Item / Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Classification	Potential Causes(s) of Failure	Current Design: Controls Prevention	Occurrence	Current Design: Controls Detection	Detection	RPN	Recommended Action	Responsibility & Target Completion Date	Action Results: Actions Taken	SEV	OCC	DET	R.P.N.
Toaster unit/Produce toasted sliced bread	Produce toasted sliced bread to an acceptable colour and texture	Corrosion of exterior case	Customer dissatisfaction/ health hazard	7		Insufficient paint thickness specified	Paint specification	4	Salt spray test to failure	4	112							
						Insufficient pre treatment specified	Pre treatment specification	4	Salt spray test to failure	4	112							
						Surface contamination	Cleaning specification	4	Salt spray test to failure	4	112							
		Corrosion of heater element	Heater element failure resulting in toaster failure	9		Incorrect material specified	Material Specification control manual	2	High Temperature performance test to failure	4	36							
			Electrical safety hazard			Incorrect material specified	Material Specification control manual	2	High Temperature performance test to failure	4	36							
		Spring failure on toast down mechanism	Toaster Inoperable	8		Incorrect material specified	Material Specification control manual	8	Performance test to failure	4	256							
			Toaster Inoperable			Incorrect force calculation	Defined force tolerance	8	Performance test to failure	4	256							