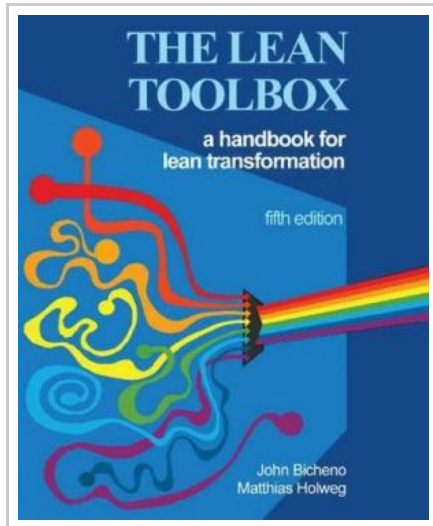




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By John R Bicheno, Professor of Operations Management
Matthias Holweg

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