya

Paul Dibene / Xavier Vela

BUYER OR BUYER/PLANNER
Adriana Romero / Amauri Ruiz

PLANT MANAGER
Jorge Bórquez

SBU PRODUCT MGR. OR SBU ENG. MGR.
Paul Dailey

OTHER:
César Rodríguez, Juan Mexia, Marisol Arvizu, Jeff Cooper

QUALITY DIRECTOR (REQUIRED FOR BACK-TO-BACK DEVIATIONS)
Blanca Salas

DESCRIPTION OF DEVIATION (IS/WAS CONDITION AND DRAWING ZONE FOR EACH PART NO. OR ATTACH REDLINE PRINTS):

F3 → **IS**: DIA .466 +.002/-.003; **WAS**: DIA .466 +.002/- .001

F3 → **IS:** .452 +/- .002; **WAS** DIA .452 +.001/- .002

D7 → **IS**: DIA .122 +.002/- .001; **WAS**: DIA .122 +.002/- .000

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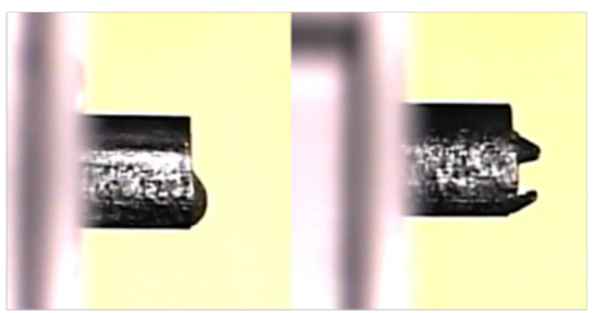

F3

F3

D7

Note 6

24-Hour Rule applies!

If additional information or more time is needed, please, vote “Discuss” to request it.

If you are not the correct Deviation approver, please, vote “Reject” to reassign it.

Regards,

Roberto Guzmán Vega
Sr. Product Engineer
+52 (3) 333 644791
+1 (626) 4283010, X 4791

Ensambles Hyson
Av. Industrial 333
Sección Dorada Parque Industrial Otay
Tijuana, México, 22500

Guzman, Roberto OTY 4791

From: Cooper, Jeff SOPT 6563
Sent: Saturday, January 18, 2025 7:23 AM
To: Guzman, Roberto OTY 4791; Aragon, Indira OTY 4360; Casas, Ramiro OTY 4364; Anaya, Claudia OTY 4329; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Romero, Adriana OTY 4351; Ruiz, Amauri OTY 4374; Borquez, Jorge OTY 4398; Dailey, Paul SOPT; Rodriguez, Cesar Alberto NOG 5053; Mexia, Juan NOG 5089; Arvizu, Marisol NOG 5017; Salas, Blanca LAM2 4020
Subject: RE: DEV25-0015_ApproveQAP1000_180514_XeriBubblers

Yes, I approve.

From: Guzman, Roberto OTY 4791 <roguzman@rainbird.com>
Sent: Friday, January 17, 2025 6:17 PM
To: Aragon, Indira OTY 4360 <IAragon@rainbird.com>; Casas, Ramiro OTY 4364 <rcasas@rainbird.com>; Anaya, Claudia OTY 4329 <Canaya@rainbird.com>; Dibene, Paul OTY2 4687 <PDibene@RainBird.com>; Vela, Xavier OTY 4377 <XVela@rainbird.com>; Romero, Adriana OTY 4351 <Aromero@rainbird.com>; Ruiz, Amauri OTY 4374 <amruiz@rainbird.com>; Borquez, Jorge OTY 4398 <jborquez@rainbird.com>; Dailey, Paul SOPT <PDailey@rainbird.com>; Rodriguez, Cesar Alberto NOG 5053 <CeRodriguez@rainbird.com>; Mexia, Juan NOG 5089 <jmexia@rainbird.com>; Arvizu, Marisol NOG 5017 <MArvizu@rainbird.com>; Cooper, Jeff SOPT 6563 <jcooper@rainbird.com>; Salas, Blanca LAM2 4020 <bsalas@rainbird.com>
Subject: DEV25-0015_ApproveQAP1000_180514_XeriBubblers

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DEV NUMBER:	ORIGINATOR:	DATE:
DEV25-0015	Roberto Guzmán	17-Jan-25

RAIN BIRD

DEVIATION FORM (DRAWING)

FORM#233813-01 REV: R

DMR# (IF APPLICABLE):	DEVIATION TYPE:	NEW ☑	EXTENSION ☐	OF DEV#:	FALSE

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SHEET: 1 OF 1

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17-Jan-25	18-Apr-25

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DRAWING NUMBER:	DRAWING REVISION:	DEVIATION REVISION:	DRAWING TITLE/ PART DESCRIPTION:	VENDOR:
180514	D	D2	UMBRELLA 360, BUBBLER	RB NOGALES

