WHY-WHY ANALYSIS

Root cause for occurrence and for escape (non-detection)

Analysis no.	Date opened	Source	Part and operation
What	Where found	When	How many
Team leader	Team	Containment	Target closure

4M check: what changed?	Measurement and environment
Man	Gauge
Machine	Frequency
Material	Environment
Method	Verified by

Why did it occur?

Why	Question	Answer (fact, not opinion)	Evidence	Verified

Why was it not detected (escape)?

Why	Question	Answer (fact, not opinion)	Evidence	Verified

Why	Question	Answer (fact, not opinion)	Evidence	Verified
Root cause				

Actions

Sr.	Action	Type	Owner	Target	Status and proof

Effectiveness check (three batches after the action)

Pieces checked after the action	
Pieces found oversize	
Rejection, PPM	

Prepared by (team leader)

Production head

QA head