

Subject Charted	Pen		
Operation	Manufacturing		
Charted by	Executive Seven Day Pen Set		
Chart No.	01	Sheet	1 of 1
Date	May 17, 2021		

## FLOW PROCESS CHART

Can I Eliminate?
Can I Combine?
Can I Change Sequence?
Can I Simplify?

Summary	Pres.	Prop.	Save
Operations	4		
Transports	3		
Inspections	2		
Delays	0		
Storages	6		
Time	16		
Distance	460		

Dist. in Feet	Time in Min.	Oper.	Tran.	Insp.	Delays	Store	Present	Descriptions	Notes
							<input checked="" type="checkbox"/>		
1	0	●	→	■		▼		Spring Supply	
2	0	●	→	■		▼		Ink Supply	
3	0	●	→	■		▼		Barrel	
4	0	●	→	■		▼		Tip	
5	250	●	→	■	□	▼		Inventory taken from warehouse to manufacturing	
6	0.2	●	→	■	□	▼		Press tip into the lower end of the barrel	
7	1	●	→	■	□	▼		Inspection if tip and barrel connect well	
8	0.4	●	→	■	□	▼		Place the refill ink with spring inside the barrel	
9	120	●	→	■	□	▼		Partially completed product transfered to final step	
10	0	●	→	■		▼		Twist Mechnaism	
11	0	●	→	■		▼		Clip	
12	0.2	●	→	■	□	▼		Insert the twist mechanism into the clip	
13	90	●	→	■	□	▼		Partially completed product transfered to final step	
14	0.7	●	→	■	□	▼		Screw Clip on higher end of the barrel	
15	2	●	→	■	□	▼		Inspect functionality of the pen	
16		●	→	■	□	▼			
17		●	→	■	□	▼			
18		●	→	■	□	▼			
19	=	●	→	■	□	▼			
20	16	●	→	■	□	▼		Total Time	
21		●	→	■	□	▼			