DEV NUMBER:	ORIGINATOR:	DATE:
25-0183	**Abdul Castillo**	20-Jun-25

RAIN BIRD

DEVIATION FORM (DRAWING)

FORM#233813-01 REV: T

BUSINESS UNIT (SBU and PLANT) W/ PRIMARY DESIGN CONTR		
025 OTY	> > >	GLF

SHEET: 1 OF 14

DMR# (IF APPLICABLE):

DEVIATION TYPE: NEW ☐ EXTENSION ☑ OF DEV#: DEV24-0004, DEV24-0087, DEV24-0376, DEV24-0445

TOP-LEVEL SKU P/N(S) AND MODEL NUMBER(S): 5XX/7XX/9XX Valves

EFFECTIVITY DATE:	EXPIRATION DATE:
20-Jun-25	6-Sep-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:

Mold 76914 with several deviations for part 211297, Dimensions out of spec. Tool in poor condition
The mold was sent for repair, the inserts were manufactured, and the QAP1000 was run with the mold maker. The data showed that adjustments to the steel are required.
The decision was made to return the mold in order to continue producing parts and then proceed with the validation of the new inserts.
This action takes more time due to the machine time availability with the molder; with this move, we reduced the risk of stopping production.
Deviation was approve for only 3 months, In 3 months, A meeting will be held to review the actions committed for the next 3 months.

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

LOW: Only adjusting tolerances on dimensions associated with energydirector use on welding process. these dims were previously used on production with no issues.
Corrective Action:
1.-**24** weeks of inventory must be built (200,000 PCs) Oscar Santillan ..... **8 weeks**
2.- Move Mold and install new cavities Jorge Rivero ..... **4 weeks**
3.- RunQAP100 Jorge Rivero ..... **2 weeks**
4.- Move Mold to Tucson Jorge Rivero ..... **1 week**
5.-Run QAP1001 @ Tucson send parts to Arimex Jorge Rivero ..... **4 weeks**
6.-Assembly parts with QAP1001 samples and send to PRC Abdul Castillo.....**1 Week**
7.-PRC Testing & Close Validation, Upload results. Abdul Castillo ..... **4 weeks**

DRAWING NUMBER:	DRAWING REVISION:	DEVIATION REVISION:	DRAWING TITLE/ PART DESCRIPTION:	VENDOR:
211297	AA	AA6	PISTON (FOUR CAVITY)	Westfall (AMA)

APPROVALS (ALL REQUIRED):

QUALITY MGR. OR QUALITY ENG.
Arturo Ramos / Ramiro Casas

MANUFACTURING ENGINEER
Guillermo Acosta

PROD.ENG. MGR. OR Plant ENG MGR
Paul Dibene / Xavier Vela

BUYER OR BUYER/PLANNER
Diana Rincon /Oscar Santillan

PLANT MANAGER
Jorge Borquez/ Victor Martinez

SBU PRODUCT MGR. OR SBU ENG. MGR
Altan Tolan / Javier Guardado

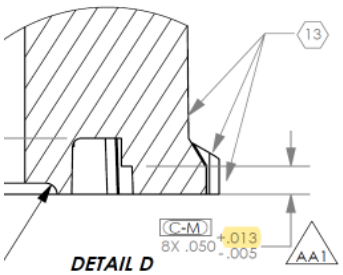
TOOLING ENGINEER (MOLDED PARTS ONLY)
Jorge Rivero / Cesar Rodriguez

OTHER:
D. Bush / C. Olvera

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

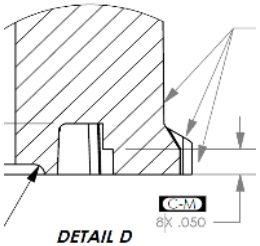
DESCRIPTION OF DEVIATION (IS/WAS CONDITION AND DRAWING ZONE FOR EACH PART NO. OR ATTACH REDLINE PRINTS):

IS



DETAIL D

WAS



DETAIL D

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: 2025-06-20 14:40-07:00

RAIN BIRD

ENGINEERING CHANGE ORDER
(CONTINUED)

FORM#233812-05 REV: AC

DEV NUMBER:	ORIGINATOR:	DATE:	SHEET
24-0376	Doug Busch	7-Oct-24	2 OF 3

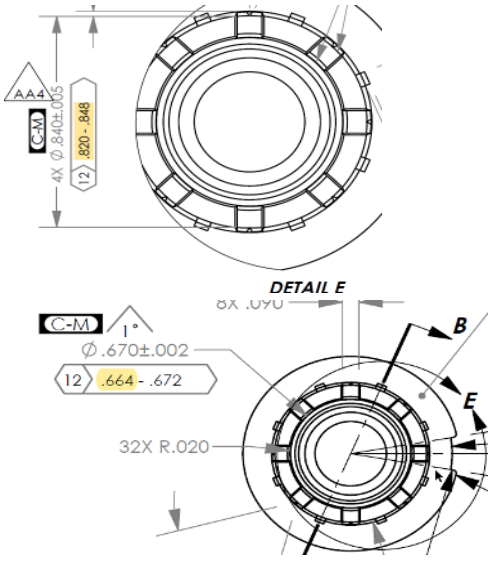
CHANGE TYPE (SELECT ONE THAT APPLIES):

- ☑ DRAWING/ BILL-OF-MATERIAL/ ITEM CHANGE
- ☐ PROCEDURE/ FORM/ SPECIFICATION CHANGE
- ☐ SBU CAD RELEASE FROM LEGACY STATUS

DESCRIPTION OF CHANGE (CONT'D):

**** NOTE THAT THIS ECO TAKES EFFECT IMMEDIATELY. FOR ALL BOM RELATED ECO'S, MAKE SURE TO INCLUDE AN EFFECTIVITY DATE IN THE DETAILS BELOW.**

IS



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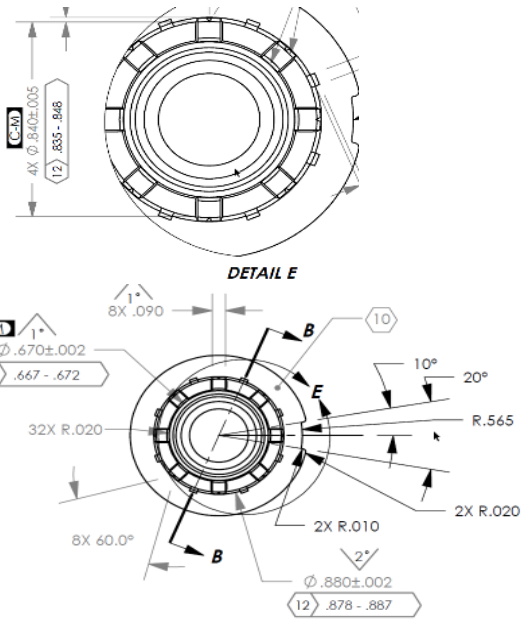


RAIN BIRD

ENGINEERING CHANGE ORDER
(CONTINUED)

FORM#233812-05 REV: AC

DEV NUMBER:	ORIGINATOR:	DATE:	SHEET
24-0376	Doug Busch	7-Oct-24	3 OF 3

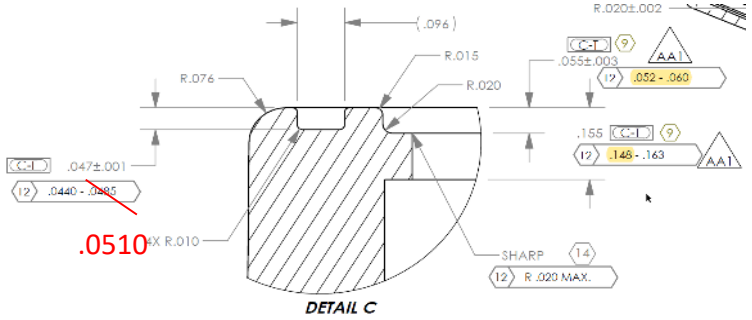
CHANGE TYPE (SELECT ONE THAT APPLIES):

- [x] DRAWING/ BILL-OF-MATERIAL/ ITEM CHANGE
- [ ] PROCEDURE/ FORM/ SPECIFICATION CHANGE
- [ ] SBU CAD RELEASE FROM LEGACY STATUS

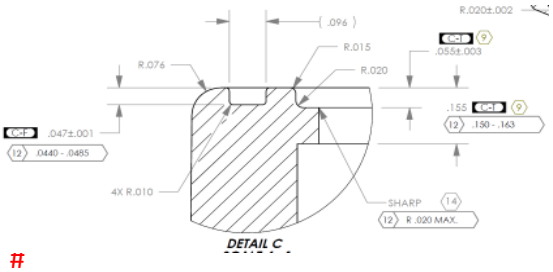
DESCRIPTION OF CHANGE (CONT'D):

**** NOTE THAT THIS ECO TAKES EFFECT IMMEDIATELY. FOR ALL BOM RELATED ECO'S, MAKE SURE TO INCLUDE AN EFFECTIVITY DATE IN THE DETAILS BELOW.**

