

# Implement Reduced Staffing in Assembly Cell

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- Using the **P.A.C.E.** approach for staffing depth and continual operation.
  - P.A.C.E. ensures that the targeted area will always be fully-staffed
  - P.A.C.E. provides structure & guidance to staffing depth management.
- **Primary** – associates selected as first choice to work in the value stream.
- **Alternate** – associates assigned to other value streams who can be easily pulled over if needed to fill in for absent Primaries.
- **Contingency** - associates assigned to other value streams who can be pulled over if needed but may require some refresher training or guidance.
- **Emergency** – associates from other areas of the operation (engineering, quality, etc.) who may be utilized but require significant training and guidance.

Ref.: John Gaul's former student and Black Belt - electronics.