

**Conceive**

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**Customer  
Needs**

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**Planning**

**Concept  
Development**

**Design**

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**Functional  
Requirements**

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**System-Level  
Design**

**Implement**

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**Physical  
Design Parameters**

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**Detailed  
Design**

**Testing and  
Refinement**

**Operate**

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**Process  
Variables**

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**Production  
Ramp-Up**

