Cause 1: Less Education
Cause 2: Bad material quality
Cause 3: minim internal communication

Problem:
Late production by operators

Effect 1: Work overtime
Effect 2: High cost shipment
Effect 3: Bad quality of product

Potential negative effects:
1. Company paying extra money to make training.
2. Not every workers give good result and feedback.

Potential positive effects:
1. affect organization’s culture
2. increase worker’s performance and responsibility

Potential negative effects:
1. need more time to follow up

Potential positive effects:
1. Traceable
2. Production can run more smoothly

Potential negative effects:
1. Need extra time to trance and repeat the meeting point to someone not come into the meeting

Potential positive effects:
1. Share information between department
2. Increasing worker’s knowledge

Chosen Solution:
1. Giving training continually to workers
2. Increasing internal communication