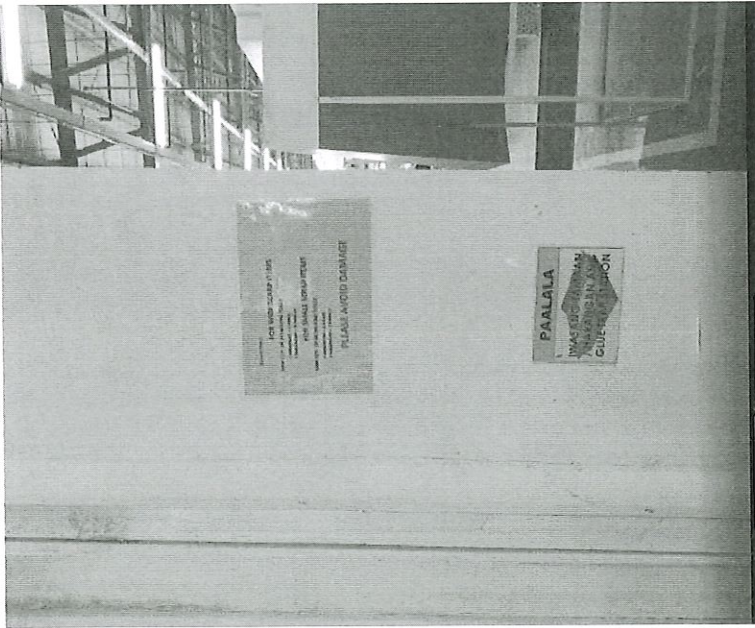


5M + 1 REVIEW

FACTORS	DETAILS
MAN	NO CHANGES
MACHINE	NO CHANGES
METHOD	No standard quantity for gripping
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: Damaged occurred during manual detaching process, edge part of board/ panel was affected and included in detaching instead of scrap part.				Why 1:				
	Why 2: Edge part of panels were included because of multiple panels were grip and detach at the same time, alignment of panels made it also difficult >Panels were not aligned due to the palletizing process from Die cut, proper alignment can't be secured even with the help of palletizing guide.				Why 2:				
	Why 3: No standard gripping quantity in Deatching.				Why 3:				
	Why 4:								
	Why 5:								
FINAL CONCLUSION									
OCCURRENCE ROOTCAUSE					OUTFLOW ROOTCAUSE				
Affected by gripping/detaching multiple panels at once.									
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		Time	9:00 am						
Title									
Attendees									
C. Reworking					Process	Reminder signage was post on working area. See attached picture. Work instruction instruction for manual detaching process is under review. Target date: 4/26/22			Prod IE, process
Rework Quantity									
Total Good									
Rework Percentage (Good)									
					Date Conducted: _____ PIC: _____				



Actual photo of posted signage/reminder

