 **Problem Solving Fish Bone Diagram (6Ms 1E)**

Morale 5WHYS?

\*QCD  
Q = Quality  
C = Cost  
D = Delivery

***INSERT QCD\* Defect  
 or   
Issue***

**Measurement**

**Machines**

**Material**

5S 5WHYS?

5S 5WHYS?

Maintenance 5WHYS?

Calibration 5WHYS?

Amount 5WHYS?

Wrong 5WHYS?

Missing 5WHYS?

**Method**

**Environment**

Maintained

Standards   
5WHYS?

Safety 5WHYS?

Improvement 5WHYS?

QA Inspection 5WHYS?

Don’t use checklist 5WHYS?

Calibration 5WHYS? 55WHYS?

Visual

Management 5WHYS?

Assessment  
5WHYS?

Tools 5WHYS?

Hot 5WHYS?

Cold 5WHYS?

Restricted 5WHYS?

Safety 5WHYS?

**Manpower**

Defective 5WHYS?

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Health 5WHYS?

Suggestions 5WHYS?

Training 5WHYS?

Skills 5WHYS?

Communication 5WHYS?

Not enough

5WHYS?

Too much

5WHYS?

**Money**