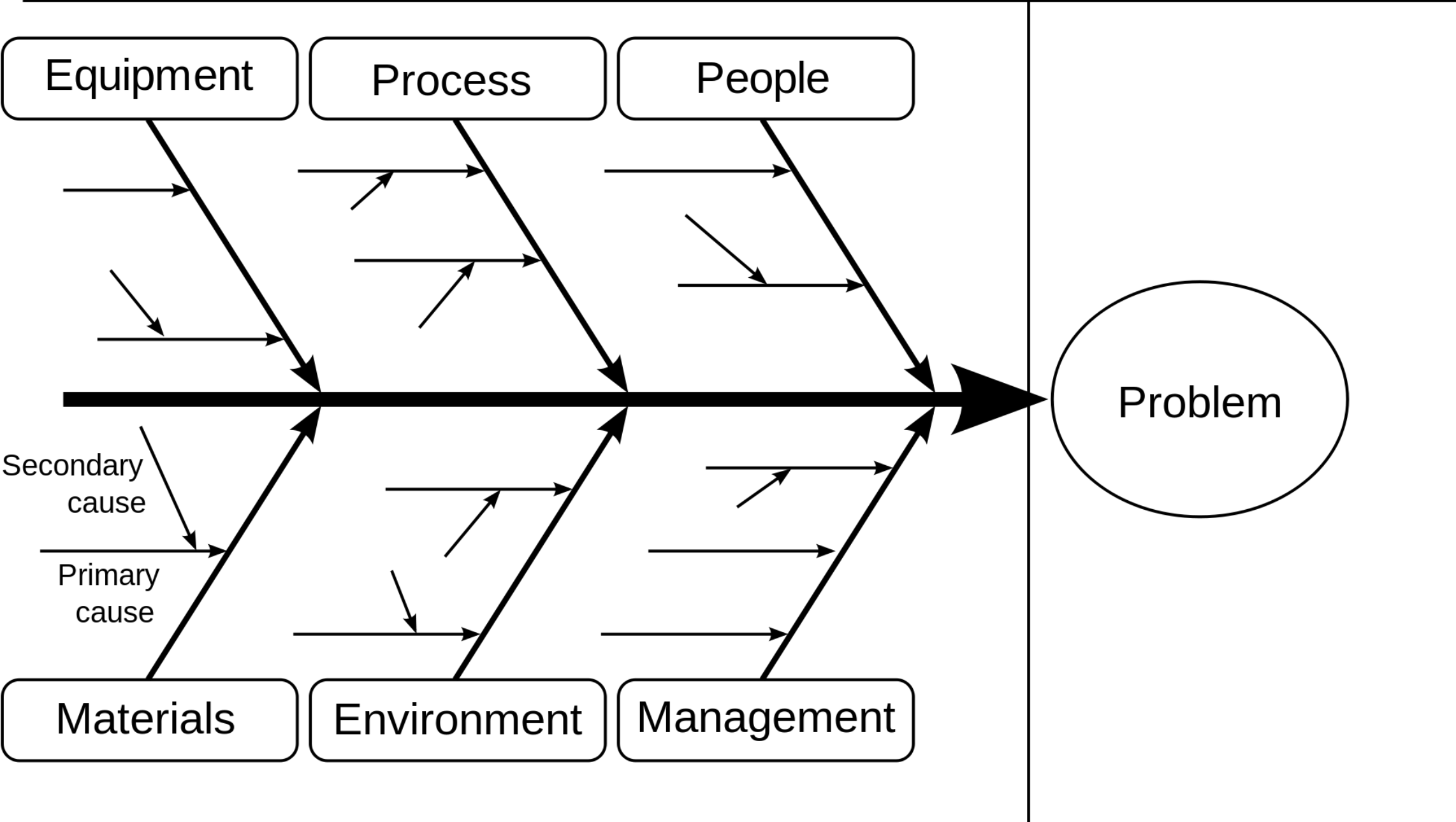


Cause

Effect



Equipment

Process

People

Secondary cause

Primary cause

Materials

Environment

Management

Problem