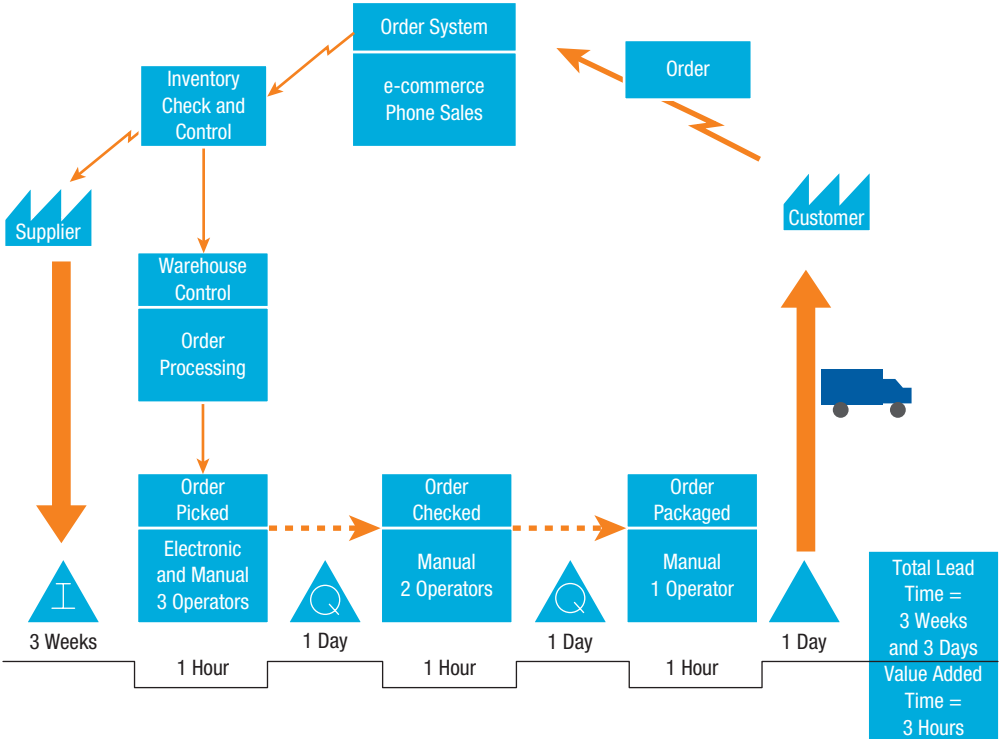FIGURE 14.1: Completed Value Stream Map[9]