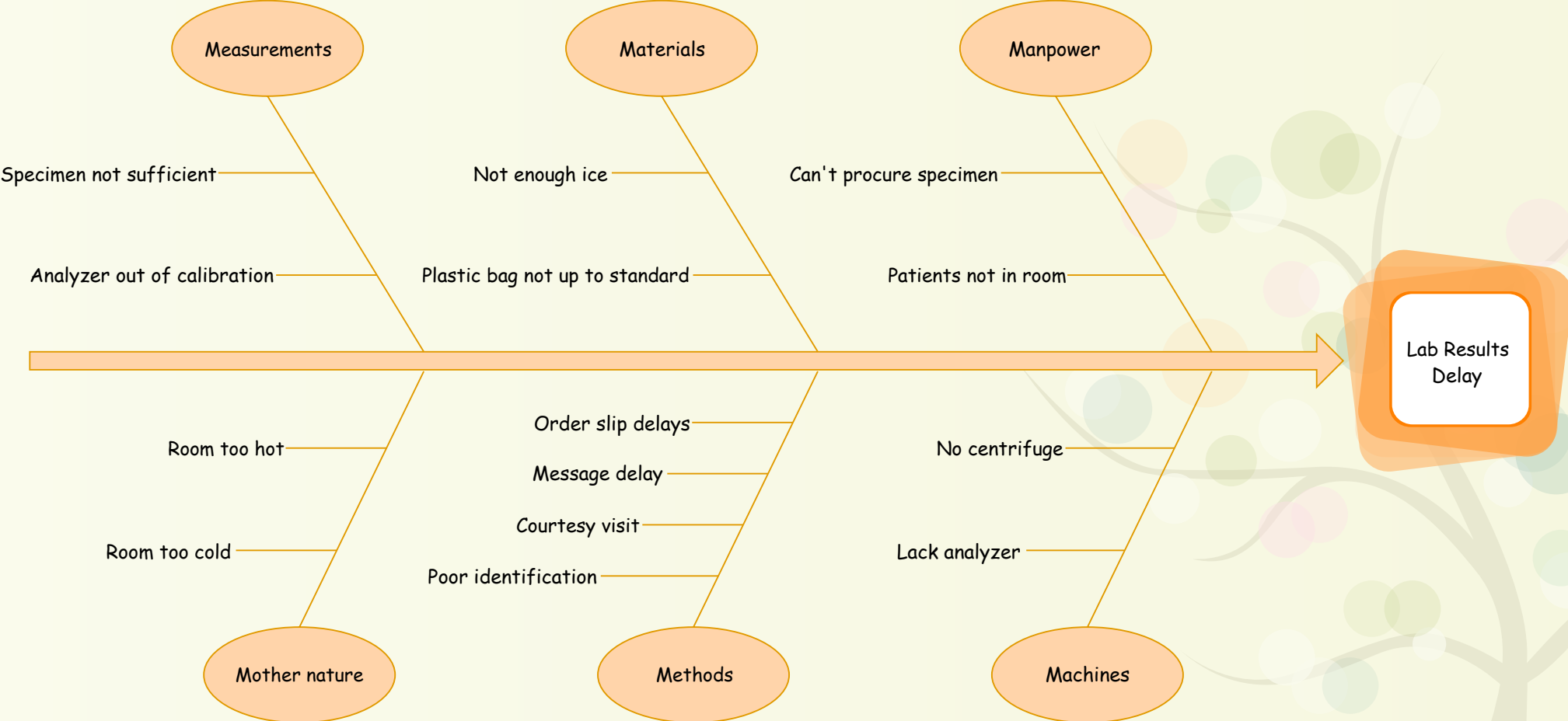


Fishbone Diagram (Cause and Effect Diagram)



Note: The 6M method is applied in this analysis, categorizing the reasons into Manpower, Materials, Measurements, Mother nature, Methods and Machines.