

EN 3313 9-49



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

FLOW PROCESS CHART

NO. 1
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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 TRIGGER ASSEMBLY
☐ MAN OR ☒ MATERIAL
 CHART BEGINS PICKING UP PARTS
 CHART ENDS TRIGGER ASSEMBLY
 CHARTED BY J. REMINGTON DATE

DETAILS OF (PRESENT PROPOSED) METHOD	OPERATION	TRANSPORT	INSPECTION	DELAY	STORAGE	DISTANCE IN FEET	QUANTITY	TIME	ANALYSIS	NOTES	ACTION
1. Picks up components from Prod.	☒	☐	☐	☐	☐	?				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 CRUSCUS CLOTH ON PLATE SURFACE	
6. D. L. S. H. P. OF CONNECTOR	☒	☐	☐	☐	☐					USE TRIGGER PIN WITH SPECIAL TOOL	
7. ASSEMBLE TRIGGER TO HOUSING	☒	☐	☐	☐	☐					INTO HOUSING	
8. ASSEMBLE CONNECTOR TO TRIGGER	☒	☐	☐	☐	☐					SCREEN IN UNTIL HEAD IS AGAINST WITH SPRING	
9. INSERT TRIGGER STOP SCREW	☒	☐	☐	☐	☐					PUT SPRING OVER TOP OF SCREW BEHIND ARM	
10. INSERT TRIGGER SPRING SCREW	☒	☐	☐	☐	☐					SCREEN IN UNTIL	
11. INSERT TRIGGER ENGAGEMENT SCREW	☒	☐	☐	☐	☐					FLUSH AS 4000 SCREW	
12. INSERT TRIGGER ADJUSTING SCREW	☒	☐	☐	☐	☐					PUT SPRING OVER TOP OF SCREW BEHIND ARM	
13. ASSEMBLE BOLT STOP RELEASE	☒	☐	☐	☐	☐					HOLD AGAINST LEFT SIDE OF HOUSING	
14. ASSEMBLE SAFETY ARM	☒	☐	☐	☐	☐					HOLD AGAINST RIGHT SIDE OF HOUSING	
15. ASSEMBLE SAFETY PILOT PIN	☒	☐	☐	☐	☐					THRU BOLT STOP RELEASE HOUSING, SAFETY ARM	
16. ASSEMBLE SAFETY DETENT BALL	☒	☐	☐	☐	☐					PUT IN HOLE IN SAFETY ARM	
17. ASSEMBLE SAFETY DETENT SPRG.	☒	☐	☐	☐	☐					PLACE OVER PILOT PIN & BALL	
18. ASSEMBLE SAFETY SNAP WASHER	☒	☐	☐	☐	☐					DEPRESS DETENT SPRG & SLIDE SNAP WASHER IN PIN	
19. INSPECT SAFETY ARM & BOLT STOP RELEASE	☒	☐	☐	☐	☐					CHECK SNAPPY ACTION OF SAFETY ARM FREE MOVEMENT OF BOLT STOP RELEASE FOR HALLS IN HAND	
20. VISUAL INSPECT SEAR SAFETY CAM	☒	☐	☐	☐	☐					USE CRUSCUS CLOTH	
21. POLISH SEAR CONNECTOR CAM SURFACE	☒	☐	☐	☐	☐					USE SLAVE PIN IN TOP FRONT OF HOUSING FROM TOP INTO	
22. ASSEMBLE SEAR SAFETY CAM	☒	☐	☐	☐	☐					HOLE IN SEAR	
23. INSERT SEAR SPRING	☒	☐	☐	☐	☐					IN SEAR SLAVE	
24. TEST SEAR	☒	☐	☐	☐	☐					PIN IN SEAR	
25. PLACE ASSEMBLY ON BENCH	☒	☐	☐	☐	☐					READY FOR ASSEMBLY	