

## FREE MANUFACTURING START-UP TEMPLATE

# Production Line Start-Up Checklist

Use this 60-point checklist to verify line clearance, utilities, safeguarding, setup, materials, quality readiness, staffing, controlled first-cycle checks, abnormal-condition response, and formal production release.

Facility / line

Start-up date

Shift / time

Product / order

Internal manufacturing template. Apply approved start-up procedures, machine instructions, product specifications, quality requirements, applicable OSHA controls, and site risk assessments as controlling references.

## 1. Shift handover, production plan, authorization, and start-up readiness

1

**Confirm the approved production order, product or SKU, batch or lot, planned quantity, line, shift, and scheduled start time match the current start-up plan.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

2

**Review the previous shift's handover for breakdowns, quality holds, safety concerns, unfinished maintenance, blocked materials, cleaning status, and open corrective actions.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

3

**Verify all required maintenance, sanitation, cleaning, changeover, engineering, or corrective work affecting start-up has been completed and released by the responsible function.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

4

**Confirm no active permit, lockout/tagout, isolation, maintenance hold, quality hold, or engineering restriction prevents the line from being energized or operated.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

5

**Verify required supervisors, operators, technicians, quality personnel, and support functions are available or on call for the planned start-up.**

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

6

**Record start-up authorization, responsible line owner, reviewer, planned product, shift, and any approved temporary control before proceeding.**

START-UP

RELEASE STATUS | Enter

REVIEWER | Enter

APPROVAL | Enter

**Execution tip:** Start with the approved production plan and previous-shift handover. Resolve open safety, quality, maintenance, material, or staffing...

## 2. Line clearance, housekeeping, previous-product removal, and work-area condition

7

Confirm the production line, conveyors, machine surfaces, worktables, bins, fixtures, and nearby staging areas are cleared of previous-product materials, components, labels, documents, and waste.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

8

Verify work areas, walkways, access points, platforms, stairs, emergency routes, and operator positions are clean, dry, unobstructed, and ready for safe operation.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

9

Check tools, loose fasteners, rags, cleaning materials, maintenance parts, ladders, temporary equipment, and other foreign objects have been removed or secured.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

10

Confirm rejected, quarantined, suspect, obsolete, or unidentified material is physically segregated and cannot enter the new production run.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

11

Verify waste containers, scrap points, spill controls, drains, dust extraction, and collection systems are empty or ready for the planned production activity.

START-UP

C

PC

NC

NA

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

12

Record line-clearance completion with area, product transition, inspector, time, exceptions, and evidence before materials are issued to the line.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Walk the complete line from infeed to discharge. Line clearance should remove previous-product, packaging, labels, tools, waste, and...

### 3. Utilities, electrical supply, compressed air, process services, and environmental readiness

- 13 Confirm electrical supply, panels, disconnects, plugs, cables, enclosures, grounding, and visible electrical components are in acceptable condition for start-up.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

- 14 Verify compressed air, vacuum, hydraulic pressure, cooling water, steam, gas, process water, chilled water, or other required utilities are available and within approved operating ranges.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

- 15 Check pressure gauges, temperature indicators, flow indicators, alarms, relief devices, and utility-monitoring instruments are available, readable, and within required status.

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

- 16 Confirm extraction, ventilation, dust collection, fume control, cooling, drainage, and environmental systems required for the process are operating before production begins.

CRITICAL

START-UP

C

PC

NC

NA

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

- 17 Verify there are no visible leaks, unusual odor, smoke, overheating, condensation, hose damage, loose connections, or abnormal utility conditions around the line.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

- 18 Record utility readings or readiness evidence for critical services where the approved start-up procedure requires documented confirmation.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Confirm each utility is stable before trial operation. Pressure, temperature, voltage, air quality, extraction, cooling, and other services should be...

