128 control points — sources and frequencies

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Controllers, laboratory and binders taken on · fictional document

Fictional document — demonstration example

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Fictional document, produced for the demonstration. **The sensors, the controllers, the MES and the CMMS stay in place:** the agent reads, it replaces nothing, and no point is added to the control plan unless the plant has written it.

Where each measurement comes from

Source	Points	Nature of the measurements	Frequency
Shop-floor supervision	**74**	Temperatures, pressures, cycle times, clamping force	**Every 90 seconds**
Control laboratory	13	Dimensions, mass, mechanical tests	1 to 4 times a shift per the control plan

Source	Points	Nature of the measurements	Frequency
Manual readings taken from the binders	**41**	Material moisture, appearance, visual inspection	**Entered on the shift terminal**
Total	**128**	—	—

What taking the binders on immediately returned

Finding	Value	Consequence
Press 2 material moisture, recorded but never compared	**11 months**	**Explains 2 of the 41 drifts, filed as “undetermined cause”**
Entry time per shift per technician	**15 min → 4 min**	**46 hours a month returned across three shifts**
Points now compared with a range	**128 of 128**	Against 87 before

What the agent adds to the control plan

Element	Decision
A new control point	**Written and signed by the quality department**
A new range	**Written and signed by the quality department**
A new trend rule	**Proposed with figures by the agent, signed by the production manager**
Reading an existing point	**Immediate, no formality**

Proposed extension: move the 41 manual points to the shift terminal on all four presses. **Eleven minutes returned per shift per technician, and a measurement that becomes comparable instead of sleeping in a binder.**

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