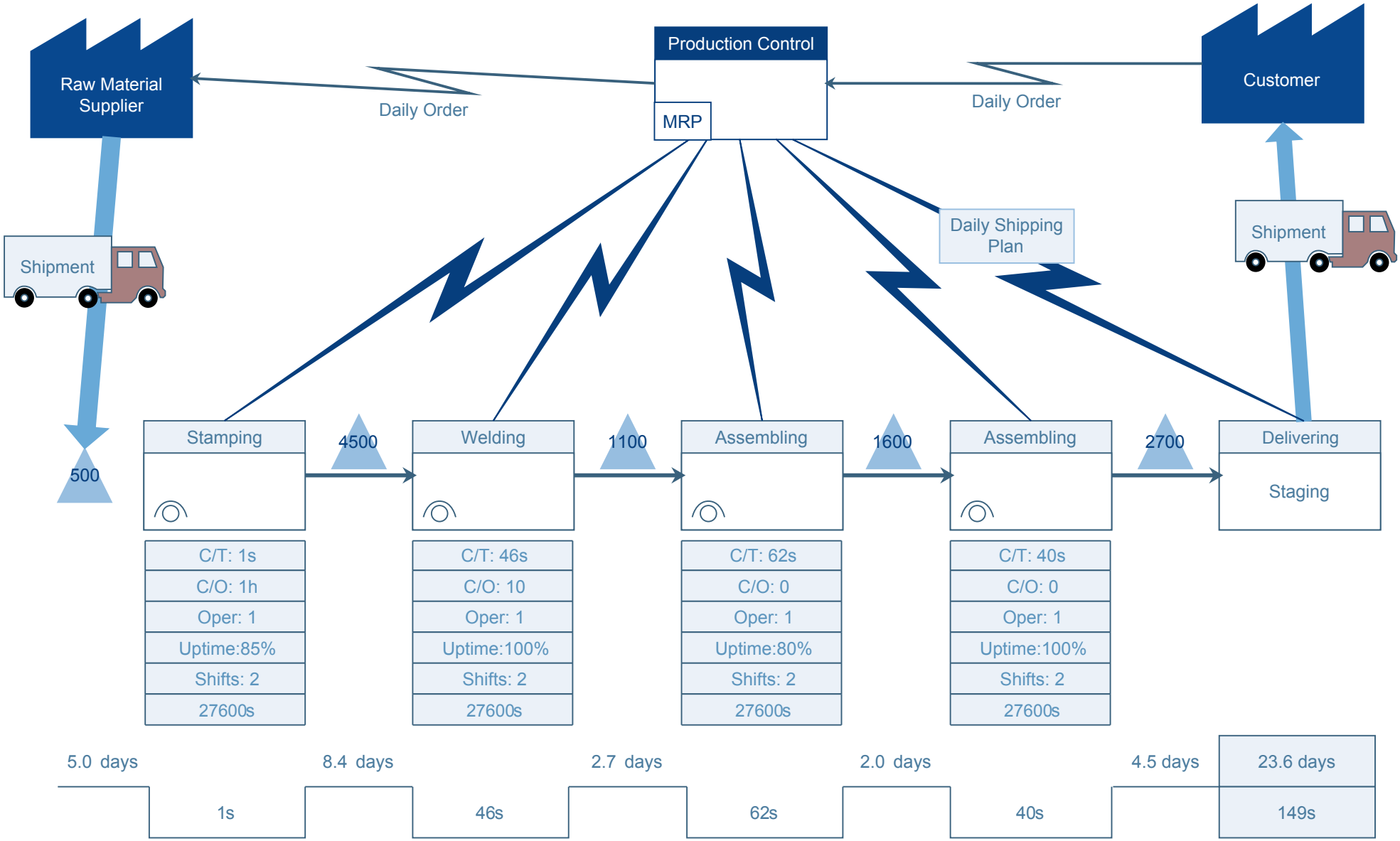Chair Production Value Stream Map