IS



WAS



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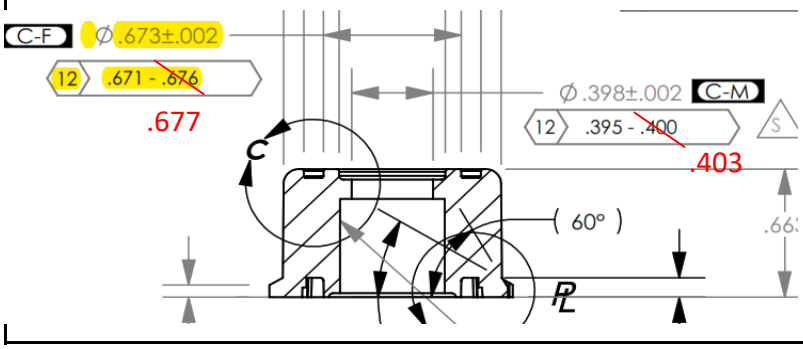
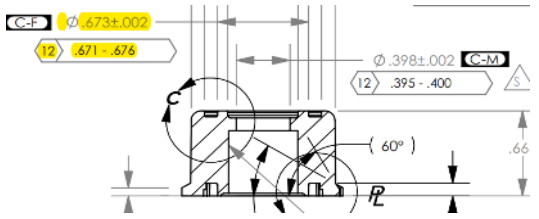
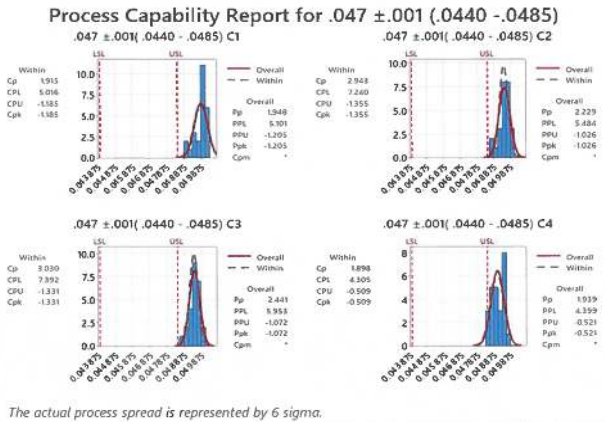
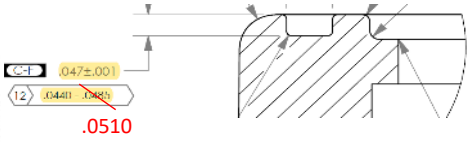
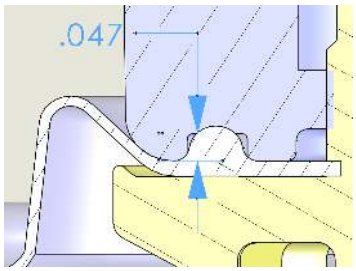


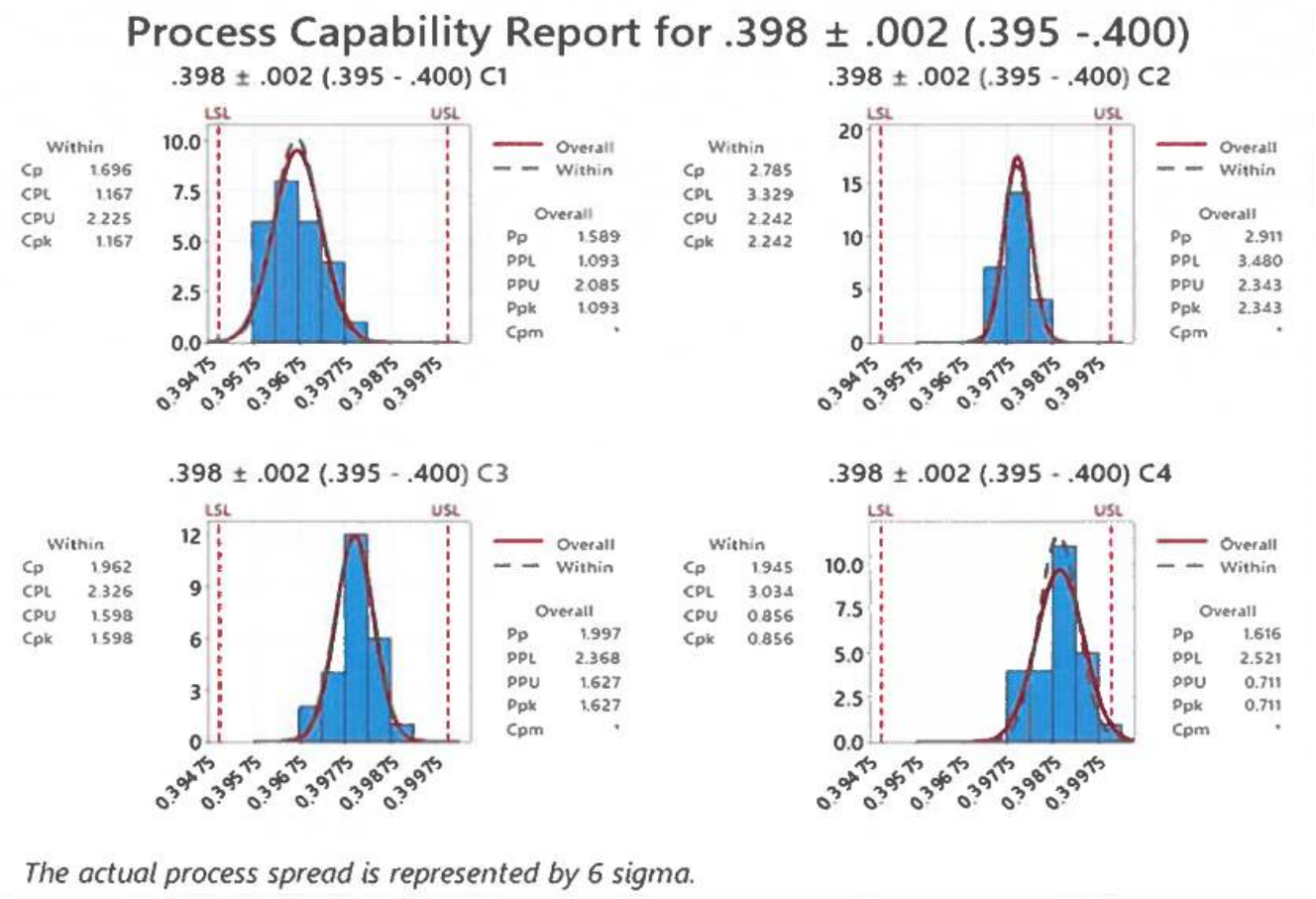


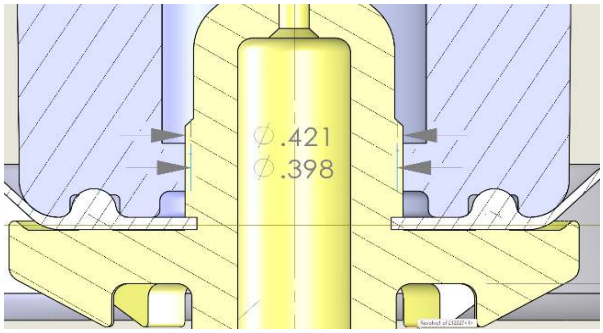

Process Capability Report for .047 ±.001 (.0440 -.0485)
.047 ±.001(.0440 - .0485) C1
.047 ±.001(.0440 - .0485) C2
.047 ±.001(.0440 - .0485) C3
.047 ±.001(.0440 - .0485) C4
LSL
USL
Within
Overall
The actual process spread is represented by 6 sigma.

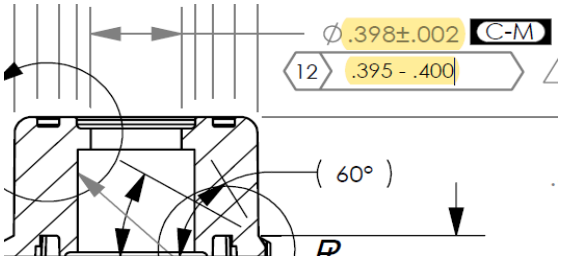

C-D
.047±.001
12
.0441
.0485
.0510


.047

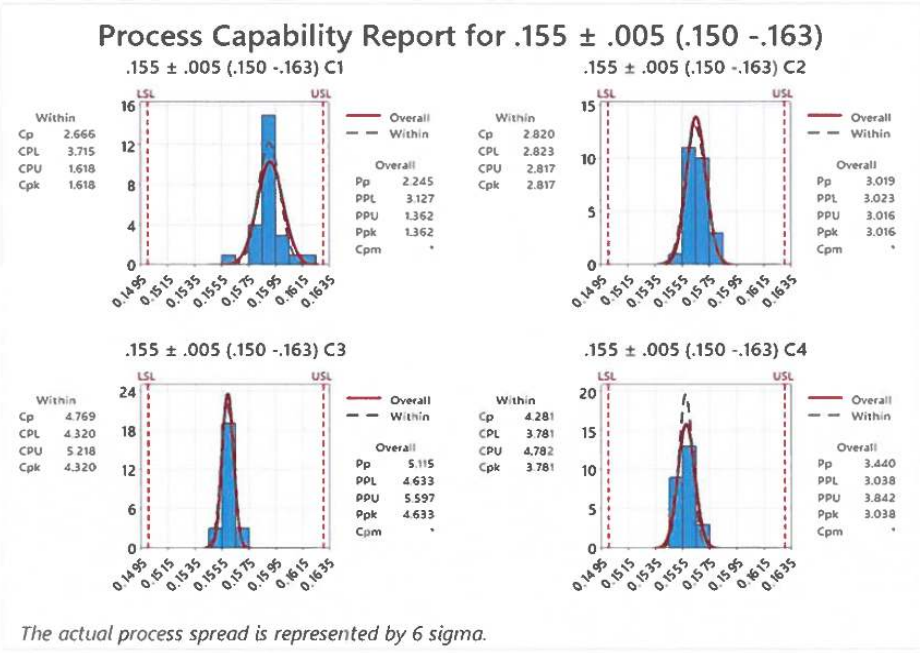
Weld overlap for piston guide assembly **Max = 0.4015**

