5M + 1 REVIEW

FACTORS	DETAILS
MAN	no changes
MACHINE	Unbalanced blade
METHOD	no changes
MATERIAL	NO CHANGES
MEASUREMENT	no changes
ENVIRONMENT	NO CHANGES

					LU	NVESTIGATIO	N / ANALYSIS		
	DIRECT	CAUSE: (Analy	ze the reason	of occurrence,	why it happen	ed?)	INDIRE	CT CAUSE: (Analyze the reason of occurrence, why it leak	ed?)
	Why 1:					· ·	Vhy 1:		
System / Training	Why 2:					\	Why 2:		
L/me	Why 3:					,	Why 3:		
Syst	Why 4:					ľ	Why 4:		
	Why 5:						Why 5:		
	Why 1:					Y	Why 1:		
s									
ooling	Why 2:					1	Why 2:		
Design / Toolings	Why 3:					ľ	Why 3:		
Desig									
	Why 4:						Why 4:		
	Why 5:						Why 5:		
3	Why 1:	Damaged occ edge part of b	ured during	manual detac	ching process I and include		Why 1:		
		detaching inste	ead of scrap	part.					
		This is due to di	ifficulty in del	tachina scrap	due to uncu		Why 2:		
<u>a</u>		parts from die		0 1					
Process / Material									
l/sse		Uncut parts fro unbalanced b		ocess was be	cause of	21			
Proc									
	Why 4:								
	Why 5:						Why 3:		
						FINAL CON	ICLUSION	QUITE OWN DOCTO MUST	
		OC	CURRENCE	ROOTCAUSE				OUTFLOW ROOTCAUSE	
							ye.		
	itticulty in	detaching du	ie to uncut p	arts because	of Unbalance	ea blade			
	IMMEDIA	ATE ACTION: (Act	tion to be done to	contain/ temporary	correct the proble	em found)	CORRECT	TIVE ACTION: (Actions to be done to ensure that the problem will not hap	open again)
A Sor	ting Resu		aon to bo dono to	Contains tomporary				Actions to be done to eliminate recurrence	Who / When
7 11 001	anig (toos	Locat	ion	Total Stock	NG	Total Good			
RM		Loodi						*	
WIP							System		
FG									
	entation								
Date		4/21/22		Time		9:00 am		Put patching tape on parts with uncut in blade.	
Title		Orientation of ro	ootcause and		res		Design /		
							Tools		
Atte	ndees	Concerned ope	rators, Proces	ss, Prod IE					
C. Re	working							>Manual Detaching operator must inform die	s.
Rew	ork Quan	ity					3	cut regarding uncut parts. >Die cut operator must adjust setting. >In case item was run already must include to	
Total	Good						Process	endorsement log book for check point on next process.	Prod IE, process
								(See attached orientation MOM)	
Rew	ork Perce	ntage (Good)							
							Date Conduct	ed: PIC:	

DORE ALLE TO SET STATE OF THE PROPERTY OF THE	11/22 Tune 2:40 pm Finish Dept. 5-07	MINUTES OF THE MEETING
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OLLOW UP MEETING.	for check point so next	
OLLOW UP MEETING.		
cate & time;	OLI OW 119 MEPTING	
Control of London	date & time)	
or KPM I fill up only	or KPPI fill up anky	

Minutes of meeting of orientation/ meeting



Actual orientation