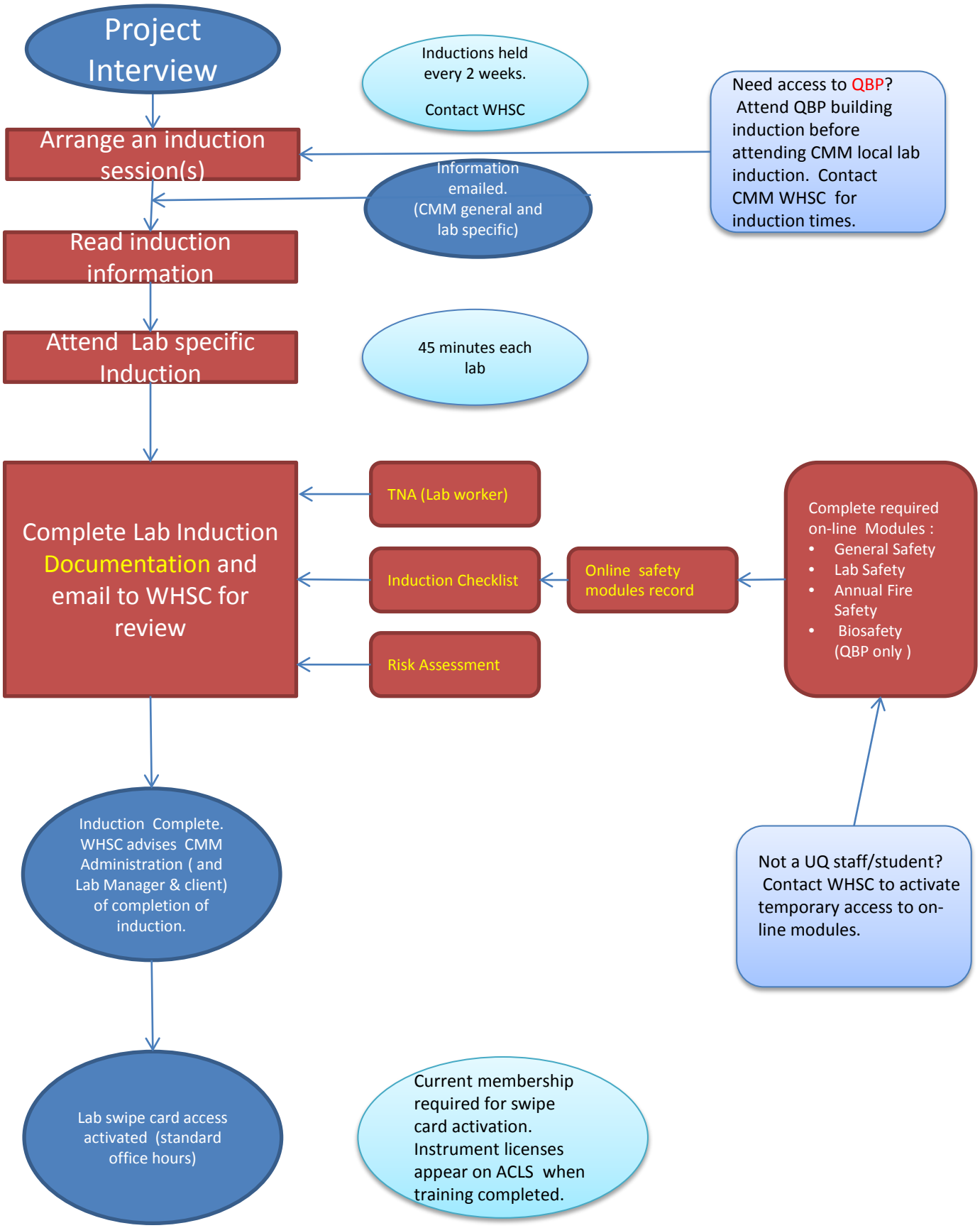CMM Induction Process