

EN 3313 9-49



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

 NO. 4
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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 Rifle
☐ MAN OR ☒ MATERIAL
 CHART BEGINS ASSEMBLED TO THE POINT
 CHART ENDS ASSEMBLED RIFLE
 CHARTED BY E. I. DuPont DATE 10-1-49

DETAILS OF (PRESENT) METHOD	OPERATION	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYZED				NOTES	ACTION			
									START	END	WHY?	HOW?		ELIMINATE	REDUCE	REPLACE	SUPPORT
1. Action taken from shelf to bench	☒	☒	☒	☒	☒	10	1										
2. Operate action to see that EP works	☒	☒	☒	☒	☒								CHECK BOLT FOR SMO OPERATION & TRIGGER FOR SMO				
3. Stock taken from shelf to bench	☒	☒	☒	☒	☒	10	1						NICKS, SCOTCH TAPE, SMO BOLT, NICK, FINISH				
4. Visual inspection of stock	☒	☒	☒	☒	☒												
5. Action placed in stock	☒	☒	☒	☒	☒												
6. Visual inspection for fit	☒	☒	☒	☒	☒												
7. Place stock in vise	☒	☒	☒	☒	☒												
8. Put block on action	☒	☒	☒	☒	☒												
9. Put action in stock	☒	☒	☒	☒	☒												
10. Remove action & stock from vise	☒	☒	☒	☒	☒												
11. Load front band & front sight	☒	☒	☒	☒	☒												
12. Tap stock gently on butt end	☒	☒	☒	☒	☒												
13. Tighten front guard screws	☒	☒	☒	☒	☒												
14. Place assembly in vise	☒	☒	☒	☒	☒												
15. Jack with paper block & flat block	☒	☒	☒	☒	☒												
16. Remove assembly from vise	☒	☒	☒	☒	☒												
17. Remove front band & screws	☒	☒	☒	☒	☒												
18. Remove action & block on bench	☒	☒	☒	☒	☒												
19. Place stock in vise	☒	☒	☒	☒	☒												
20. Load stock	☒	☒	☒	☒	☒												
21. Remove stock from vise	☒	☒	☒	☒	☒												
22. Assemble barrel & action on assembly stock	☒	☒	☒	☒	☒		2										
23. Assemble barrel & action on assembly stock	☒	☒	☒	☒	☒		1										
24. Assemble barrel & action on assembly stock	☒	☒	☒	☒	☒		1										
25. Assemble barrel & action on assembly stock	☒	☒	☒	☒	☒												