APPROVALS (ALL REQUIRED):

QUALITY MGR. OR QUALITY ENG.
Indira Aragón / Ramiro Casas

MANUFACTURING ENGINEER
Claudia Anaya

Paul Dibene / Xavier Vela

BUYER OR BUYER/PLANNER
Adriana Romero / Amauri Ruiz

PLANT MANAGER
Jorge Bórquez

SBU PRODUCT MGR. OR SBU ENG. MGR.
Paul Dailey

OTHER:
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QUALITY DIRECTOR (REQUIRED FOR BACK-TO-BACK DEVIATIONS)
Blanca Salas

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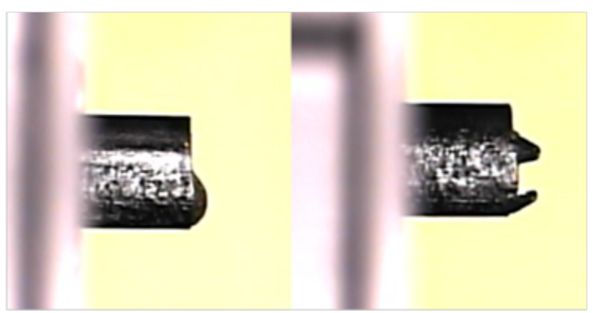
Note 6 → **IS**: MAX FLASH APPENDAGE TO BE .012 HIGH; **WAS**: MAX FLASH APPENDAGE TO BE .005 HIGH



F3

F3

D7

Note 6

24-Hour Rule applies!

If additional information or more time is needed, please, vote “Discuss” to request it.

If you are not the correct Deviation approver, please, vote “Reject” to reassign it.

Regards,

Roberto Guzmán Vega
Sr. Product Engineer
+52 (3) 333 644791
+1 (626) 4283010, X 4791

Ensambles Hyson
Av. Industrial 333
Sección Dorada Parque Industrial Otay
Tijuana, México, 22500

Nombre del operador:___Angel Gasga/ Carlos Bautista

Fecha: 01/09/2025 __

Turno:_3 / 2_

PCO:29463

El patrón de riego de tres muestras no fue confirmado en una segunda prueba por parte de Ingeniería de Producto.
Las muestras con flujo alto se ajustaron ("cerraron") de acuerdo con Product Specification 178487, rev. B y están dentro de especificación.

Pruebas de Xeri bubblers

Cavidad 1

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.477	OK	OK	0.548	OK	OK	0.543
2	OK	OK	0.471	OK	OK	0.552	OK	OK	0.536
3	OK	OK	0.484	OK	OK	0.542	OK	OK	0.521

Cavidad 2

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.505	OK	OK	0.567	OK	OK	0.542
2	OK	OK	0.514	OK	OK	0.558	OK	OK	0.543
3	OK	OK	0.47	OK	OK	0.553	OK	OK	0.518

Cavidad 3

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.478	OK	OK	0.522	OK	OK	0.527
2	OK	OK	0.505	OK	OK	0.562	OK	OK	0.52
3	OK	OK	0.504	OK	OK	0.553	OK	OK	0.528

Cavidad 4

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.47	OK	OK	0.586	OK	OK	0.539
2	OK	OK	0.476	OK	OK	0.553	OK	OK	0.534
3	OK	OK	0.497	OK	OK	0.557	OK	OK	0.522

Pruebas realizadas en turno 2 por Carlos Bautista

Cavidad 5

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.447	NG	OK	0.545	NG	OK	0.514
2	OK	OK	0.439	OK	OK	0.518	OK	OK	0.516
3	OK	OK	0.453	OK	OK	0.516	NG	OK	0.52

Cavidad 6

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.475	OK	OK	0.49	OK	OK	0.487
2	OK	OK	0.493	OK	OK	0.523	OK	OK	0.485
3	OK	OK	0.466	OK	OK	0.505	OK	OK	0.478

Cavidad 7

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.489	OK	OK	0.511	OK	OK	0.507
2	OK	OK	0.491	OK	OK	0.519	OK	OK	0.483
3	OK	OK	0.475	OK	OK	0.503	OK	OK	0.514

Cavidad 8

	Modelo con estaca 177452 STAKE WITH STREAM 360, MICRO S			Modelo con base de rosca 179223 THREADED BASE, ASSEMBLED WITH			Modelo con base de punta, 179227 BARB BASE, ASSEMBLED WITH BUBB		
	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo	Patron de riego	Fuga	Flujo
1	OK	OK	0.483	OK	OK	0.5	OK	OK	0.505
2	OK	OK	0.478	OK	OK	0.496	OK	OK	0.51
3	OK	OK	0.493	OK	OK	0.495	OK	OK	0.498