

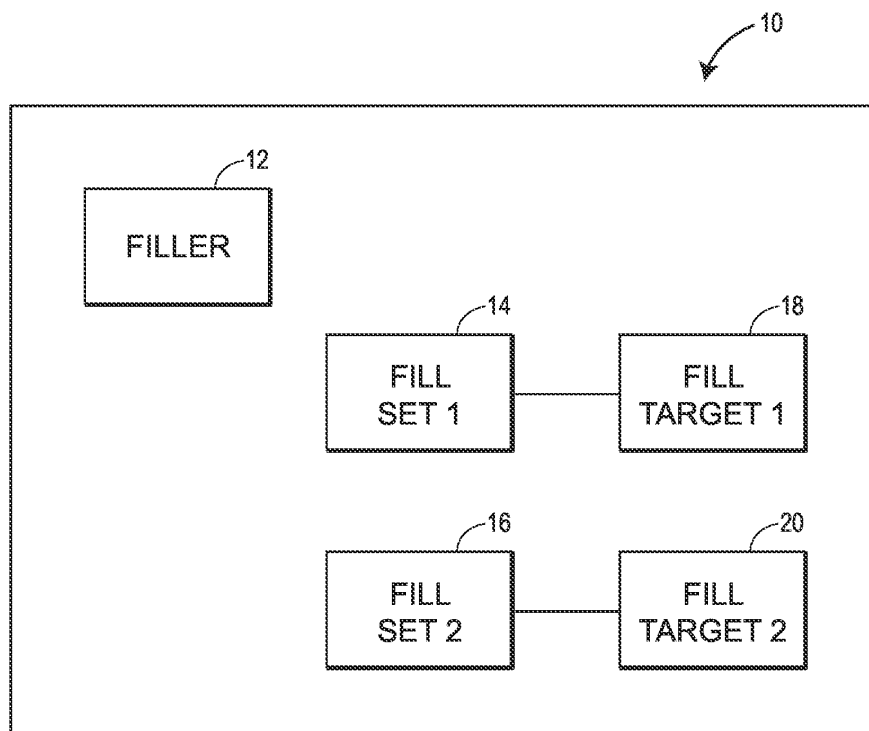


FIG. 1

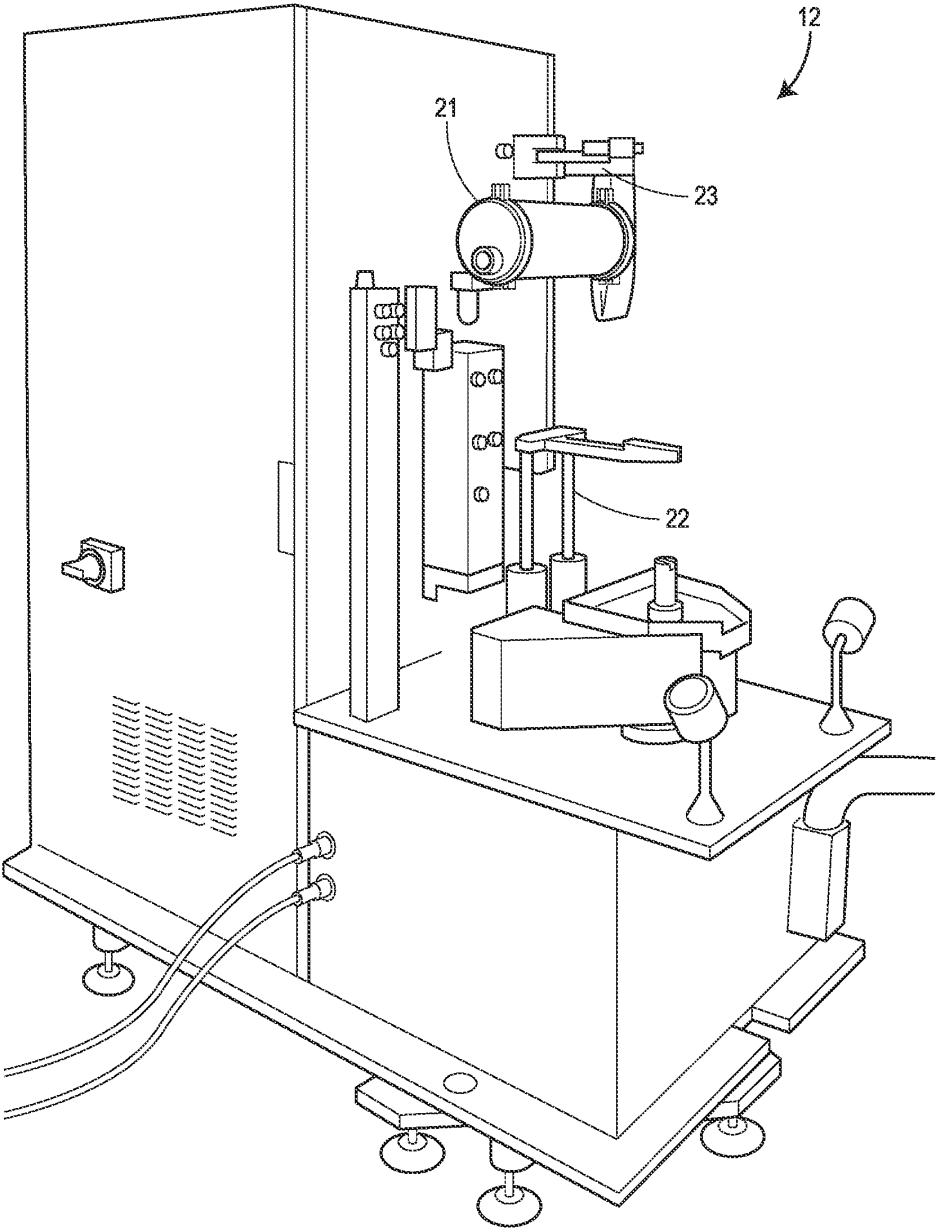


FIG. 2A

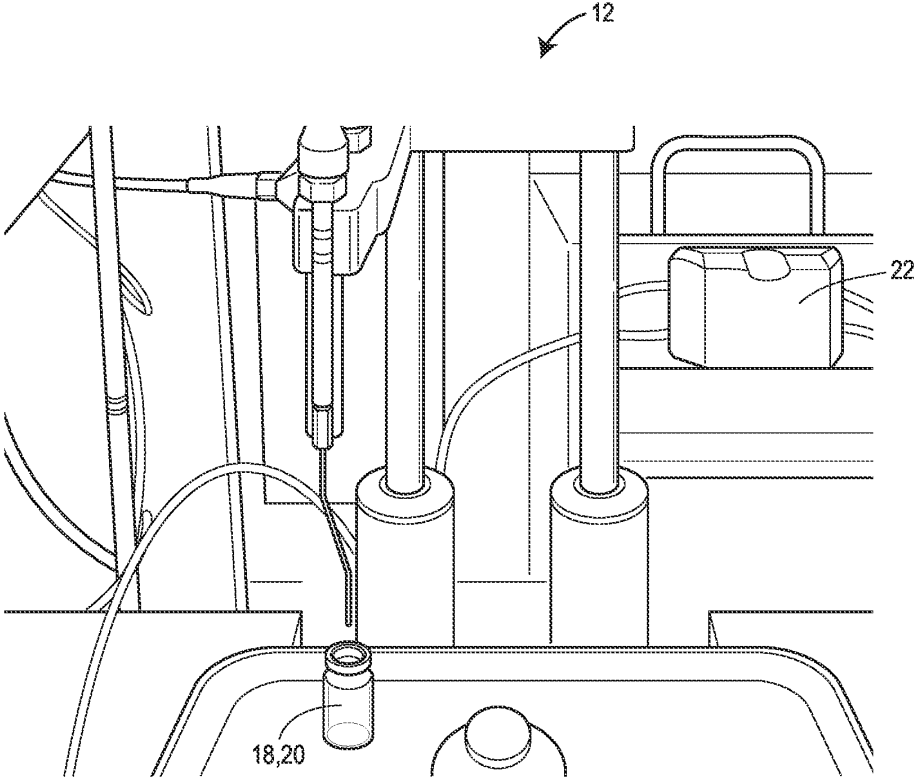


FIG. 2B

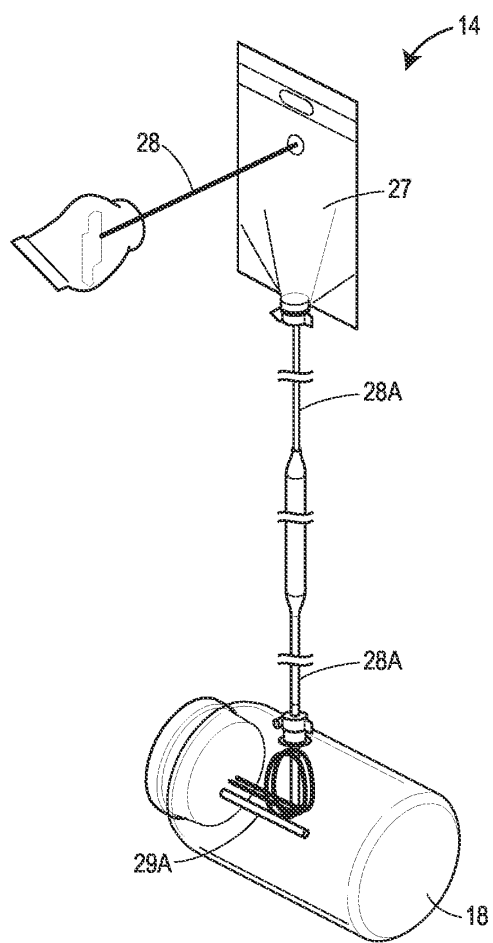


