
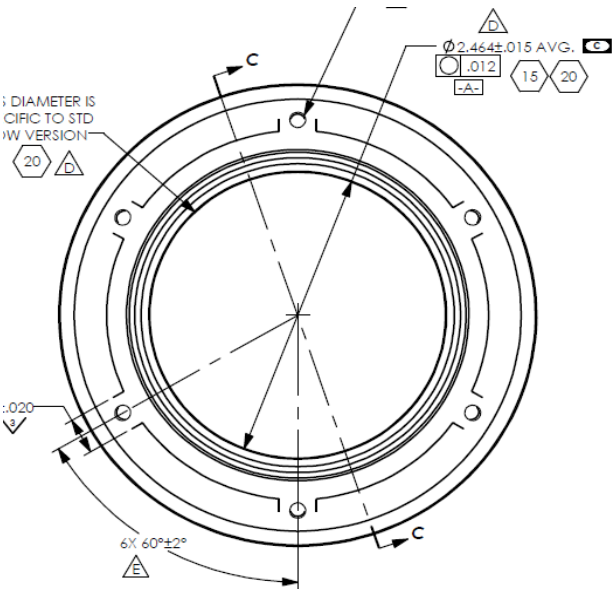


DEV NUMBER: DEV25-0192	ORIGINATOR: Abdul Castillo	DATE: 13-Jun-25	RAIN BIRD		BUSINESS UNIT (SBU and PLANT) W/ PRIMARY DESIGN CONTR		SHEET:	
			DEVIATION FORM (DRAWING)		025 OTY >>> GLF		1 OF 1	
DMR# (IF APPLICABLE):			DEVIATION NEW <input type="checkbox"/>					
			TYPE: EXTENSION <input checked="" type="checkbox"/> OF DEV#: 23-0336		FORM#233813-01 REV: T			
TOP-LEVEL SKU P/N(S) AND MODEL NUMBER(S): Golf: 900, 950, 952, 11000			EFFECTIVITY DATE: 13-Jun-25		EXPIRATION DATE: 25-Sep-25		AFFECTED MFG PLANTS (WHERE USED):	
PROJECT NAME OR NO. (OPTIONAL):					005 LAM <input type="checkbox"/> 013S STL <input type="checkbox"/> 025 OTY <input checked="" type="checkbox"/> 041 NOG <input type="checkbox"/>		008 BUY <input type="checkbox"/> 019 AZU <input type="checkbox"/> 028 TUC <input type="checkbox"/> 047 TUC <input type="checkbox"/>	
					013E EEX <input type="checkbox"/> 020MX NMD <input type="checkbox"/> 026 ELG <input checked="" type="checkbox"/> CHINA <input type="checkbox"/>			
REASON FOR DEVIATION:						APPROVALS (ALL REQUIRED):		
<p>This tool has been experiencing this flash (flake) issue since its release as a new mold. In August 2023, the NPD team released the mold and performed a deviation to accept the condition, indicating that it was a process issue. This tool was moved from KAS to El Lago (January 2025) due to a dimensional issue. The plan is to validate the mold and understand the root cause of the problems in order to resolve them. During these months, testing and validation were performed, and the flash (flake) was presented to us again. Due to low inventory, it has not been possible to evaluate and/or repair any possible damage at some injection points. The NPD team never mentioned the previous deviation or defined any action to repair the mold. To eliminate the defect, we will follow the following plan:</p> <p>RISK ASSESSMENT/ CORRECTIVE ACTION PLAN (NAMES & DATES)/ COMMITMENT:</p> <p>Samples of the impacted areas were obtained and examined. Though they don't pose a functional threat, the small flakes should be investigated because they could be gradually harming the tool. insert. Deviation is to be issued to allow use of the part as tool is evaluated and determination made whether the tool should be adjusted or process improved to avoid this.</p> <p>1.- Run 20 weeks of coverage (155,600 pcs) 1 month Oscar Santillan 2.- Take mold out for reverse Eng and reapi. . 2 months Jorge Rivero 3.- Run QAP1001. send samples to evaluation. 1 month Jorge Rivero 4.-Evaluate parts 3 weeks Abdul Castillo</p>						QUALITY MGR. OR QUALITY ENG. A.Ramos/ R. Casas/ O. Curiel / M.Beltran		
						MANUFACTURING ENGINEER G. Acosta /J. Sandoval		
						PROD. ENG. MGR. OR PLANT ENG. MGR Paul Dibene / Xavier Vela/ D. Ramirez		
						BUYER OR BUYER/PLANNER Diana Rincon /Belem Carrillo		
DRAWING NUMBER: DRAWING REVISION: DEVIATION REVISION: DRAWING TITLE/ PART DESCRIPTION: VENDOR:						PLANT MANAGER		
215014 E E3 Bearing guide ELAG						J. Borquez/ V. Soto/ V. Martinez/ S.Sanchez		
215015 C C2 Bearing guide Low flow ELAG						SBU PRODUCT MGR. OR SBU ENG. MGR		
						Altan Tolan / Javier Guardado		
						TOOLING ENGINEER (MOLDED PARTS ONLY)		
						Jorge Rivero / Cesar Rodriguez		
						OTHER:		
						D. Bush / E. Iniguez/ C. Olvera		
DESCRIPTION OF DEVIATION (IS/WAS CONDITION AND DRAWING ZONE FOR EACH PART NO. OR ATTACH REDLINE PRINTS):						QUALITY DIRECTOR (REQUIRED FOR BACK-TO-BACK DEVIATIONS)		
IS						Blanca Salas		
WAS								
<div>15. FLASH PERMITTED IN THIS AREA .015 HIGH X .010 THK. NON CONTINUOUS FLAKES OF FLASH MAX .125 X .125 X .010 ARE PERMITTED.</div>								
								
