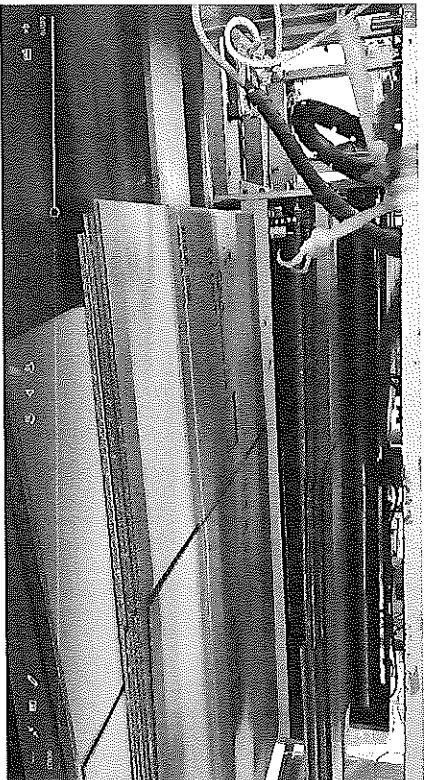


## 5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	Problem in conveyor's timing
METHOD	NO CHANGES
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:	Damaged occurred due to direct contact of boards in the metal in conveyor.		Why 1:		
	Why 2:	Direct contact was because of disarranged pile of boards from conveyor during gluing process. Previous boards bump with coming boards from conveyor causing some parts of boards bump in the metal, thus the damaged. Factor added was the height of the item (811 mm) (see attached files for reference)		Why 2:		
	Why 3:	Disarrangement of piling was because of the timing of the outs of boards from the conveyor.		Why 3:		
	Why 4:	Conveyor's timing has a problem.		Why 4:		
	Why 5:			Why 5:		
Process / Material	Why 1:			Why 2: Late trapping due to overlooking of catcher because of focusing in other item.		
	Why 2:					
	Why 3:					
	Why 4:					
	Why 5:					
FINAL CONCLUSION						
OCCURRENCE ROOTCAUSE				OUTFLOW ROOTCAUSE		
Direct bumping of boards in the metal due to disarrangement of piling from the conveyor.						
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	For checking of engineering No target date yet.	Engineering
Date	04/19/2022	Time				
Title	Reorientation of standard process; counter measures					
Attendees	Concerned operators, Process, Prod IE					
C. Reworking				Process		
Rework Quantity						
Total Good						
Rework Percentage (Good)						
				Date Conducted: _____ PIC: _____		



*Actual disarranged piles of boards OCB item*



VID\_20220418\_084222.mp4



VID\_20220418\_084329.mp4

*Video attachment*

