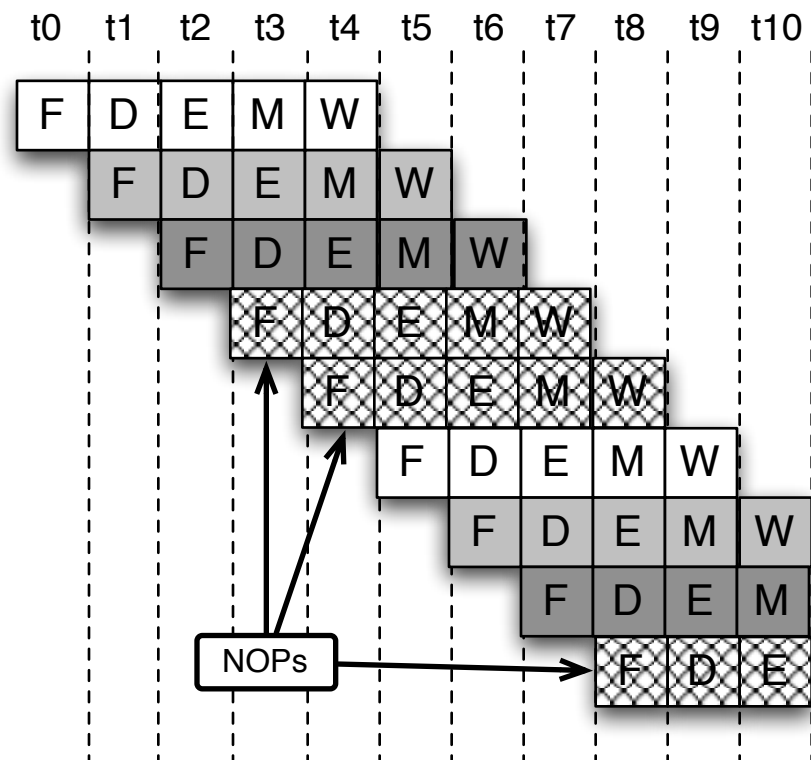


Data and Control Hazards Re-Introduced



Remove Hazards with NOP insertion