FIG. 2C

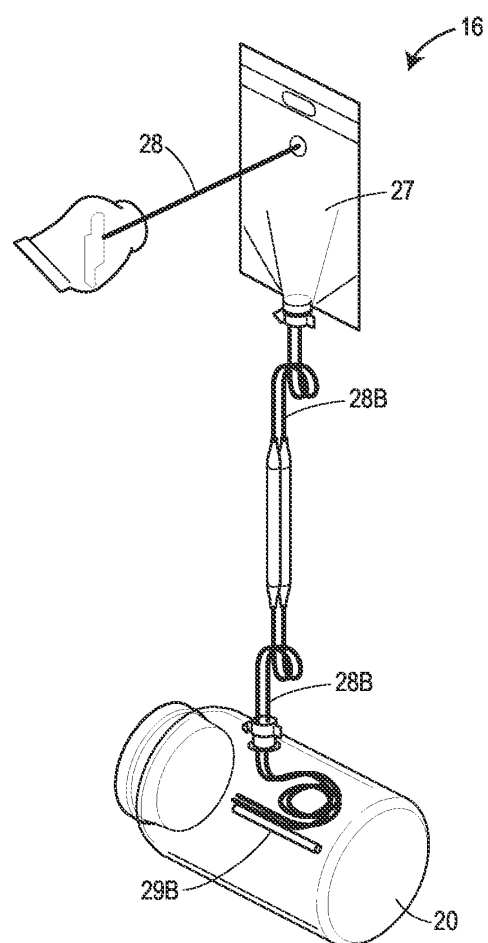


FIG. 2D

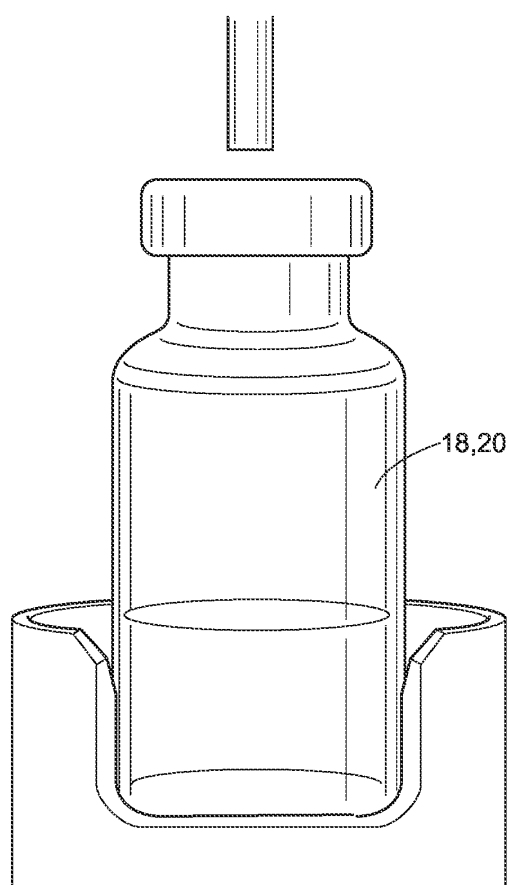


FIG. 2E

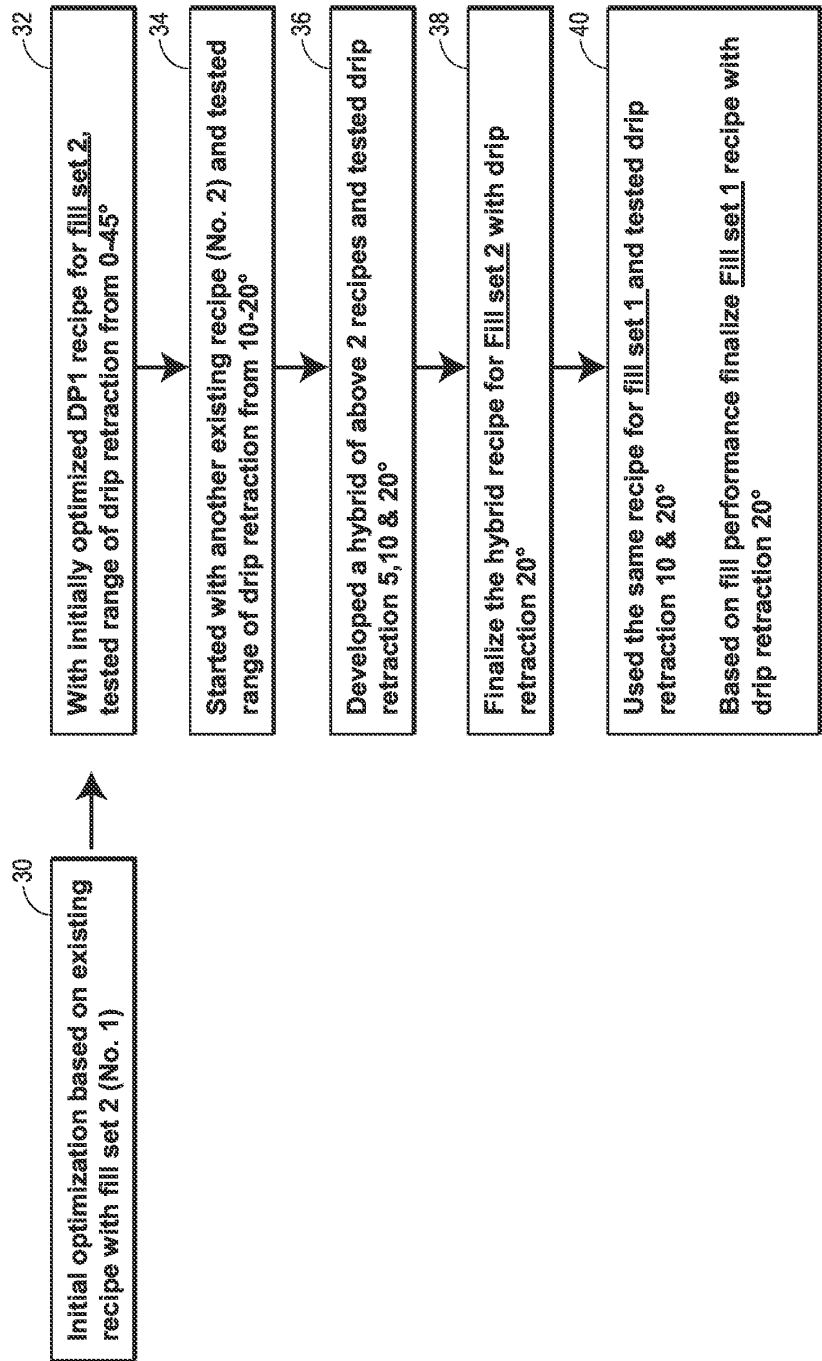


FIG. 4

Fill Recipe	Parameters In Bench Scale
Start pump dosing°	40
Pump dosing start ramp°	90
Pump dosing stop ramp°	210
End pump dosing°	260
End drip retraction°	310
Pump distance run for drip retraction°	0-40
Distance run per dose (pump 1)°	766