								

Castillo, Abdul Ivan OTY 4332

From: Castillo, Abdul Ivan OTY 4332
Sent: Thursday, June 12, 2025 4:42 PM
To: Ramos, Arturo OTY2 4313; Casas, Ramiro OTY 4364; Curiel, Omar ELAG 1284; Beltran, Martin LAG 1229; Acosta, Guillermo OTY 4319; Sandoval, Jorge ELAG 1298; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Ramirez, Delfino ELAG 1202; Rincon, Diana OTY 4341; Carrillo, Belem OTY 4376; Borquez, Jorge OTY 4398; Soto, Valeria OTY 4337; Martinez, Victor OTY 4334; Sanchez, Sara ELAG 1295; Tolan, Altan SOPT 6553; Guardado, Javier OTY 4310; Rivero, Jorge ELAG 4342; Rodriguez, Cesar Alberto NOG 5053; Busch, Doug SOPT 6533; Iniguez, Efrain OTY 3810; Olvera, Charles ELAG 1271; Salas, Blanca LAM2 4020
Subject: DEV25-0192 back to back of DEV23-0336 Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot
Attachments: DEV25-0192 Bearing Guide and Bearing guide low flow.xls

Importance: High

Follow Up Flag: Follow up
Flag Status: Flagged

Tracking:	Recipient	Read	Response
	Ramos, Arturo OTY2 4313		24 hrs rule apply
	Casas, Ramiro OTY 4364		24 hrs rule apply
	Curiel, Omar ELAG 1284		24 hrs rule apply
	Beltran, Martin LAG 1229		24 hrs rule apply
	Acosta, Guillermo OTY 4319		Approve: 6/12/2025 4:45 PM
	Sandoval, Jorge ELAG 1298	Read: 6/12/2025 4:56 PM	24 hrs rule apply
	Dibene, Paul OTY2 4687		24 hrs rule apply
	Vela, Xavier OTY 4377	Read: 6/12/2025 5:13 PM	Approve: 6/13/2025 7:29 AM
	Ramirez, Delfino ELAG 1202	Read: 6/12/2025 4:43 PM	Approve: 6/12/2025 4:43 PM
	Rincon, Diana OTY 4341		24 hrs rule apply
	Carrillo, Belem OTY 4376	Read: 6/13/2025 7:45 AM	24 hrs rule apply
	Borquez, Jorge OTY 4398		24 hrs rule apply
	Soto, Valeria OTY 4337		24 hrs rule apply
	Martinez, Victor OTY 4334	Read: 6/12/2025 7:00 PM	24 hrs rule apply
	Sanchez, Sara ELAG 1295		24 hrs rule apply
	Tolan, Altan SOPT 6553		Approve: 6/13/2025 8:19 AM
	Guardado, Javier OTY 4310	Read: 6/13/2025 8:10 AM	Approve: 6/13/2025 8:16 AM
	Rivero, Jorge ELAG 4342	Read: 6/13/2025 7:44 AM	Approve: 6/13/2025 7:44 AM
	Rodriguez, Cesar Alberto NOG 5053		24 hrs rule apply
	Busch, Doug SOPT 6533	Read: 6/16/2025 9:00 AM	Approve: 6/16/2025 9:17 AM
	Iniguez, Efrain OTY 3810		24 hrs rule apply
	Olvera, Charles ELAG 1271	Read: 6/12/2025 4:42 PM	24 hrs rule apply
	Salas, Blanca LAM2 4020	Read: 6/17/2025 11:53 AM	Reject: 6/18/2025 10:56 AM

