

PPAP

Production Part Approval Process

Submission Requirements

Quick Reference

(For Internal Cooper use Only)

Note: This document is meant to be a desk reference for Cooper Industries PPAP submissions. Complete guidelines and definition are provided in the Cooper Industries PPAP manual. Application and defined requirements are at the discretion of your Cooper Divisional Quality Representative. Contact them with any additional questions.

| Item<br>Order | PPAP Requirements<br><small>As of PPAP Fourth Edition</small> | Level 1 | Level 2 | Level 3 | Level 4 | Level 5 | Required Documents                                                                      | Additional Comments and Clarity                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|---------------|---------------------------------------------------------------|---------|---------|---------|---------|---------|-----------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1             | Part Submission Warrant (PSW)                                 |         |         |         | AR      |         | Cooper PSW only                                                                         | Cooper PSW is required for all submissions and required on all Cooper designed parts.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
| 2             | Design Records & Bubbleed part prints(s).                     |         |         |         | AR      |         | Cooper Divisional Part Print                                                            | Include one clean copy of the current approved revision print with all dimensions, applicable specifications, and notes, bubbleed (circle with corresponding number) on the print for reference to dimensional report.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| 3             | Approved Engineering Change Documentation                     |         |         |         | AR      | AR      | Various engineering documentation                                                       | Any formal documentation that is not reflected in the current released print such as un-released marked up prints, formal engineering changes and any pertinent engineering correspondence.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
| 4             | Customer Engineering Approvals                                |         |         |         |         |         | Not Required for Cooper Submissions                                                     | Not used with Cooper Industries submissions.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |
| 5             | Design FMEA,                                                  |         |         |         | AR      | AR      | Can be Cooper FMEA Form or an AIAG compliant DFMEA.                                     | Required only if supplier is responsible for part design.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| 6             | Process Flow Diagrams                                         |         |         |         | AR      |         | Any standard flowchart format.                                                          | Identifies all process steps from receiving to shipping/warehouse operations. Must include all offline and in process inspections and testing including ongoing routine performance checks such as annual dimensional layouts. Process steps must match PFMEA and Control Plan steps.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
| 7             | Process FMEA                                                  |         |         |         | AR      |         | Can be Cooper PFMEA Form or an AIAG compliant PFMEA.                                    | PFMEA must be AIAG or comparable format that contains the same information as the AIAG form. Process steps must match Process Flow Chart, Control Plan and address all characteristics associated with each operation. RPN numbers must be in accordance with AIAG guidelines with critical processes and inspections identified. Recommended Actions for high RPN items are required.                                                                                                                                                                                                                                                                                                                                                                                                    |
| 8             | Control Plan                                                  |         |         |         | AR      |         | Can be Cooper Control Plan or AIAG compliant format.                                    | Control Plan must be AIAG or comparable format that contains the same information. Must match the Flow Chart/FMEA, process steps and describe the actions of each phase of the manufacturing process from receiving to shipping/warehouse. All CTQ's and SPC items must be addressed within the corresponding process step. Any dedicated check/testing features that are used will be identified along with the numbered characteristics if measures/verifies/tests on the print. <b>All CTQ's must be identified in the control plan.</b>                                                                                                                                                                                                                                               |
| 9             | Measurement System Analysis Studies                           |         | AR      |         | AR      |         | Cooper GRR format or any statistical package format for gage RMR.                       | Require an analysis of the capability of all measuring tools identified in the Control Plan (in process or offline) used in the decision making process of normal production. As a minimum gauge RMRs, using percent of total tolerance must be included for all process tools used in determining acceptability of equipment measurement capability.                                                                                                                                                                                                                                                                                                                                                                                                                                     |
