Process Step / Function	Requirement	Potential Failure Mode	Potential Effect(s) of Failure	Severity	Classification	Poential Causes(s) of Failure	Current Process				RPN	Recommended Action	Responsibility & Target Completion Date	Action Results				
							Controls Prevention	Occurance	Controls Detection	Detection				Actions Taken	SEV	OCC	DET	R.P.N.
Operation 30 Produce toasted sliced bread	Produce toasted sliced bread to an acceptable colour and texture	Insufficient paint thickness	Unsatisfactory appearance	6		Spray head clogged on robot	Preventive maintenance	3	Paint thickness checks	3	54							
		Insufficient pre treatment	Poor adhesion of paint resulting in unsatisfactory appearance	6		Contamination of pre treatment bath	Preventive maintenance	2	Weekly solution check	3	36							
		Insufficinet assembly of string unit	Inoperable "toast down" mechanism	8		Installed incorrectly		3	First off check, one sample every hour	2	48							