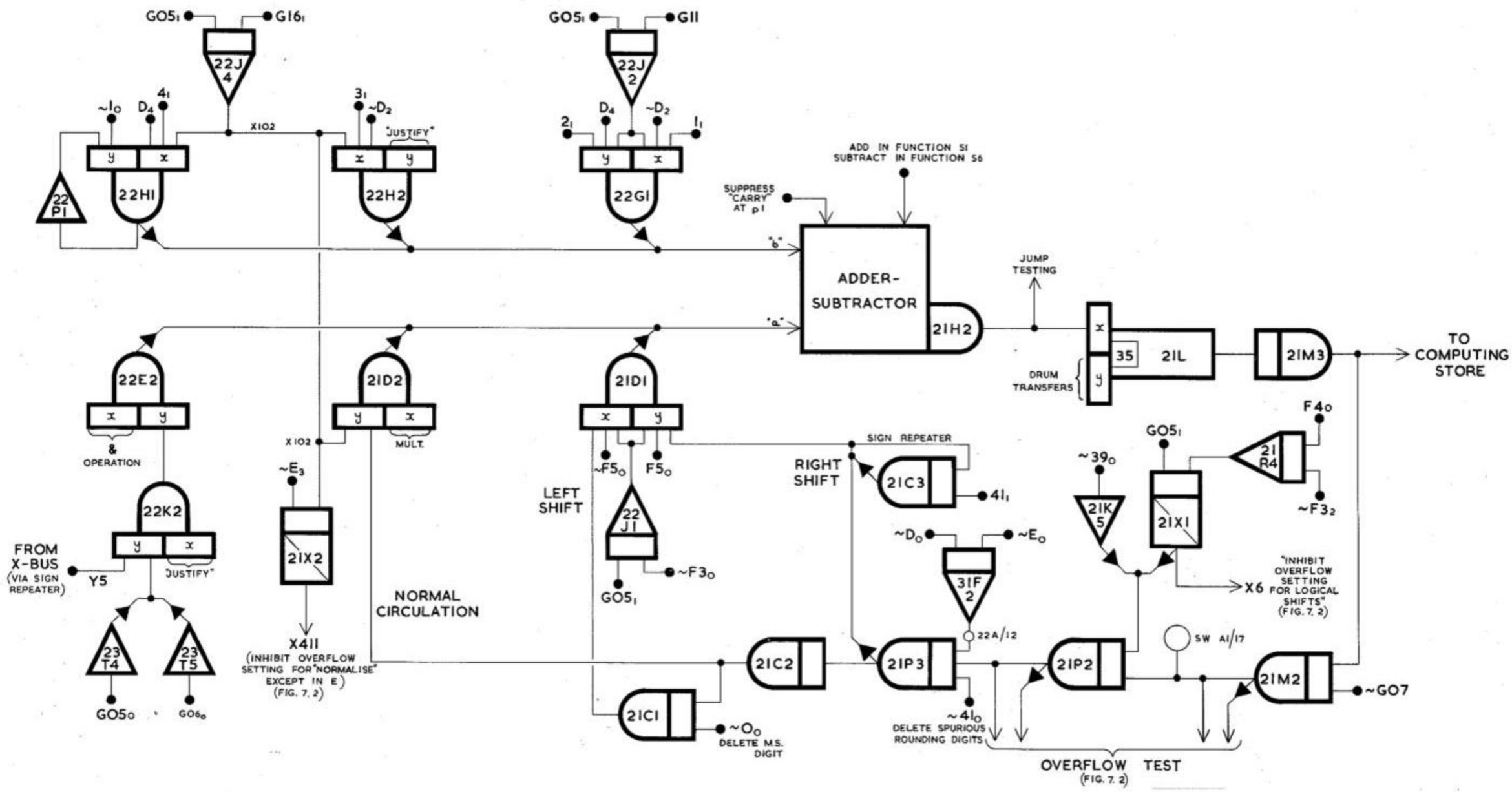

FIG. 16. 2 THE MILL IN SHIFT ORDERS