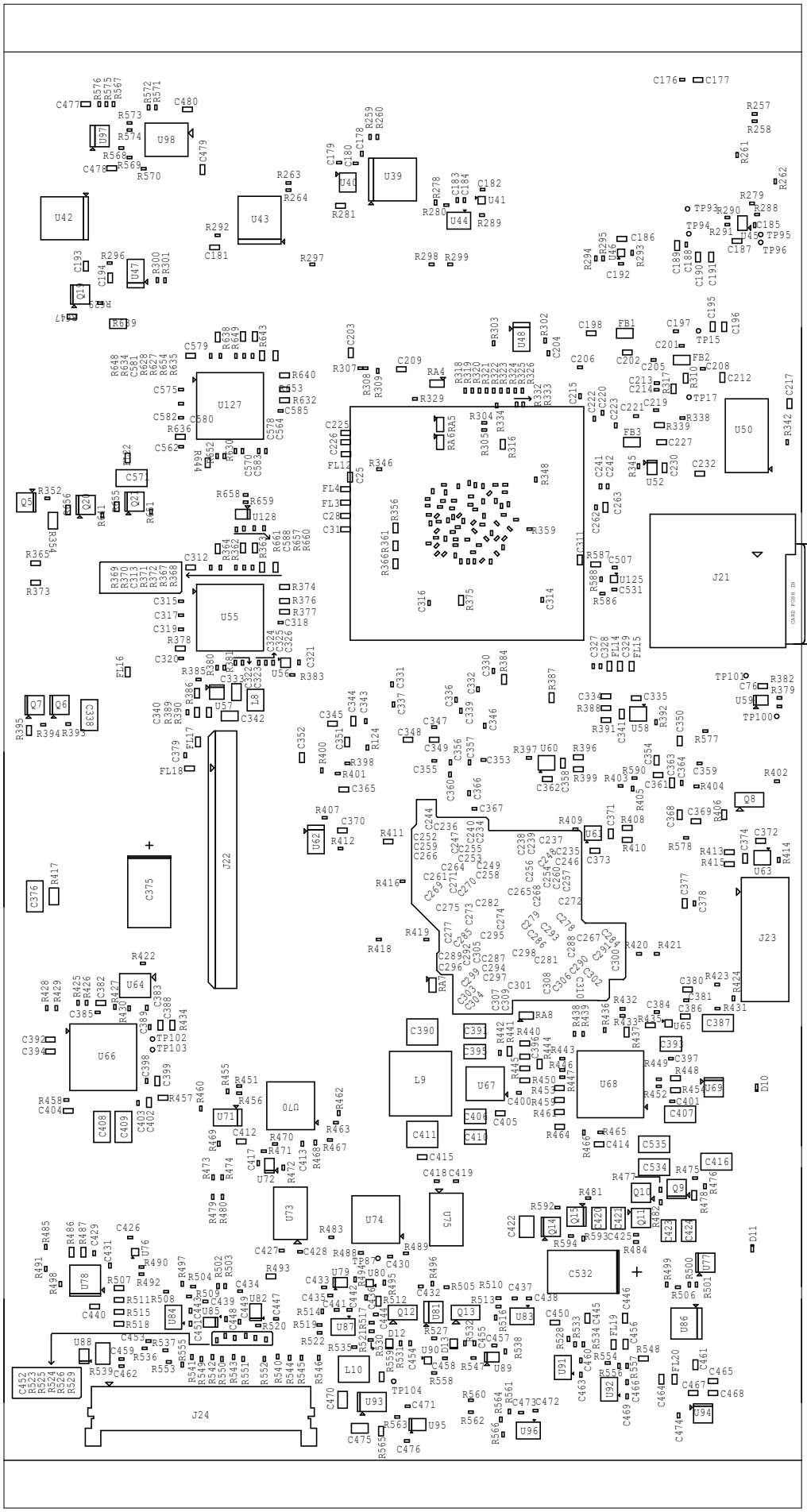PROC124E2 ASSEMBLY BOTTOM REV 1