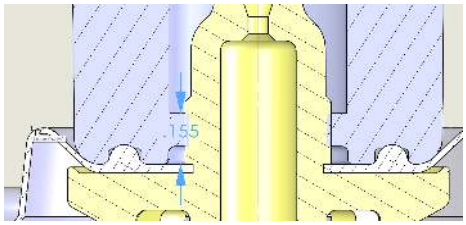


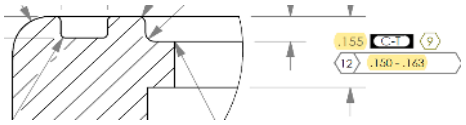




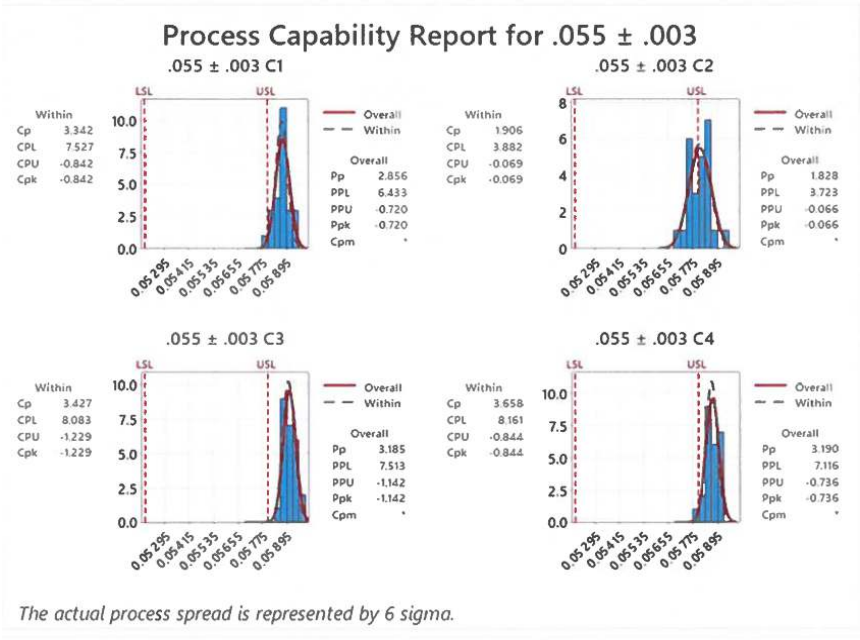
Depth of melt rib for piston guide **Min = 0.1498**

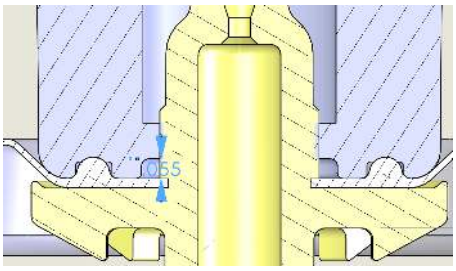


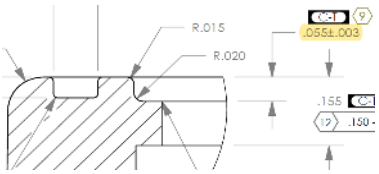


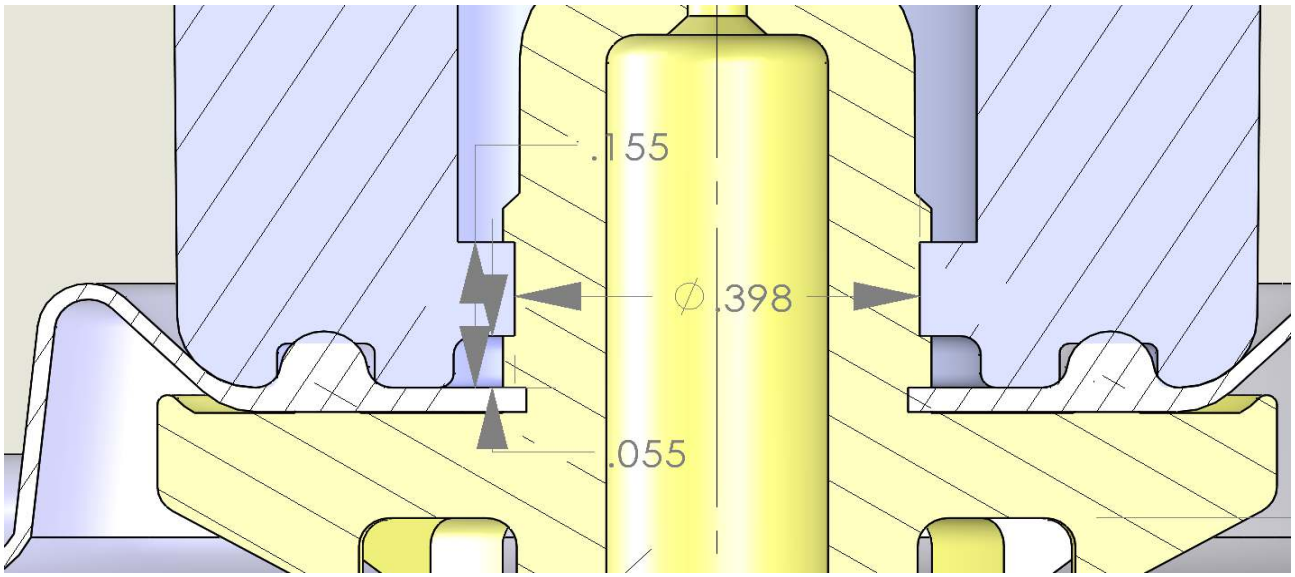


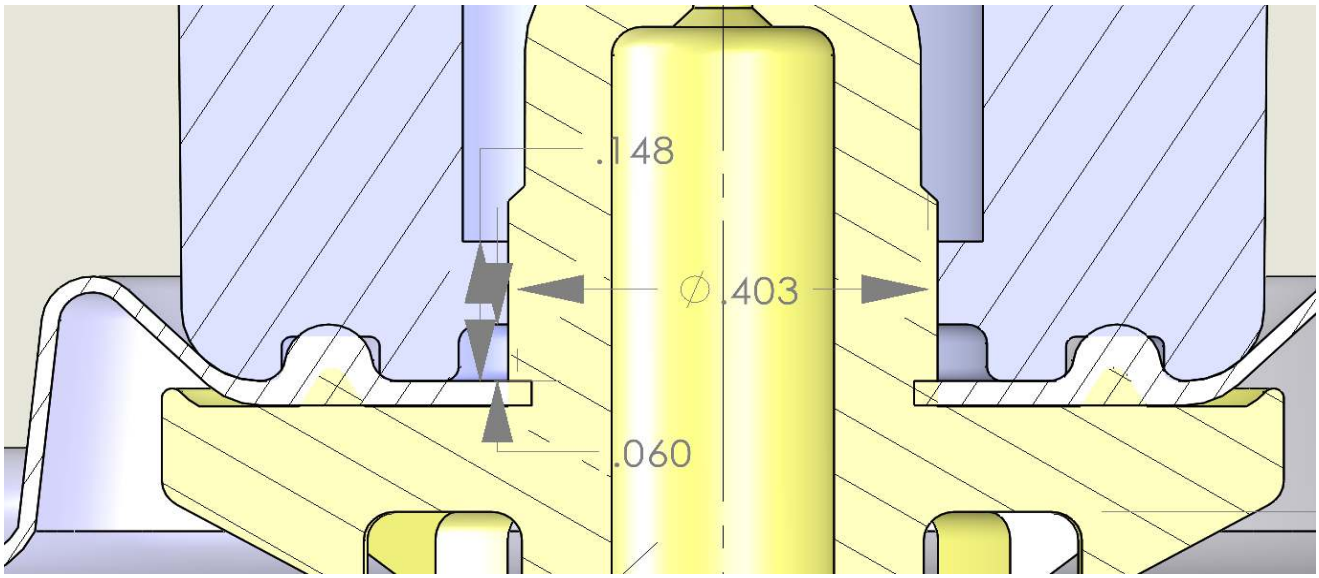
distance to top of piston guide melt rib **MAX = 0.0589**



