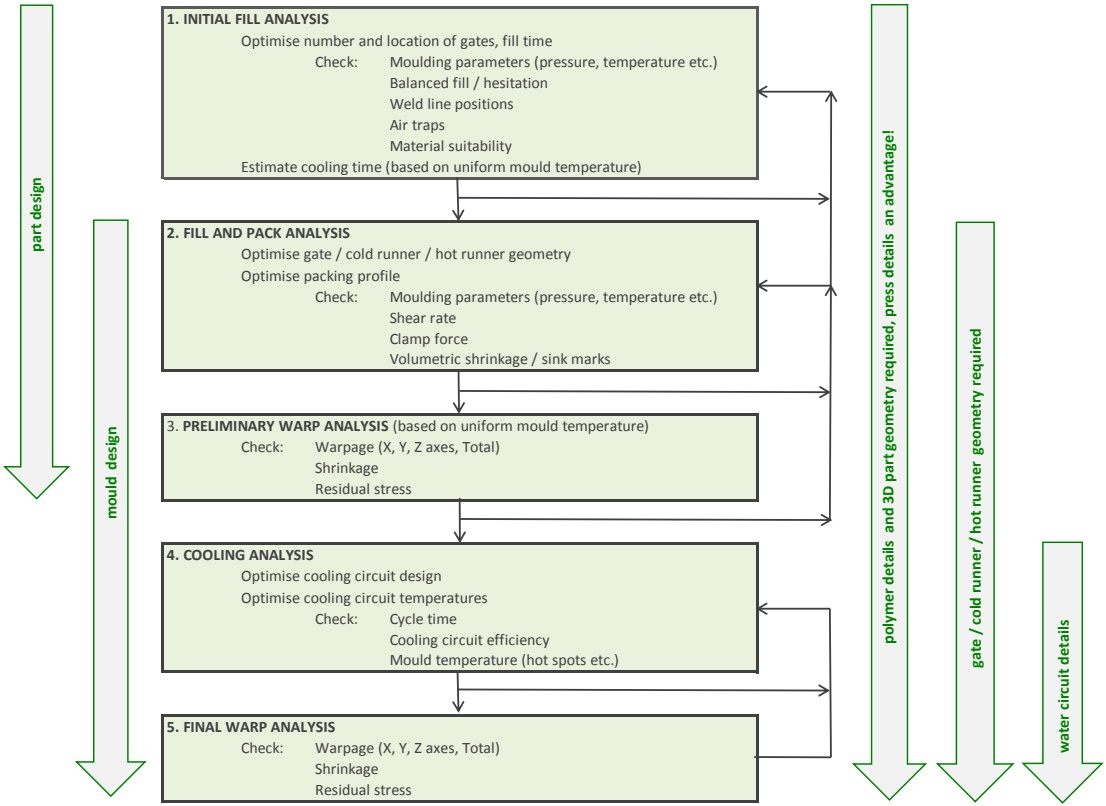TYPICAL FULL MOULD FLOW ANALYSIS SEQUENCE FOR A NEW PART