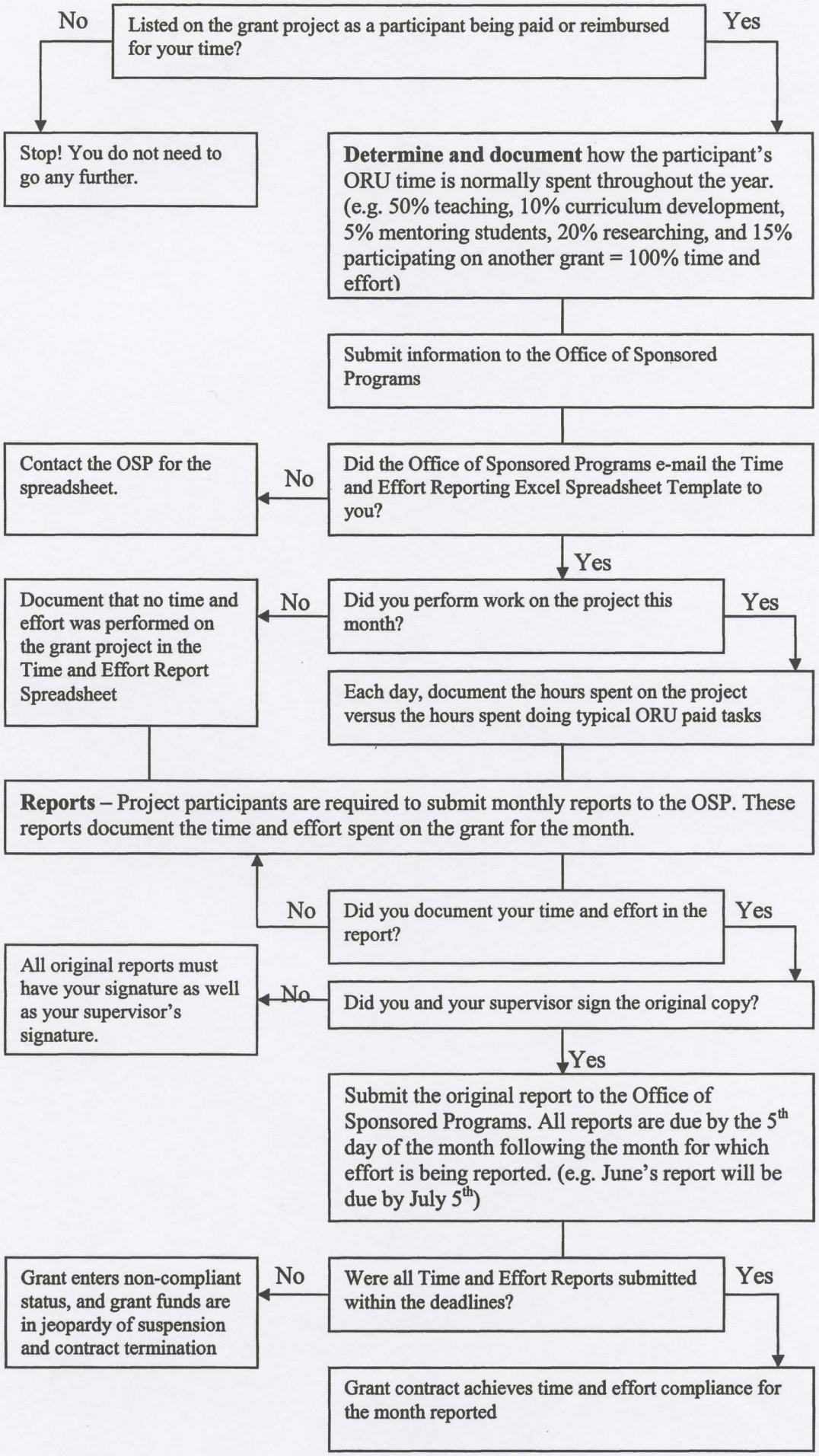Time and Effort Procedure Chart