| 10            | Dimensional Results                                           |         |         |         | AR      |         | Must be on Cooper Dimensional report format                                             | Cooper Dimensional Data Sheet is only acceptable format.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| 11            | Material, Performance Test Results                            |         | AR      |         | AR      |         | Industry Standard reports or test result formats designated by Cooper Industries.       | Certificates of Analysis for all primary raw materials such as chemicals, plastic resins and rubber. Chemical composition lab reports for all metals and controlled substances. Performance life testing results such as salt spray, impact testing, heat, humidity, electrical performance, etc. when required either by print, specification or specific request by Cooper representative to be submitted on AIAG forms (CPG-1004, CPG-1005, or equivalent). For Catalog Parts Generic or family data maybe substituted with prior approval. AEC Qualification testing or equivalent is required for semiconductor devices. Any gaps between supplier qualification testing and AEC qualification testing requirements should be documented and approved by Cooper Prior to submission. |
| 12            | Initial Process Study (Cpk) Capability Studies                |         | AR      |         | AR      |         | Process Capability Study using any statistical package or Cooper Capability Data Forms. | A short term study of process control capability (Cpk), must come from one continuous significant production run. At least 100 individual samples must be used for Cpk calculations. Multi-cavity tools would require a separate study per cavity. Supplier must have minimum Cpk value of 1.33 on all CTQ's. No attribute data will be accepted for any PPAP submissions for Initial Process Study. If CTQ's are NOT identified on the print, the supplier will identify a minimum of two characteristics that have a direct effect on fit, form, or function and perform Initial Process Studies on them.                                                                                                                                                                               |
| 13            | Qualified Laboratory Documentation                            |         |         |         | AR      |         | Lab Scope and outside lab proof of accreditation.                                       | A Quality Record that contains the specific test/evaluation/calibrations that your facility performs, a list of your personnel's competency to perform these tests/evaluations/calibrations, a list of all measuring equipment used during production, and a list of methods and standards used to calibrate those tools. NOTE: All outside calibration or testing labs are required to show proof of certification.                                                                                                                                                                                                                                                                                                                                                                      |
| 14            | Appearance Approval Report                                    | AR      | AR      | AR      | AR      | AR      | AIAG format AAR                                                                         | Needed only if part has color, grain, or some other cosmetic appearance requirement specified on the part print, or if specifically requested by Cooper to clarify a cosmetic requirement not clearly identified on a print. Format is AIAG form CPG-1002.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| 15            | Sample Product Parts                                          |         |         |         | AR      |         | Parts tagged in accordance with Cooper PPAP reference manual                            | The organization shall provide 3 sample parts WITH EVERY submission unless otherwise requested. Multi-cavity tools require 1 part per cavity.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| 16            | Master Samples                                                |         |         |         |         |         | Required only for level 5.                                                              | Not required for submission but must be maintained by the supplier.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| 17            | Checking aids                                                 |         |         |         | AR      |         | Checking and design prints and GRR for checking fixtures.                               | Any part specific fixture, gauge, model or template. Tooling/gauges/fixtures must include design prints and a 3rd party layout confirming conformity to print.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |
| 18            | Customer Specific Requirements                                |         |         |         |         |         | Documents as specified by Cooper Industries                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
| a             | Tooling Information Form                                      |         |         |         | AR      |         | Specific Cooper Document                                                                | Applies to all Cooper owned tooling. Typical application includes information and pictures on production tools such size, maximum cycles, ownership etc.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| b             | Packaging Form                                                |         |         |         | AR      |         | Specific Cooper Document                                                                | Used to outline and verify both external and internal packaging requirements including any related testing.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |
| c             | Inspection Plan (AIAG Inspection map)                         |         | AR      | AR      | AR      | AR      | Specific AIAG Format                                                                    | Specific format used by many AEC suppliers to document quality inspections                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| d             | Specification Deviation Form                                  |         | AR      | AR      | AR      | AR      | Specific Cooper Document                                                                | Used for any requirement that is non-conforming and requires review by Cooper to provide for approval of the PPAP submission. The supplier must provide a recommended action plan for any issue identified on the Specification Deviation Form.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
| e             | Supplier PPAP Checklist                                       |         |         |         | AR      |         | Specific Cooper Document                                                                | To be submitted with every submission level except level 1 and must be signed by supplier representative. Used as both a reference/checklist tool as well as a verification that the right documentation is provided at the time of submission.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |

