

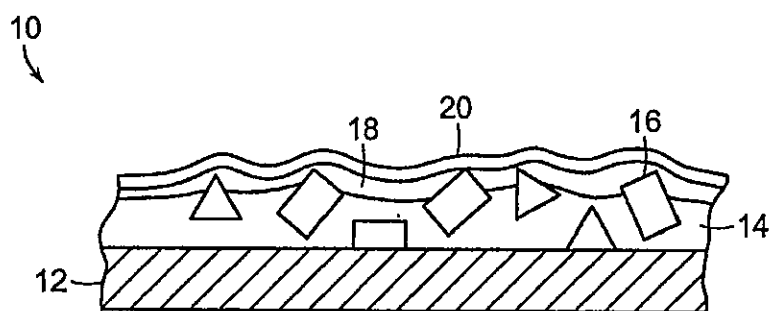


FIG. 1

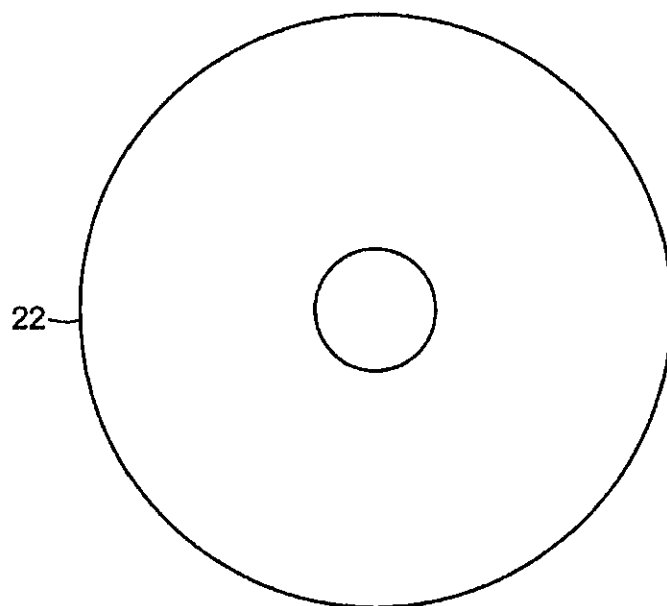


FIG. 2

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Testing Result for Formulation #1 30 lbs on Loesser									
Part #	MRR, g/part		CMR, g		Surface finish, u inch		Abrasive loss, %		
	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment	
1	32.89	26.36	32.89	26.36	80.87	62.47	11.35	24.62	
2	30.48	24.07	63.37	50.43	77.70	66.43	12.77	28.41	
5	27.37	21.86	150.15	119.32	83.37	63.07	17.02	35.98	
10	26.30	20.34	284.32	224.82	69.73	65.40	20.57	45.45	
15	26.08	19.39	415.27	324.15	71.47	52.57	24.11	50.19	
20	25.03	18.80	543.04	419.62	71.77	54.20	25.53	51.14	
40	25.08	21.56	1044.15	823.23	73.57	49.80	29.79	60.61	
60	22.92	17.83	1524.15	1217.13	68.93	35.83	34.04	66.29	
80	21.87	15.66	1972.05	1552.03	62.53	39.07	36.88	68.18	
100	20.58	14.10	2396.55	1849.63	59.53	30.73	38.30	68.18	
120	20.54	13.81	2807.75	2128.72	58.10	34.75	38.30	69.13	
140	19.33	11.92	3206.45	2386.02	55.07	32.67	39.72	73.86	
160	18.89	9.09	3588.64	2596.12	51.40	38.57	42.55	73.86	
180	18.50	10.26	3982.54	2789.62	48.83	36.40	42.55	73.86	
200	19.05	9.34	4338.04	2985.62	51.27	38.87	45.39	73.86	
Average after 20 parts		21.18	14.24	60.10	39.09				

