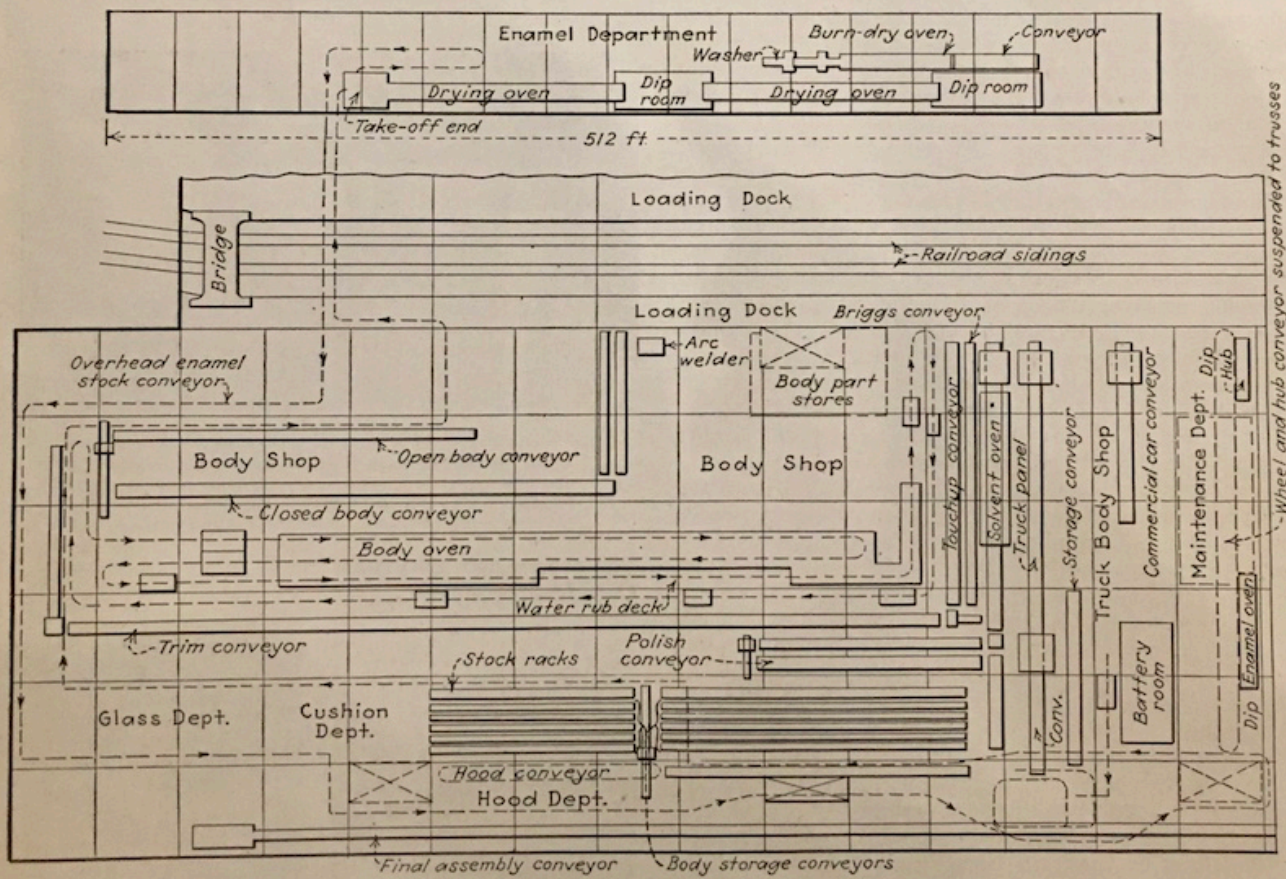


Trimming is done as the bodies travel along this conveyor, some men working inside and some outside the body. Kits of upholstery parts, ready for tacking in place, are fed in from bays at the left where some of these sub-assemblies are prepared

cations and samples from each shipment are carefully tested to see that standards are maintained. This makes mixing and matching paints at the assembly plant unnecessary and assures uniform results at all times.

Before finishing operations start, an air jet is used to remove all dust from the bodies, and they are washed with a mixture of alcohol, ammonia, and water to remove any remaining traces of oil and grease. Following this operation they are rubbed with a tack-rag and then enter the first spray booth where they are sprayed with a coat of brown primer inside and outside. The bodies next enter an oven through which they travel slowly for 2½ hours in a temperature of 225 to 250 deg. F. supplied by steam heat. Some loose parts, a certain number of which are intended for service stock, are hung upon the body conveyors and receive the same treatment and finishing given to the bodies themselves.

A scuffing or dry sanding operation of the primer coat with a 6-0 paper follows the baking. A pyroxylin filler coat is next applied and the bodies are allowed to air dry for a few minutes. This coat then is mossed over with dry 6-0 paper, the dust is wiped off, and a second coat of pyroxylin surfacer is sprayed on, after which the bodies pass through a 150-ft. steam-heated drying oven. As they issue from this oven they are cooled with a water spray and then are water sanded. Each workman has



Layout of conveyor system in portions of the Ford Chester plant where finishing and body operations are performed. Fabricated parts are unloaded into racks at the railway siding docks or are carried, either by conveyors or by trucks, to the point where finishing or assembly operations begin. All conveyors feed parts or subassemblies toward the final assembly line with minimum handling. Chain and slot conveyors are used.