

Make the station check and reaction inseparable

Execute the full check-record-react-verify sequence at a station and preserve the actual abnormal reading and product identity.



Record 10.13, not a green tick

Fictional case: operator Noor measures a slot at 10.13 mm against the current example range 9.90-10.10 mm. The value and criterion remain unchanged from the core lesson. The previous record has only a signature, and downstream work is waiting. Noor must respond through the authorized station method rather than adjusting until a later reading looks acceptable.

Your role and the reference condition

Station operator with shift and quality support

Normal: Correct product/instruction identity, ready measurement method, actual observations and a clear abnormality response are available at the point of work.

Gap: The operator is encouraged to mark the check complete because a later part may pass. That would hide the original result and leave affected material unidentified.

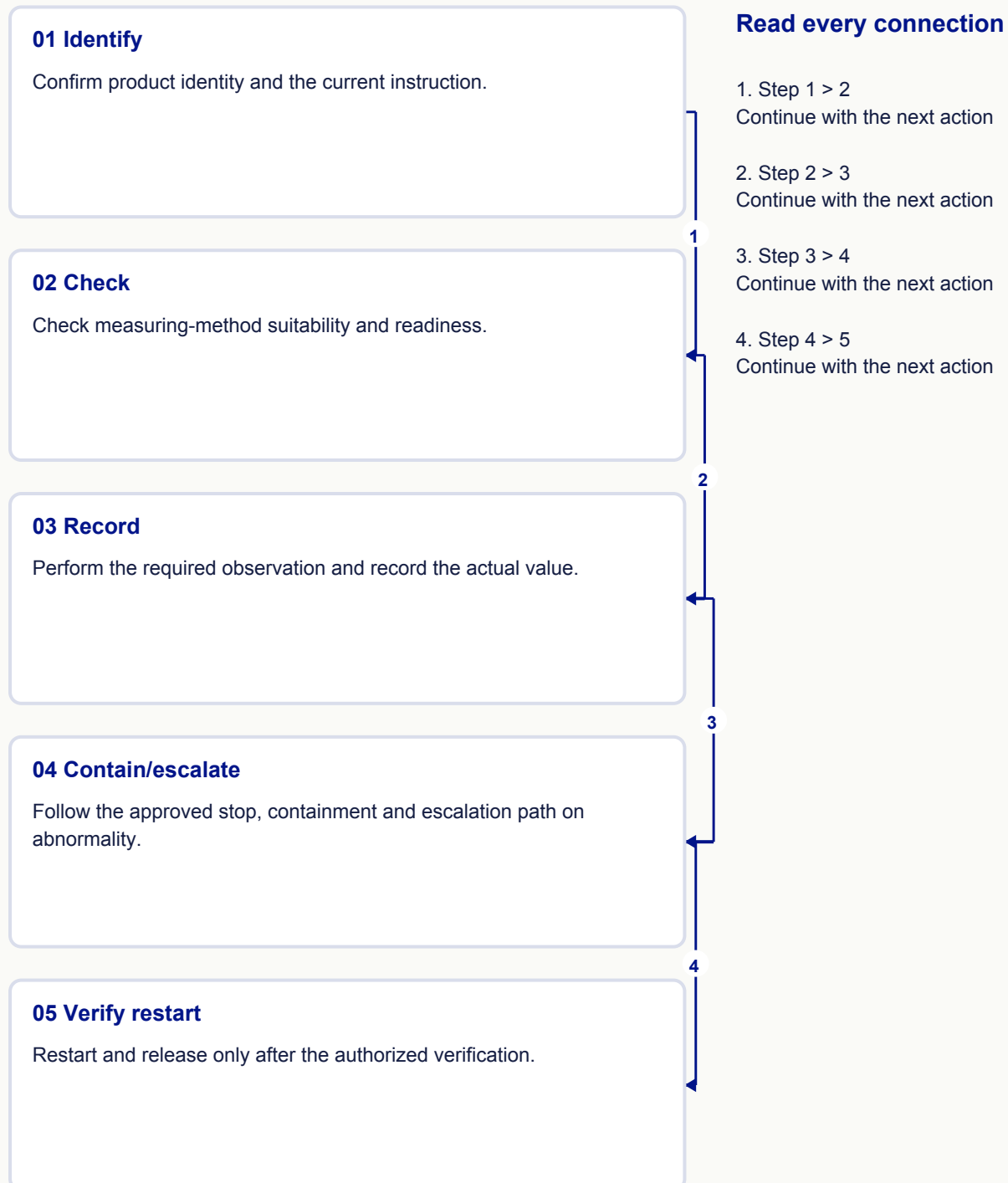
Work within these conditions

1. No equipment adjustment or technical repair procedure is supplied.
2. The example range is a fictional product criterion, not a statistical control limit.

Fictional teaching case. Supplied observations support the exercise; proposed actions are not verified customer results.

See how the method works

Point-of-work control combines the check with the response. Before measuring, confirm the item identity, current instruction and suitable measurement method. Record the actual observation and its relevant context, not simply a reassuring tick. If the result is abnormal, follow the approved stop, containment and escalation path. Preserve the affected identities so later disposition can be justified. A supervisor's desire to resume output is not a replacement for authorized verification. Once the process is restored, confirm the required first acceptable evidence and document the decision. This lesson describes a management routine; it does not supply machine settings, interlock bypasses or an engineering controller design.



Method exhibit: Identify, Check, Record, Contain/escalate, Verify restart.

Follow the evidence and decisions

Inspect the supplied case inputs

Evidence at the check	Supplied fact
Product / operation	Fictional slot operation; current example instruction
Specified range	9.90-10.10 mm
Observed reading	10.13 mm
Last recorded check	Signature only; actual value/identity to retrieve
Disposition / restart	Authorized quality/process decisions required

01 / Identify the work and current instruction

Noor matches the product, operation and revision to the station instruction before interpreting the measurement. She checks the method and readiness conditions required by that instruction.

