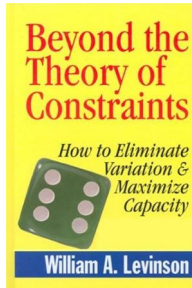


Beyond the Theory of Constraints: How to Eliminate Variation and Maximize Capacity



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