**Cooper Industries PPAP Submission Levels (in compliance with AIAG Fourth Edition PPAP March 2008 release)**

**Level 1:** Warrant only and Appearance Approval Report as requested submitted to the customer. **Applied to:** "non-critical" parts, "non critical" rework, material or catalog commodity parts for electrical applications, and re-certification of existing parts previously approved by Cooper at levels 3, 4 or 5. Also used for Self Certification.

**Level 2:** Warrant with product samples and limited supporting data submitted to the customer. **Applied to:** Critical Bulk products such as Plastic/Powder/Chemicals, critical fasteners, simple material changes, simple revision level only changes or simple print updates not affecting form-fit-function. This level can also be applied to low and medium risk parts within a product family.

**Level 3:** Warrant with product samples and complete supporting data submitted to customer. **Default Cooper Industries Submission Level** **Applied to:** All new parts on Cooper programs. All changes affecting form-fit-function, reliability, or performance. All product resources to new suppliers, initial production parts, existing high risk parts undergoing a part number change.

**Level 4:** Warrant and other requirements as defined by the customer. This level is reserved for special applications only. **Applied to:** This level can only be applied with prior approval from the designated divisional Cooper Quality PPAP representative.

**Level 5:** Warrant with product samples and complete supporting data reviewed at the supplier's manufacturing location. **Applied to:** On site review as requested by each Cooper Division

Required for PPAP submission

Not required

Documents on a case by case basis are marked AR for "As Requested"

AR

If Applicable

AR

# Aiag Ppap 4th Edition

**Bryan Dodson,Patrick Hammett,Rene  
Klerx**

## **Aiag Ppap 4th Edition :**

Advanced Product Quality Planning D. H. Stamatis, 2018-11-12 This book defines develops and examines the foundations of the APQP Advanced Product Quality Planning methodology It explains in detail the five phases and it relates its significance to national international and customer specific standards It also includes additional information on the PPAP Production Part Approval Process Risk Warranty GD T Geometric Dimensioning and Tolerancing and the role of leadership as they apply to the continual improvement process of any organization Features Defines and explains the five stages of APQP in detail Identifies and zeroes in on the critical steps of the APQP methodology Covers the issue of risk as it is defined in the ISO 9001 IATF 16949 the pending VDA and the OEM requirements Presents the role of leadership and management in the APQP methodology Summarizes all of the change requirements of the IATF standard **Quality Management in**

**Engineering** Jong S. Lim, 2019-07-30 This book introduces fundamental advanced and future oriented scientific quality management methods for the engineering and manufacturing industries It presents new knowledge and experiences in the manufacturing industry with real world case studies It introduces Quality 4 0 with Industry 4 0 including quality engineering tools for software quality and offers lean quality management methods for lean manufacturing It also bridges the gap between quality management and quality engineering and offers a scientific methodology for problem solving and prevention The methods techniques templates and processes introduced in this book can be utilized in various areas in industry from product engineering to manufacturing and shop floor management This book will be of interest to manufacturing industry leaders and managers who do not require in depth engineering knowledge It will also be helpful to engineers in design and suppliers in management and manufacturing all who have daily concerns with project and quality management Students in business and engineering programs may also find this book useful as they prepare for careers in the engineering and manufacturing industries Presents new knowledge and experiences in the manufacturing industry with real world case studies Introduces quality engineering methods for software development Introduces Quality 4 0 with Industry 4 0 Offers lean quality management methods for lean manufacturing Bridges the gap between quality management methods and quality engineering Provides scientific methodology for product planning problem solving and prevention management Includes forms templates and tools that can be used conveniently in the field **Fundamentals of Design of Experiments for**

**Automotive Engineering Volume I** Young J. Chiang, Amy L. Chiang, 2023-11-28 In a world where innovation and sustainability are paramount Fundamentals of Design of Experiments for Automotive Engineering Volume I serves as a definitive guide to harnessing the power of statistical thinking in product development As first of four volumes in SAE International's DOE for Product Reliability Growth series this book presents a practical application focused approach by emphasizing DOE as a dynamic tool for automotive engineers It showcases real world examples demonstrating how process improvements and system optimizations can significantly enhance product reliability The author Yung Chiang leverages

extensive product development expertise to present a comprehensive process that ensures product performance and reliability throughout its entire lifecycle Whether individuals are involved in research design testing manufacturing or marketing this essential reference equips them with the skills needed to excel in their respective roles This book explores the potential of Reliability and Sustainability with DOE featuring the following topics Fundamental prerequisites for deploying DOE Product reliability processes measurement uncertainty failure analysis and design for reliability Full factorial design 2K A system identification tool for relating objectives to factors and understanding main and interactive effects Fractional factorial design 2RK P Ideal for identifying main effects and 2 factor interactions General fractional factorial design LK P Systematically identification of significant inputs and analysis of nonlinear behaviors Composite designs as response surface methods Resolving interactions and optimizing decisions with limited factors Adapting to practical challenges with short DOE Leveraging optimization schemes like D optimality and A optimality for optimal results Readers are encouraged not to allow product failures to hinder progress but to embrace the statistical thinking embedded in DOE This book can illuminate the path to designing products that stand the test of time resulting in satisfied customers and thriving businesses ISBN 9781468606027 ISBN 9781468606034 ISBN 9781468606041 DOI 10 4271 9781468606034 *Global Standards and Publications Edition 2023 - 2024* Van Haren Publishing, 2023-02-05 Van Haren Publishing is the world's leading publisher in best practice methods and standards within IT Management Project Management Enterprise Architecture and Business Management We are the official publisher for some of the world's leading organizations and their frameworks including BIAN CATS DID Foundation Half Double Institute Agile Consortium IACCM IAOP IPMA ISM LSSA Nederlandse AI Coalitie PMI The Open Group This catalog will provide you with an overview of our learning solutions and training material but also gives you a quality summary on internationally relevant frameworks Van Haren Publishing is an independent worldwide recognized publisher well known for our extensive professional network authors reviewers and accreditation bodies of standards flexibility and years of experience We make content available in hard copy and digital formats designed to suit your personal preference iPad Kindle and online available through over 2000 distribution partners Amazon Google Play Managementboek and Bol.com etc

