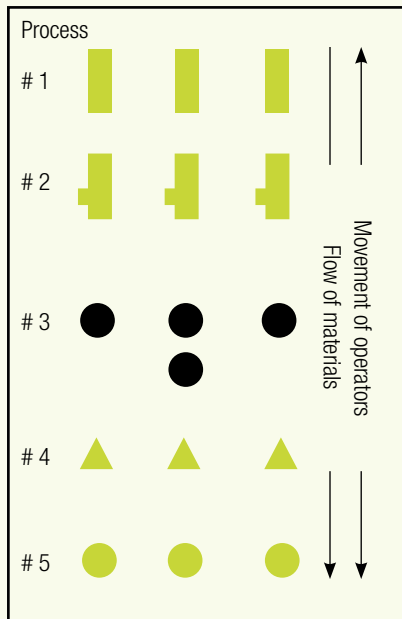


Process layout



Nagare cell layout

EXHIBIT 5.21 Changing from process to Nagare cell layout

SOURCE: Hill, T. (2005) *Operations Management*, 2nd edn, Basingstoke, Palgrave Macmillan