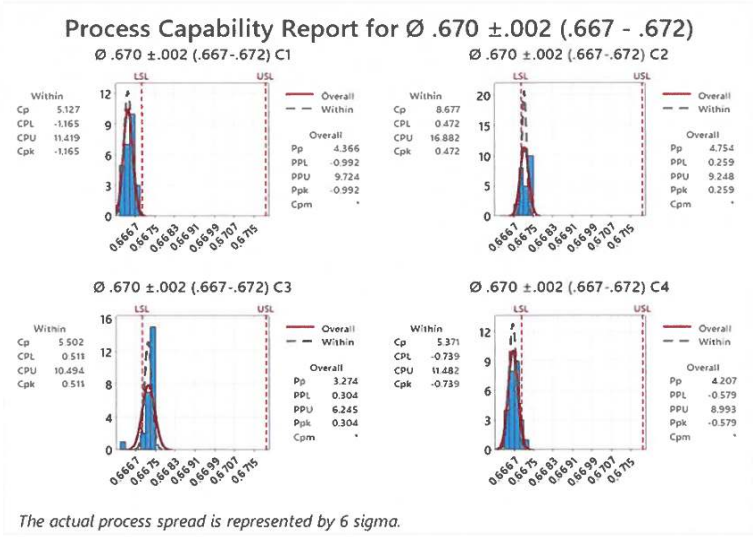


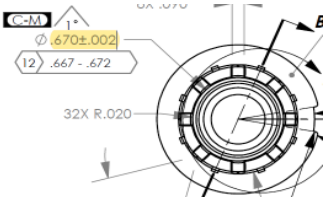



.155
∅.398
.055

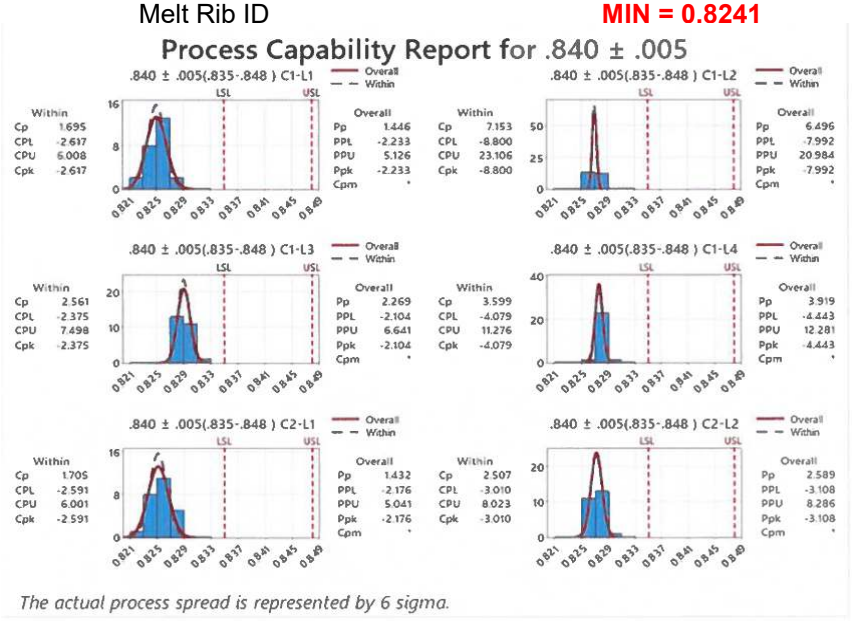

.148
∅.403
.060

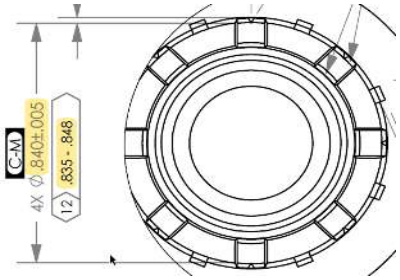
Filler Ring Groove ID **Min = 0.6656**

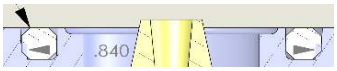


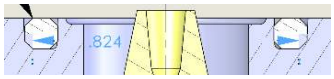


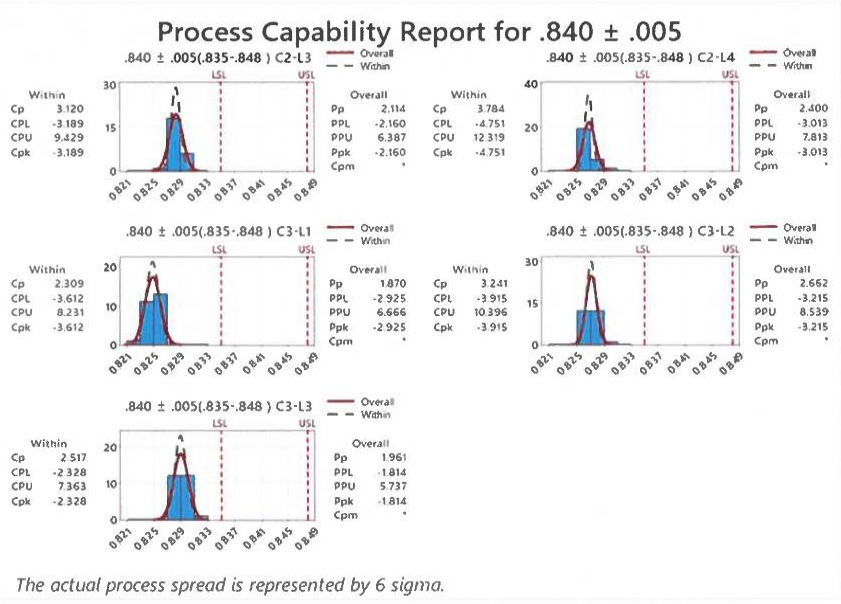
Melt Rib ID **MIN = 0.8241**



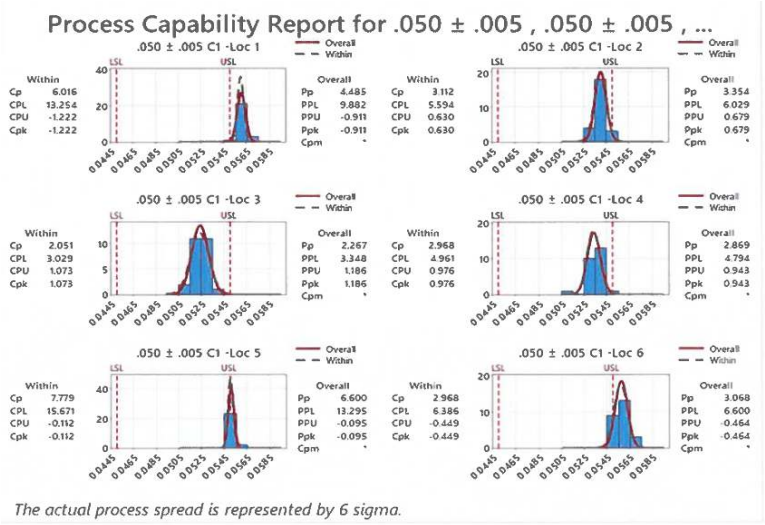


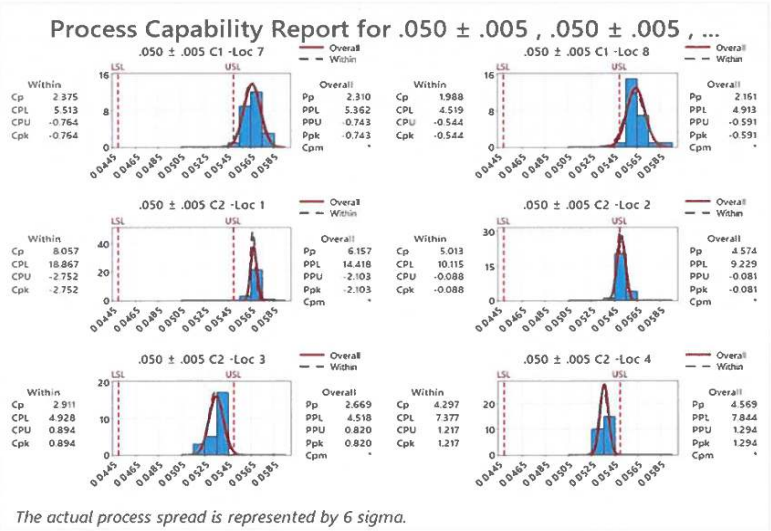


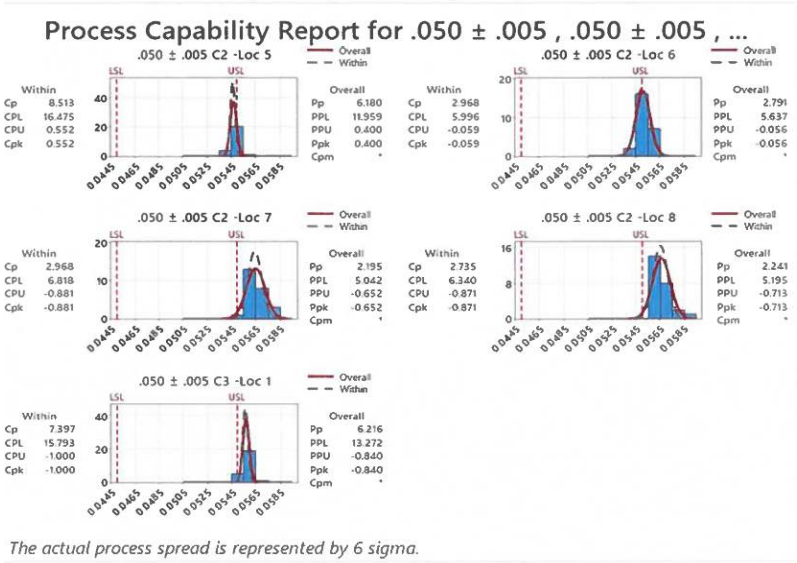


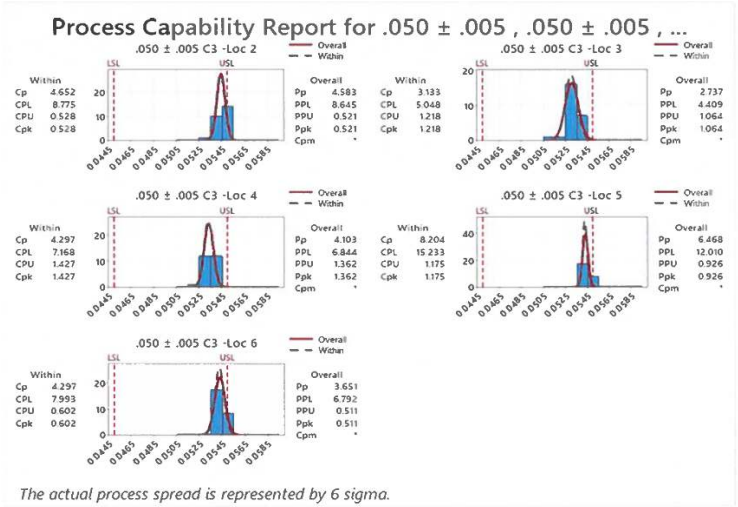


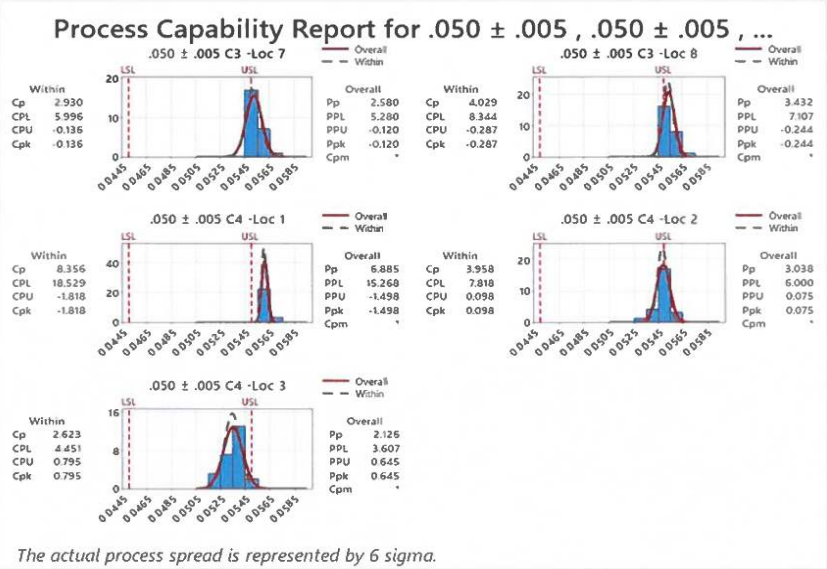
Distance to top of melt rib **MAX= 0.613**