Quality Planning and Assurance Herman Tang, 2021-11-23 QUALITY PLANNING AND ASSURANCE Discover the most crucial aspects of quality systems planning critical to manufacturing and service success In Quality Planning and Assurance Principles Approaches and Methods for Product and Service Development accomplished engineer Dr Herman Tang delivers an incisive presentation of the principles of quality systems planning The book begins with an introduction to the meaning of the word quality before moving on to review the principles of quality strategy and policy management The author then offers a detailed discussion of customer needs and the corresponding quality planning tasks in design phases as well as a treatment of the design processes necessary to ensure product or service quality Readers will enjoy explorations of advanced topics related to proactive approaches to quality management like failure modes and effects

analysis FMEA They ll discover discussions of issues like supplier quality management and the key processes associated with quality planning and execution The book also includes A thorough introduction to quality planning including definitions discussions of quality system and an overview of the planning process A comprehensive exploration of strategic planning development including strategic management risk management and analysis and pull and push strategies Practical discussions of customer centric planning including customer oriented design quality function deployment and affective engineering In depth examinations of quality assurance by design including the design review process design verification and validation and concurrent engineering Perfect for senior undergraduate and graduate students in technology and management programs Quality Planning and Assurance will also earn a place in the libraries of managers and technical specialists in a wide range of fields including quality management

**Functional Safety for Road Vehicles** Hans-Leo Ross,2016-07-25 This book highlights the current challenges for engineers involved in product development and the associated changes in procedure they make necessary Methods for systematically analyzing the requirements for safety and security mechanisms are described using examples of how they are implemented in software and hardware and how their effectiveness can be demonstrated in terms of functional and design safety are discussed Given today s new E mobility and automated driving approaches new challenges are arising and further issues concerning Road Vehicle Safety and Road Traffic Safety have to be resolved To address the growing complexity of vehicle functions as well as the increasing need to accommodate interdisciplinary project teams previous development approaches now have to be reconsidered and system engineering approaches and proven management systems need to be supplemented or wholly redefined The book presents a continuous system development process starting with the basic requirements of quality management and continuing until the release of a vehicle and its components for road use Attention is paid to the necessary definition of the respective development item the threat hazard and risk analysis safety concepts and their relation to architecture development while the book also addresses the aspects of product realization in mechanics electronics and software as well as for subsequent testing verification integration and validation phases In November 2011 requirements for the Functional Safety FuSa of road vehicles were first published in ISO 26262 The processes and methods described here are intended to show developers how vehicle systems can be implemented according to ISO 26262 so that their compliance with the relevant standards can be demonstrated as part of a safety case including audits reviews and assessments

**Project Management of Complex and Embedded Systems** Kim H. Pries,Jon M. Quigley,2008-10-22 There are many books on project management and many on embedded systems but few address the project management of embedded products from concept to production Project Management of Complex and Embedded Systems Ensuring Product Integrity and Program Quality uses proven Project Management methods and elements of IEEE embedded software development techniques to explain how to deliver a reliable complex system to market This volume begins with a general discussion of project management followed by an examination

