**Pizza USA customer orders arrive at a rate of 20 per hour during peak hours.**

1. What is the takt time, i.e. how much time can anyone activity (or person) spend on an order?

Takt time = 20 pizzas per hour = 3 minutes per step in the process to make a pizza

Each person can spend 3 minutes

1. How many ovens do you need?

It takes 24 minutes to bake 4 pizzas

6 minutes per pizza, so we need 2 ovens (presuming no downtime)

1. How would you staff the roles above to achieve ‘flow’?

We would need roughly 3 people; a 4th could be helpful if we ever encounter staffing issues or issues with anything.

3 minutes of total assistant time = less than or equal to the 3 minutes each person can spend in the process

5 minutes of total chef time = greater than or equal to 3 minutes each person can spend in the process = 5/3 = 2 rounded up. 2 chefs.

3 people total