

M J 2 P

C M 18 24 4 J P 3 W 1

Piston Anvil. Dr. 10682

IRON CASTING

WEIGHT { UNIT: LBS. TOTAL: LBS.

1/10 WANTED

OPERATION	BONUS	INST. CARD	TOOL LIST	SKETCH	MATERIAL ORDERED, Fdy.	P.O.	ITEM
MATERIAL IN STORES							
1st.		L 0					1 M J 2 P
2nd.		D 1					2 M J 2 P
3rd.		L 4					3 M J 2 P
4th.		M 5					4 M J 2 P
5th.		L 0					5 M J 2 P
6th.		D 17					6 M J 2 P
7th.		V 28					7 M J 2 P
8th.		V 28					8 M J 2 P
To Assem.							

TOTAL

FIGURE 6

hand column must be performed in succession as indicated by their operation numbers. At the top of the sheet are listed the component parts of each operation with spacing provided for checking, as follows:—

The space in the "list of parts made" column is for checking the progress of each component part of the operation, showing it to be finished and delivered to the assembly floor.

The first two spaces in the "list of stores" column, immediately following the quantity, is for the balance of stores clerk to show materials ordered and in stores. The last two columns show the material prepared (or stores issues filled) and moved to the assembly floor.

To provide for the systematic filling of stores issues by the storekeeper or his assistants a standing order is posted in the storeroom bulletin board showing exactly what is wanted and the order in which it is to be filled.

By referring to the route sheet it will be seen that all lines are checked for the first operation, showing everything in readiness to proceed. This sheet is so simple that any boy could, with but little practice, operate it intelligently.

In connection with the assembly route sheet there is also a detail or piece route sheet for each unit made up for the order which is shown in Figure 6.

This sheet is operated very much the same as the assembly sheet, there being but one set of lines for checking. The operations through which the several units pass are listed in logical order, giving the machine or vise numbers, drawings, instruction cards, tool lists etc., for each operation. It is upon the completion of each unit on these sheets that the progress is transferred to the assembly sheet.

This sheet is used for routing small stock orders consisting of only one piece, or a combination of these sheets can be used on jobs for which there is no route chart.

The issues shown in Figures 7, 8, 9, and 10 are for the various items to be taken from the store-room for use in the first assembly operation, also the bar stock for one of the units used in this operation.

If the product to be analyzed were large enough to be divided into many groups, there would be a route chart and an assembly route sheet for each individual group, all of which would, as heretofore stated, be united in a final or miscellaneous assembly.

CHARGE TO ORDER NO.

STORES TAG NO. C M 18 24 4 J P 3

S V 1 S 1 R C M 18 24 4 J P 3

S 1 ISSUED FOR 1 M J 4 P

QUANTITY	UNIT	NUMBER
1302"	13"	100
TOTAL WEIGHT	UNIT PRICE	TOTAL VALUE
		51985
DRAWING NO. 51985		
MACHINE NO. L 14		
ISSUE WRITTEN 2 9 17		
STORES DELIVERED 19		

STORES ISSUE

STOREKEEPER { DO NOT FILL OUT NAME FOR ORDERS ON STORE-KEEPER.

Mr. L 14

PLEASE ISSUE ABOVE TO BEARER SIGNED 6

APPROVED	ENTERED	STORES DESCRIBED ABOVE HAVE BEEN ISSUED			
TAG	STORES	BALANCE	COST		
	ADD'D	ADD'D	ADD'D		
				SIGNED BY STOREKEEPER OR HIS REPRESENTATIVE	

FIGURE 7

CHARGE TO ORDER NO.

STORES TAG NO. C M 18 24 4 J P 3

S V 7/8 Z 7 W C M 18 24 4 J P 3

S 1 ISSUED FOR 1 M J P

QUANTITY	UNIT	NUMBER
100	1	100
TOTAL WEIGHT	UNIT PRICE	TOTAL VALUE
		51917
DRAWING NO. 51917		
MACHINE NO. Assem.		
ISSUE WRITTEN 2 9 17		
STORES DELIVERED 19		

STORES ISSUE

STOREKEEPER { DO NOT FILL OUT NAME FOR ORDERS ON STORE-KEEPER.

Mr. Assem.

PLEASE ISSUE ABOVE TO BEARER SIGNED 6

APPROVED	ENTERED	STORES DESCRIBED ABOVE HAVE BEEN ISSUED			
TAG	STORES	BALANCE	COST		
	ADD'D	ADD'D	ADD'D		
				SIGNED BY STOREKEEPER OR HIS REPRESENTATIVE	

FIGURE 9

CHARGE TO ORDER NO.

STORES TAG NO. C M 18 24 4 J P 3

S V 7/8 Z 2 N C M 18 24 4 J P 3

S 1 ISSUED FOR 1 M J P

QUANTITY	UNIT	NUMBER
100	1	100
TOTAL WEIGHT	UNIT PRICE	TOTAL VALUE
		51917
DRAWING NO. 51917		
MACHINE NO. Assem.		
ISSUE WRITTEN 2 9 17		
STORES DELIVERED 19		

STORES ISSUE

STOREKEEPER { DO NOT FILL OUT NAME FOR ORDERS ON STORE-KEEPER.

Mr. Assem.

PLEASE ISSUE ABOVE TO BEARER SIGNED 6

APPROVED	ENTERED	STORES DESCRIBED ABOVE HAVE BEEN ISSUED			
TAG	STORES	BALANCE	COST		
	ADD'D	ADD'D	ADD'D		
				SIGNED BY STOREKEEPER OR HIS REPRESENTATIVE	

FIGURE 8

CHARGE TO ORDER NO.

STORES TAG NO. C M 18 24 4 J P 3

S V 1 Z 2 N C M 18 24 4 J P 3

S 1 ISSUED FOR 2 M J 4 P

QUANTITY	UNIT	NUMBER
100	1	100
TOTAL WEIGHT	UNIT PRICE	TOTAL VALUE
		51985
DRAWING NO. 51985		
MACHINE NO. D 10		
ISSUE WRITTEN 2 9 17		
STORES DELIVERED 19		

STORES ISSUE

STOREKEEPER { DO NOT FILL OUT NAME FOR ORDERS ON STORE-KEEPER.

Mr. D 10

PLEASE ISSUE ABOVE TO BEARER SIGNED 6

APPROVED	ENTERED	STORES DESCRIBED ABOVE HAVE BEEN ISSUED			
TAG	STORES	BALANCE	COST		
	ADD'D	ADD'D	ADD'D		
				SIGNED BY STOREKEEPER OR HIS REPRESENTATIVE	

FIGURE 10