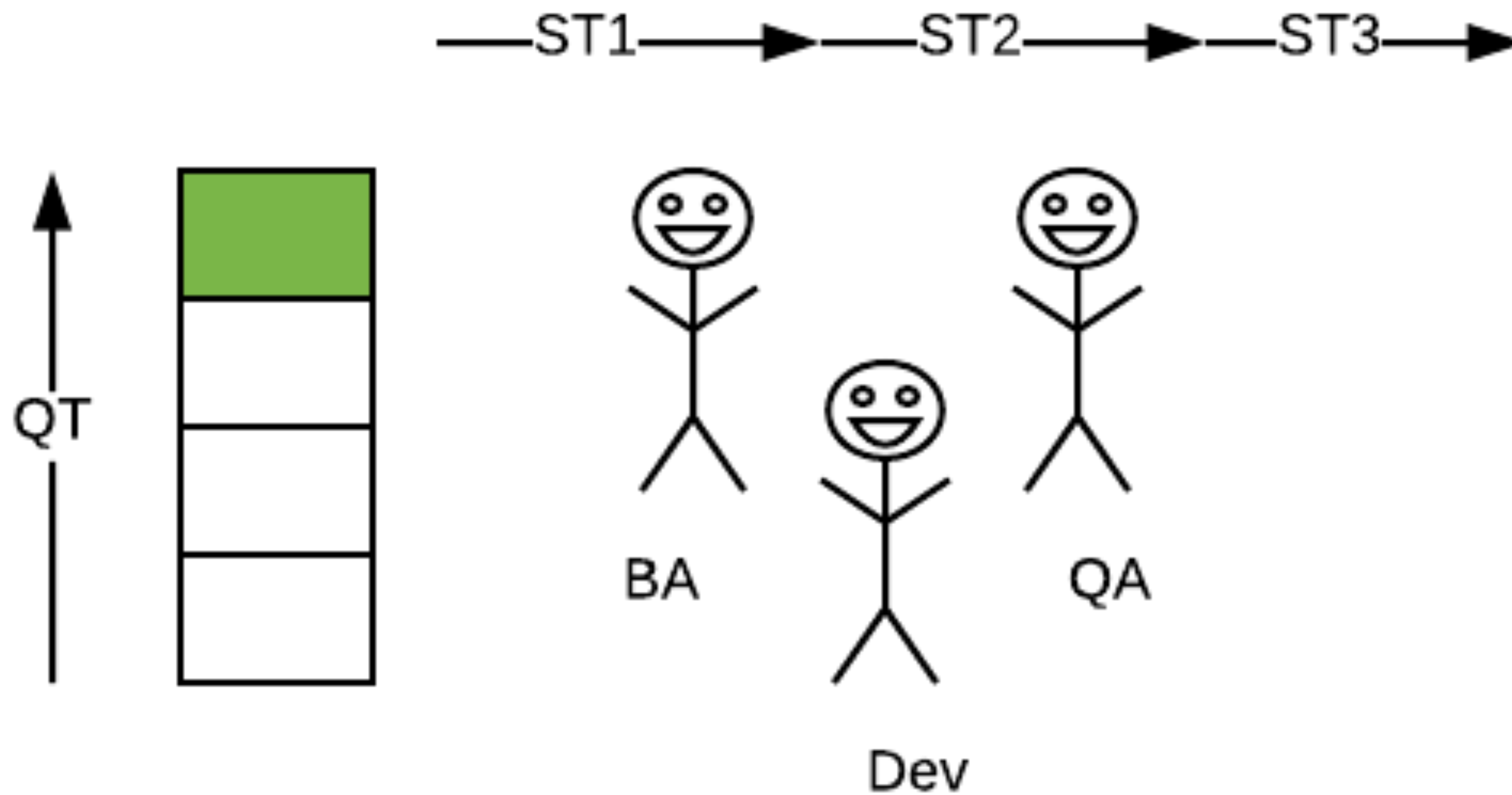


$$\text{Cycle Time} = (\text{QT1} + \text{ST1}) + (\text{QT2} + \text{ST2}) + (\text{QT3} + \text{ST3})$$

ILLUSION OF AN EFFICIENT TEAM



Cycle Time = QT + ST1 + ST2 + ST3

***NICCE* IS EFFECTIVE**