FIG. 5B

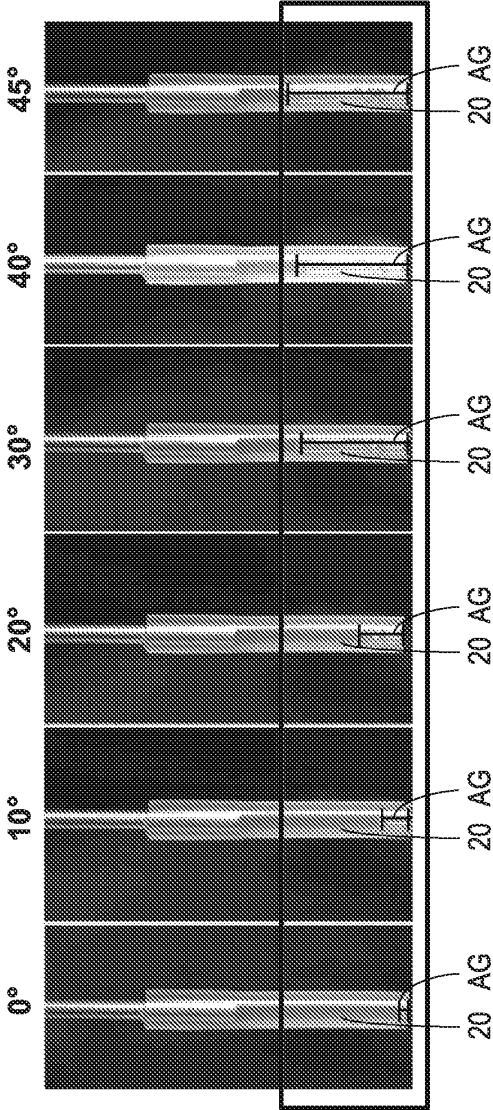


FIG. 5A

Start pump dosing°	Pump dosing start ramp°	Pump dosing stop ramp°	End pump dosing°	End drip retraction°	Pump travel for drip retraction°	Distance run per dose (pump 1)°
40	90	210	260	290	20	766

FIG. 6A

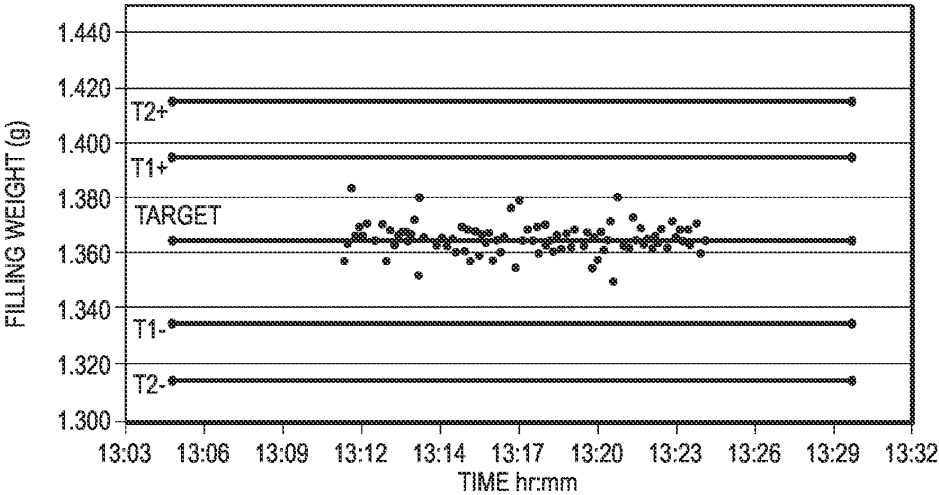


FIG. 6B

Number of Fills	103
Minimum (g)	1.348
Maximum (g)	1.384
Average (g)	1.366
Standard Deviation (g)	0.006
CpK against T2	2.69

FIG. 6C

Needle parameters

Fill Recipe	Parameters in Bench Scale	Parameters in NSVL
Needle Setting Dimension (mm)	134.5	39.0
Basic Needle Position (mm)	7	7
Start Needle Down (°)	25	25
Needle at dosing Start (mm)	10	10
Needle Down (°)	60	60
Needle Down (mm)	23	23
Start needle up (°)	125	125
Needle at end of dosing (mm)	13	13
Needle at end of dosing (°)	310	310
Start needle to cut-off position (°)	315	315
Cut-Off Position Reached (mm)	13	13
Cut-off position reached (°)	315	315
Start Needle to Basic Position (°)	315	315
Basic needle position reached(°)	359	359

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↙**FIG. 7A****Pump parameters**

Fill Recipe	Parameters in Bench Scale	Parameters in NSVL
Start pump dosing°	40	40
Pump dosing start ramp°	90	90
Pump dosing stop ramp°	210	210
End pump dosing°	260	260
End drip retraction°	290	290
Pump distance run for drip retraction°	20	20
Distance run per dose (pump 1)°	766	766

50
↙**FIG. 7B**

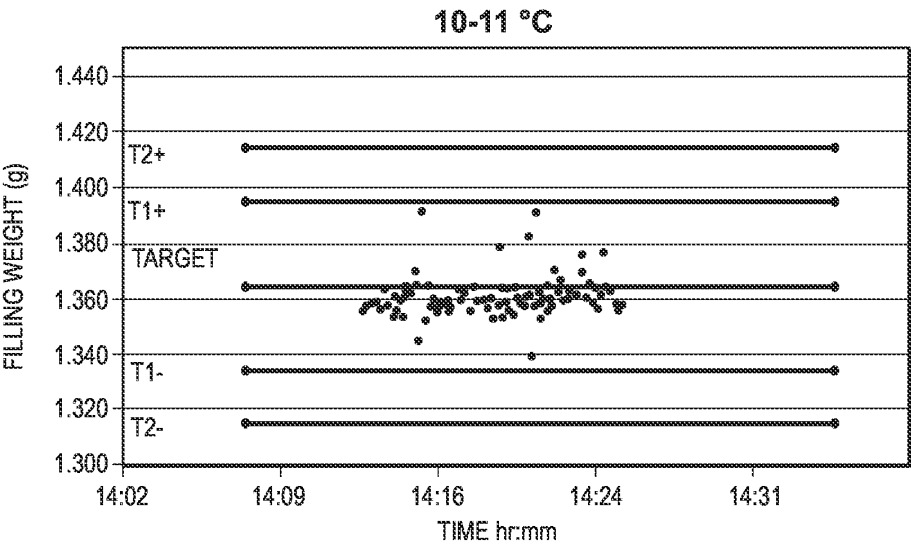


FIG. 8A

Number of Fills	103
Minimum (g)	1.340
Maximum (g)	1.393
Average (g)	1.362
Standard Deviation (g)	0.008
CpK against T2	1.95

