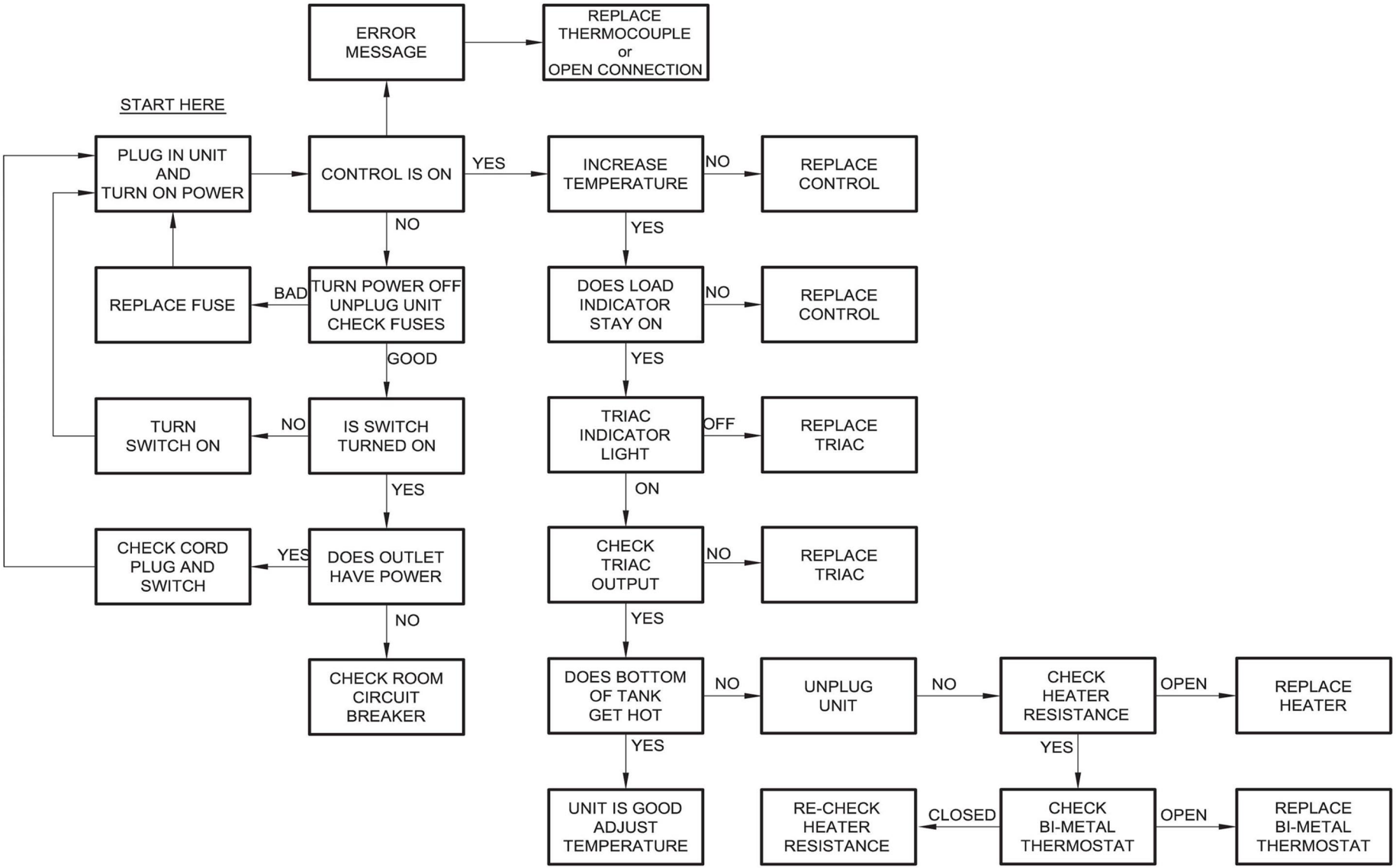DIGITAL THERMOPLASTIC WATER BATH TROUBLESHOOTING FLOWCHART