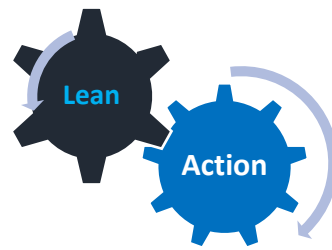
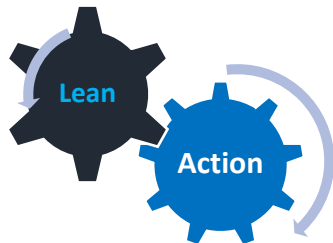


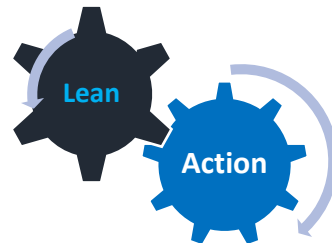
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2. Only plan ready work.
3. Measure, learn and improve with a goal of 100% reliability.
4. Make it visual and easy to understand.



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