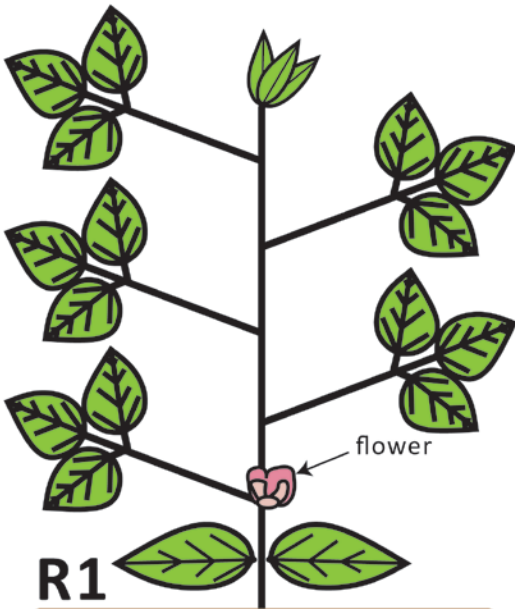
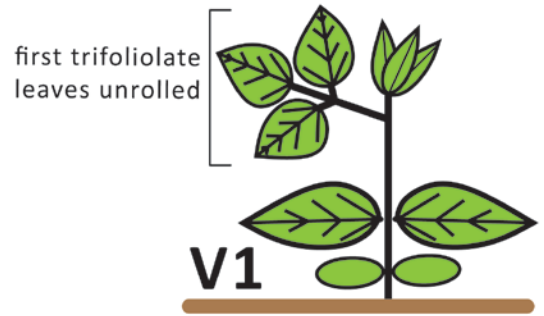
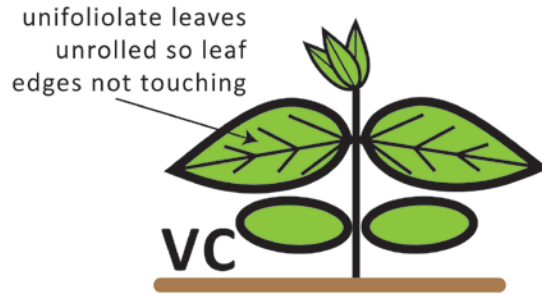
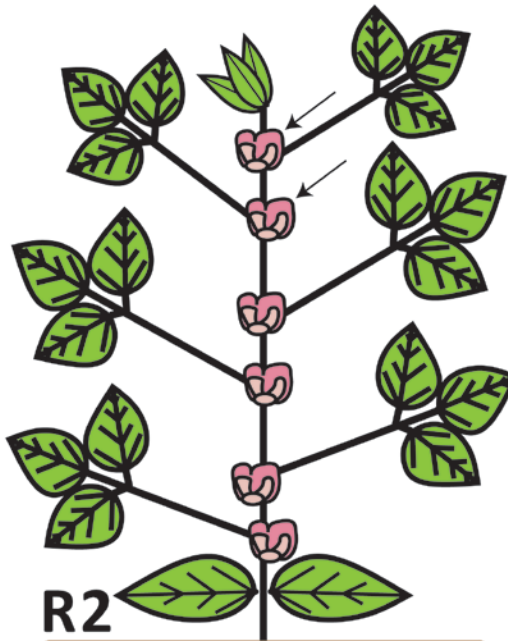


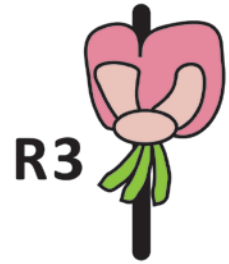
# SOYBEAN GROWTH AND DEVELOPMENT



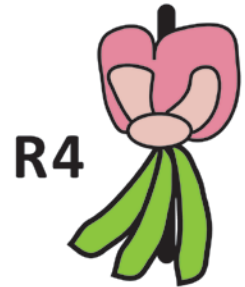
beginning bloom: open flower at any node on main stem



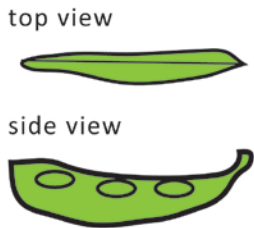
full bloom: open flower at one of the two uppermost nodes on main stem



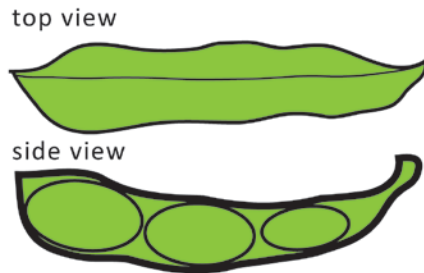
beginning pod set: pods <math>< 5/16</math> in (5 mm) long at four uppermost nodes



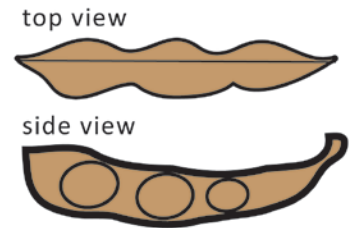
full pod set: pods  $3/4$  in (2 cm) long at four uppermost nodes



**R5** beginning seed set: seed is  $1/8$  in (3 mm) long at one of four uppermost nodes



**R6** full seed set: green seed that fills pod capacity at one of four uppermost nodes



**R7** beginning maturity: one pod on the main stem has reached mature pod color

**R8** full maturity: 95% of pods have reached mature pod color