



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

NO. 2  
PAGE 1 OF 1

## SUMMARY

|                                       | PRESENT |      | PROPOSED |      | DIFFERENCE |      |
|---------------------------------------|---------|------|----------|------|------------|------|
|                                       | NO.     | TIME | NO.      | TIME | NO.        | TIME |
| <input type="radio"/> OPERATIONS      |         |      |          |      |            |      |
| <input type="radio"/> TRANSPORTATIONS |         |      |          |      |            |      |
| <input type="radio"/> INSPECTIONS     |         |      |          |      |            |      |
| <input type="radio"/> DELAYS          |         |      |          |      |            |      |
| <input type="radio"/> STORAGES        |         |      |          |      |            |      |
| DISTANCE TRAVELLED                    |         | FT.  |          | FT.  |            | FT.  |

JOB BOLT FINAL ASSEMBLY  
☐ MAN OR ☒ MATERIAL  
 CHART BEGINS BOLT REPAIR  
 CHART ENDS BOLT FINAL ASSEMBLY  
 CHARTED BY S. P. Smith DATE

| DETAILS OF (PRESENT PROPOSED) METHOD | OPERATION                        | TRANSPORT                        | INSPECTION                       | DELAY                            | STORAGE                          | DISTANCE IN FEET | QUANTITY | TIME | ANALYSIS WHY? | NOTES                                                      | ACTION  |        |
|--------------------------------------|----------------------------------|----------------------------------|----------------------------------|----------------------------------|----------------------------------|------------------|----------|------|---------------|------------------------------------------------------------|---------|--------|
|                                      |                                  |                                  |                                  |                                  |                                  |                  |          |      |               |                                                            | REMARKS | CHANGE |
| TRAY OF BOLT BODY ASSEMBLY           | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | RECEIVED FROM CHAMBERLAIN'S SECTION                        |         |        |
| CLEAN FIRING PIN SHOULDER            | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | HAND REAMWORK DRILL END                                    |         |        |
| CLEAN FIRING PIN HOLE                | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | HAND REAMWORK                                              |         |        |
| CLEAN IN CLEANING TANK               | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | 84-1                                                       |         |        |
| TAKE TO PRODUCTION AREA              | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | 84-3                                                       |         |        |
| CLEAN EXTRACTOR GROOVE               | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | SPECIAL TOOL TO HILL ONE EXTRACTOR SIZE. BLOW OUT WITH AIR |         |        |
| TAKE TO EXTRACTOR ASSEMBLY           | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | 10               |          |      |               | SAME AREA                                                  |         |        |
| ASSEMBLE EXTRACTOR IN RIVET          | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | DO ONE                                                     |         |        |
| RIVET                                | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | CHECK WITH HODDER GAUGES                                   |         |        |
| ASSEMBLE REST OF BOLTS               | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | REAR EXTRACTOR REPAIR AREA. USE REPAIR                     |         |        |
| FILE OFF EXCESS RIVET MATERIAL       | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
| CHECK EXTRACTOR IN EACH BOLT         | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | USE PUNCH TO CHECK SPRING BACK & CO. HOLE SIZE             |         |        |
| FINISH OTHER BOLT SIZES              | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | REPEAT OPERATIONS 5-13                                     |         |        |
| TAKE BOLTS TO LATHE                  | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
| CLEAN EXTRACTOR HOLE                 | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | USE DRILL IN CHUCK                                         |         |        |
| RETURN TO PRODUCTION SHOP            | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
| WORK                                 | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | FOR FINAL ASSEMBLY                                         |         |        |
| ASSEMBLE EXTRACTOR IN RIVET          | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | DO EXTRACTOR AND HOLE FINISH                               |         |        |
| ASSEMBLE FIRING PIN ASSEMBLY         | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | DO EXTRACTOR AND HOLE FINISH                               |         |        |
| GUN SLICK ON CHECKING CAM PLUGS      | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               | DO EXTRACTOR AND HOLE FINISH                               |         |        |
|                                      | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
| Work could be done by                | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
| Want to be done                      | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
|                                      | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |
|                                      | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> | <input checked="" type="radio"/> |                  |          |      |               |                                                            |         |        |