

PRODUCTION SCHEDULE

(PRECEDE IN ORDER AND CHECK OFF WHEN BOX IS COMPLETED AND DELIVER TO NEXT STATION) ~~DO NOT SAY SEPARATE STATIONS IN ONE BOX.~~

Note: This schedule is intended to streamline the production of toys. Whatever station you are working please mark the section as completed and deliver to the next station in order listed.

Note: Each station should inspect each piece for flaws. If there are any flaws that cannot be removed in the following stations then discard it.

Note: See other side for suggestions to watch for at each step.

- #1 _____ MARK LUMBER
- #2 _____ BAND SAW
- #3 _____ DRILL AXLE HOLES (PLUS ANY OTHER HOLES OF SAME OR SIMILAR SIZE)
- #4 _____ DRILL LARGE WINDOW HOLES
- #5 _____ FLAT SAND
- #6 _____ LARGE ORBITAL SANDER
- #7 _____ SMALL ORBITAL SANDER
- #8 _____ ROUTER KNOCK OFF SHARP EDGES (EITHER WITH ROUTER OR TAKE TO SANDER)
- #9 _____ CLEAN (AIR COMPRESSOR)
- #10 _____ FINISH
- #11 _____ BUFF
- #12 _____ ASSEMBLY
- #13 _____ READY FOR DISTRIBUTION

ADDENDUM TO PRODUCTION SCHEDULE

#1 MARK LUMBER.

Check for any defaults in lumber and mark on all four side so sawyers can readily spot faults and remove them.

#2 BAND SAW.

Cut within 1/16th of line. Make cut as smooth as possible.

#3 Drill AXLE HOLES (PLUS ANY OTHER HOLES OF SAME OR SIMILAR SIZE).

This is meant to include holes for the king pin on semi-trucks or toys of other designs requiring extra holes.

#4 DRILL LARGE WINDOW HOLES.

If possible, set depth so just the point of bit shows through the reverse side, turn over and use hole for center and finish drilling hole. This eliminates tear out.

#5 FLAT SAND.

TRY to maintain square. Remove imperfections, including tool marks, without compromising the integrity of the design. Round off corners when possible.

#6 LARGE ORBITAL SANDER.

Remove all tool marks in concave areas that are reachable. Round of edges left from flat sanding.

#7 SMALL ORBITAL SANDER.

Continuation of #6 in smaller concave areas.

#8 ROUTER. ()

REMEMBER there are at least six sides to the project and all have to be rounded. This sometimes requires that the piece needs to be flipped over and a second pass made. BEFORE passing on rub your hands over the whole piece and check for sharp corners. If you are unable to correct on the router TAKE IT TO A SANDER to remove them.

#9 CLEAN (AIR COMPRESSOR).

Remove all shavings and saw dust. Blow dust etc. out of box you put them in so there is no contamination for the next step.

#10 FINISH.

Finish according to procedures and materials available.

#11 BUFF.

Buff entire piece removing raised grain, etc. until toy is smooth to the touch.

#12 ASSEMBLY.

Glue should be put in axle holes, NOT ON AXLES. Wipe and glue off the side of the toy. With a spacer at least 3/32nd " install wheel and axle. Let sit for a minute or two and check to make sure wheels turn freely.

#13 READY FOR DISTRIBUTION.

When all the above steps have been completed, and checked off including #13 place this check sheet in box and label box with the number and type of toy inside.