



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

LINDBERGH FORMATION — a simplified joint-stock company with share capital of €250,000 · Registered office: 16 rue de Maillé, 91310 Montlhéry, France · Companies register (RCS) Evry 817 946 114 · SIRET 817 946 114 00029 · VAT FR 60 817 946 114 · "Blue Lemon Agent" trade mark · Training-provider registration no. 119 108 635 91 (Île-de-France prefect — this registration does not amount to State approval) · Qualiopi certified, no. 03896, for the "training actions" category · contact@bluelemonagent.ai · dpo@bluelemonagent.ai · Hosted in France.

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

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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