The system's inability to update demand data in real-time.

Existing measurement systems are unable to update or collect demand data in real-time

Errors in demand measurement

Lack of careful or real-time market analysis to respond to changes in market demand.

The existing system is not optimal in monitoring machine capacity usage efficiently.

Inaccurate raw material procurement planning.

High and unpredictable market demand fluctuations

Inflexible production policies towards market changes.

Lack of an integrated machine scheduling system

Large machine capacity resulting in high production volumes

Excessive raw material stock

Excessive raw material procurement

Inability to capture demand fluctuations

Dependence on manual forecasting methods that are unresponsive to market demand changes.

Inaccurate production planning

Lack of understanding in data analysis or forecasting

Decision-making based on intuition or assumptions derived from prior experience

Inaccurate decision-making regarding production quantity

**People**

**Overproduction**

**Methods**

**Materials**

**Environment**

**Measurements**

**Machines**

Uncontrolled market demand fluctuations prompting the company to order more raw materials than necessary.

Low machine reliability

Failure to consider material lead time in procurement planning.

Concerns over raw material delivery delays

Uncertainty in raw material supply

Inability of the company’s measurement system to provide accurate, real-time data.secara real time

Absence of a detailed measurement system

Insufficient maintenance of production machines

Materials remain unused due to machine downtimeproduksi

Inaccuracy in raw material measurement

Ordering raw materials in large quantities as stock

Dependence on a single supplier

Dependency on manual planning that is not responsive to changes in demand

Uncertainty in determining production quantityproduksi

Inaccuracy in estimating raw material requirements

Lack of employee development policies and initiatives

Insufficient training for human resource development

Lack of skills in forecasting production needs

**People**

**Inventory Waste**

**Methods**

**Materials**

**Environment**

**Measurements**

**Machines**

Suboptimal machine performance

Weak control over supplier selection and raw material inspection.

Inaccurate manual measurement systems to detect defects.

Lack of accuracy in measurement

Inadequate machine maintenance or outdated equipment

Lack of standardized maintenance schedules for production machines.

Lack of real-time or continuous measurement

Materials not meeting quality standards

Inaccurate raw material procurement

Inability to implement an effective quality control system

Lack of standardized monitoring procedures kualitas

Lack of monitoring system

Insufficient supervisory personnel.

Lack of dedicated supervision during the packaging process

Operator errors due to non-compliance with standard procedures

**People**

**Defective Products**

**Methods**

**Materials**

**Measurements**

**Machines**