



Supplier Run at Rate Form

SECTION 1 - GENERAL INFORMATION

SECTION 2 - CAPACITY REQUIREMENTS

Stackpole Receiving Division: _____
 SI Contact (Program Manager): _____
 Supplier Name: _____
 Date: _____
 Supplier Location : _____

APW	MPW
Requirements: _____	
Supplier Plant Contact: _____	
Stackpole Plant Contact: _____	

SECTION 3 - PRODUCT INFORMATION

SECTION 4 - SUPPLIER WORK SCHEDULE - (Supplier)

Stackpole Part #	Part Name & Description	Program Name & Year	Annual Volume	Wks/Year
				47.2

SECTION 5 -SUPPLIER PROCESS FLOW (Supplier Data to Determine/Estimate Efficiency and Scrap)

OP #	Description	HRS/Shift	Shifts/Day	Cycle (Sec.)	Efficiency %	% Scrap	Adj. Cycle	Allocation %	PCS/HR	Target/HR	Utilization %

Primary Capacity Constraint 0%

SECTION 6 -CHECKLIST ITEMS

ITEM	YES	NO	COMMENTS
Product - Has AIAG APQP A-2 been verified and acceptable?	<input type="checkbox"/>	<input type="checkbox"/>	
Process Plan - have A-3, 5, 6 & 7 been verified and acceptable?	<input type="checkbox"/>	<input type="checkbox"/>	
Process Implementation - has A-4 been verified and acceptable?	<input type="checkbox"/>	<input type="checkbox"/>	
Are the correct number of operators being used per quote?	<input type="checkbox"/>	<input type="checkbox"/>	
Control Plan - has A-8 been verified and acceptable?	<input type="checkbox"/>	<input type="checkbox"/>	
Is mistake proofing acceptable (including zebra parts)?	<input type="checkbox"/>	<input type="checkbox"/>	
- zebra part listing including back-ups			
- mistake proofing for changeovers if applicable			
- mistake-proof of non-automated operations to prevent manual mistakes			
Are both the calculated and actual capacity <100%?	<input type="checkbox"/>	<input type="checkbox"/>	
Are all FTC %'s > 70%? And Overall Line FTC acceptable?	<input type="checkbox"/>	<input type="checkbox"/>	
Is SPC in place per control plan and visual near production?	<input type="checkbox"/>	<input type="checkbox"/>	
Has the ramp plan been discussed and verified?	<input type="checkbox"/>	<input type="checkbox"/>	
Have all open SCARs and SECRs been reviewed?	<input type="checkbox"/>	<input type="checkbox"/>	
Has sub-supplier Run-at-Rate been completed and approved?	<input type="checkbox"/>	<input type="checkbox"/>	
Have provisions been made to address shelf-life if applicable?	<input type="checkbox"/>	<input type="checkbox"/>	
Have long lead-time components been ordered to support SOP?	<input type="checkbox"/>	<input type="checkbox"/>	
Is packaging in place per the approved Packaging Declaration?	<input type="checkbox"/>	<input type="checkbox"/>	
Has a contingency plan been developed?	<input type="checkbox"/>	<input type="checkbox"/>	

SECTION 7 - SIGNATURES

Supplier Sign-Off	Stackpole Sign-Off	Date
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Supplier Run at Rate Form

SECTION 1 - GENERAL INFORMATION

Stackpole Receiving Division: Engineered Products Division - Ancaster
SI Contact (Program Manager): Mary Jane
Supplier Name: ABC Stamping Co. - #99911
Date: mm-dd-yyyy
Supplier Location : Ancaster, Ontario - Canada

SECTION 2 - CAPACITY REQUIREMENTS

Requirements:	APW	MPW
	685	785
Supplier (Plant) Contact:	Jane Mary	
Supplier (Plant) Contact Email:	janemary@supplier.com	

SECTION 3 - PRODUCT INFORMATION

Stackpole Part #	Part Name & Description	Program Name & Year	Annual Volume
12345AB	Cover Housing Bracket LH	Ford P221 2019	750,000

SECTION 4 - SUPPLIER WORK SCHEDULE - (Supplier)

Wks/Year
47.2

SECTION 5 - SUPPLIER PROCESS FLOW (Supplier Data to Determine/Estimate Efficiency and Scrap)

