

Occurrence Potential (O) for the Process

Potential Failure Causes rated according to the criteria below. Consider Prevention Controls when determining the best Occurrence estimate. Occurrence is a predictive qualitative rating made at the time of evaluation and may not reflect the actual occurrence. The occurrence rating number is a relative rating within the scope of the FMEA (process being evaluated). For Prevention Controls with multiple Occurrence Ratings, use the rating that best reflects the robustness of the control.

O	Time Based Failure Cause Prediction	Type of Control	Prevention Controls
10	Every time	None	<u>No</u> prevention controls.
9	Almost every time	Behavioral	Prevention controls will have <u>little</u> effect in preventing failure cause.
8	More than once per shift		
7	More than once per day	Behavioral or Technical	Prevention controls <u>somewhat</u> effective in preventing failure cause.
6	More than once per week		
5	More than once per month		Prevention controls <u>are</u> effective in preventing failure cause.
4	More than once per year		
3	Once per year	Best practices; Behavioral or Technical	Prevention controls are <u>highly</u> effective in preventing failure cause.
2	Less than once per year		
1	Never	Technical	Prevention controls are <u>extremely</u> effective in preventing failure cause from occurring due to design (e.g. part geometry) or process (e.g. fixture or tooling design). Intent of prevention controls- Failure Mode cannot be physically produced due to the Failure Cause.

Prevention Control Effectiveness: Consider if prevention controls are technical (rely on machines, tool life, tool material, etc), or use best practices (fixtures, tool design, calibration procedures, error-proofing verification, preventive maintenance, work instructions, statistical process control charting, process monitoring, product design, etc.) or behavioral (rely on certified or non-certified operators, skill trades, team leaders, etc.) when determining how effective the prevention controls will be.