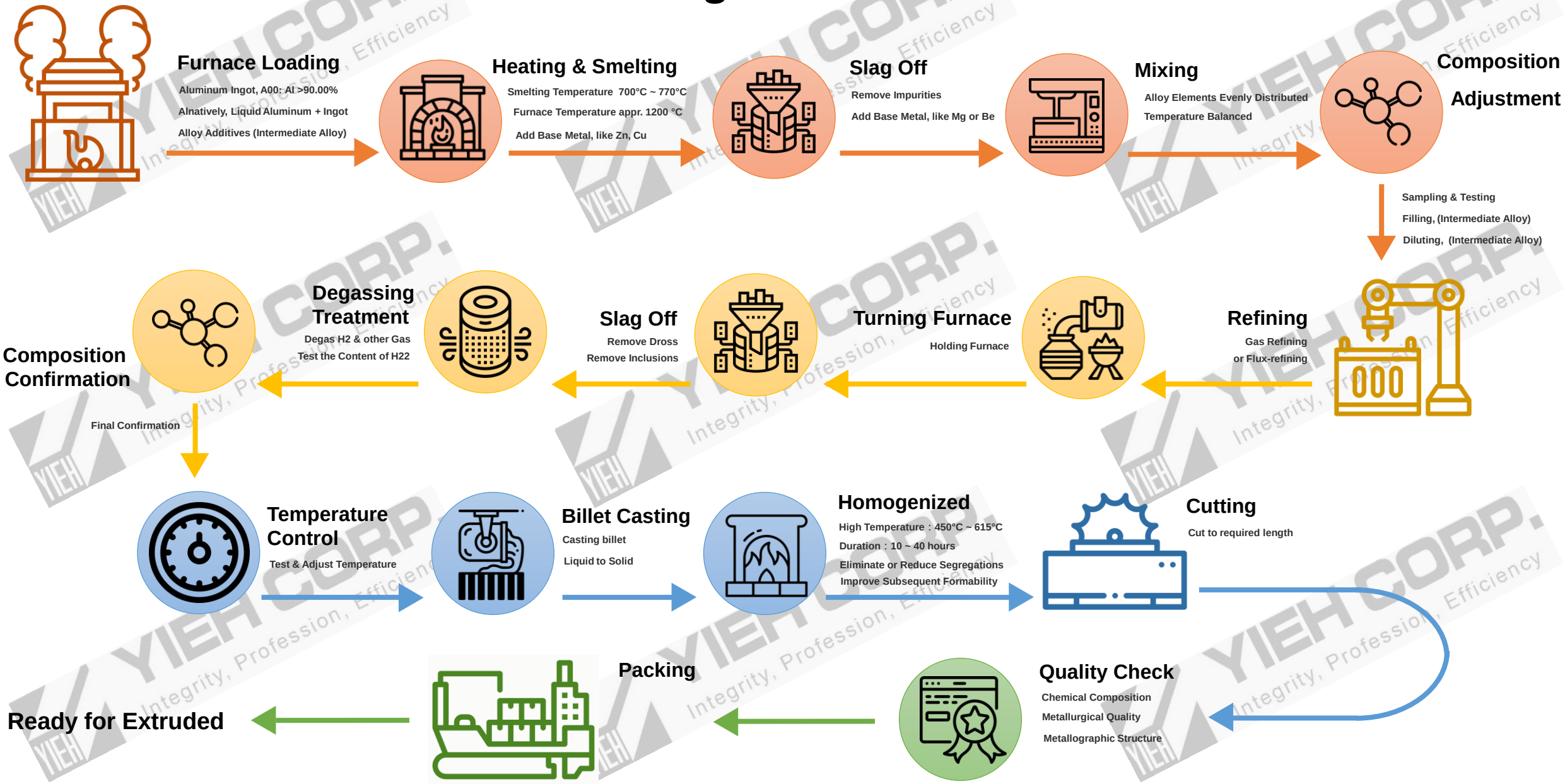Aluminum Casting Round Billet Process