FIG. 8B

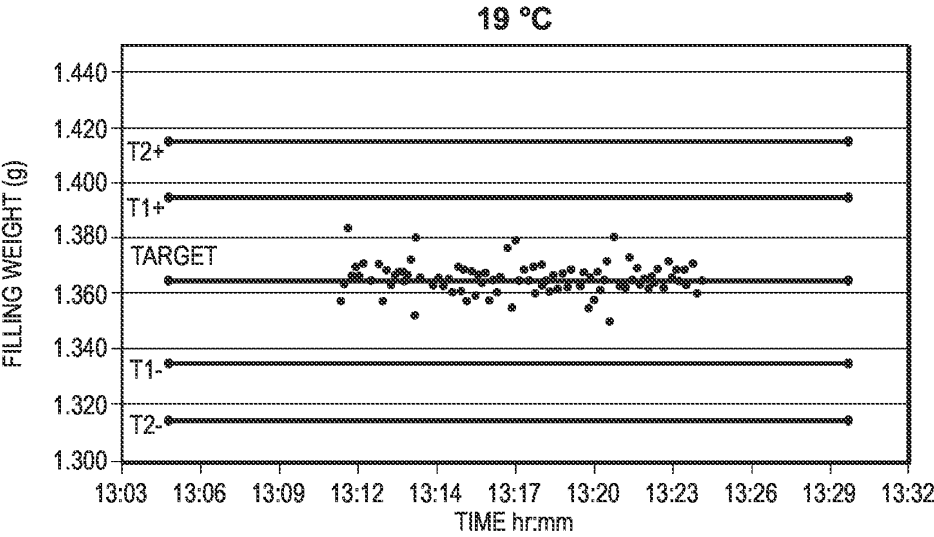


FIG. 9A

Number of Fills	103
Minimum (g)	1.348
Maximum (g)	1.384
Average (g)	1.366
Standard Deviation (g)	0.006
CpK against T2	2.69

FIG. 9B

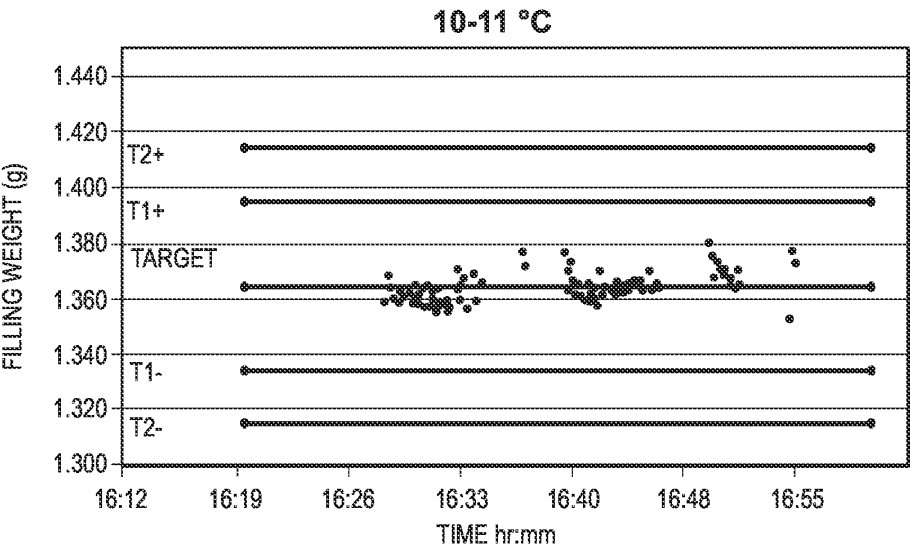


FIG. 10A

Number of Fills	100
Minimum (g)	1.354
Maximum (g)	1.380
Average (g)	1.365
Standard Deviation (g)	0.005
CpK against T2	3.16

FIG. 10B

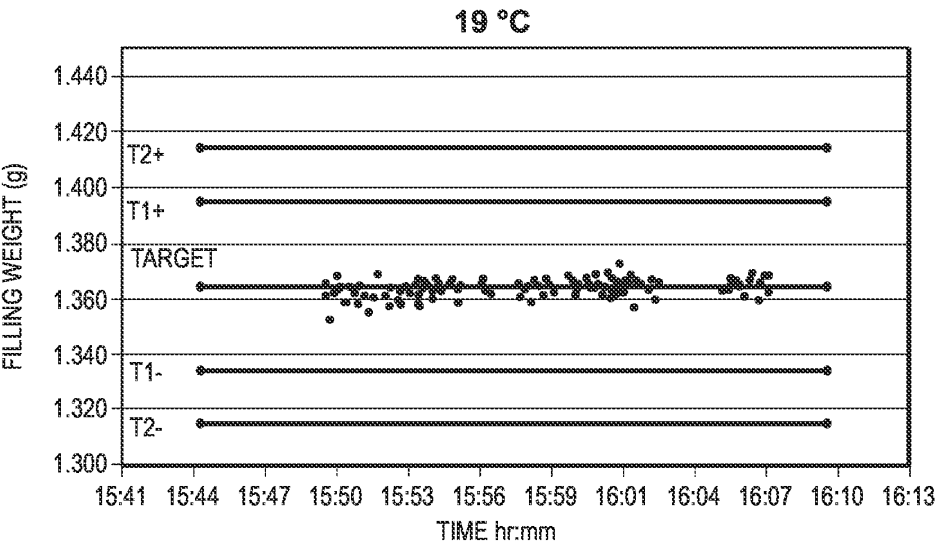


FIG. 11A

Number of Fills	120
Minimum (g)	1.352
Maximum (g)	1.373
Average (g)	1.362
Standard Deviation (g)	0.004
CpK against T2	3.61

