



WORK SIMPLIFICATION
E. I. DU PONT DE NEMOURS & COMPANY
INCORPORATED
FLOW PROCESS CHART

NO. 4
PAGE 1 OF 1

SUMMARY

	PRESENT NO. TIME	PROPOSED NO. TIME	DIFFERENCE NO. TIME
○ OPERATIONS			
◇ TRANSPORTATIONS			
□ INSPECTIONS			
▽ DELAYS			
▽ STORAGES			
DISTANCE TRAVELLED	FT.	FT.	FT.

JOB Assemble Rifle
☐ MAN OR ☒ MATERIAL
 CHART BEGINS ASSEMBLY TIME
 CHART ENDS ASSEMBLED RIFLE
 CHARTED BY E. I. DuPont DATE

DETAILS OF (PRESENT) METHOD	OPERATION	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYST	NOTES	ACTION CHANGE
1. Action taken from shelf to bench	○	◇	□	▽		10	1				
2. Open action to see that L.P. works	○	◇	□	▽						CHECK BOLT FOR COR- OPERATION + TRIGGER FOR SIGHT	
3. Stock taken from shelf to bench	○	◇	□	▽		10	1				
4. Visual inspection of stock	○	◇	□	▽						NICKS, SCREWS, CRACKS, ETC.	
5. Action placed in stock	○	◇	□	▽						Don't get new stock	
6. Visual inspection for fit	○	◇	□	▽							
7. Place stock in vise	○	◇	□	▽							
8. Put block on action	○	◇	□	▽						TO COLLECT STOCK TO CHECK FOR FIT	
9. Put action in stock	○	◇	□	▽						as a unit	
10. Remove action + stock from vise	○	◇	□	▽							
11. Load barrel and screw tight	○	◇	□	▽							
12. Tap stock gently on butt end	○	◇	□	▽						TO INSURE BARREL BRACKET CONTACT WITH STOCK	
13. Tighten front guard screw	○	◇	□	▽							
14. Place assembly in vise	○	◇	□	▽							
15. Tighten with pipe block as flat block	○	◇	□	▽							
16. Remove assembly from vise	○	◇	□	▽							
17. Remove front guard screw	○	◇	□	▽							
18. Remove action + stock on bench	○	◇	□	▽							
19. Place stock in vise	○	◇	□	▽							
20. Place stock	○	◇	□	▽							
21. Place stock in vise	○	◇	□	▽							
22. Assemble barrel + action assembly to stock	○	◇	□	▽			2			TO INSURE BARREL BRACKET CONTACT WITH STOCK	
23. Assemble barrel + action assembly to stock	○	◇	□	▽			1				
24. Assemble barrel + action assembly to stock	○	◇	□	▽			1			3 screws	
25. Assemble barrel + action assembly to stock	○	◇	□	▽						used to check	