FIG. 3A

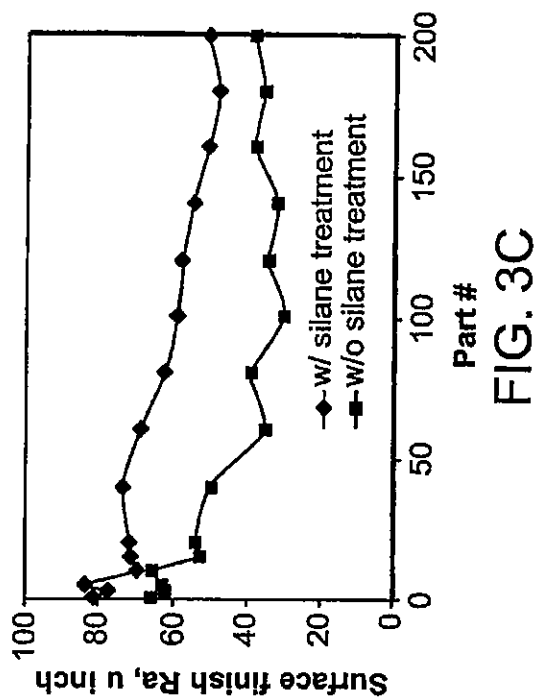


FIG. 3C

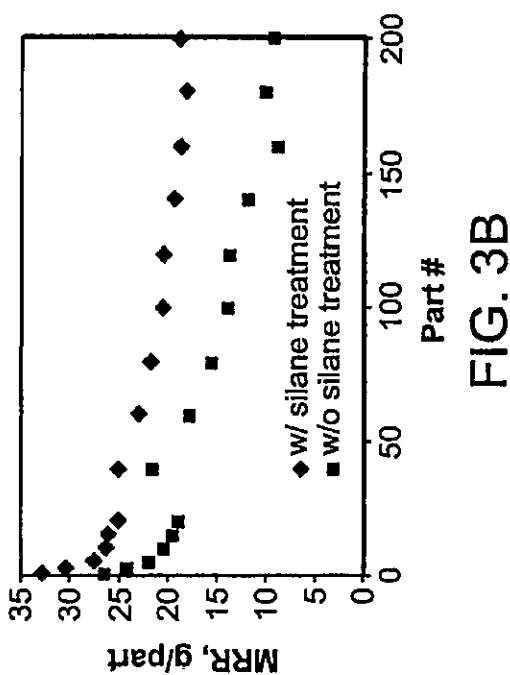


FIG. 3B

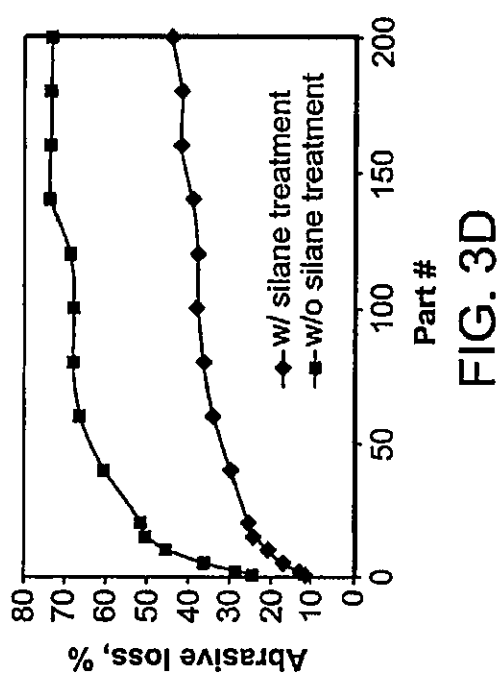


FIG. 3D

50 lbs on Loesser											
Part #	MRR, g/part		CMR, g		Surface finish, u inch		Abrasive loss, %				
	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment	W/ silane treatment	w/o silane treatment			
1	57.29	32.10	57.29	32.10	104.33	74.10	16.30	30.08			
2	47.60	28.02	104.89	60.12	84.03	82.97	19.26	33.08			
5	44.67	25.34	243.30	140.16	85.90	71.60	23.70	42.11			
10	39.08	22.94	452.67	260.86	81.20	70.60	29.63	52.63			
15	36.78	21.80	642.32	372.71	79.50	61.60	35.56	57.14			
20	33.91	22.03	819.05	482.28	77.60	58.93	40.00	61.65			
40	33.11	20.49	1489.25	907.48	75.80	59.87	54.81	66.17			
60	32.08	17.07	2141.15	1283.08	64.57	42.43	59.26	70.68			
80	30.99	18.06	2771.85	1634.38	62.30	42.63	62.22	75.19			
100	27.24	15.45	3354.15	1969.48	52.97	41.73	63.70	76.69			
120	27.38	16.67	3900.35	2280.68	49.00	56.90	66.67	78.20			
140	24.39	13.50	4418.05	2592.38	51.60	49.37	71.11	79.70			
160	24.55	14.31	4907.45	2870.48	46.97	50.67	71.11	79.70			
180	20.82	11.38	5361.15	3127.38	43.20	43.80	71.11	79.70			
200	22.08	11.84	5790.15	3359.58	42.70	38.53	71.11	79.70			
Average after 20 parts	27.66	16.08			56.67	48.49					