OP #	Description	HRS/Shift	Shifts/Day	Cycle (Sec.)	Efficiency %	% Scrap	Adj. Cycle	Allocation %	PCS/HR	Target/HR	Utilization %
10	Stamp Bracket in Press	10.00	2	6.00	95%	3.0%	6.49	75.5%	555		
20	Vibratory Debur	8.00	2	3.20	95%	1.0%	3.39	100.0%	1061		
30	Weld Stud to Bracket	8.00	2	6.50	80%	8.0%	8.42	100.0%	427		
40	E-Coat (Batch)	8.00	3	2.10	97%	5.0%	2.27	55.0%	1585		
50	Inspect Part	8.00	2	4.50	90%	0.0%	4.95	100.0%	727		
60	Pack and Label box	8.00	2	5.50	90%	0.0%	6.05	100.0%	595		

Primary Capacity Constraint **0%**

SECTION 6 - CHECKLIST ITEMS

ITEM	YES	NO	COMMENTS
Product - Has AIAG APQP A-2 been verified and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Current design level is AB, Team Feasibility is approved without issues
Process Plan - have A-3, 5, 6 & 7 been verified and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	one custom gauge owned by Ford to measure stud location. Stamping tool and gauge marked as "Property of Ford Motor Co."
Process Implementation - has A-4 been verified and acceptable?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Operator training complete on 1st shift only. Second shift to be complete by 6/20/06
Are the correct number of operators being used per quote?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	3.5 operators quoted in RFQ and verified
Control Plan - has A-8 been verified and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is mistake proofing acceptable (including zebra parts)? - zebra part listing including back-ups - mistake proofing for changeovers if applicable - mistake-proof of non-automated operations to prevent manual mistakes	<input type="checkbox"/>	<input checked="" type="checkbox"/>	mistake proofing in place but back-up zebra parts not available. Back-up parts to be created and logged in system by 4/24/06
Are both the calculated and actual capacity <100%?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	No, new welder is being installed to double capacity for welding operation - ready on 8/5/06
Are all FTC %'s > 70%? And Overall Line FTC acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is SPC in place per control plan and visual near production?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	SPC charts are kept in QC area - need to bring out to work cells
Has the ramp plan been discussed and verified?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Have all open SCARs and SECRs been reviewed?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	SL12020069999 corrective action verified, no SECRs
Has sub-supplier Run-at-Rate been completed and approved?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	R@R completed at stud supplier 4/14/06. Results acceptable and on file.
Have provisions been made to address shelf-life if applicable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	does not apply
Have long lead-time components been ordered to support SOP?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is packaging in place per the approved Packaging Declaration?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Has a contingency plan been developed?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Evaluating running die on alternate presses for contingency plan

