OWA  
  
ACCESS

* Full Access > Open Another Mailbox <https://outlook.office.com/mail/USER@OTHERMAILBOX.com>
* Folder permissions

SENDING  
SendAs OR Sendonbehalf  
  
Outlook

* Full access + Automapping
* Account / Delegate
* As Separate mailbox

Sending

* Needs SendonBehalf (**NOT in Exchange Admin** only Admin + Powershell