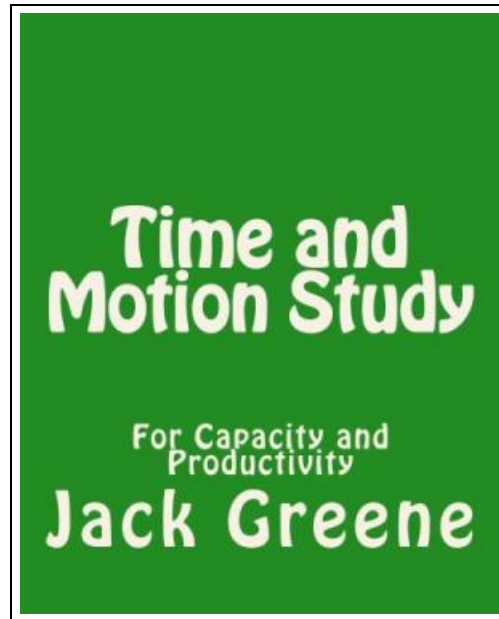


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TIME AND MOTION STUDY: FOR CAPACITY AND PRODUCTIVITY



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