



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

FLOW PROCESS CHART

NO. 1
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SUMMARY

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

JOB

40X-B
TRIGGER ASSEMBLY☐ MAN OR ☒ MATERIALCHART BEGINS PICKING UP PARTSCHART ENDS TRIGGER ASSEMBLYCHARTED BY J. Remington DATE

DETAILS OF (PRESENT) METHOD	OPERATION	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYSIS	NOTES	ACTION	
											ELIMINATE	CHANGE
1. Pick up components from Part	☒	☐	☐	☐	☐	?				ASSEMBLY AREA IN PLANT		
2. Visual inspect TRIGGER housing	☒	☐	☐	☐	☐					inside of Housing		
3. FILE TRIGGER PIN HOLE BURR	☒	☐	☐	☐	☐							
4. VISUAL INSPECT OF CONNECTOR	☒	☐	☐	☐	☐					VISUAL - IN PLACE		
5. CHECK FOR PROPER FIT TO TRIGGER	☒	☐	☐	☐	☐					USE CROCODUS CLOTH		
6. POLISH TOP OF CONNECTOR	☒	☐	☐	☐	☐					ON END SURFACE		
7. ASSEMBLE TRIGGER TO HOUSING	☒	☐	☐	☐	☐					USE TRIGGER PIN WITH SPECIAL TOOL		
8. ASSEMBLE CONNECTOR TO TRIGGER	☒	☐	☐	☐	☐					INTO HOUSING		
9. INSERT TRIGGER STOP SCREW	☒	☐	☐	☐	☐					SCREW IN UNTIL HEAD IS AGAINST WITH SPRING		
10. INSERT TRIGGER SPRING SCREW	☒	☐	☐	☐	☐					PUT SPRING OVER TIP OF SCREW BEFORE ASSEMBLY		
11. INSERT TRIGGER ENGAGEMENT SCREW	☒	☐	☐	☐	☐					SCREW IN UNTIL FLUSH AS SCREW SCREW		
12. INSERT TRIGGER ADJUSTING SCREW	☒	☐	☐	☐	☐					PUT SPRING OVER TIP OF SCREW BEFORE ASSEMBLY		
13. ASSEMBLE BOLT STOP RELEASE	☒	☐	☐	☐	☐					HOLD AGAINST LEFT SIDE OF HOUSING		
14. ASSEMBLE SAFETY ASSEMBLY	☒	☐	☐	☐	☐					HOLD AGAINST RIGHT SIDE OF HOUSING		
15. ASSEMBLE SAFETY PILOT PIN	☒	☐	☐	☐	☐					THRU BOLT STOP RELEASE HOUSING, SAFETY ASSEMBLY		
16. ASSEMBLE SAFETY DETENT BALL	☒	☐	☐	☐	☐					PUT IN HOLE IN SAFETY ASSEMBLY		
17. ASSEMBLE SAFETY DETENT SPRING	☒	☐	☐	☐	☐					PLACE OVER PILOT PIN & BALL		
18. ASSEMBLE SAFETY SNAP WASHER	☒	☐	☐	☐	☐					DEPRESS DETENT SPRING & SLIDE SNAP WASHER IN PIN		
19. INSPECT SAFETY ASSEMBLY & BOLT STOP RELEASE	☒	☐	☐	☐	☐					CHECK SNAPPY ACTION OF SAFETY & FREE MOVEMENT OF BOLT STOP RELEASE FOR HALLS IN HOLE		
20. VISUAL INSPECT SEAR SAFETY CAM	☒	☐	☐	☐	☐							
21. POLISH SEAR CONNECTOR CAM SURFACE	☒	☐	☐	☐	☐					USE CROCODUS CLOTH		
22. ASSEMBLE SEAR SAFETY CAM	☒	☐	☐	☐	☐					USE SLAVE PIN IN TOP FRONT OF HOUSING FROM TOP HITS		
23. INSERT SEAR SPRING	☒	☐	☐	☐	☐					HOLD IN SEAR		
24. TEST SEAR	☒	☐	☐	☐	☐					IN SEAR SLAVE PIN IN SEAR		
25. PLACE ASSEMBLY IN BENCH	☒	☐	☐	☐	☐					READY FOR INSPECTION		