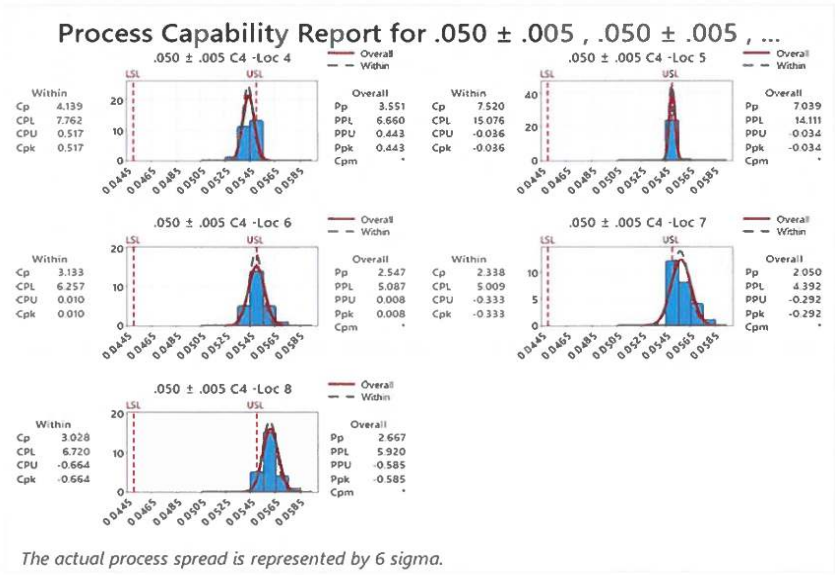




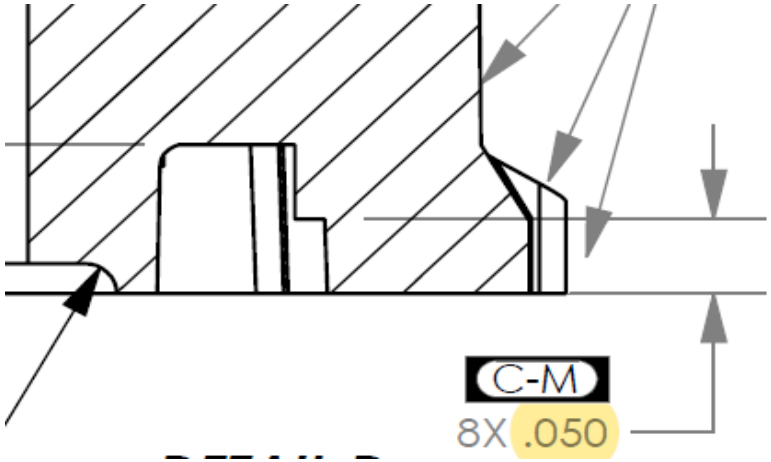


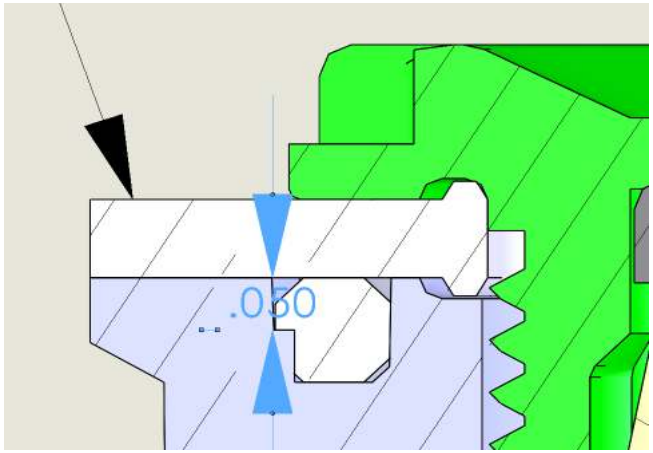


The actual process spread is represented by 6 sigma.

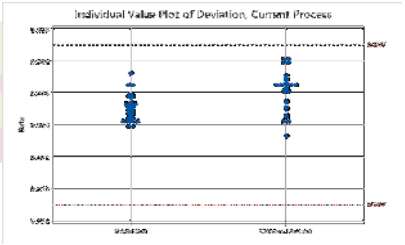


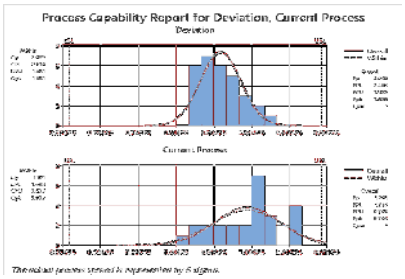
The actual process spread is represented by 6 sigma.





	DEV24-0376	DEV24-0445
8X .050 ±.005	+0.013 -0.005	+0.013 -0.005
.740 ±.005	.820 -.848	.820 -.848
.670 ±.002	.664 -.672	.664 -.672
.047±.001	.0440 -.0485	.0440 -.0510
0.055 ±.003	.052 -.060	.052 -.060
.155± .005	.1480 -.0163	.1480 -.0163
.673 ± .002	.671 -.676	.671 -.677
.398 ±.002	.395 -.400	.395 -.403





En base a la muestra tomada de n=30. Estos son los resultados comparativos, ***"deviation"*** vs ***"current process"*** .

T-test de promedios. Ambos grupos cuentan con una diferencia significativa. (P-value = 0.001). El material bajo propuesta de desviación se comporta con una ***mejor localización (media) de datos*** respecto a las especificaciones.

T-test de varianzas: Ambos grupos cuentan con una diferencia significativa. (P-value = 0.020). El material bajo propuesta de desviación se comporta con una ***menor varianza de datos*** respecto a las especificaciones.

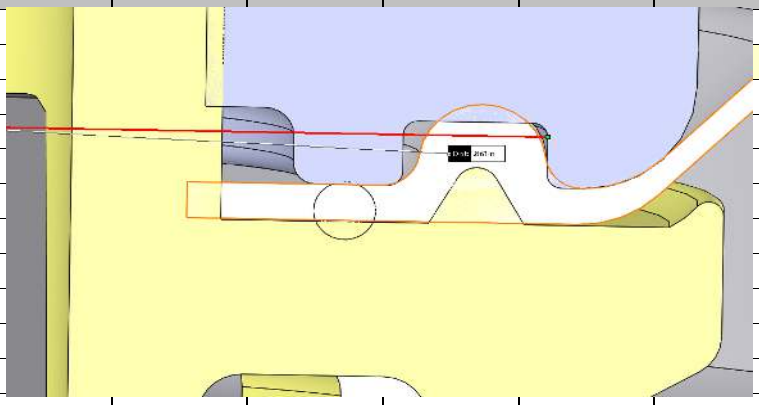
Por esta razón, la capacidad de proceso se observa mejor con el material bajo desviación, contra el material actual.

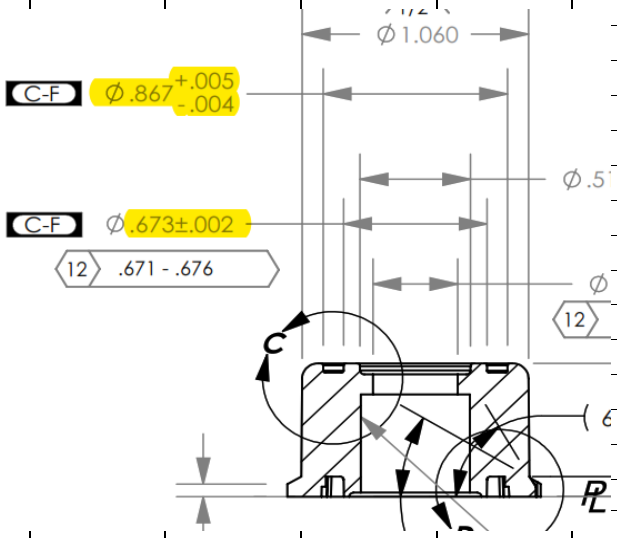
Material bajo desviación: Ppk = 1.67 (n=30) CPK 1.661
Proceso actual: Ppk = 0.746 (n=25), Cpk = 1.55

DIMENSIONAL ANALYSIS REPORT

PART N0.	211297	**MOLD. #**	76914	**FECHA DE MFG:**	Eng	**INSPECTOR:**	Flor Ruiz
DESC	Piston	**CAVs.**	1-4	**LOTE:**	Eng	**INSP. DATE**	6/6/2025
REV.	AA			**VENDOR:**	Eng	**REQ BY:**	Abdul Castillo

CAVITY ID	ZONE - DWG	D-4	E-4							
	DIMENSION	.671-.676	.867+.005/-.004							
	LSL	0.671	0.863							
	USL	0.676	0.872							
	Inspection Method	Smart scope	Smart scope							
	Sample#									
1	1	0.6765	0.8626							
1	2	0.6768	0.8625							
1	3	0.6767	0.8622							
1	4	0.6764	0.8621							
1	5	0.6769	0.8632							
2	1	0.6770	0.8614							
2	2	0.6775	0.8616							
2	3	0.6765	0.8613							
2	4	0.6764	0.8622							
2	5	0.6765	0.8616							
3	1	0.6765	0.8608							
3	2	0.6767	0.8611							
3	3	0.6765	0.8610							
3	4	0.6771	0.8613							
3	5	0.6764	0.8606							
4	1	0.6774	0.8615							
4	2	0.6768	0.8609							
4	3	0.6767	0.8609							
4	4	0.6771	0.8617							
4	5	0.6771	0.8612							
	Comentarios									
	Adicionales:									
	Min	0.6764	0.8606	0.0000	0.0000	0.8606	0.1920	0.5180	0.1506	0.0753
	Max	0.6775	0.8632	0.0000	0.0000	0.8606	0.1920	0.5180	0.6686	0.0753
	Dev at Min	0.0000	0.0024	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000	0.0000
	Dev at Max	0.0015	0.000000	0.0000	0.0000	0.8606	0.1920	0.5180	0.6686	0.0753
	Range	0.0011	0.0027	0.0000	0.0000	0.0000	0.0000	0.0000	0.5180	0.0000
	Average	0.6768	0.8616			0.8606	0.1920	0.5180	0.4096	0.0753
	Standard Dev	0.0003	0.0007			0.0000	#DIV/0!	0.0000	0.3663	#DIV/0!