FIG. 11B

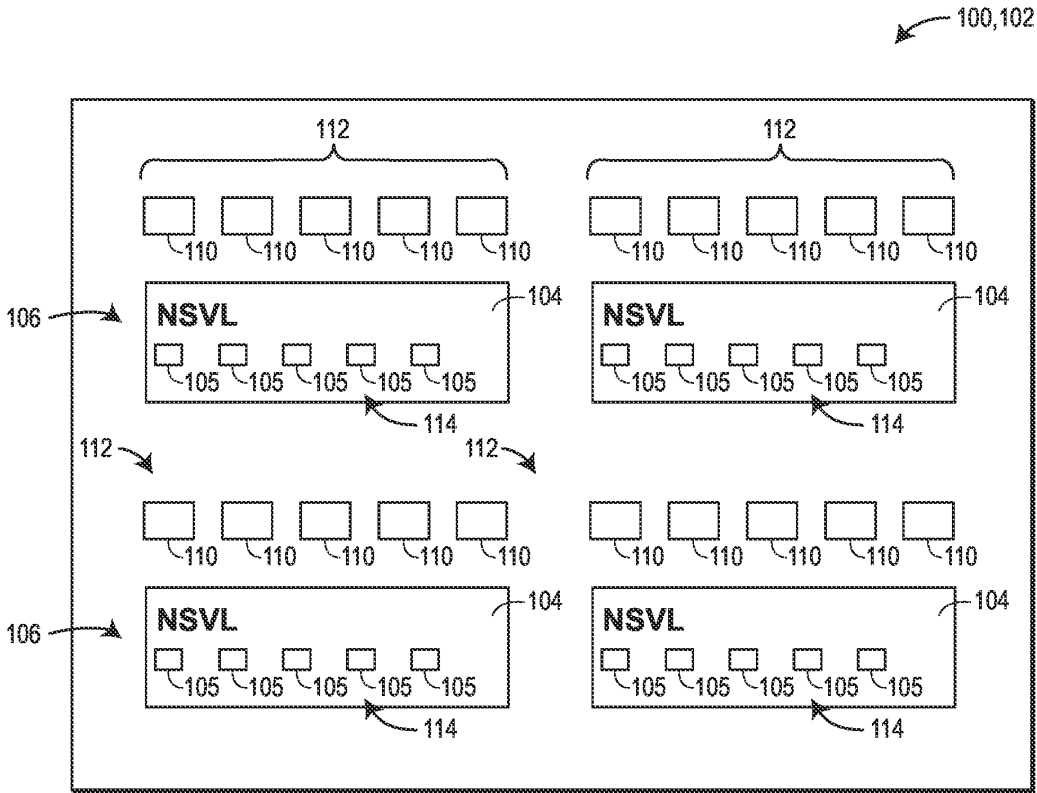


FIG. 12

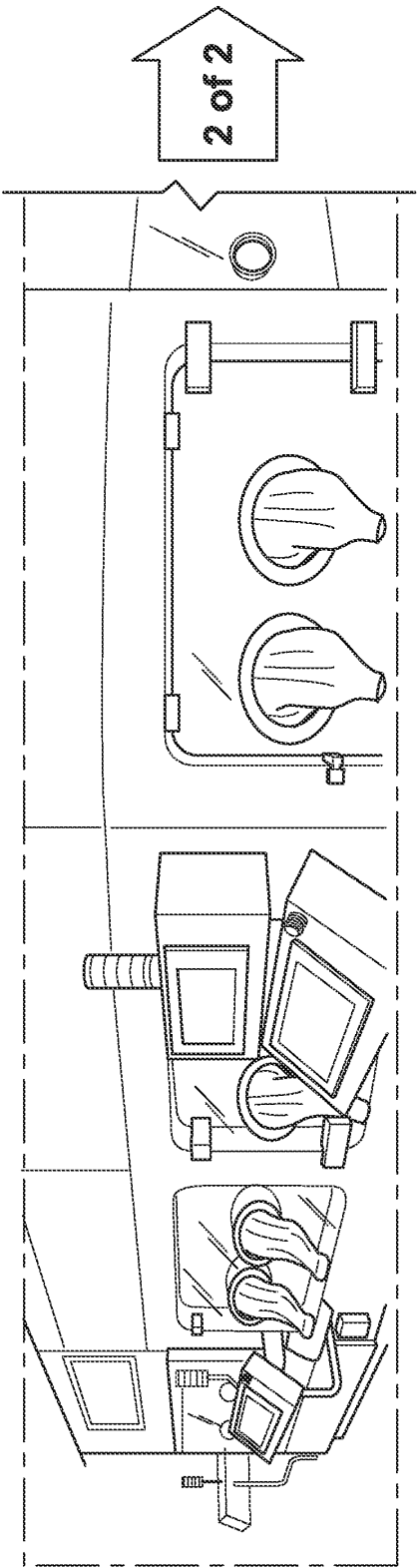


FIG. 13A
(1 of 2)

