5 WHYS WORKSHEET · CONCLUSION

AREA	DATE	METHOD	SHEET
TEAM	VALIDATED	FOLLOWS	STATUS

1 PROBLEM

WHAT	WHERE	WHEN	IMPACT	STANDARD VS ACTUAL



2 WHY CHAIN

#	WHY?	BECAUSE… (A CAUSE, NOT A SYMPTOM)	EVIDENCE · WHO · WHEN	✓
1	Why did it miss the cutoff?			☐
2	Why still in pack at 16:12?			☐
3	Why did Team B go first?			☐
4	Why no agreed priority?			☐
5	Why never written down?			☐

3 SKETCH · WHERE THE EVIDENCE IS

4 ROOT CAUSE · 6M CATEGORY

☐ Method ☐ People ☐ Machine
☐ Material ☐ Measurement ☐ Environment

5 COUNTERMEASURES

ACTION (TIED TO THE ROOT)	OWNER	DUE	STATUS

6 EFFECTIVENESS & RED FLAGS

Measure: _____

Target: _____ · Recheck: _____

- Blame is not a root cause
- No new printer yet (Tool 08)