Process Capability Report

Report #	Preliminary
Customer:	RAINBIRD
Address:	1100 Citrus St. Riverside, Ca 92507
Part Number:	211297
Rev:	AA
Part Name:	PISTON
Cavity #	1-4
Date:	6/4/2025
Mold Number:	RBM162
Material Used:	M90 Natural ACE
Sampling Date:	6/4/2025
Number of Samples:	2
Units:	INCH

Cavity #	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4
DESCRIPTION	.047 ±.001(.0440 - .0485)				Ø .867 + .005 / -.004				Ø .673 ±.002 (.671 -.676)				Ø .670 ±.002 (.667-.672)			
Tolerance Upper Limit(s)	0.0485	0.0485	0.0485	0.0485	0.8720	0.8720	0.8720	0.8720	0.6760	0.6760	0.6760	0.6760	0.6720	0.6720	0.6720	0.6720
Tolerance Lower Limit(s)	0.0440	0.0440	0.0440	0.0440	0.8630	0.8630	0.8630	0.8630	0.6710	0.6710	0.6710	0.6710	0.6670	0.6670	0.6670	0.6670
SAMPLE 1	0.0484	0.0498	0.0497	0.0498	0.8633	0.8634	0.8622	0.8627	0.6754	0.6760	0.6753	0.6756	0.6666	0.6674	0.6666	0.6669
2	0.0493	0.0497	0.0493	0.0490	0.8635	0.8636	0.8624	0.8627	0.6754	0.6760	0.6754	0.6758	0.6666	0.6674	0.6666	0.6669

Process Capability Report

Report #	Preliminary
Customer:	RAINBIRD
Address:	1100 Citrus St. Riverside, Ca 92507
Part Number:	211297
Rev:	AA
Part Name:	PISTON
Cavity #	1-4
Date:	6/4/2025
Mold Number:	RBM162
Material Used:	M90 Natural ACE
Sampling Date:	6/4/2025
Number of Samples:	2
Units:	INCH

Cavity #	1	2	3	4	1	2	3	4	1	2	3	4	1	2	3	4
DESCRIPTION	.047 ±.001(.0440 - .0485)				Ø .867 + .005 / -.004				Ø .673 ±.002 (.671 -.676)				Ø .670 ±.002 (.667-.672)			
Tolerance Upper Limit(s)	0.0485	0.0485	0.0485	0.0485	0.8720	0.8720	0.8720	0.8720	0.6760	0.6760	0.6760	0.6760	0.6720	0.6720	0.6720	0.6720
Tolerance Lower Limit(s)	0.0440	0.0440	0.0440	0.0440	0.8630	0.8630	0.8630	0.8630	0.6710	0.6710	0.6710	0.6710	0.6670	0.6670	0.6670	0.6670
SAMPLE 1	0.0484	0.0498	0.0497	0.0498	0.8633	0.8634	0.8622	0.8627	0.6754	0.6760	0.6753	0.6756	0.6666	0.6674	0.6666	0.6669
2	0.0493	0.0497	0.0493	0.0490	0.8635	0.8636	0.8624	0.8627	0.6754	0.6760	0.6754	0.6758	0.6666	0.6674	0.6666	0.6669

Process Capability Report

Report #	Preliminary
Customer:	RAINBIRD
Address:	1100 Citrus St. Riverside, Ca 92507
Part Number:	211297
Rev:	AA
Part Name:	PISTON
Cavity #	1-4
Date:	6/4/2025
Mold Number:	RBM162
Material Used:	M90 Natural ACE
Sampling Date:	6/4/2025
Number of Samples:	25
Units:	INCH

Cavity #	1								2							
DESCRIPTION	8 X .050 ± .005								8 X .050 ± .005							
Tolerance Upper Limit(s)	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550
Tolerance Lower Limit(s)	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450
SAMPLE 1	0.0560	0.0547	0.0535	0.0540	0.0548	0.0549	0.0550	0.0552	0.0563	0.0555	0.0538	0.0538	0.0545	0.0535	0.0553	0.0562
2	0.0561	0.0551	0.0539	0.0544	0.0548	0.0544	0.0547	0.0550	0.0566	0.0554	0.0540	0.0538	0.0544	0.0538	0.0554	0.0560

Process Capability Report

Report #	Preliminary
Customer:	RAINBIRD
Address:	1100 Citrus St. Riverside, Ca 92507
Part Number:	211297
Rev:	AA
Part Name:	PISTON
Cavity #	1-4
Date:	6/4/2025
Mold Number:	RBM162
Material Used:	M90 Natural ACE
Sampling Date:	6/4/2025
Number of Samples:	25
Units:	INCH

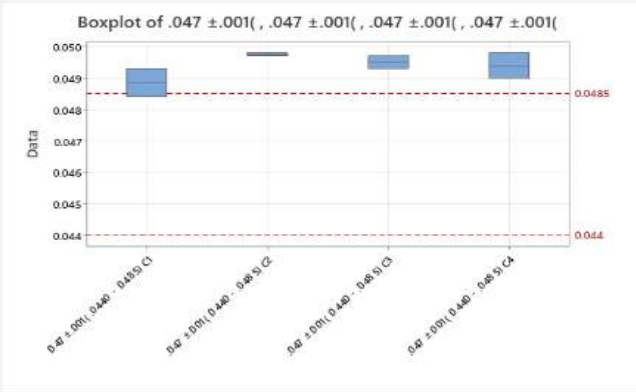
Cavity #	3								4							
DESCRIPTION	8 X .050 ± .005								8 X .050 ± .005							
Tolerance Upper Limit(s)	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550	0.0550
Tolerance Lower Limit(s)	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450	0.0450
SAMPLE 1	0.0558	0.0550	0.0539	0.0539	0.0544	0.0538	0.0544	0.0550	0.0567	0.0561	0.0547	0.0549	0.0546	0.0539	0.0547	0.0554
2	0.0558	0.0550	0.0537	0.0537	0.0543	0.0537	0.0545	0.0548	0.0565	0.0561	0.0550	0.0551	0.0547	0.0537	0.0544	0.0553

Process Capability Report

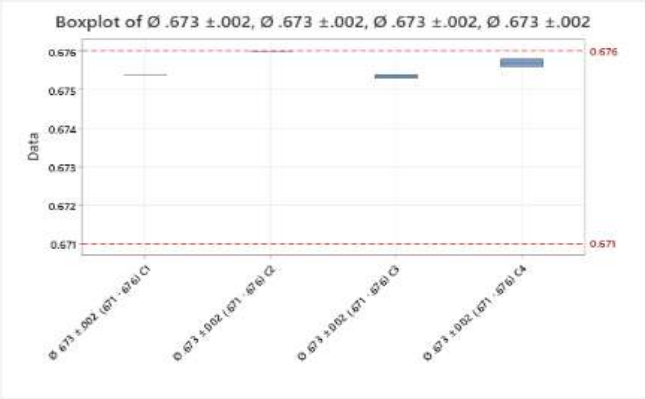
Report #	Preliminary
Customer:	RAINBIRD
Address:	1100 Citrus St. Riverside, Ca 92507
Part Number:	211297
Rev:	AA
Part Name:	PISTON
Cavity #	1-4
Date:	6/4/2025
Mold Number:	RBM162
Material Used:	M90 Natural ACE
Sampling Date:	6/4/2025
Number of Samples:	25
Units:	INCH

Cavity #	1				2				3				4			
DESCRIPTION	.840 ± .005 (.835 - .848)				.840 ± .005 (.835 - .848)				.840 ± .005 (.835 - .848)				.840 ± .005 (.835 - .848)			
Tolerance Upper Limit(s)	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480	0.8480
Tolerance Lower Limit(s)	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350	0.8350
SAMPLE 1	0.8236	0.8253	0.8263	0.8261	0.8242	0.8304	0.8306	0.826	0.8238	0.8259	0.8262	0.8266	0.8233	0.8258	0.8284	0.8264
2	0.8232	0.8255	0.8293	0.8261	0.8233	0.8257	0.8304	0.8258	0.8236	0.8255	0.8258	0.8260	0.8243	0.8262	0.8274	0.8275

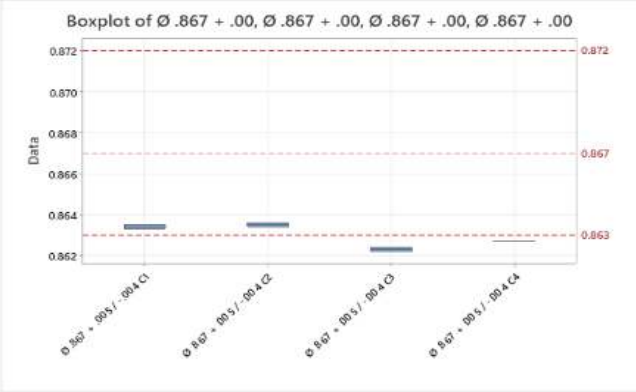
Boxplot of .047 ±.001(.0440 - .0485)



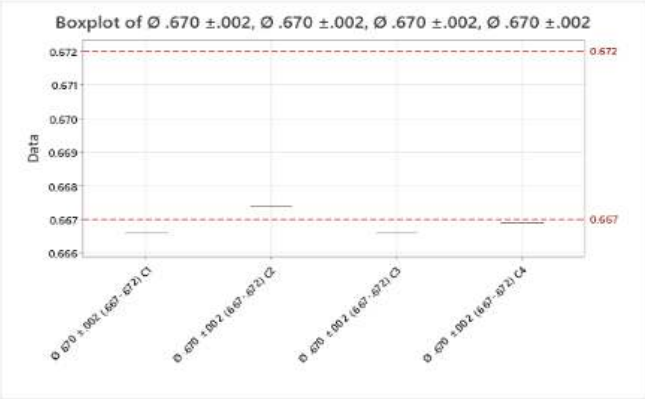
Boxplot of Ø .673 ±.002 (.671 -.676)



