

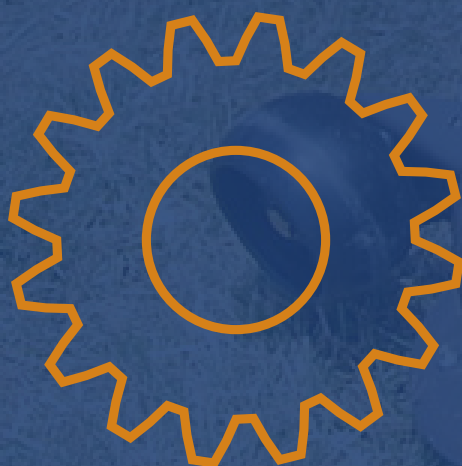
### General Description

- Headcount reduction in Operations (including Manufacturing and Materials)
- Improve through-put (efficiencies) in assembly Lines
- Improve Line Side delivery of parts to Line
- Eliminate line stoppage due to late delivery of parts

### Scope

- Reduced overall headcount by 12 %, Increased units per head 18%, and Reduced internal inventories by 24%
- Developed and implemented new work standards and work instructions in Manufacturing and Materials Departments
- Developed and implemented new assembly line layouts on all assembly lines
- Developed and implemented new warehousing footprint and routes for all material handlers
- Developed and implement New Product (Launch) standards and manpower requirements
- Created new production schedule to maximize through put and reduce changeovers
- Developed and implemented new training programming in warehousing to improve accuracy and safety

### Success

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- We transformed the Nashville Assembly plant by creating a new manufacturing footprint, maximizing efficiency, and reducing internal inventory
  - Set standards to reduce manpower and improve internal and external quality concerns