## 4. Machine guarding, emergency stops, interlocks, and safety-device verification

19

Confirm fixed, adjustable, interlocked, or other machine guards are installed, secure, correctly positioned, and free from damage or unauthorized modification.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

20

Verify point-of-operation hazards, rotating parts, nip points, belts, chains, gears, shafts, and other accessible moving hazards are effectively safeguarded.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

21

Test emergency-stop devices, pull cords, trip devices, gate switches, light curtains, scanners, mats, and similar safety devices using the approved start-up verification method.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

22

Confirm resetting an emergency stop, guard interlock, fault, or power interruption does not cause unexpected automatic start-up of hazardous movement.

CRITICAL

START-UP

C

PC

NC

NA

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

23

Verify safety doors, access gates, perimeter barriers, warning devices, beacons, alarms, and operator-protection devices are present and functional where required.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

24

If any safeguard or safety device is defective, missing, bypassed, defeated, or unreliable, stop start-up and place the affected equipment under controlled restriction until corrected.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Verify safeguards before normal production. A line should not start with missing guards, bypassed interlocks, failed emergency stops, or...

## 5. Tooling, change parts, machine setup, settings, recipes, and configuration control

25

Confirm installed tooling, dies, molds, fixtures, guides, nozzles, cutters, change parts, screens, plates, rollers, or other product-contact/setup components match the approved production requirement.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

26

Verify tooling and change parts are correctly seated, secured, aligned, tightened, and free from visible damage, excessive wear, contamination, or foreign material.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

27

Confirm machine recipe, program, PLC selection, speed, temperature, pressure, torque, timing, dimensions, and other process settings match the current approved specification.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

28

Verify parameter limits, alarms, interlocks, counters, sensors, vision systems, reject devices, and automatic checks are enabled and configured as required.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

29

Check unauthorized or obsolete programs, recipes, setup sheets, labels, or parameter files cannot be accidentally selected for the planned run.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

30

Record setup verification, key parameters, tooling ID where applicable, setter/operator, reviewer, and any approved deviation before trial production.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Compare the actual machine configuration with the approved setup sheet or recipe. Wrong tooling, guides, programs, limits, or settings can...

## 6. Raw materials, components, packaging, labels, and traceability readiness

31

Confirm raw materials, components, subassemblies, packaging, and consumables staged for the line match the approved bill of materials, production order, and current specification.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

32

Verify material identity, lot or batch number, status, expiry or use-by date where applicable, quantity, and release status before loading or feeding the line.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

33

Check packaging, labels, printed materials, barcodes, date codes, artwork, instructions, and product identification match the correct product and approved revision.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

34

Confirm damaged, contaminated, mixed, unidentified, obsolete, expired, quarantined, or unreleased materials are prevented from entering production.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

35

Verify traceability controls can link finished output to the raw-material, component, packaging, line, shift, and production-lot information required by the site.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

36

Record initial material issue or scan confirmation and any shortages, substitutions, excess material, or discrepancies requiring approval before start-up.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Match every issued material to the production order before loading the line. Verify identity, lot status, quantity, condition, label version, and...

## 7. Quality instruments, calibration status, inspection plans, and first-off readiness

37

**Confirm required gauges, scales, torque tools, thermometers, pressure instruments, test equipment, vision systems, and measuring devices are available and within calibration or verification status.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

38

**Verify inspection plans, control plans, sampling requirements, drawings, specifications, acceptance limits, defect standards, and reference samples are current and accessible.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

39

**Check in-line sensors, metal detection, checkweighing, vision inspection, leak testing, functional testing, or other automated quality checks are ready where applicable.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

40

**Confirm reference samples, master samples, test pieces, challenge samples, or verification standards required for start-up checks are correct, identifiable, and within approved status.**

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

41

**Verify the first-off, first-piece, start-up sample, or initial batch approval criteria are defined before normal production quantity is released.**

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

42

**Record required quality checks, responsible inspector, sample frequency, acceptance criteria, and release evidence for the controlled start-up run.**

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Make sure the line can measure what it must control before making product. Gauges, testers, limits, samples, and first-off criteria should be...