Approve by Email

Hello everyone

Review and approve the attached DEV25-0193 back to back of DEV23-0336

Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot (pictured)

Mold was moved to EL Lago, process improvement was done in order to solve previous issue of roundness at KAS Engineering.

Let me know if you need more information, I'll be happy to provide it.

24-hour rule is invoked for indicated approvals

Greetings

Abdul I. Castillo

Sr. Product Engineer at Ensamblados Hyson

US Phone: 619-661-4332

MX Phone: 664-973-4332

Castillo, Abdul Ivan OTY 4332

From: Salas, Blanca LAM2 4020
Sent: Friday, June 20, 2025 5:13 PM
To: Castillo, Abdul Ivan OTY 4332; Ramos, Arturo OTY2 4313; Casas, Ramiro OTY 4364; Curiel, Omar ELAG 1284; Beltran, Martin LAG 1229; Acosta, Guillermo OTY 4319; Sandoval, Jorge ELAG 1298; Dibene, Paul OTY2 4687; Vela, Xavier OTY 4377; Ramirez, Delfino ELAG 1202; Rincon, Diana OTY 4341; Carrillo, Belem OTY 4376; Borquez, Jorge OTY 4398; Soto, Valeria OTY 4337; Martinez, Victor OTY 4334; Sanchez, Sara ELAG 1295; Tolan, Altan SOPT 6553; Guardado, Javier OTY 4310; Rivero, Jorge ELAG 4342; Rodriguez, Cesar Alberto NOG 5053; Busch, Doug SOPT 6533; Iniguez, Efrain OTY 3810; Olvera, Charles ELAG 1271
Subject: RE: DEV25-0192 back to back of DEV23-0336 Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot

Hi Abdul.

I approve this deviation for 3 months. Let's review the progress of the actions at that time.

Thanks,

Blanca Salas

Director of Quality
(619) 671-4020

From: Castillo, Abdul Ivan OTY 4332 <AbCastillo@rainbird.com>
Sent: Wednesday, June 18, 2025 1:09 PM
To: Salas, Blanca LAM2 4020 <bsalas@rainbird.com>; Ramos, Arturo OTY2 4313 <arramos@rainbird.com>; Casas, Ramiro OTY 4364 <rcasas@rainbird.com>; Curiel, Omar ELAG 1284 <Ocuriel@rainbird.com>; Beltran, Martin LAG 1229 <jubeltran@rainbird.com>; Acosta, Guillermo OTY 4319 <gacosta@rainbird.com>; Sandoval, Jorge ELAG 1298 <jsandoval@rainbird.com>; Dibene, Paul OTY2 4687 <PDibene@RainBird.com>; Vela, Xavier OTY 4377 <XVela@rainbird.com>; Ramirez, Delfino ELAG 1202 <DRamirez@rainbird.com>; Rincon, Diana OTY 4341 <drincon@rainbird.com>; Carrillo, Belem OTY 4376 <becarrillo@rainbird.com>; Borquez, Jorge OTY 4398 <jborquez@rainbird.com>; Soto, Valeria OTY 4337 <Vasoto@rainbird.com>; Martinez, Victor OTY 4334 <VMartinez@rainbird.com>; Sanchez, Sara ELAG 1295 <Sasanchez@rainbird.com>; Tolan, Altan SOPT 6553 <atolan@rainbird.com>; Guardado, Javier OTY 4310 <Jguardado@RainBird.com>; Rivero, Jorge ELAG 4342 <JRivero@rainbird.com>; Rodriguez, Cesar Alberto NOG 5053 <CeRodriguez@rainbird.com>; Busch, Doug SOPT 6533 <DBusch@rainbird.com>; Iniguez, Efrain OTY 3810 <Elniguez@rainbird.com>; Olvera, Charles ELAG 1271 <colvera@rainbird.com>
Subject: RE: DEV25-0192 back to back of DEV23-0336 Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot

Hi Blanca

Below you can find a better explanation

This tool has been experiencing this flash (flake) issue since its release as a new mold. In August 2023, the NPD team released the mold and performed a deviation to accept the condition, indicating that it was a process issue. This tool was moved from KAS to El Lago (January 2025) due to a dimensional issue. The plan is to validate the

mold and understand the root cause of the problems to resolve them. During these months, testing and validation were performed, and the flash (flake) was presented to us again. Due to low inventory, it has not been possible to evaluate and/or repair any possible damage at some injection points. The NPD team never mentioned the previous deviation or defined any action to repair the mold. To eliminate the defect, we will follow the following plan:

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insert. Deviation is to be issued to allow use of the part as tool is evaluated and determination made whether the tool should be adjusted, or process improved to avoid this.

- 1.- Run 20 weeks of coverage (155,600 pcs) 1 month Oscar Santillan
- 2.- Take mold out for reverse Eng and reapiir , 2 months Jorge Rivero
- 3.- Run QAP1001. send samples to evaluation. 1 month Jorge Rivero
- 4.-Evaluate parts 3 weeks Abdul Castillo

Abdul I. Castillo

Sr. Product Engineer at Ensambls Hyson

US Phone: 619-661-4332

MX Phone: 664-973-4332

From: Salas, Blanca LAM2 4020 <bsalas@rainbird.com>



Sent: Wednesday, June 18, 2025 10:52 AM

To: Castillo, Abdul Ivan OTY 4332 <AbCastillo@rainbird.com>; Ramos, Arturo OTY2 4313 <arramos@rainbird.com>; Casas, Ramiro OTY 4364 <rcasas@rainbird.com>; Curiel, Omar ELAG 1284 <Ocuriel@rainbird.com>; Beltran, Martin LAG 1229 <jubeltran@rainbird.com>; Acosta, Guillermo OTY 4319 <gacosta@rainbird.com>; Sandoval, Jorge ELAG 1298 <jsandoval@rainbird.com>; Dibene, Paul OTY2 4687 <PDibene@RainBird.com>; Vela, Xavier OTY 4377 <XVela@rainbird.com>; Ramirez, Delfino ELAG 1202 <DRamirez@rainbird.com>; Rincon, Diana OTY 4341 <drincon@rainbird.com>; Carrillo, Belem OTY 4376 <becarrillo@rainbird.com>; Borquez, Jorge OTY 4398 <jborquez@rainbird.com>; Soto, Valeria OTY 4337 <Vasoto@rainbird.com>; Martinez, Victor OTY 4334 <VMartinez@rainbird.com>; Sanchez, Sara ELAG 1295 <Sasanchez@rainbird.com>; Tolan, Altan SOPT 6553 <atolan@rainbird.com>; Guardado, Javier OTY 4310 <Jguardado@RainBird.com>; Rivero, Jorge ELAG 4342 <JRivero@rainbird.com>; Rodriguez, Cesar Alberto NOG 5053 <CeRodriguez@rainbird.com>; Busch, Doug SOPT 6533 <DBusch@rainbird.com>; Iniguez, Efrain OTY 3810 <Elniguez@rainbird.com>; Olvera, Charles ELAG 1271 <colvera@rainbird.com>

Subject: RE: DEV25-0192 back to back of DEV23-0336 Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot

Buen dia,

Duda, porque no se hizo el trabajo que se tenía que hacer con el molde desde enero que se venció la desviación?