of the various tools used before a project is underway The book then delves into the specific project stages concept product development process development validation of the product and process and release to production Finally post project stages are explored including failure reporting analysis corrective actions and product support The book draws heavily on information from Department of Defense sources as well as systems developed by the Automotive Industry Action Group General Motors Chrysler and Ford to standardize the approach to designing and developing new products These automotive development and production ideas have universal value particularly the concept of process and design controls The authors use these systems to explain project management techniques that can assist developers of any embedded system The methods explored can be adapted toward mechanical development projects as well The text includes numerous war stories offering concrete solutions to problems that might occur in production Tables and illustrative figures are provided to further clarify the material Organized sequentially to follow the normal life cycle of a project this book helps project managers identify challenges before they become problems and resolve those issues that cannot be avoided [Probabilistic Design for Optimization and Robustness for Engineers](#) Bryan Dodson,Patrick Hammett,Rene Klerx,2014-07-21 Probabilistic Design for Optimization and Robustness Presents the theory of modeling with variation using physical models and methods for practical applications on designs more insensitive to variation Provides a comprehensive guide to optimization and robustness for probabilistic design Features examples case studies and exercises throughout The methods presented can be applied to a wide range of disciplines such as mechanics electrics chemistry aerospace industry and engineering This text is supported by an accompanying website featuring videos interactive animations to aid the readers understanding **Automotive Process Audits** D. H. Stamatis,2021-04-29 With a detailed discussion on the preparation and tools needed for an automotive process audit this book addresses the fundamental issues and concerns by focusing on two objectives explaining the methods and tools used in the process for the organization and provide a reference or manual for dealing with documenting quality issues This book addresses the fundamental issues and concerns for a successful automotive process audit and details specifically how to prepare for it It presents a complete assessment of what an organization must do to earn certification in ISO standards industry standards and customer specific requirements It also focuses on the efficiency of resources within an organization so that an audit can be successful and describes the methodologies to optimize the process by knowing what to do what to say and how to prove it A road map is offered for the process audit and the layered audit and defines a clear distinction between the preparation details for each This book is intended for those that conduct audits those who are interested in auditing and those who are being audited It specifically addresses how to prepare for an automotive process audit for readers who are involved in quality manufacturing and operations management and those who work with suppliers

**Lean Six Sigma for Hospitals: Improving Patient Safety, Patient Flow and the Bottom Line, Second Edition** Jay Arthur,2016-09-05 Simple Steps to Improve Patient Safety Patient Flow and the Bottom Line A Doody s Core Title for 2021

This thoroughly revised resource shows step by step how to simplify streamline analyze and optimize healthcare performance using tested Lean Six Sigma and change management techniques Lean Six Sigma for Hospitals Second Edition follows the patient from the front door of the hospital or emergency room all the way through discharge The book fully explains how to improve operations and quality of care while dramatically reducing costs often in just five days Real world case studies from major healthcare institutions illustrate successful implementations of Lean Six Sigma Coverage includes Lean Six Sigma for hospitals emergency departments operating rooms medical imaging facilities nursing units pharmacies and ICUs Patient flow and quality Clinical staff Order and claims accuracy Billing and collection Defect and medical error reduction Excel power tools for Lean Six Sigma Data mining and analysis Process flow charts and control charts Laser focused process innovation Statistical tools for Lean Six Sigma Planning and implementation

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## **Table of Contents Aiag Ppap 4th Edition**

1. Understanding the eBook Aiag Ppap 4th Edition
  - The Rise of Digital Reading Aiag Ppap 4th Edition
  - Advantages of eBooks Over Traditional Books
2. Identifying Aiag Ppap 4th Edition
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Aiag Ppap 4th Edition
  - User-Friendly Interface
4. Exploring eBook Recommendations from Aiag Ppap 4th Edition
  - Personalized Recommendations
  - Aiag Ppap 4th Edition User Reviews and Ratings
  - Aiag Ppap 4th Edition and Bestseller Lists

5. Accessing Aiag Ppap 4th Edition Free and Paid eBooks
  - Aiag Ppap 4th Edition Public Domain eBooks
  - Aiag Ppap 4th Edition eBook Subscription Services
  - Aiag Ppap 4th Edition Budget-Friendly Options
6. Navigating Aiag Ppap 4th Edition eBook Formats
  - ePub, PDF, MOBI, and More
  - Aiag Ppap 4th Edition Compatibility with Devices
  - Aiag Ppap 4th Edition Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Aiag Ppap 4th Edition
  - Highlighting and Note-Taking Aiag Ppap 4th Edition
  - Interactive Elements Aiag Ppap 4th Edition
8. Staying Engaged with Aiag Ppap 4th Edition
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Aiag Ppap 4th Edition
9. Balancing eBooks and Physical Books Aiag Ppap 4th Edition
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Aiag Ppap 4th Edition
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Aiag Ppap 4th Edition
  - Setting Reading Goals Aiag Ppap 4th Edition
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Aiag Ppap 4th Edition
  - Fact-Checking eBook Content of Aiag Ppap 4th Edition
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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