

3.3.1. DIRECT CAUSE					
PROBLEM:	WHY 1	WHY 2	WHY 3	WHY 4	
Wide Gap occurred at the upper flap of the glue tab portion.	> Wide Gap occur at first gluing at semi-auto gluing machine 3 (with hot melt).	> Operator set the first gluing with 10mm gap and the standard set-up is 8mm $\pm$ 2mm.	> During set-up they use the tolerance with 2mm cause of the machine movement and sometime the item are warp.	> Operator failed to check the Gap and not meet the standard procedure on their check point.	

3.3.2. INDIRECT CAUSE					
PROBLEM:	WHY 1	WHY 2	WHY 3	WHY 4	
	> During trial, they get the standard length and proceed to mass production but failed on conducting 5minutes checking after the curing time of the item.				

WHY 5

WHY 5