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Principle #1 – “Base your  
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term philosophy, even at the expense of short-term financial goals.”. Principle #2 - “Create a continuous process flow to bring problems to the surface.”. Principle #3 - “Use ‘pull’ systems to avoid overproduction.”. Principle #4 - “Level out the

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workload (work like the tortoise,  
not the hare).”.

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Liker, Jeffrey K. (författare)  
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