

EN 3313 9-49



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

NO. 2
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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 BOLT FINAL ASSEMBLY
☐ MAN OR ☒ MATERIAL
 CHART BEGINS BOLT REPAIR
 CHART ENDS BOLT FINAL ASSEMBLY
 CHARTED BY S. P. 10 DATE _____

DETAILS OF (PRESENT) METHOD	OPERATION	TRANSPORT	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYSIS	NOTES	ACTION
TRAY OF BOLT BODY ASSEMBLY	☒	☒	☒	☒					RECEIVED FROM CHARGING STATION	
CLEAN FIRING PIN SHOULDER	☒	☒	☒	☒					HAND REAMER DRILL END	
CLEAN FIRING PIN HOLE	☒	☒	☒	☒					HAND REAMER	
CLEAN IN CLEANING TANK	☒	☒	☒	☒					84-4	
TAKE TO PRODUCTION AREA	☒	☒	☒	☒					84-3	
CLEAN EXTRACTOR GROOVE	☒	☒	☒	☒					SPECIAL TOOL TO HOLD ONE EXTRACTOR SIZE. GLOW OUT WITH AIR	
TAKE TO EXTRACTOR ASSEMBLY	☒	☒	☒	☒	10				SAME AREA	
ASSEMBLE EXTRACTOR RINGS	☒	☒	☒	☒					DO ONE	
RIVET	☒	☒	☒	☒					CHECK WITH TAPPED GAUGES	
ASSEMBLE REST OF BOLTS	☒	☒	☒	☒					BEND EXTRACTOR RING ASSEMBLY IF NECESSARY	
FILE OFF EXCESS RIVET MATERIAL	☒	☒	☒	☒					USE PUNCH TO CHECK SPRING BACK + CO-NISSED GAGE	
CHECK EXTRACTOR IN EACH BOLT	☒	☒	☒	☒					REPEAT OPERATIONS 5-12	
FINISH OTHER BOLT SIZES	☒	☒	☒	☒						
TAKE BOLTS TO LATHE	☒	☒	☒	☒					USE DRILL IN CHUCK	
CLEAN EXTRACTOR HOLE	☒	☒	☒	☒						
RETURN TO PRODUCTION SHOP	☒	☒	☒	☒					FOR FINAL ASSEMBLY	
WASH	☒	☒	☒	☒						
ASSEMBLE RIVET RINGS	☒	☒	☒	☒					DO NOT USE RIVET RINGS WHILE FINISHING	
ASSEMBLE RIVET RINGS	☒	☒	☒	☒					DO NOT USE RIVET RINGS WHILE FINISHING	
GUNSLICK ON CRACKING CAM LUGS	☒	☒	☒	☒					DO NOT USE RIVET RINGS WHILE FINISHING	
	☒	☒	☒	☒						
This could be done by	☒	☒	☒	☒						
plant	☒	☒	☒	☒						
	☒	☒	☒	☒						
	☒	☒	☒	☒						
	☒	☒	☒	☒						