Drift on press 3 — seven readings and their reading

LINDBERGH FORMATION — 16 rue de Maillé, 91310 Montlhéry, France · Companies register (RCS) Evry 817 946 114

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Morning shift, 6.40 to 6.51 a.m. · fictional document

> **Fictional document — demonstration example**
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> **Fictional document**, produced for the demonstration. **Every reading below is inside the permitted range.** That is exactly what makes the reading useful: the decision is taken before the bound is crossed, not after.

The control point and its range

Element	Value	Origin
Control point	Melt temperature at the nozzle, press 3	Shop-floor supervision
Target value	**232 °C**	Control plan
Permitted range	**228 – 236 °C**	**Quality department, written on 14/03/2019**

The seven readings

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Time	Reading	Deviation from target	Inside the range?
6.40	231.4 °C	−0.6	Yes
6.42	231.7 °C	−0.3	Yes
6.43	232.0 °C	0.0	Yes
6.45	232.4 °C	+0.4	Yes
6.46	232.8 °C	+0.8	Yes
6.48	233.1 °C	+1.1	Yes
6.51	**233.4 °C**	**+1.4**	**Yes — and seven readings without a step back**

What the run announces

Measure	Value
Speed of movement	**+0.33 °C per reading**
Rule fired	**Rule 5 — confirmed 21 times out of 26 in the history**
Upper bound crossed	**In 12 minutes**
Parts involved before crossing	**≈ 250**
Parts already made since the first sign	**230, identified by batch and cavity**

What the history says about this exact signature

Finding	Value
Occurrences over 18 months	**14**

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Finding	Value
Followed by a scrapped batch	**11**
Cause written in the file	**9 times out of 11: worn non-return valve on the injection screw**

The cavity is the mould recess in which each part was formed. The press 3 mould has eight, and every part carries its number — **which is what later allows a sorting scope to be cut down to what is genuinely involved.**

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> https://bluelemonagent.ai/en/entreprises/cas-usage/agent-de-supervision-qualite-production

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