## 8. Operator readiness, staffing, PPE, SOPs, communication, and task competence

43

Confirm the planned line is staffed with the required number of authorized and competent operators, setters, material handlers, inspectors, and support personnel.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

44

Verify operators have access to the current approved SOP, work instruction, setup standard, quality criteria, safety requirements, and escalation process for the product being started.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

45

Confirm required PPE is available, correctly selected for the task, in serviceable condition, and worn before exposure to relevant production hazards.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

[LIVE PHOTO | Add](#)

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

46

Check employees understand start-up sequence, machine hazards, guarding, emergency stops, jam-clearing rules, prohibited bypasses, and when lockout/tagout or other isolation is required.

CRITICAL

START-UP

C

PC

NC

NA

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

47

Verify shift communication covers product change, special quality requirements, temporary controls, maintenance work, unusual process risks, customer requirements, and open actions.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

48

Confirm unauthorized or untrained personnel are prevented from starting, adjusting, bypassing, troubleshooting, or entering restricted production-line areas.

CRITICAL

START-UP

C

PC

NC

NA

**Execution tip:** Observe the people who will actually start the line. Confirm staffing, role clarity, current instructions, PPE, training, and communication for...

## 9. Controlled trial run, first-cycle observation, abnormal-condition response, and release

49

Start the line using the approved sequence and verify machines, conveyors, feeders, sensors, controls, and downstream equipment operate in the intended order.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

50

Observe the first cycles or trial run for unusual noise, vibration, heat, smell, leakage, misalignment, unstable material flow, repeated stops, jams, or other abnormal behavior.

CRITICAL

START-UP

Ready

Needs action

Stop start-up

LIVE PHOTO | Add

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

51

Confirm emergency stops, alarms, sensors, reject systems, interlocks, counters, guards, and automatic monitoring remain functional during the controlled start-up.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

52

Verify initial product or process results meet the defined first-off or start-up quality criteria before normal-speed or normal-volume production is authorized.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

53

If a safety, quality, equipment, utility, material, or process abnormality occurs, stop or contain the line, record the issue, assign ownership, and verify correction before restart.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

54

Record the formal production release, approving person, time, first-off result, approved operating status, and any temporary condition that must be monitored during the run.

CRITICAL

START-UP

RELEASE STATUS | Enter

REVIEWER | Enter

APPROVAL | Enter

**Execution tip:** Use a deliberate low-risk trial or first-cycle check where appropriate. Watch the entire line for abnormal noise, motion, leaks, jams, rejects,...

## 10. Start-up records, open actions, escalation, performance review, and management sign-off

55

Confirm the completed start-up checklist records line, product, batch or order, date, shift, operator, reviewer, start time, exceptions, evidence, and final release status.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...

56

Verify all start-up defects or deviations are assigned to named owners with priority, due date, interim control, required evidence, and escalation route.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...

57

Confirm unresolved critical safety, equipment, quality, material, or utility issues prevent unrestricted production release until formally corrected or otherwise controlled by authorized personnel.

CRITICAL

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...

58

Review recurring start-up delays, first-off failures, jams, breakdowns, missing materials, setup errors, quality defects, and repeated checklist findings for systemic causes.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...

59

Verify lessons from start-up failures are fed into preventive maintenance, setup standards, spare-parts planning, training, supplier controls, line design, or work instructions where needed.

START-UP

| Record / item | Current status | Owner | Evidence | Action |
|---------------|----------------|-------|----------|--------|
|---------------|----------------|-------|----------|--------|

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...

60

Record final checklist status, unresolved restrictions, follow-up actions, next review date, line owner, quality or safety reviewer where applicable, date, and management approval.

CRITICAL

START-UP

RELEASE STATUS | Enter

REVIEWER | Enter

APPROVAL | Enter

**Execution tip:** Treat start-up as complete only when evidence, exceptions, and ownership are clear. Repeated start-up losses or failures should feed...