

EN 3313 9-49



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

FLOW PROCESS CHART

NO. 3
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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 Assemble Action☐ MAN OR ☒ MATERIALCHART BEGINS Parts + sub-assemblies L.V.CHART ENDS assembled action L.V.CHARTED BY J. W. Roberts DATE 9-8-65

DISTANCE TRAVELLED		FT.		FT.		ANALYSIS				ACTION										
DETAILS OF (PRESENT PROPOSED) METHOD						OPERATION	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	WHY?	NOTES	ELIMINATE	CHANGE	IMPROVE	APPROVE	
1	Barrel Receiver From Shelf					○◇□DV					10	1								
2	Wipe out Barrel I.D.					○◇□DV										clean cloth				
3	Chamfer muzzle end					⊙◇□DV										HAND CHAMFERIC TOOL WITH GUIDE				
4	Wipe Barrel with Kerosene					○◇□DV										From rec to muzzle				
5	Assemble Plug into					○◇□DV					4					muzzle of Barrel to prevent the rec.				
6	Assemble Screw barrel					○◇□DV					2					rear of barrel to rear of rec.				
7	assemble plug screw					○◇□DV					2					left side of rec.				
8	Slingshot barrel					●◇□DV										left SIDE OF BARREL				
9	Slingshot magazine on barrel					⊙◇□DV										RIGHT SIDE OF BARREL				
10	Assemble trigger assembly to rec.					○◇□DV					1					USE SEAR PIN				
11	assemble Bolt stop & spring					○◇□DV					1					USE BOLT STOP PIN check for free movement				
12	Push Pin Rec. to left end of Bolt stop					●◇□DV										TO PREVENT FROM WIRING OUT				
13	Assemble Bolt Finish - WIPING TO ACTION					○◇□DV										CHECK FOR DRIFT OPERATION				
14	ADJUST FIRE CONTROL					○◇□DV										CHECK FOR EASE OF FIRE + OVER TRAVEL				
15	S-TAKE + RECHECK					●◇□DV										CHECK FOR TRIGGER PULL OVER TRAVEL				
16	Done					●◇□DV										DUPONT				
17	Place Assembled Action in Shelf					○◇□DV					10	1				READY FOR ASSEMBLY → STOCK				
18						○◇□DV														
19						○◇□DV														
20						○◇□DV														
21						○◇□DV														
22						○◇□DV														
23						○◇□DV														
24						○◇□DV														
25						○◇□DV														