SECTION 7 - SIGNATURES

Supplier Sign-Off

Stackpole Sign-Off

Date

Section 1: Capacity Planning															
Supplier to demonstrate APW of		-		parts per week operating no more than 5 days a week											
Supplier to demonstrate MPW of		-		parts per week operating no more than 6 days a week											
Planned Operating Pattern & Available Time				Process 1		Process 2		Process 3		Process 4		Process 5		Process 6	
A	Process Description			APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW
B	Days/week														
C	Shifts/Day														
D	Total Hours/Shift														
E	Planned Downtime (min/shift)														
F	Allocation Percent														
G	Net Available Time (Hours/Week)														
(i)	Planned minutes per changeover (into this part#)														
(ii)	Planned changeover freq/Week (into this part#)														
Section 2: Required Good Parts per Week															
H	Percentage of parts scrapped			APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW
I	Required good parts per week to support next process														
Req'd Incoming parts for		Avg Weekly	Max Weekly												
		-	-												
Section 3: Required OEE (Overall Equipment Effectiveness)															
K	Ideal Cycle Time per Tool or Machine (sec/cycle)			APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW
L	# of Tools or Machines in parallel														
M	# of identical parts produced per Tool/Machine Cycle														
N	Net Ideal Cycle Time (sec/part)														
P	Theoretical Parts per week at 100% OEE														
Q	Required OEE														
R	Percent of parts reworked (re-run through process)														
S	Can process contain its changeover, scrap & rework assumptions?														
T	% Remaining for Availability & Performance Efficiency losses														
Section 4: Supplier - Historical Performance															
Historical Performance (Historical Manufacturing Performance Summary)															
	GPP	NICT	NAT	OEE		GPP	NICT	NAT	OEE		GPP	NICT	NAT	OEE	
Week #1				-	Week #1				-	Week #1				-	
Week #2				-	Week #2				-	Week #2				-	
Week #3				-	Week #3				-	Week #3				-	
Week #4				-	Week #4				-	Week #4				-	
Week #5				-	Week #5				-	Week #5				-	
Week #6				-	Week #6				-	Week #6				-	
Week #7				-	Week #7				-	Week #7				-	
Week #8				-	Week #8				-	Week #8				-	
Average Historical OEE				-	Average Historical OEE				-	Average Historical OEE				-	
	GPP	NICT	NAT	OEE		GPP	NICT	NAT	OEE		GPP	NICT	NAT	OEE	
Week #1				-	Week #1				-	Week #1				-	
Week #2				-	Week #2				-	Week #2				-	
Week #3				-	Week #3				-	Week #3				-	
Week #4				-	Week #4				-	Week #4				-	
Week #5				-	Week #5				-	Week #5				-	
Week #6				-	Week #6				-	Week #6				-	
Week #7				-	Week #7				-	Week #7				-	
Week #8				-	Week #8				-	Week #8				-	
Average Historical OEE				-	Average Historical OEE				-	Average Historical OEE				-	
Process Description (Historical Performance)															
Supplier Name															
Supplier Location															
Surrogate Customer & Program reference															
Reference Surrogate Process (- Coiling Coiler #45)															
Enter any other assumptions for clarification (Part Number, ...)															
Section 5: Shared Process - Total Allocation Plan															
U	Total % Allocation for the process/tool														
Part #	Stackpole Part	Process 1		Process 2		Process 3		Process 4		Process 5		Process 6			
		Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation		
Other % Allocation - Description															
Percentage of NAT not utilized for production (%) (PM, etc.)															
Total % Allocation															
Section 6: Supplier Demonstrated OEE (Overall Equipment Effectiveness)															
Equipment Availability															
V	Total available time (minutes) (Actual changeover NOT included for shared)														
W	Planned downtime - lunches, breaks (minutes)														
X	Net Available time (minutes) [V-W]														
Y	Shared Equipment changeover time ACTUAL		NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED	NOT REQUIRED		
Z	Shared Equipment changeover time Weekly scaled														
AB	Observed Unplanned Downtime (minutes)														
AC	Operating time (Minutes) [X-AB]														
AD	Equipment Availability														
Performance Efficiency															
AE	Total parts run (Good, Scrapped, and Reworked)														
AF	Planned Net Ideal Cycle Time(Sec/part)														
AG	Performance Efficiency														
AH	"Availability" and/or "Performance Efficiency" Losses not captured (minutes)														
Quality rate															
AJ	# Parts Scrapped														
AK	# Parts Reworked														
AL	Quality rate														
AM	Overall Equipment Effectiveness														
Required OEE Vs. Demonstrated OEE															
Demonstrated OEE > Required OEE?															
Section 7: DOWNTIME / NONCONFORMANCE ANALYSIS															
OP #	DESCRIPTION	Downtime	Reject Qty	DOWNTIME REASON				REJECT REASON							
-	-	-	-	-	-	-	-	-	-	-	-				
-	-	-	-	-	-	-	-	-	-	-	-				
-	-	-	-	-	-	-	-	-	-	-	-				
-	-	-	-	-	-	-	-	-	-	-	-				
-	-	-	-	-	-	-	-	-	-	-	-				

