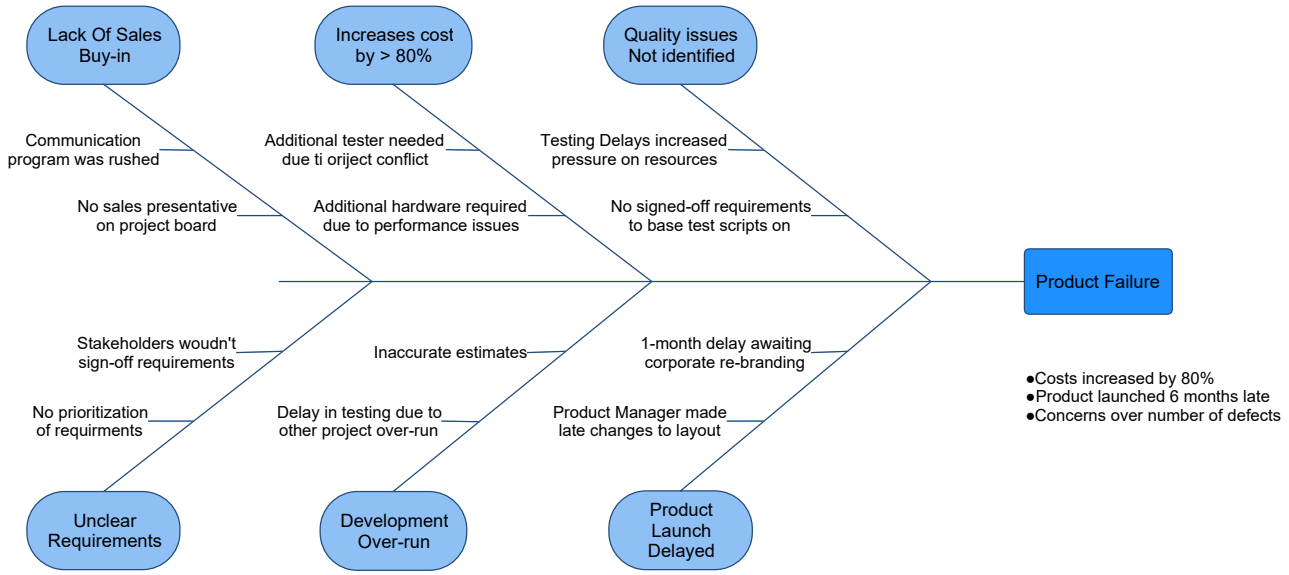
Product Failure Cause & Effect Diagram



- Costs increased by 80%
- Product launched 6 months late
- Concerns over number of defects