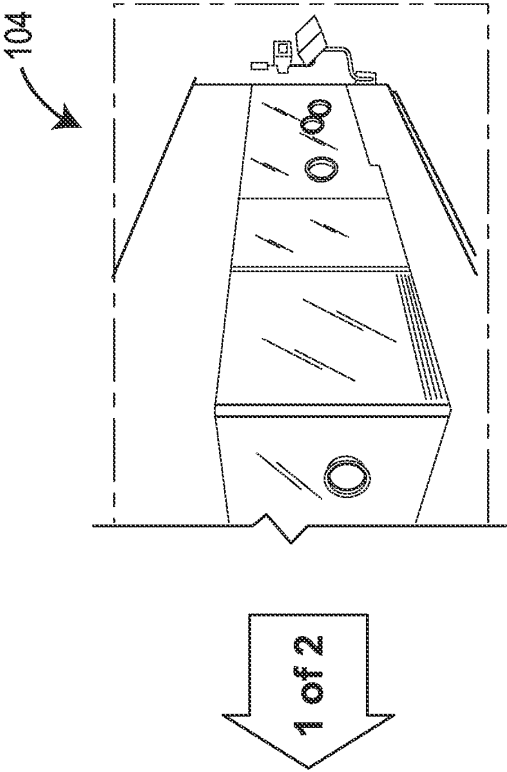


FIG. 13A
(2 of 2)

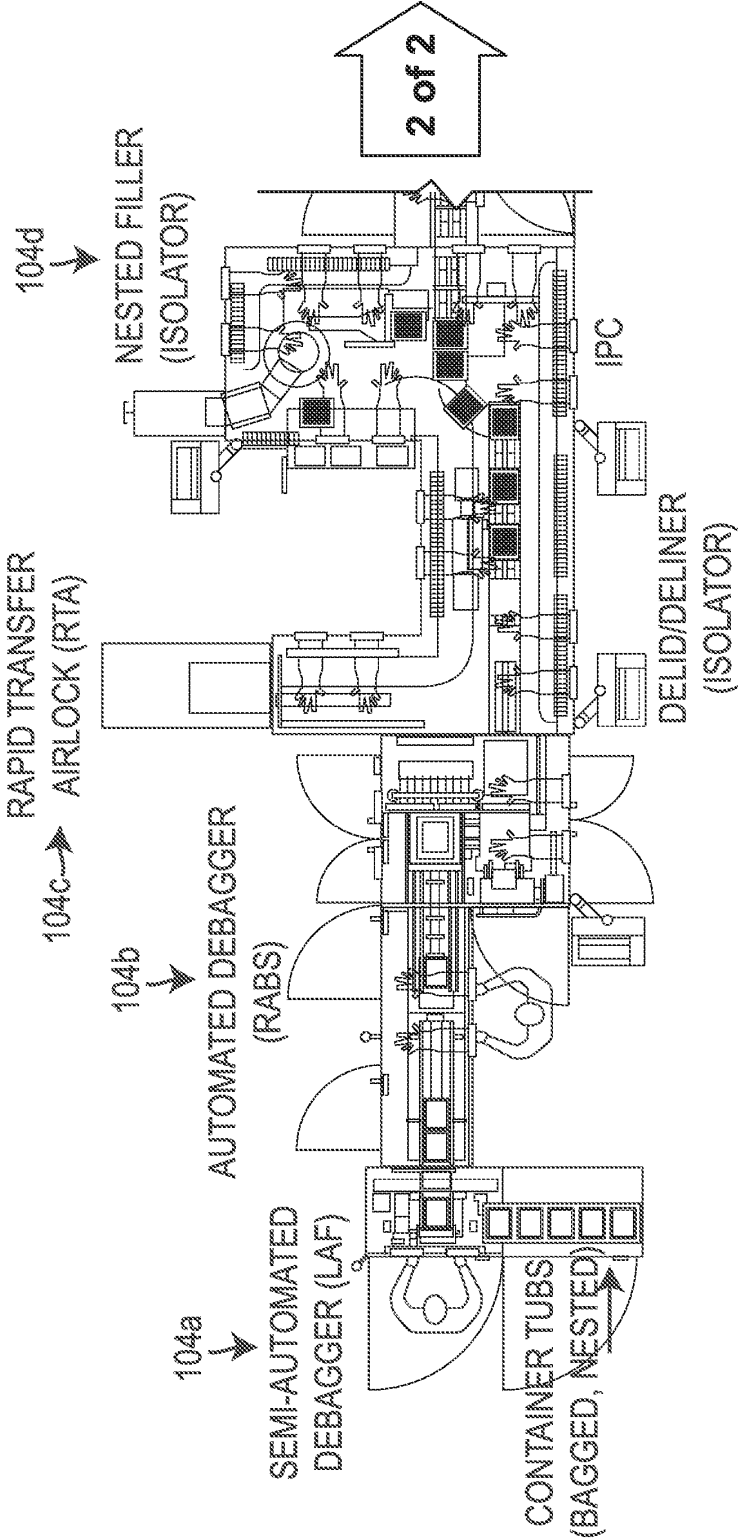


FIG. 13B
(1 of 2)

