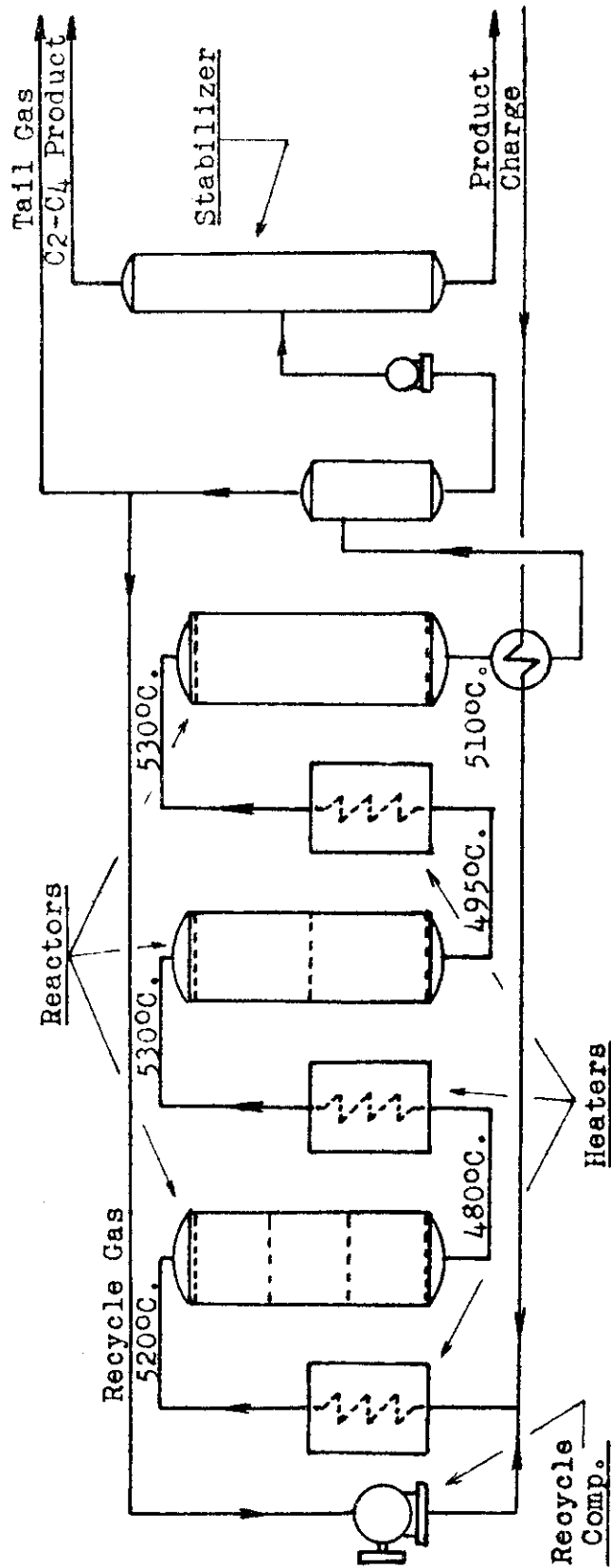


FIG. XIV



FLOW DIAGRAM - HYDROFORMING PROCESS