

B D 6

MANUFACTURING ORDER Y 18 24 4 J P 1.

FOR Stock.

ORDER ISSUED			WANTED		
MONTH	DAY	YEAR	MONTH	DAY	YEAR
1	25	17	3	1	17

100 - 4" Plain Jarring Machines.

CHECK DUE SIG. FIN.	ORDER WRITTEN		APPROVED MANAGER		DRAWINGS PREPARED		ROUTING		FOUNDRY TAGS WRITTEN		MATERIAL APPORTIONED		TAGS ORDERS, ETC. WRITTEN		TIME STUDY		ROUTE FILE PREPARED		FINISHED			
	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	DAY	HOUR	MONTH	DAY	YEAR	
																						191
																						191

FIGURE 1

proper location and the machine was erected as a whole, a slow process compared with that of the Taylor plan, which is to divide the general assembly into groups, each group being worked entirely independently of the others, and the several groups united as a whole at a subsequent period.

These groups, as well as their component parts, must come together in their proper sequence. Figure 2 may help to visualize the method.

There is hardly any complicated product in which the general assembly cannot be divided into groups as heretofore mentioned. The method of dividing it into groups; the subdivision of groups into operations; the operations into units and the analysis of these components to ascertain what processes are necessary to convert the raw material into these several units, would very much resemble the outline of a tree.

For example, the trunk would represent the final or miscellaneous assembly; the boughs the groups; the branches the group operations, and the twigs the com-

ponent parts of each operation, while the leaves would represent the finishing touches such as painting, boxing, etc. It will be noticed that the boughs are not all joined to the trunk at equal intervals, while in some instances two or more groups may be united at the same time and others follow on in logical order. The same is true of operations, sometimes as high as five or six can be going on at the same time. Now compare this with the layout to the left of the illustration, which is intended to represent a machine whose assembly would consist of three groups (enclosed by heavy lines) each one entirely independent of the other, and a final or miscellaneous group, and you will note the familiarity. Each one of these groups contains a number of assembly operations appearing in the order in which they can be done, viz.: Group Assembly Op. Nos. 1, 2, 3, etc., hereafter designated GA No. 1, GA No. 2, GA No. 3, etc.

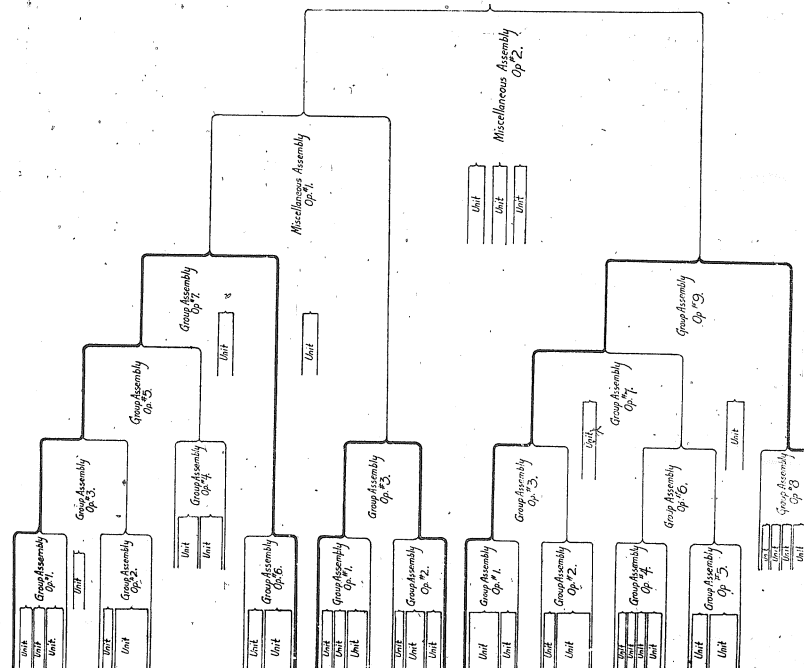
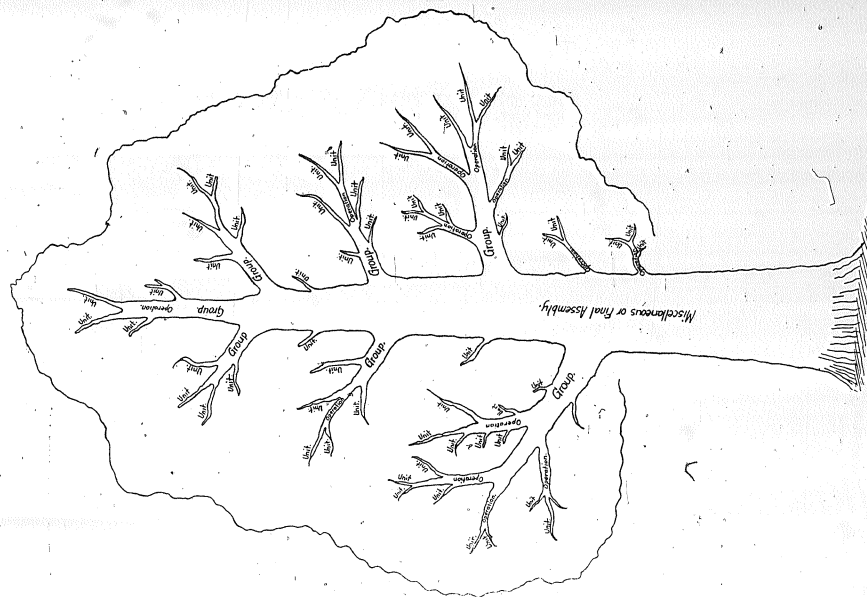


FIGURE 2