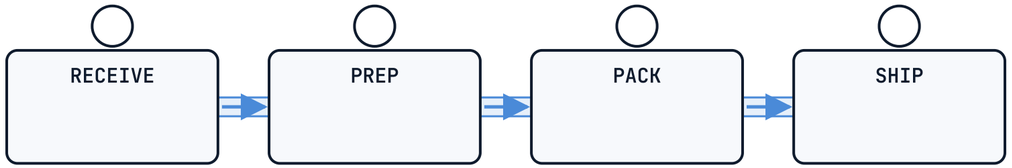
ANDON WORKSHEET · CONCLUSION

AREA	PERIOD	SIGNAL METHOD	SHEET
PREPARED BY	CHECKED BY	DATE	REVIEW

1 ANDON BOARD · STATIONS AND ESCALATION



LIGHT CODE ● **OK** running to standard ● **HELP** lead ≤ 2 min ● **STOP** 3rd hit or unresolved

PULL THE CORD FOR
- equipment issue
- material shortage
- quality defect
- safety concern

OPERATOR
pulls the cord

LEAD
responds ≤ 2 min
authorizes the reset

SUPERVISOR
3rd hit or unresolved
→ A3 / 5 Whys

2 ANDON LOG THIS WEEK

● closed ● 2nd hit ● escalated · open

DAY	TIME	FLAG	WHO	RESPONSE	MIN	STATUS

Total minutes

3 ESCALATION CRITERION

● 1 hit: reset ● 2: watch ● ≥ 3: escalate

METRIC	FORMULA	VALUES	TARGET	RESULT
CAUSE MINUTES	sum of its events		—	
CAUSE SHARE	cause minutes ÷ log total		—	
CAUSE RECURRENCE	same cause in 5 days		< 3	

4 RESULT AND ACTION

Repeat count =

ACTION

5 RULES AND RED FLAGS

3RD HIT = ESCALATE · LEAD ≤ 2 MIN

- Any cause with 3 flags in 5 days leaves “reset” and enters A3 / 5 Whys.
- A week with no pulls is a finding too: a broken cord or scared people.