



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

FLOW PROCESS CHART

NO. 3
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SUMMARY

	PRESENT		PROPOSED		DIFFERENCE	
	NO.	TIME	NO.	TIME	NO.	TIME
☐ OPERATIONS						
☐ TRANSPORTATIONS						
☐ INSPECTIONS						
☐ DELAYS						
☐ STORAGES						
DISTANCE TRAVELLED		FT.		FT.		FT.

JOB

Assemble Action☐ MAN OR ☒ MATERIALCHART BEGINS Parts + sub assemblies L.V.CHART ENDS assembled action L.V.CHARTED BY J. G. 10-6-57 DATE 9-5-65

DETAILS OF (PRESENT) METHOD	OPERATIVE	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYSIS					ACTION				
									WHAT?	WHY?	HOW?	WHEN?	WHERE?	ELIMINATE	COMBINE	REWORK	REPLACE	PURPOSE
1. Barrel Receivers From Shelf	☒	☐	☐	☐	☐	10	1											
2. Wipe out Barrel I.D.	☒	☐	☐	☐	☐													clean cloth
3. Chamber mag. to end	☒	☐	☐	☐	☐													HAND CHAMFER TOOL WITH GUIDE
4. Wipe Barrel with Keros.	☒	☐	☐	☐	☐													From rec to mag. &
5. Assemble Plug screw	☒	☐	☐	☐	☐		4											mag. of Barrel & barrel to rec.
6. Assemble screw barrel & plug	☒	☐	☐	☐	☐		2											rec. of barrel & rec. of rec.
7. Assemble plug screw	☒	☐	☐	☐	☐		2											left side of rec.
8. Stage chamber barrel	☒	☐	☐	☐	☐													left SIDE OF BARREL
9. Stage mag. reflex on barrel	☒	☐	☐	☐	☐													RIGHT SIDE OF BARREL
10. Assemble trigger assembly to rec.	☒	☐	☐	☐	☐		1											USE SEAR PIN
11. Assemble Bolt stop & spring	☒	☐	☐	☐	☐		1											USE BOLT STOP PIN check for free movement
12. Push Pin Rec. to left end of Bolt stop	☒	☐	☐	☐	☐													TO PREVENT FROM WIRING OUT
13. Assemble Bolt Final Assembly To Action	☒	☐	☐	☐	☐													CHECK FIRE ARMSTR. OPERATION
14. ADJUST FIRE CONTROL	☒	☐	☐	☐	☐													CHECK FOR EASE OF FIRE + OVER TRAVEL
15. S-TAKE + RECHECK	☒	☐	☐	☐	☐													CHECK FOR STICKAGE PULL OVER TRAVEL
16. Done	☒	☐	☐	☐	☐													DUPONT
17. Place Assembled Action on shelf	☒	☐	☐	☐	☐	10	1											READY FOR ASSEMBLY - 2 - S-TAKE
18	☒	☐	☐	☐	☐													
19	☒	☐	☐	☐	☐													
20	☒	☐	☐	☐	☐													
21	☒	☐	☐	☐	☐													
22	☒	☐	☐	☐	☐													
23	☒	☐	☐	☐	☐													
24	☒	☐	☐	☐	☐													
25	☒	☐	☐	☐	☐													