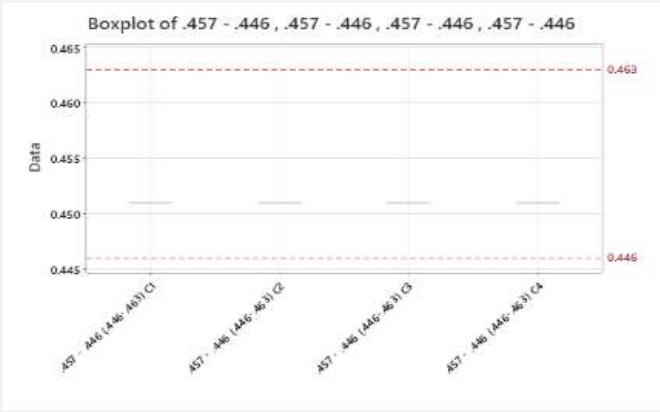
Boxplot of Ø .867 + .005 / -.004



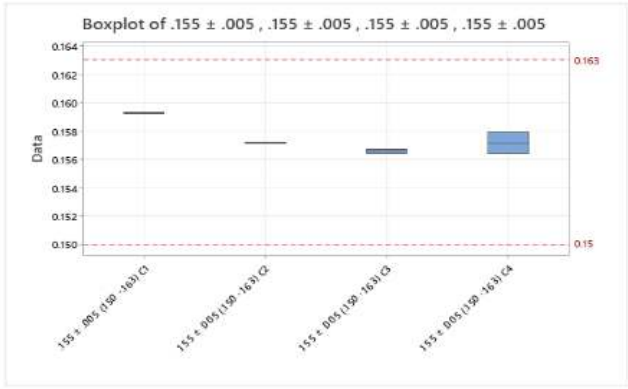
Boxplot of Ø .670 ±.002 (.667-.672)



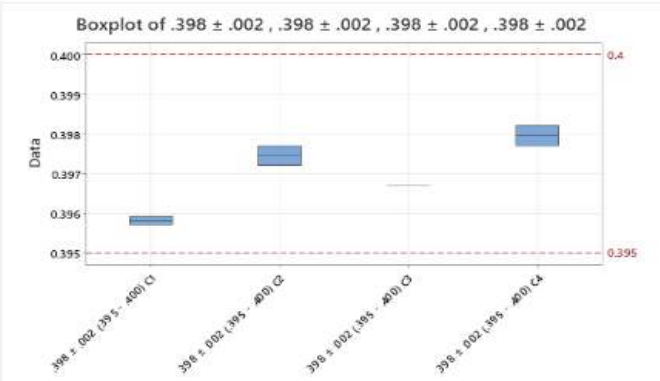
Boxplot of .457 - .446 (.446-.463)



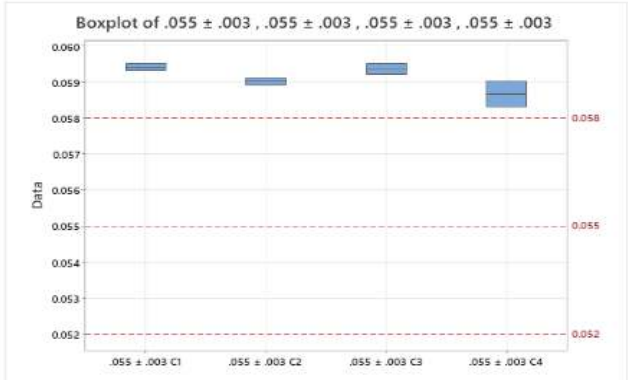
Boxplot of .155 ± .005 (.150 -.163)



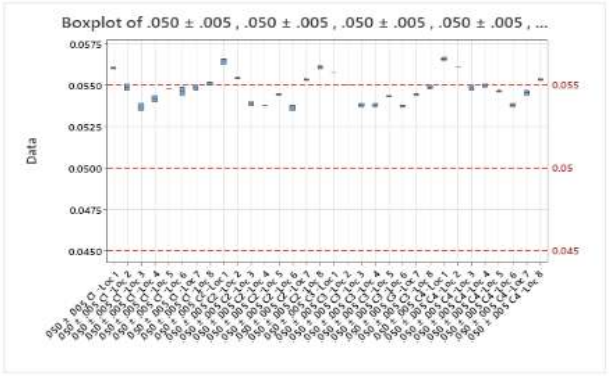
Boxplot of .398 ± .002 (.395 - .400)



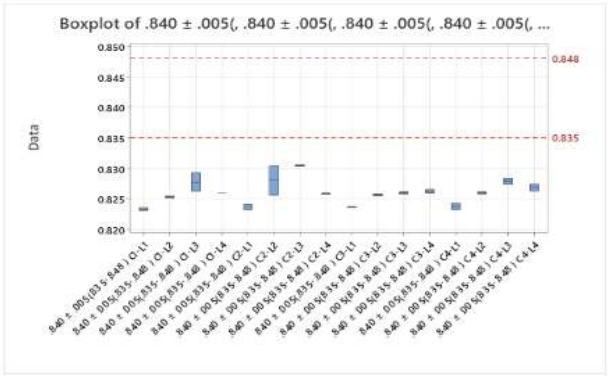
Boxplot of .055 ± .003



Boxplot of .050 ± .005



Boxplot of .840 ± .005



0.05	0.0556	0.0557	0.8252	0.6665	0.0583	0.6761
0.0497	0.0543	0.0547	0.8267	0.6669	0.0582	0.6763
0.0499	0.0529	0.0534	0.8281	0.6662	0.0587	0.6766
0.0496	0.0538	0.0536	0.8274	0.6671	0.058	0.6765
0.0502	0.0549	0.0538	0.825	0.6663	0.0586	0.6755
0.0496	0.0556	0.0541	0.8268	0.6671	0.0575	0.6765
0.0493	0.056	0.0547	0.8278	0.6675	0.0591	0.6765
0.0486	0.0556	0.0548	0.8263	0.6669	0.0588	0.6766
0.0501	0.0567	0.0565	0.8254	0.6661	0.0583	0.6759
0.0496	0.0557	0.0558	0.827	0.667	0.0576	0.6766
0.0497	0.054	0.0545	0.8328	0.6673	0.0588	0.6767
0.0497	0.0539	0.0548	0.8277	0.6668	0.0582	0.6766
0.0503	0.0544	0.0549	0.8244	0.6662	0.0584	0.6756
0.0499	0.0547	0.0541	0.8263	0.667	0.0579	0.6762
0.0498	0.0557	0.0548	0.8287	0.6675	0.0588	0.6765
0.0495	0.0567	0.0554	0.8274	0.6668	0.0584	0.6765
0.0501	0.0566	0.0554	0.8218	0.6665	0.0588	0.6755
0.0495	0.0533	0.0546	0.8279	0.6672	0.058	0.6764
0.0494	0.051	0.0536	0.83	0.6673	0.0588	0.6764
0.0495	0.0528	0.0535	0.8288	0.6667	0.0585	0.6765
0.05	0.0556	0.054	0.8246	0.6664	0.0586	0.6757
0.0496	0.0554	0.0541	0.8276	0.6672	0.0585	0.6763
0.0494	0.0555	0.0548	0.8298	0.6673	0.0587	0.6764
0.0484	0.0577	0.0549	0.8269	0.6668	0.059	0.6765
0.0501	0.0566	0.0557	0.8268	0.6664	0.059	0.6758
0.0494	0.0549	0.0552	0.828	0.6673	0.0581	0.6765
0.0492	0.053	0.0543	0.8279	0.6673	0.0594	0.6764
0.0485	0.0531	0.0548	0.8283	0.6665	0.0591	0.6764
0.0495	0.0548	0.0548	0.827	0.6667	0.0595	0.6759
0.05	0.0556	0.0544	0.8267	0.6674	0.0584	0.6765
0.0497	0.0568	0.0552	0.8273	0.6673	0.0594	0.6765
0.0495	0.0556	0.0554	0.8272	0.6668	0.0588	0.6764
0.0499	0.0562	0.0558	0.8233	0.6666	0.0591	0.6758
0.0493	0.0541	0.0547	0.8273	0.667	0.0586	0.6765
0.0493	0.0524	0.0531	0.8293	0.667	0.0597	0.6764
0.0487	0.0536	0.0535	0.8278	0.6664	0.0592	0.6764
0.0503	0.0554	0.0546	0.827	0.6664	0.0588	0.6757
0.0493	0.0561	0.0542	0.8273	0.667	0.0576	0.6764
0.0492	0.0568	0.0548	0.8288	0.6671	0.0591	0.6764
0.0491	0.0562	0.0552	0.8273	0.6663	0.0588	0.6765
0.0492	0.0567	0.0559	0.8239	0.6663	0.0587	0.6756
0.0498	0.0551	0.0555	0.8269	0.6668	0.0583	0.6762
0.0496	0.0537	0.0542	0.829	0.6672	0.0589	0.6767
0.0487	0.0536	0.055	0.8278	0.6667	0.0584	0.6765
0.0503	0.0548	0.0551	0.8261	0.6664	0.0588	0.6757
0.0498	0.0555	0.0546	0.8279	0.667	0.0586	0.6763
0.05	0.0568	0.0551	0.8289	0.6671	0.059	0.6764
0.049	0.0566	0.0556	0.8284	0.6666	0.0586	0.6766
0.0498	0.0562	0.0556	0.8266	0.6661	0.0586	0.6763
0.0498	0.054	0.0544	0.8274	0.667	0.0571	0.6768
0.0495	0.0522	0.0531	0.8296	0.6672	0.0585	0.6768
0.0494	0.0535	0.0534	0.8291	0.6664	0.0586	0.677
0.0499	0.0554	0.0542	0.8272	0.6661	0.0587	0.6763
0.0495	0.0562	0.0541	0.8273	0.6671	0.0586	0.6768
0.0496	0.057	0.0551	0.8289	0.6672	0.0592	0.6769
0.0492	0.0566	0.0552	0.8308	0.6665	0.0583	0.6769
0.0501	0.0567	0.056	0.8252	0.6665	0.0588	0.6763
0.0497	0.0548	0.0553	0.827	0.6668	0.0576	0.6768
0.0494	0.0526	0.0541	0.8287	0.667	0.0592	0.6769
0.0487	0.0532	0.0548	0.8278	0.6663	0.059	0.677
0.049	0.0548	0.0549	0.8247	0.6662	0.059	0.6762
0.0499	0.056	0.0545	0.8272	0.667	0.0572	0.6765
0.0496	0.0574	0.0551	0.8285	0.6672	0.0587	0.677
0.0491	0.0556	0.0554	0.8273	0.6665	0.0587	0.6768
0.05	0.0557	0.0557	0.8249	0.6664	0.0589	0.6759
0.0498	0.0545	0.0542	0.8267	0.6673	0.0576	0.6763
0.049	0.0531	0.0525	0.8281	0.6674	0.0591	0.6764
0.0493	0.0539	0.0532	0.8271	0.6666	0.0589	0.6764
0.0498	0.0549	0.0545	0.8277	0.6667	0.0588	0.6759
0.0489	0.0552	0.0548	0.828	0.6673	0.058	0.6761
0.0489	0.0559	0.0557	0.8283	0.6675	0.0593	0.6764
0.0487	0.0557	0.0556	0.8275	0.6666	0.0591	0.6765
0.0502	0.0569	0.0561	0.8243	0.6665	0.0587	0.6759
0.0492	0.0555	0.055	0.8274	0.6672	0.0587	0.6762
0.0488	0.0543	0.0538	0.8291	0.6673	0.0597	0.6763
0.0488	0.0538	0.0546	0.8278	0.6667	0.0587	0.6765
0.0495	0.0545	0.0551	0.8247	0.6666	0.0594	0.6758
0.0495	0.0544	0.055	0.8265	0.6673	0.0583	0.6763
0.0497	0.056	0.0556	0.8284	0.6673	0.0593	0.6765
0.049	0.0563	0.0559	0.8269	0.6669	0.0586	0.6766
0.0496	0.0563	0.0554	0.8247	0.6665	0.0588	0.6757
0.0494	0.0544	0.0548	0.827	0.6673	0.0575	0.6764
0.0497	0.053	0.0533	0.8285	0.6674	0.0589	0.6764
0.0494	0.0538	0.0534	0.827	0.6666	0.0585	0.6766
0.0501	0.0549	0.0541	0.824	0.6668	0.0587	0.676
0.0488	0.055	0.0542	0.8266	0.6673	0.0585	0.6765
0.0498	0.0562	0.0549	0.8282	0.6673	0.0593	0.6766
0.0494	0.0558	0.0548	0.8264	0.6669	0.0586	0.6767
0.0502	0.0569	0.0562	0.8246	0.6665	0.0583	0.6758
0.0488	0.0552	0.055	0.8267	0.6673	0.0586	0.6763
0.0498	0.0536	0.0535	0.8281	0.6674	0.0589	0.6765
0.0496	0.0537	0.0544	0.8268	0.6667	0.0584	0.6766
0.0501	0.0545	0.0547	0.8248	0.6666	0.0593	0.676
0.0498	0.055	0.0546	0.8273	0.6673	0.0583	0.6765
0.0495	0.0563	0.0554	0.8296	0.6672	0.0594	0.6765
0.0489	0.0568	0.0561	0.828	0.6666	0.0591	0.6766
0.049	0.0563	0.0556	0.8248	0.6665	0.058	0.6766
0.0498	0.0538	0.0545	0.8272	0.6673	0.0594	0.6763
0.0494	0.0516	0.0532	0.8299	0.6673	0.059	0.6765
0.0493	0.0529	0.0534	0.8279	0.6667	0.059	0.6767
0.0503	0.0552	0.0543	0.8251	0.6675	0.0597	0.677
Max	0.0566	0.0543	0.8263	0.6661	0.0571	0.6755
min	0.0575	0.0549	0.8284	Max	min	Max
	0.0569	0.0551	0.8265		0.055	0.005
	0.0565	0.0563	0.8244			-0.003

