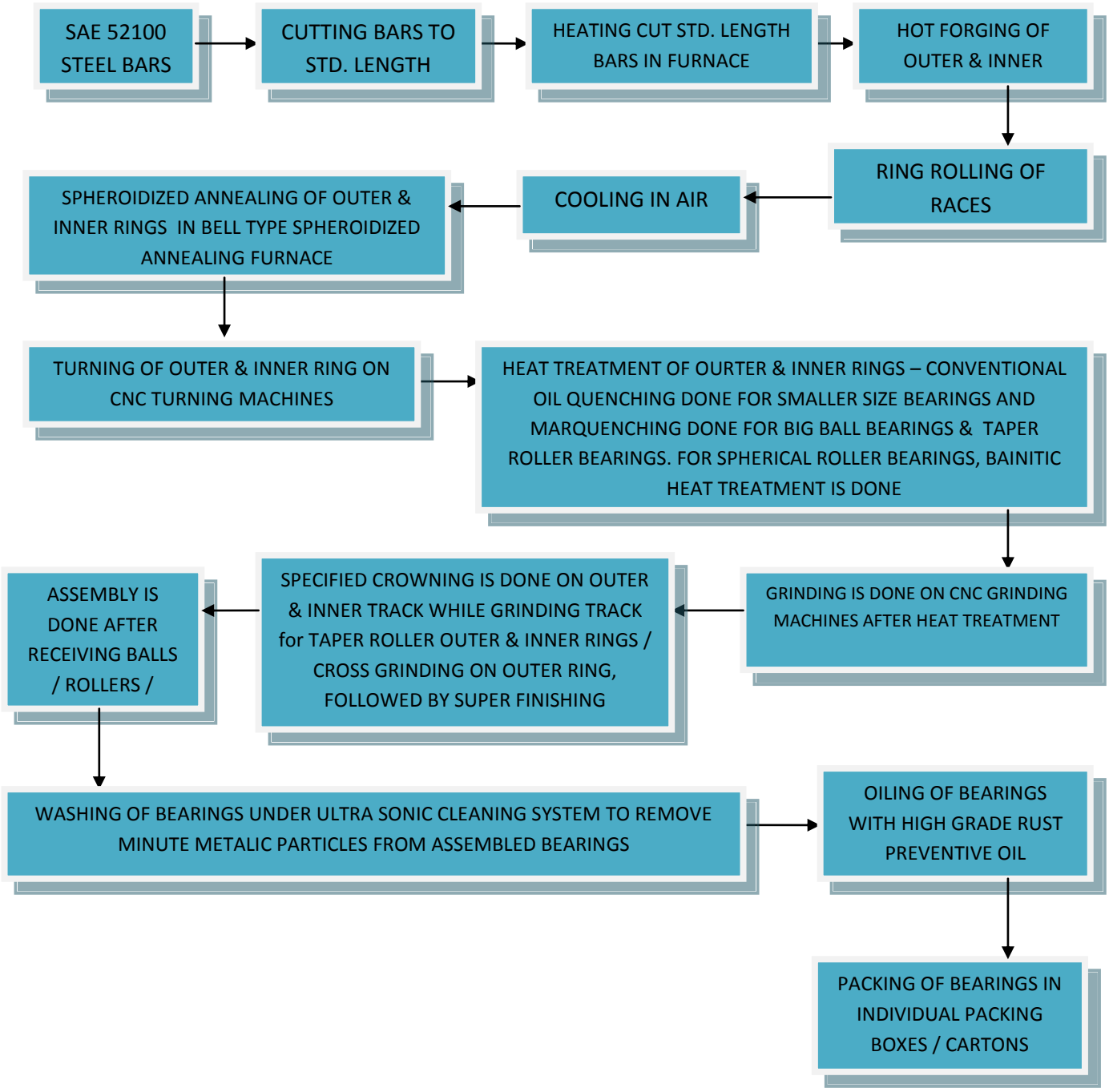PROCESS CHART FOR MANUFACTURING U.R.B. ® BEARINGS OUTER & INNER RACES