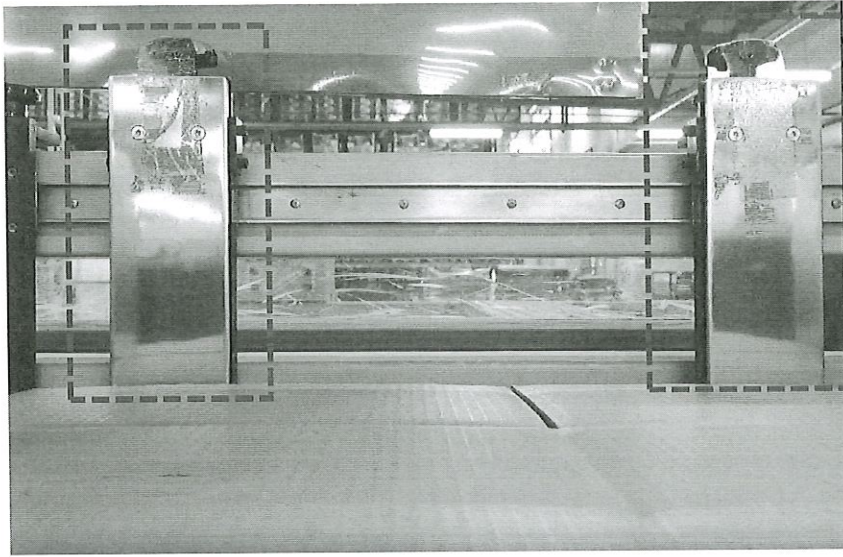


5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	Movement from sheet stopper due to loosed thread
METHOD	NO CHANGES
MATERIAL	NO CHANGES
MEASUREMENT	NO CHANGES
ENVIRONMENT	NO CHANGES

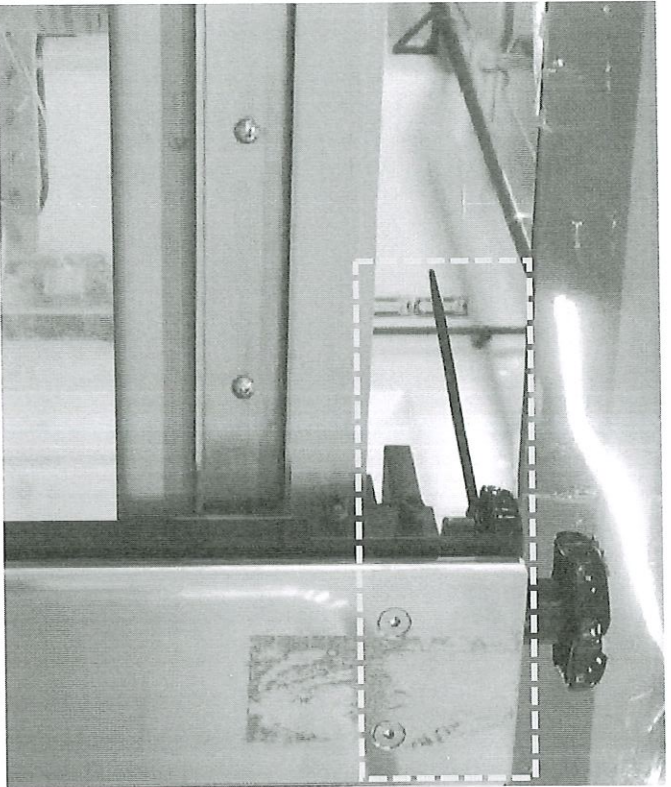
I. INVESTIGATION / ANALYSIS									
DIRECT CAUSE: (Analyze the reason of occurrence, why it happened?)					INDIRECT CAUSE: (Analyze the reason of occurrence, why it leaked?)				
System / Training	Why 1:				Why 1:				
	Why 2:				Why 2:				
	Why 3: N/A				Why 3: N/A				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Design / Toolings	Why 1: Scratches occurred due to direct contact of panels with the sheet stopper of the machine. Defect were only visible on the blue part of the item. Factor added, blue part of panel are feeded first.				Why 1:				
	Why 2: Sheet stopper has movement (downward) during running				Why 2: N/A				
	Why 3: Movement were due to the loose thread of the stopper.				Why 3:				
	Why 4:				Why 4:				
	Why 5:				Why 5:				
Process / Material	Why 1: N/A				Why 1: Late trapping due to overlooking. Increased number of defect were due to trial of corrective action done during occurrence.				
	Why 2:				Why 2:				
					Why 3:				
FINAL CONCLUSION									
OCCURRENCE ROOTCAUSE					OUTFLOW ROOTCAUSE				
Contact between panels and sheet stopper due to loose thread.					Late trapping due to overlooking.				
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	N/A			
RM	N/A								
WIP	N/A								
FG	N/A								
B. Orientation					Design / Tools	Already coordinated to engineering for checking. Target Date: April 8, 2022			Engineering
Date	April 11, 2022	Time							
Title	Morning meeting (Reminder of proper inspection in each position)								
Attendees	All staff and operators								
C. Reworking					Process	Operator positioned both stopper on the other side (with white design) to remove scratches and perform trial to prevent misalignment.			
Rework Quantity		N/A							
Total Good		N/A							
Rework Percentage (Good)		N/A							
					Date Conducted: _____ PIC: _____				



Actual stopper with tape to temporarily controll movement

QUANTITY	PER INVOICE	QTY.

IRF- 04-0004 SCRATCHES



Lock temporarily by cable tie to avoid movement.
STATUS: Tentative date for cheAPRIL 27 or 28, no running