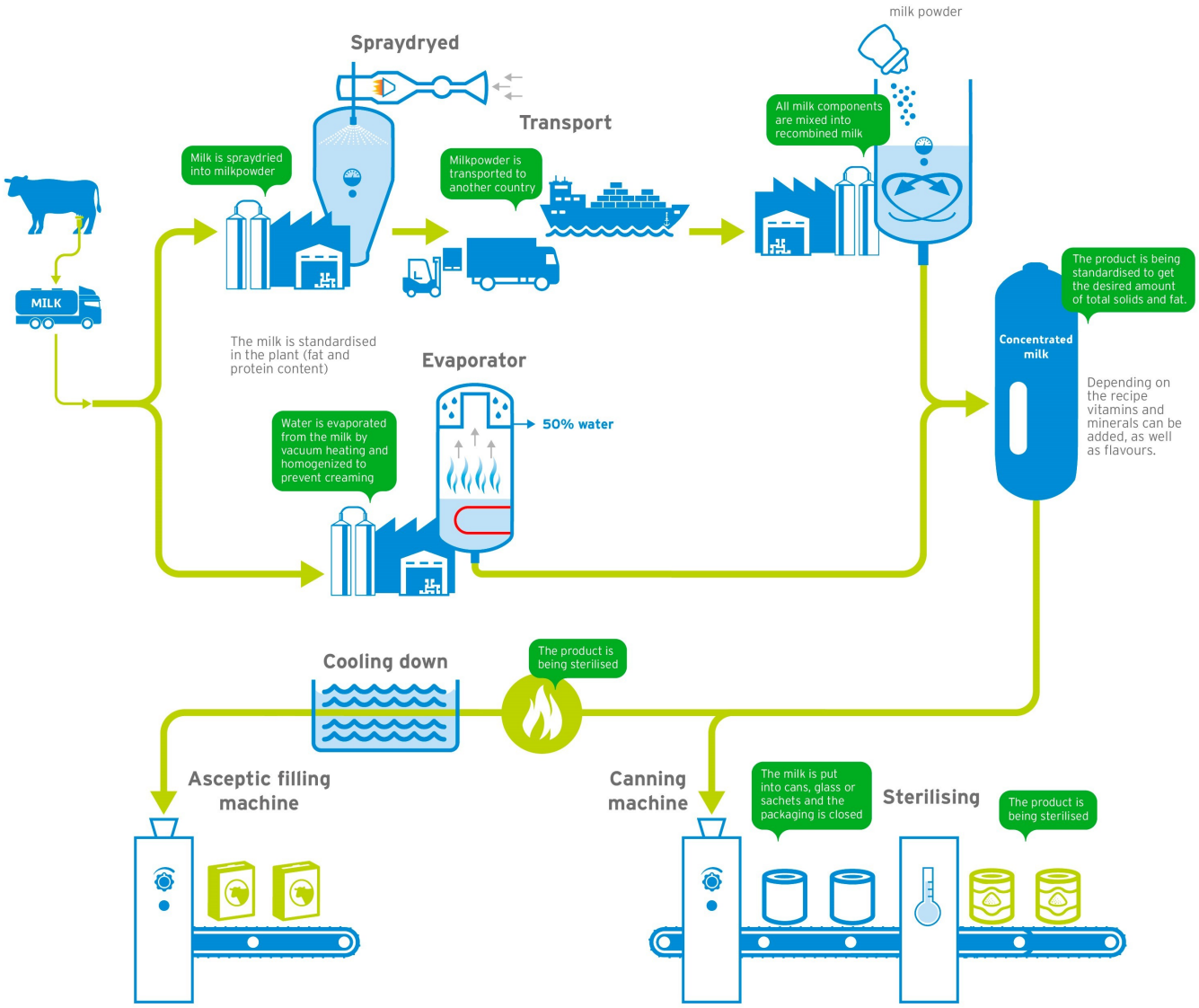How is evaporated milk made?