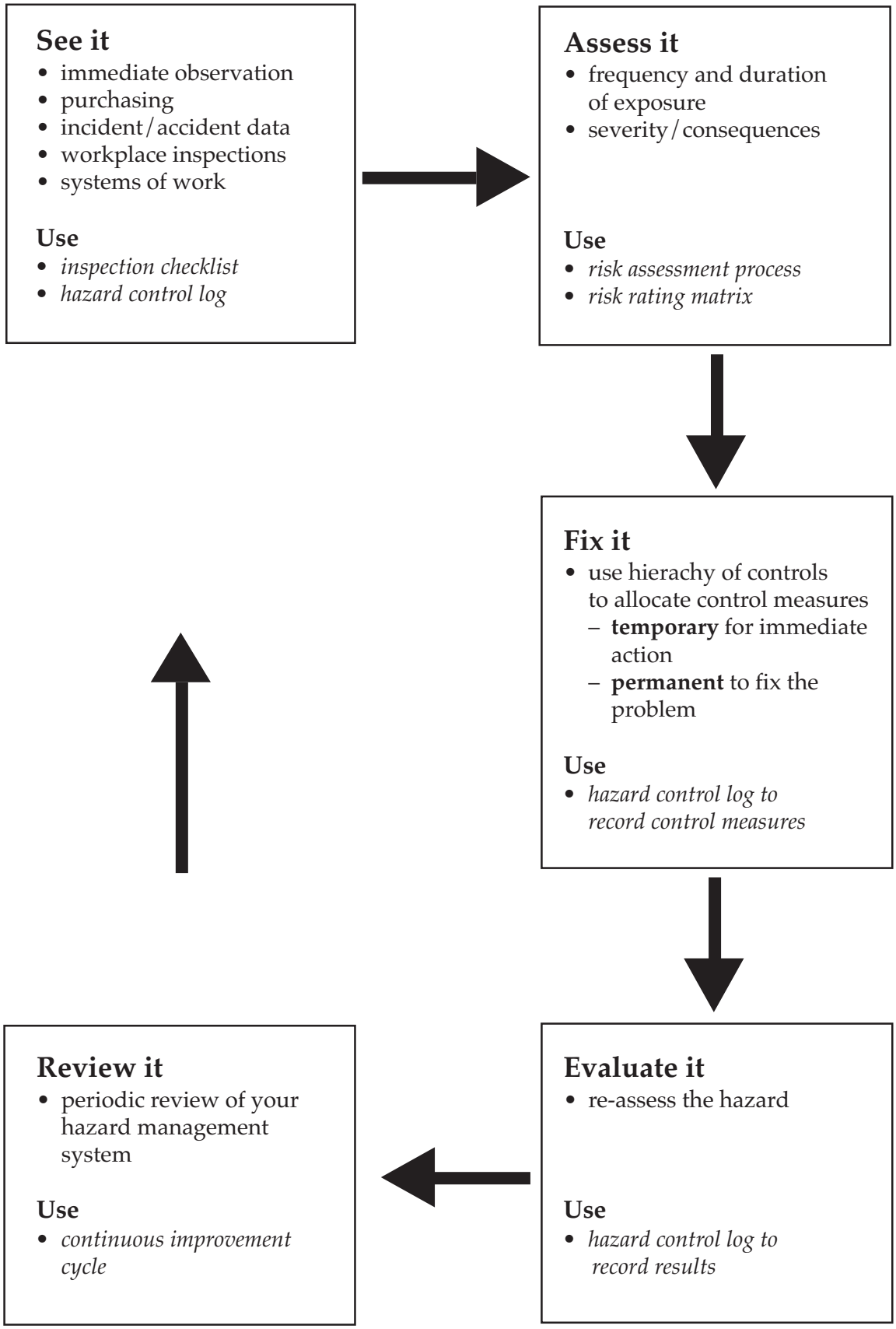SAFER process flowchart