FIG. 4A

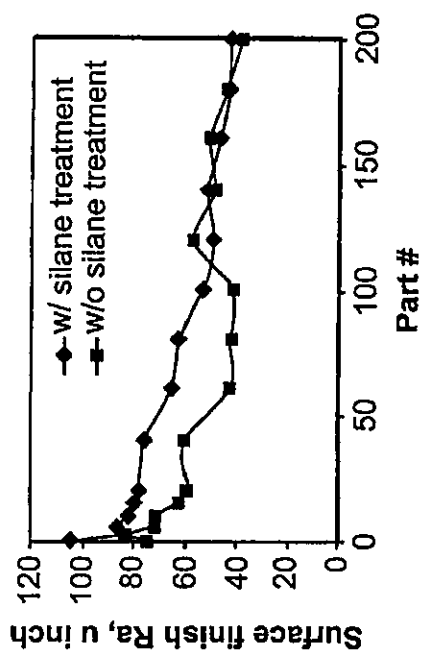


FIG. 4C

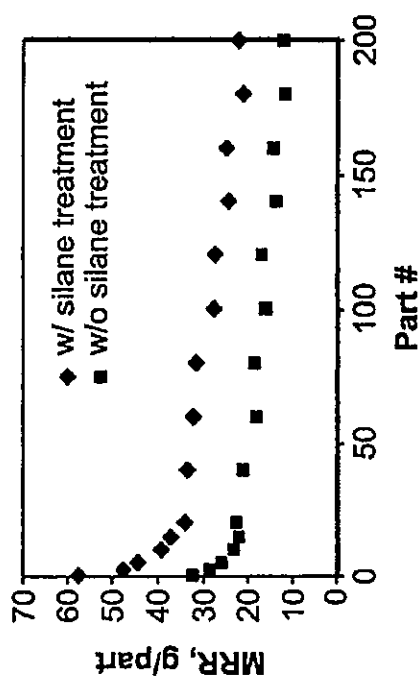


FIG. 4B

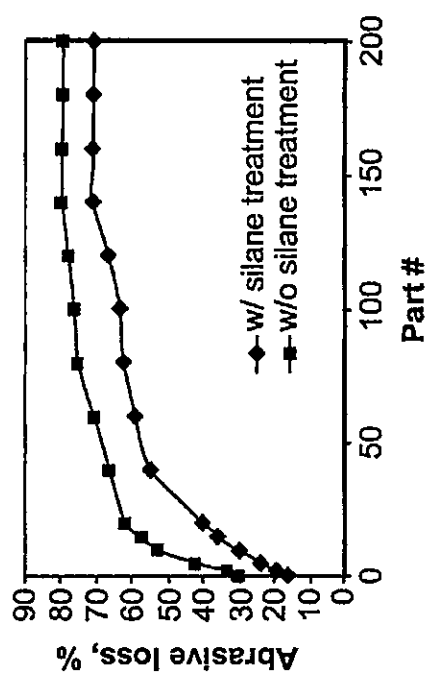
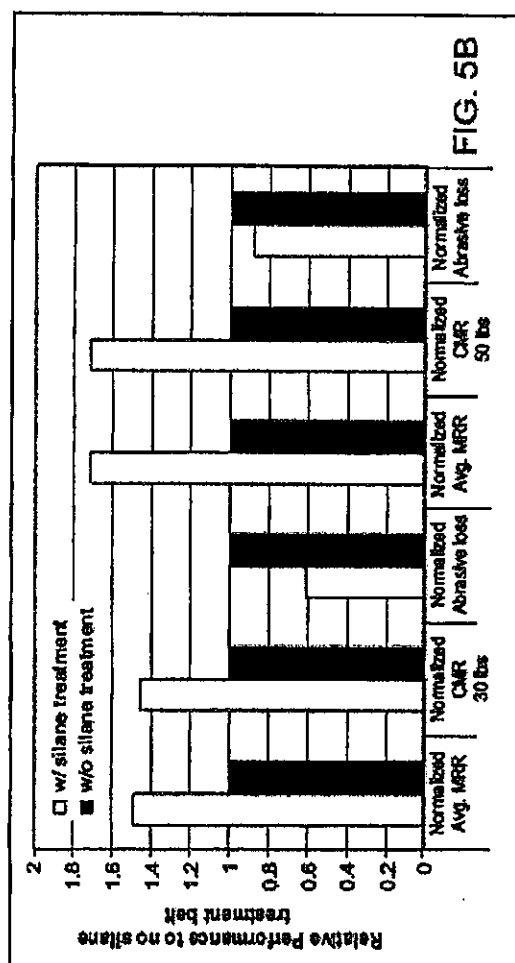


