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Solutions from Montgomery, D. C. (2017) Design and Analysis of Experiments, Wiley, NY 1-3 Experimental runs can be expensive and time consuming. If an error were to occur while running the experiment, the cost of redoing the experiment is much more manageable with one of the small sequential experiments than the large comprehensive experiment. 1.11.

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experimental design early in the product cycle can substantially reduce development lead time and cost, leading to processes and products that perform better in the field and have higher reliability than those developed using other approaches.

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