

5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	Did not used proper blade.
MATERIAL	NO CHANGES
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

I. INVESTIGATION / ANALYSIS									
DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)					INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)				
System / Training	Why 1:				Why 1:				
	Why 2:				Why 2:				
	Why 3:				Why 3:				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Design / Toolings	Why 1:				Why 1:				
	Why 2:				Why 2:				
	Why 3:				Why 3:				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Process / Material	Why 1: Proper blade was not used during running >Cutting knife of blade used were intentionally removed, it was originally for auto stripping process to fit for manual stripping process. It was also on monitoring category of Tooling Custodian (290,000+ punches already) with wave issue.				Why 1: Operator didn't follow Tooling Custodian instruction/recommendation to not used the blade.				
	Why 2: Changed stripping process due to problems encountered to not further cause damaged and downtime .				Why 2: Why 3:				
FINAL CONCLUSION									
OCCURRENCE ROOTCAUSE					OUTFLOW ROOTCAUSE				
No proper orientation/ training for newly assigned operator for the certain position.									
IMMEDIATE ACTION: (Action to be done to contain/ temporary correct the problem found)					CORRECTIVE ACTION: (Actions to be done to ensure that the problem will not happen again)				
A. Sorting Result					Actions to be done to eliminate recurrence				Who / When
	Location	Total Stock	NG	Total Good	System				
RM									
WIP									
FG									
B. Orientation					Design / Tools				
Date	April 11, 2022	Time							
Title	Orientation for Authorization power and procedures involved toolings.								
Attendees	Prod IE, Process, concerned operator								
C. Reworking					Process	Issuance of NTE to concerned personnel. Orientation.			Leader Prod IE
Rework Quantity									
Total Good									
Rework Percentage (Good)									
					Date Conducted: _____ PIC: _____				