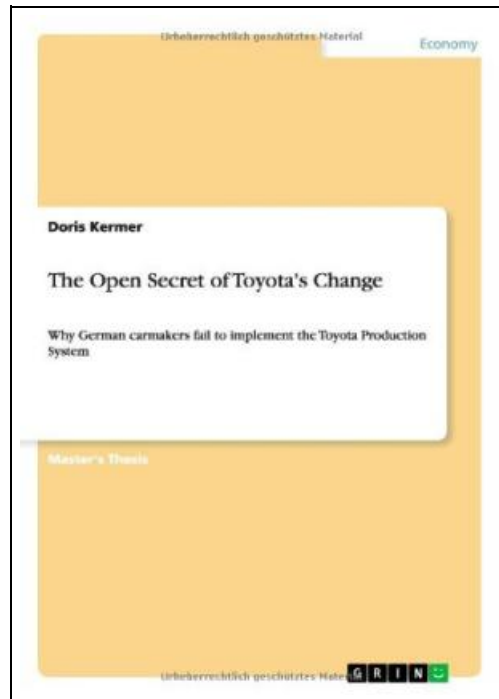


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THE OPEN SECRET OF TOYOTA'S CHANGE



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