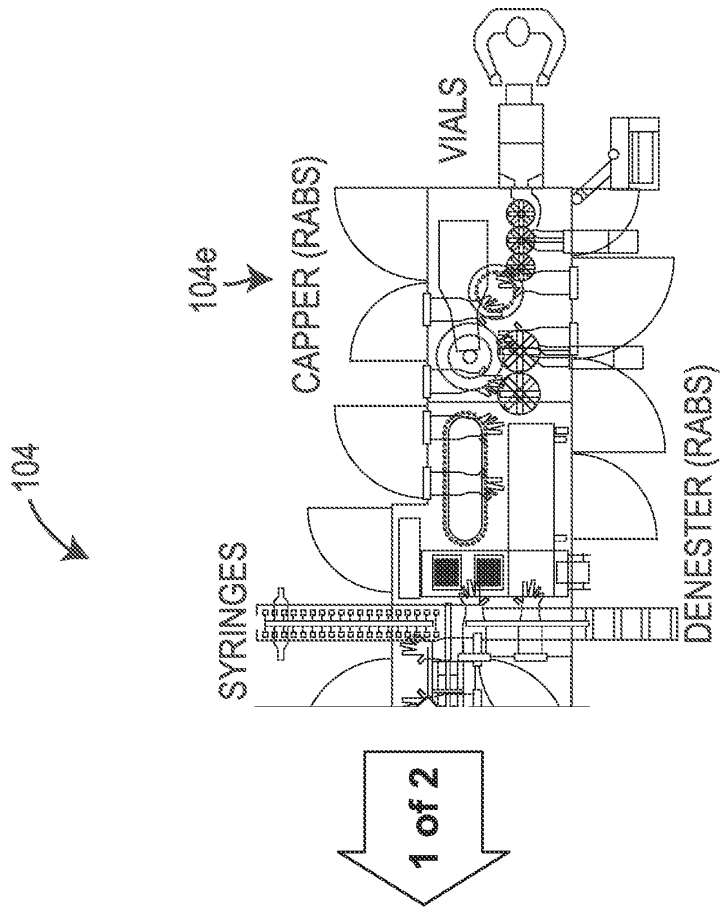


FIG. 13B
(2 of 2)

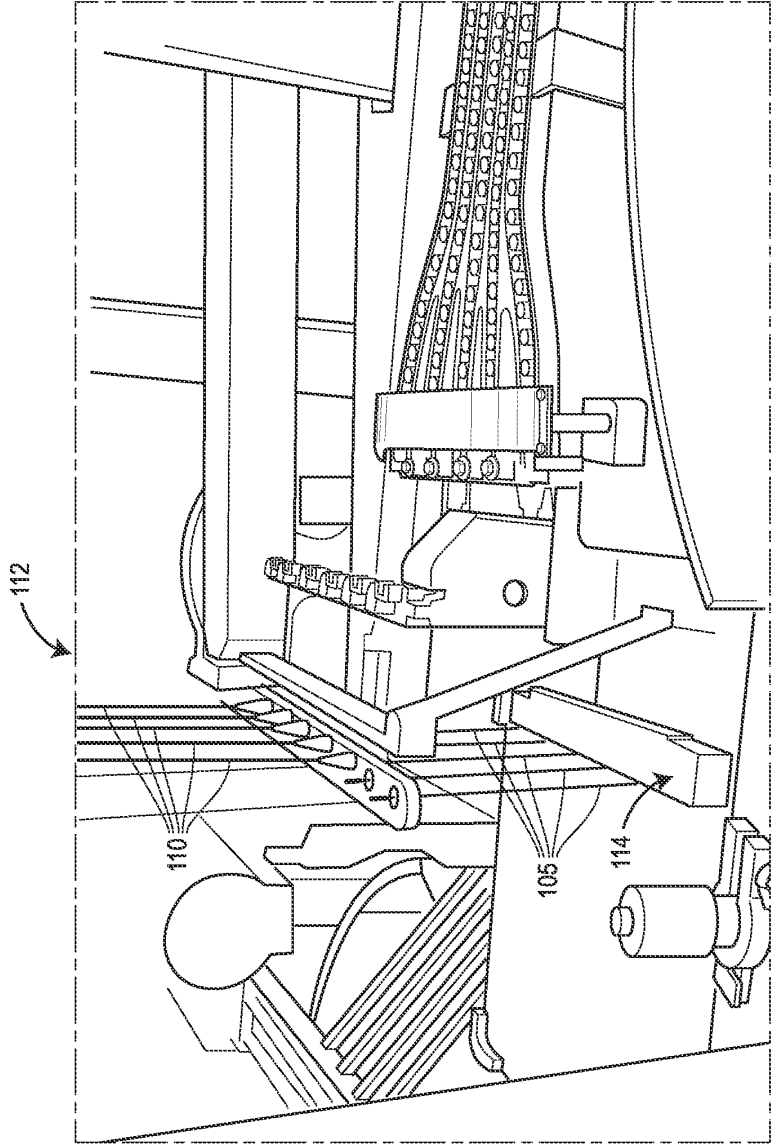


FIG. 13C

New Universal Recipe	Product (lot)	Total dose optimization cycle	Performance criteria	Nozzle 1	Nozzle 2	Nozzle 3	Nozzle 4	Nozzle 5	All Nozzles
	DP1	4	Cpk	1.61	1.63	1.45	1.31	2.05	1.4

FIG. 14

Previous Recipe	Product (lot)	Total dose optimization cycle	Performance criteria	Nozzle 1	Nozzle 2	Nozzle 3	Nozzle 4	Nozzle 5	All Nozzles
	DP3	174	Cpk	0.9	0.8	0.9	1	0.8	0.9
	DP3	93	Cpk	0.9	0.9	1	0.8	1	0.9
	DP4	66	Cpk	0.7	0.7	0.7	0.8	0.8	0.8
	DP5	12	Cpk	1.1	1	1	1	1.1	1
	DP6	8	Cpk	1.2	1.3	0.8	0.8	1.2	1
	Placebo	76	Cpk	1.2	0.5	1.1	1.1	1.2	0.8
	DP6	58	Cpk	0.8	1.6	1.4	0.9	1.3	1.1
	DP3	76	Cpk	1.1	0.9	0.9	0.9	1	1
	All <1.33								

FIG. 15