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Empowering Kanban through TPS-principles – an empirical analysis of the Toyota Production System

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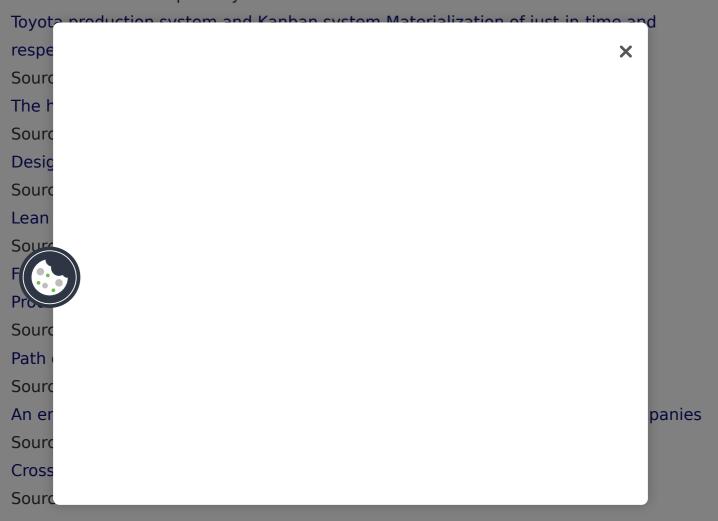
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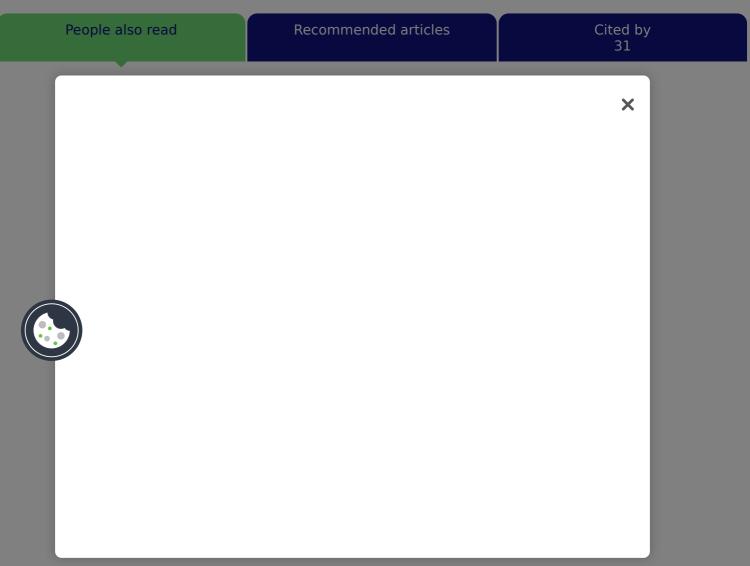
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