Castillo, Abdul Ivan OTY 4332

From: Castillo, Abdul Ivan OTY 4332
Sent: Tuesday, June 10, 2025 3:05 PM
To: Ramos, Arturo OTY2 4313; Casas, Ramiro OTY 4364; Acosta, Guillermo OTY 4319; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Rincon, Diana OTY 4341; Santillan, Oscar OTY 4311; Borquez, Jorge OTY 4398; Soto, Valeria OTY 4337; Martinez, Victor OTY 4334; Tolan, Altan SOPT 6553; Guardado, Javier OTY 4310; Rivero, Jorge ELAG 4342; Rodriguez, Cesar Alberto NOG 5053; Busch, Doug SOPT 6533; Olvera, Charles ELAG 1271; Salas, Blanca LAM2 4020; Iniguez, Efrain OTY 3810
Subject: DEV25-0183 Back to back deviation Mold 76914 with several deviations for part 211297, Dimensions out of spec. Tool in poor condition
Attachments: DEV25-0183 supercede DEV24-0445 and DEV24-0376.xls

Follow Up Flag: Follow up
Flag Status: Flagged

Tracking:

Recipient	Read	Response
Ramos, Arturo OTY2 4313		Approve: 6/11/2025 7:47 AM
Casas, Ramiro OTY 4364	Read: 6/10/2025 3:11 PM	Approve: 6/10/2025 3:11 PM
Acosta, Guillermo OTY 4319		Approve: 6/13/2025 7:25 AM
Dibene, Paul OTY2 4687		24 hrs rule apply
Vela, Xavier OTY 4377	Read: 6/10/2025 3:59 PM	24 hrs rule apply
Rincon, Diana OTY 4341	Read: 6/10/2025 4:20 PM	Approve: 6/10/2025 4:20 PM
Santillan, Oscar OTY 4311		Approve: 6/11/2025 11:50 AM
Borquez, Jorge OTY 4398		24 hrs rule apply
Soto, Valeria OTY 4337		24 hrs rule apply
Martinez, Victor OTY 4334	Read: 6/13/2025 11:52 AM	Approve: 6/13/2025 11:52 AM
Tolan, Altan SOPT 6553	Read: 6/10/2025 3:09 PM	Approve: 6/10/2025 4:50 PM
Guardado, Javier OTY 4310	Read: 6/10/2025 4:48 PM	Approve: 6/10/2025 4:48 PM
Rivero, Jorge ELAG 4342	Read: 6/10/2025 3:43 PM	Approve: 6/10/2025 3:43 PM
Rodriguez, Cesar Alberto NOG 5053		Approve: 6/10/2025 3:47 PM
Busch, Doug SOPT 6533	Read: 6/10/2025 4:02 PM	Approve: 6/10/2025 4:52 PM
Olvera, Charles ELAG 1271	Read: 6/10/2025 3:06 PM	Approve: 6/10/2025 3:06 PM
Salas, Blanca LAM2 4020	Read: 6/17/2025 11:54 AM	Approve by Email
Iniguez, Efrain OTY 3810		24 hrs rule apply

Hello everyone
Review and approve the attached DEV25-0183 **Back to back**
Mold 76914 with several deviations for part 211997, Dimensions out of spec. Tool in poor condition.

Let me know if you need more information, I'll be happy to provide it.
24-hour rule is invoked for indicated approvals

Castillo, Abdul Ivan OTY 4332

From: Salas, Blanca LAM2 4020
Sent: Thursday, June 19, 2025 5:42 PM
To: Castillo, Abdul Ivan OTY 4332; Garcia, Omar SOPT 6547; Rodriguez, Cesar Alberto NOG 5053; Ramos, Arturo OTY2 4313; Casas, Ramiro OTY 4364; Acosta, Guillermo OTY 4319; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Rincon, Diana OTY 4341; Santillan, Oscar OTY 4311; Borquez, Jorge OTY 4398; Soto, Valeria OTY 4337; Martinez, Victor OTY 4334; Tolan, Altan SOPT 6553; Guardado, Javier OTY 4310; Rivero, Jorge ELAG 4342; Busch, Doug SOPT 6533; Olvera, Charles ELAG 1271; Iniguez, Efrain OTY 3810
Subject: RE: DEV25-0183 Back to back deviation Mold 76914 with several deviations for part 211297, Dimensions out of spec. Tool in poor condition

Abdul,
I have approved this deviation, however, is only approved for 3 months, please update the form.
In 3 months, I want to see the completion of the actions committed for the next 3 months.

	Pending	Built inventory to cover 20 weeks	06/30/25	08/06/25	08/06/25	OS Oscar Santillan
	Open	Create validation plan new inserts CQF1007	06/30/25	06/30/25	07/04/25	Abdul Ivan Castillo
	Pending	Run QAP1000 New cavities mold Maker	08/06/25	08/20/25	08/20/25	JR Jorge Rivero

Thanks,

Blanca Salas
Director of Quality
(619) 671-4020

From: Castillo, Abdul Ivan OTY 4332 <AbCastillo@rainbird.com>
Sent: Wednesday, June 18, 2025 1:59 PM
To: Garcia, Omar SOPT 6547 <OGarcia@rainbird.com>; Rodriguez, Cesar Alberto NOG 5053 <CeRodriguez@rainbird.com>; Salas, Blanca LAM2 4020 <bsalas@rainbird.com>; Ramos, Arturo OTY2 4313 <arramos@rainbird.com>; Casas, Ramiro OTY 4364 <rcasas@rainbird.com>; Acosta, Guillermo OTY 4319 <gacosta@rainbird.com>; Dibene, Paul OTY2 4687 <PDibene@RainBird.com>; Vela, Xavier OTY 4377 <XVela@rainbird.com>; Rincon, Diana OTY 4341 <drincon@rainbird.com>; Santillan, Oscar OTY 4311 <OSantillan@rainbird.com>; Borquez, Jorge OTY 4398 <jborquez@rainbird.com>; Soto, Valeria OTY 4337 <Vasoto@rainbird.com>; Martinez, Victor OTY 4334 <VMartinez@rainbird.com>; Tolan, Altan SOPT 6553 <atolan@rainbird.com>; Guardado, Javier OTY 4310 <Jguardado@RainBird.com>; Rivero, Jorge ELAG 4342 <JRivero@rainbird.com>; Busch, Doug SOPT 6533 <DBusch@rainbird.com>; Olvera, Charles ELAG 1271 <colvera@rainbird.com>; Iniguez, Efrain OTY 3810 <EIniguez@rainbird.com>
Subject: RE: DEV25-0183 Back to back deviation Mold 76914 with several deviations for part 211297, Dimensions out of spec. Tool in poor condition

Hi Omar

Greetings

Abdul I. Castillo
Sr. Product Engineer at Ensambles Hyson

US Phone: 619-661-4332
MX Phone: 664-973-4332