Why: A correct number against the wrong product criterion is not a valid check. Identity and method precede a pass/fail comparison.

Evidence / check: The record carries product/lot, operation and instruction revision.

02 / Record the actual observation

She enters 10.13 mm with time, relevant item identity and her observation record. She preserves any method issue instead of replacing the value with a tick.

Why: Actual data support later reconstruction and cause investigation. A status mark alone cannot show the size or nature of the observed departure.

Evidence / check: The original 10.13 mm result remains visible.

03 / Compare with the approved example criterion

10.13 exceeds the upper criterion 10.10 by .03 mm. Noor identifies the abnormal condition and follows the station's permitted stop/hold/escalation path.

Why: Recognizing the departure does not authorize an improvised process adjustment. The criterion and response authority are distinct parts of the instruction.

Evidence / check: The abnormality ticket references the actual value and the applicable criterion.

04 / Preserve and investigate exposure

With the quality owner, Noor identifies the last reliable check and affected product locations, including downstream stock where applicable. The earlier signature-only record is treated as an evidence gap.

Why: A passing later part does not erase potentially affected earlier product. Exposure must be reconstructed from reliable records and the approved response process.

Evidence / check: The ticket identifies known material, uncertain boundaries and the owner resolving them.

05 / Verify restart and disposition separately

Authorized personnel restore the process as required and verify restart conditions. Held material remains under its own disposition decision; Noor records the evidence and receiving role.

Why: Process readiness and product release can require different evidence. Closing the ticket before both responsibilities are clear would leave the control loop incomplete.

Evidence / check: The record distinguishes restart verification from held-product status.

Completed station abnormality record

Step	Completed entry	Decision
Check	10.13 mm vs 9.90-10.10 mm	Abnormal by .03 mm above upper criterion
Record	Identity/time/value retained	No replacement green tick
Exposure	Last reliable check to be established	Escalate signature-only evidence gap
Restart	Authorized verification required	No operator-invented adjustment
Held product	Separate quality disposition	No automatic release

A repeat reading is 10.08 mm

A later remeasurement produces 10.08 mm after the original 10.13 mm result.

Decision

Retain both observations and investigate the reason for disagreement under the approved measurement/response method. Do not delete 10.13 or release material solely from the later reading.

Reasoning

A discrepancy may involve measurement, location or process variation. Selecting the favorable value would conceal the evidence needed to decide.

What would change the decision?

The record links both readings to their conditions and responsible review.

Practise with a changed case

A different check with missing identity

New fictional station criterion is 12.00-12.20 mm. A reading 12.24 mm is written on scrap paper without lot identity; downstream containers have already moved.

Evidence	Value or status
Criterion	12.00-12.20 mm
Reading	12.24 mm
Identity	Missing from the note
Downstream	Containers moved; trace needed

Your task

1. Identify the abnormality and preserve the evidence.
2. Describe immediate permitted response and how to resolve the identity/exposure gap.
3. Separate restart evidence from product disposition.

Use the next page to record your reasoning before reading the answer.

Your practice worksheet

A different check with missing identity

Actual value and criterion

Identity reconstruction

Known/uncertain exposure

Escalation owner

Restart and release records

Complete your reasoning before turning to the answer. Use the separate learner workbook for group practice.

Check your reasoning and transfer it

1. 12.24 exceeds 12.20 by .04 mm. Preserve the note and timing/context, follow approved containment/escalation, and trace product identity using reliable process/material records.
2. The uncertain identity widens the investigation problem; it is not permission to assume one convenient lot. Restart and held-product disposition remain authorized decisions supported by separate evidence.

Suggested completed record

Issue	Required response	Boundary
Reading	12.24 vs 12.20: abnormal	Do not rewrite as pass
Identity	Reconstruct trace and exposure	Do not invent a lot
Restart/disposition	Verify through named roles	No automatic release

Plausible wrong turns

1. Remeasuring until a pass appears does not resolve the original abnormality.
2. A completed check requires a usable response, not just a signature.

Evidence of a sound answer

1. Preserve actual readings.
2. Make uncertainty visible.
3. Close both process and product responsibilities.

Take the learning back to work

Commitment	Agreed follow-through
Owner	Station owner with quality and process support
Record	Actual check record, exposure map and verification ticket
Review	At each required check and at handover of unresolved abnormalities
Verification evidence	Traceable observations and authorized restart/disposition evidence
If unresolved	Escalate unresolved identity, method or recurrence gaps rather than closing on a later favorable reading.

Help someone else apply the method

Prepare

1. Abnormal-reading card
2. Blank ticket
3. Station-role map

Minutes	Activity and coaching prompt
5	Read the current criterion What exactly is abnormal?
8	Trace the response Who owns the affected material?
10	Work the unidentified reading What evidence can recover identity?
5	Debrief repeat measurement Why keep both results?

Debrief

1. Challenge any shortcut that deletes an unfavorable observation.
2. Ask learners to name the receiving role for each unresolved decision.

Individual or remote practice

Write the ticket so another shift can understand the value, identity gap and remaining decisions.

Connect the method and check its boundaries

Before application

1. Current authorized station instruction
2. Suitable measuring method and product identity

Outside this lesson

1. Machine-specific operating instructions
2. A feedback-controller implementation

AIAG/Plexus: APQP and control plan overview

AIAG/Plexus: APQP and control plan overview

Control plans link process risks and controls, with explicit reaction ownership, containment and return-to-control actions.

Public overview only. Do not reproduce licensed forms or infer a universal sampling frequency or safe-launch exit period.

[Open this lesson and its visual aids](#)