Section 1: Capacity Planning																	
Supplier to demonstrate APW of				parts per week operating no more than 5 days a week													
Supplier to demonstrate MPW of				parts per week operating no more than 6 days a week													
Planned Operating Pattern & Available Time		Process 1		Process 2		Process 3		Process 4		Process 5		Process 6					
		APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW				
A	Process Description																
B	Days/week	7.00	6	5	6	5	6	5	6	5	6	5	6				
C	Shifts/Day	3.00	3	3	3	3	3	3	3	3	3	3	3				
D	Total Hours/Shift	8.00	8	8	8	8	8	8	8	8	8	8	8				
E	Planned Downtime (min/shift)	75.00	75	75	75	75	75	75	75	75	75	75	75				
F	Allocation Percent	75%	75%	75%	75%	75%	75%	75%	75%	75%	75%	75%	75%				
G	Net Available Time (Hours/Week)	106.31	91.13	75.94	91.13	75.94	91.13	75.94	91.13	75.94	91.13	75.94	91.13				
(i)	Planned minutes per changeover (into this part#)	45.00		45.00		45.00		45.00		45.00		45.00					
(ii)	Planned changeover freq/Week (into this part#)	5.00		5.00		5.00		5.00		5.00		5.00					
Section 2: Required Good Parts per Week																	
		APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW				
H	Percentage of parts scrapped	2%		2%		2%		2%		2%		2%					
I	Required good parts per week to support next process																
Req'd Incoming parts for		Avg Weekly		Max Weekly													
Section 3: Required OEE (Overall Equipment Effectiveness)																	
		APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW	APW	MPW				
K	Ideal Cycle Time per Tool or Machine (sec/cycle)	100.00	105	110	115	102	117	119	125	127	128	137	139				
L	# of Tools or Machines in parallel	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00				
M	# of identical parts produced per Tool/Machine Cycle	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00	2.00				
N	Net Ideal Cycle Time (sec/part)	50.00	52.50	55.00	57.50	51.00	58.50	59.50	62.50	63.50	64.00	68.50	69.50				
P	Theoretical Parts per week at 100% OEE	7654.00	6248.00	4970.00	5705.00	5360.00	5607.00	4594.00	5248.00	4305.00	5125.00	3990.00	4720.00				
Q	Required OEE																
R	Percent of parts reworked (re-run through process)	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%	3.00%				
S	Can process contain its changeover, scrap & rework assumptions?																
T	% Remaining for Availability & Performance Efficiency losses																
Section 4: Supplier - Historical Performance																	
Historical Performance (Historical Manufacturing Performance Summary)																	
GPP		NICT		NAT		OEE				GPP		NICT		NAT		OEE	
Week #1	2000.00	45.00	50.00	50.00%	Week #1	2000.00	45.00	50.00	50.00%	Week #1	2000.00	45.00	50.00	50.00%			
Week #2					Week #2					Week #2							
Week #3					Week #3					Week #3							
Week #4					Week #4					Week #4							
Week #5					Week #5					Week #5							
Week #6					Week #6					Week #6							
Week #7					Week #7					Week #7							
Week #8					Week #8					Week #8							
Average Historical OEE				50.00%		Average Historical OEE		50.00%		Average Historical OEE		50.00%					
GPP		NICT		NAT		OEE				GPP		NICT		NAT		OEE	
Week #1	2000.00	45.00	50.00	50.00%	Week #1	2000.00	45.00	50.00	50.00%	Week #1	2000.00	45.00	50.00	50.00%			
Week #2					Week #2					Week #2							
Week #3					Week #3					Week #3							
Week #4					Week #4					Week #4							
Week #5					Week #5					Week #5							
Week #6					Week #6					Week #6							
Week #7					Week #7					Week #7							
Week #8					Week #8					Week #8							
Average Historical OEE				50.00%		Average Historical OEE		50.00%		Average Historical OEE		50.00%					
Process Description (Historical Performance)																	
Supplier Name																	
Supplier Location																	
Surrogate Customer & Program reference																	
Reference Surrogate Process (~ Coiling Coiler #45)																	
Enter any other assumptions for clarification (Part Number, ...)																	
Section 5: Shared Process - Total Allocation Plan																	
U Total % Allocation for the process/tool																	
Part #	Stackpole Part	Process 1		Process 2		Process 3		Process 4		Process 5		Process 6					
		Time Req'd @	% Allocatio	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation	Time Req'd @	% Allocation				
Other % Allocation - Description																	
Percentage of NAT not utilized for production (%) (PM, etc.)																	
Total % Allocation																	
Section 6: Supplier Demonstrated OEE (Overall Equipment Effectiveness)																	
Equipment Availability																	
V	Total available time (minutes) (Actual changeover NOT included for shared)	100.00		100.00		100.00		100.00		100.00		100.00					
W	Planned downtime - lunches,breaks (minutes)	60.00		60.00		60.00		60.00		60.00		60.00					
X	Net Available time (minutes) [V-W]	40		40		40		40		40		40					
Y	Shared Equipment changeover time ACTUAL	NOT REQUIRED		NOT REQUIRED		NOT REQUIRED		NOT REQUIRED		NOT REQUIRED		NOT REQUIRED					
Z	Shared Equipment changeover time Weekly scaled	1.462522852		2.077922078		2.077922078		2.077922078		2.077922078		2.077922078					
AB	Observed Unplanned Downtime (minutes)	20.00		20.00		20.00		20.00		20.00		20.00					
AC	Operating time (Minutes) [X-AB]	20.00		20.00		20.00		20.00		20.00		20.00					
AD	Equipment Availability	48.24%		47.53%		47.53%		47.53%		47.53%		47.53%					
Performance Efficiency																	
AE	Total parts run (Good, Scrapped, and Reworked)	10.00		10.00		10.00		10.00		10.00		10.00					
AF	Planned Net Ideal Cycle Time(Sec/part)	50.00		55.00		51.00		59.50		63.50		68.50					
AG	Performance Efficiency	41.67%		45.83%		42.50%		49.58%		52.92%		57.08%					
AH	"Availability" and/or "Performance Efficiency" Losses not captured (minutes)	11.67		10.83		11.50		10.08		9.42		8.58					
Quality rate																	
AJ	# Parts Scrapped	1.00	10.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%				
AK	# Parts Reworked	2	20.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%	2.00	20.0%				
AL	Quality rate	70.00%		60.00%		60.00%		60.00%		60.00%		60.00%					
AM	Overall Equipment Effectiveness	14.1%		13.1%		12.1%		14.1%		15.1%		16.3%					
Required OEE Vs. Demonstrated OEE																	
		Process 1		Process 2		Process 3		Process 4		Process 5		Process 6					
Demonstrated OEE>Required OEE?																	