FIG. 4D

	30 lbs			50 lbs			30 lbs			50 lbs		
	Avg. MRR part 20 - 200, g/part	CMR at part 200, g	Abrasive loss at part 200, %	Avg. MRR part 20 - 200, g/part	CMR at part 200, g	Abrasive loss at part 200, %	Normalized Avg. MRR	Normalized CMR	Normalized Abrasive loss	Normalized Avg. MRR	Normalized CMR	Normalized Abrasive loss
W/ silane treatment	21.18	4338.04	45.39	27.66	5790.15	71.11	1.487602725	1.452977182	0.614512	1.719838	1.72347	0.892243
W/o silane treatment	14.24	2985.62	73.86	16.08	3359.58	79.70	1	1	1	1	1	1

FIG. 5A



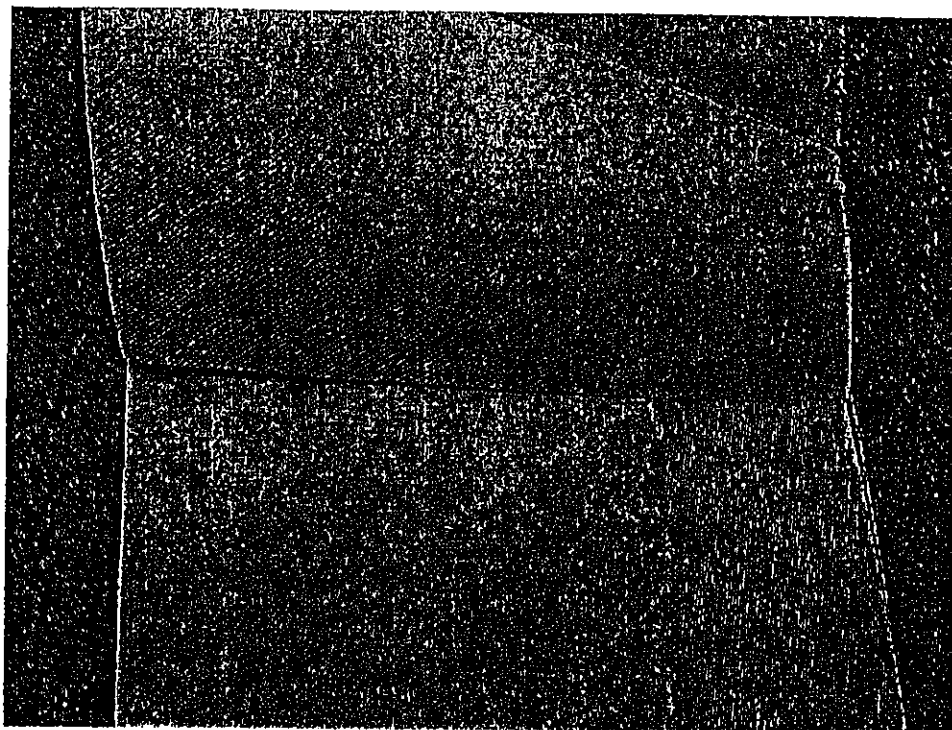


FIG. 6