DEV NUMBER: DEV23-0336	ORIGINATOR: Mateusz Kruzel	DATE: 16-Oct-23	RAIN BIRD		BUSINESS UNIT (SBU and PLAN) 025 OTY
DMR# (IF APPLICABLE):			DEVIATION NEW <input checked="" type="checkbox"/> TYPE: EXTENSION <input type="checkbox"/> OF DEV#:		AFFECTED MFG PLANTS (WHEEL)
TOP-LEVEL SKU P/N(S) AND MODEL NUMBER(S): 900, 950, 952, 11000			EFFECTIVITY DATE: 16-Oct-23	EXPIRATION DATE: 26-Jan-24	005 LAM <input type="checkbox"/> 013S STL 008 BUY <input type="checkbox"/> 019 AZU 013E EEX <input type="checkbox"/> 020MX NMD
PROJECT NAME OR NO. (OPTIONAL): 6311					
REASON FOR DEVIATION: Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot (pictured)					
RISK ASSESSMENT/ CORRECTIVE ACTION PLAN (NAMES & DATES)/ COMMITMENT: Samples of the affected parts were received and reviewed. Small flakes noted are not posing functional threat but should be checked into since this could be progressively damaging the insert. Deviation is to be issued to allow use of the part as tool is evaluated and determination made whether the tool should be adjusted or process improved to avoid this.					
DRAWING NUMBER:	DRAWING REVISION:	DEVIATION REVISION:	DRAWING TITLE/ PART DESCRIPTION:		VENDOR
215014	E	E2	Bearing guide		KAS
215015	C	C1	Bearing guide low flow		KAS
DESCRIPTION OF DEVIATION (IS/WAS CONDITION AND DRAWING ZONE FOR EACH PART NO. OR ATTACH REDLINE PRINTS):					
IS:  FLASH PERMITTED IN THIS AREA .015 HIGH X .010 THK. NON CONTINUOUS FLAKES OF FLASH MAX .125 X .125 X .010 ARE PERMITTED. WAS:  FLASH PERMITTED IN THIS AREA .015 HIGH X .010 THK.					

Regards,

Blanca Salas

Director of Quality
(619) 671-4020

From: Castillo, Abdul Ivan OTY 4332 <AbCastillo@rainbird.com>

Sent: Thursday, June 12, 2025 4:42 PM

To: Ramos, Arturo OTY2 4313 <arramos@rainbird.com>; Casas, Ramiro OTY 4364 <rcasas@rainbird.com>; Curiel, Omar ELAG 1284 <Ocuriel@rainbird.com>; Beltran, Martin LAG 1229 <jubeltran@rainbird.com>; Acosta, Guillermo OTY 4319 <gacosta@rainbird.com>; Sandoval, Jorge ELAG 1298 <jsandoval@rainbird.com>; Dibene, Paul OTY2 4687 <PDibene@RainBird.com>; Vela, Xavier OTY 4377 <XVela@rainbird.com>; Ramirez, Delfino ELAG 1202 <DRamirez@rainbird.com>; Rincon, Diana OTY 4341 <drincon@rainbird.com>; Carrillo, Belem OTY 4376 <becarrillo@rainbird.com>; Borquez, Jorge OTY 4398 <jborquez@rainbird.com>; Soto, Valeria OTY 4337 <Vasoto@rainbird.com>; Martinez, Victor OTY 4334 <VMartinez@rainbird.com>; Sanchez, Sara ELAG 1295 <Sasanchez@rainbird.com>; Tolan, Altan SOPT 6553 <atolan@rainbird.com>; Guardado, Javier OTY 4310 <Jguardado@RainBird.com>; Rivero, Jorge ELAG 4342 <JRivero@rainbird.com>; Rodriguez, Cesar Alberto NOG 5053 <CeRodriguez@rainbird.com>; Busch, Doug SOPT 6533 <DBusch@rainbird.com>; Iniguez, Efrain OTY 3810 <Einiguez@rainbird.com>; Olvera, Charles ELAG 1271 <colvera@rainbird.com>; Salas, Blanca LAM2 4020 <bsalas@rainbird.com>

Subject: DEV25-0192 back to back of DEV23-0336 Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot

Importance: High

Hello everyone

Review and approve the attached DEV25-0193 back to back of DEV23-0336

Molder reported flash occurring due to gate vestige getting trapped in the tool and attached to the next shot (pictured)

Mold was moved to EL Lago, process improvement was done in order to solve previous issue of roundness at KAS Engineering.

Let me know if you need more information, I'll be happy to provide it.

24-hour rule is invoked for indicated approvals

Greetings

Abdul I. Castillo

Sr. Product Engineer at Ensamblados Hyson

US Phone: 619-661-4332

MX Phone: 664-973-4332