WORKSHEET TO DETERMINE ALLOCATION %			Use this form if the machine or work cell requires significant changeover time between products				
AVAILABLE HOURS PER YEAR		6,720		Operation Description		250T Injection Molding #12	
AVAILABLE HOURS PER MONTH		560					
Part Loading on Machine	Annual Volume Requirement	Monthly Volume Requirement	No. of Runs per Month	Set-Up Time (Hours)	Run Rate (Units/Hr)	Machine Utilization	
						Hrs/Month	% Allocation
Stackpole Int'l Brackets	200,000	16,667	4	0.5	60	279.78	50.0%
Customer A Part	50,000	4,167	2	0.5	55	76.76	13.7%
Customer B Part	40,000	3,333	2	0.8	45	75.67	13.5%
Required Time (Hrs)						432.21	77.2%
Available Time (Hrs)						560.00	100%
Available Capacity (Hrs)						127.79	22.8%
Total % Allocation for Stackpole Int'l						50.0%	
Total % Allocation for SI and Open						72.8%	

WORKSHEET TO DETERMINE ALLOCATION % - (Example)							
AVAILABLE HOURS PER YEAR		6,720		Operation Description		E-Coat	
AVAILABLE HOURS PER MONTH		560					
Part Loading on Machine	Annual Volume Requirement	Monthly Volume Requirement	No. of Runs per Month	Set-Up Time (Hours)	Run Rate (Units/Hr)	Machine Utilization	
						Hrs/Month	% Allocation
Stackpole Int'l Brackets	1,500,000	125,000	1	0.6	500	250.60	44.8%
Customer A Part	500,000	41,667	1	0.6	500	83.93	15.0%
Customer B Part	400,000	33,333	1	0.6	500	67.27	12.0%
Customer C Part	600,000	50,000	1	0.6	500	100.60	18.0%
Required Time (Hrs)						502.40	89.7%
Available Time (Hrs)						560.00	100%
Available Capacity (Hrs)						57.60	10.3%
Total % Allocation for Stackpole Int'l						44.8%	
Total % Allocation for SI and Open						55.0%	

This worksheet is similar to the allocation % above but does not include time for changeovers.

WORKSHEET TO DETERMINE ALLOCATION %			Use this form if the machine or work cell does not require significant changeover time between products		
AVAILABLE HOURS PER YEAR		5,280		MACHINE DESCRIPTION	
AVAILABLE HOURS PER MONTH		440		Bracket Assembly	
Part Loading on Machine	Annual Volume Requirement	Monthly Volume Requirement	Run Rate (Units/Hr)	Machine Utilization	
				Hrs/Month	% Allocation
Stackpole Int'l Brackets	200,000	16,667	80	208	47.3%
CUSTOMER A	50,000	4,167	75	56	12.6%
CUSTOMER B	40,000	3,333	68	49	11.1%
Required Time (Hrs)			312.91	71.1%	
Available Time (Hrs)			440.00	100%	
Available Capacity (Hrs)			127.09	28.9%	
Total % Allocation for Stackpole Int'l			47.3%		
Total % Allocation for SI and Open			76.2%		



Instructions: record time observations for 12 cycles. The formula in column P will automatically take out the min and max value and average the remaining values.

Cycle Time Observations for Supplier Run at Rate														
TIME IN SECONDS														
OP #	OPERATION DESCRIPTION	Time 1	Time 2	Time 3	Time 4	Time 5	Time 6	Time 7	Time 8	Time 9	Time 10	Time 11	Time 12	Average
10		12.00	10.00	5.00	13.00	14.00	12.00	19.00	13.00	15.00	10.00	12.00	11.00	12.20
														0.00
														0.00
20														0.00
														0.00
														0.00
30														0.00
														0.00
														0.00
40														0.00
														0.00
														0.00
50														0.00
														0.00
														0.00
60														0.00
														0.00
														0.00
70														0.00
														0.00
														0.00
80														0.00
														0.00
														0.00
90														0.00
														0.00
														0.00
100														0.00
														0.00
														0.00
Comments:														