

1 / 53

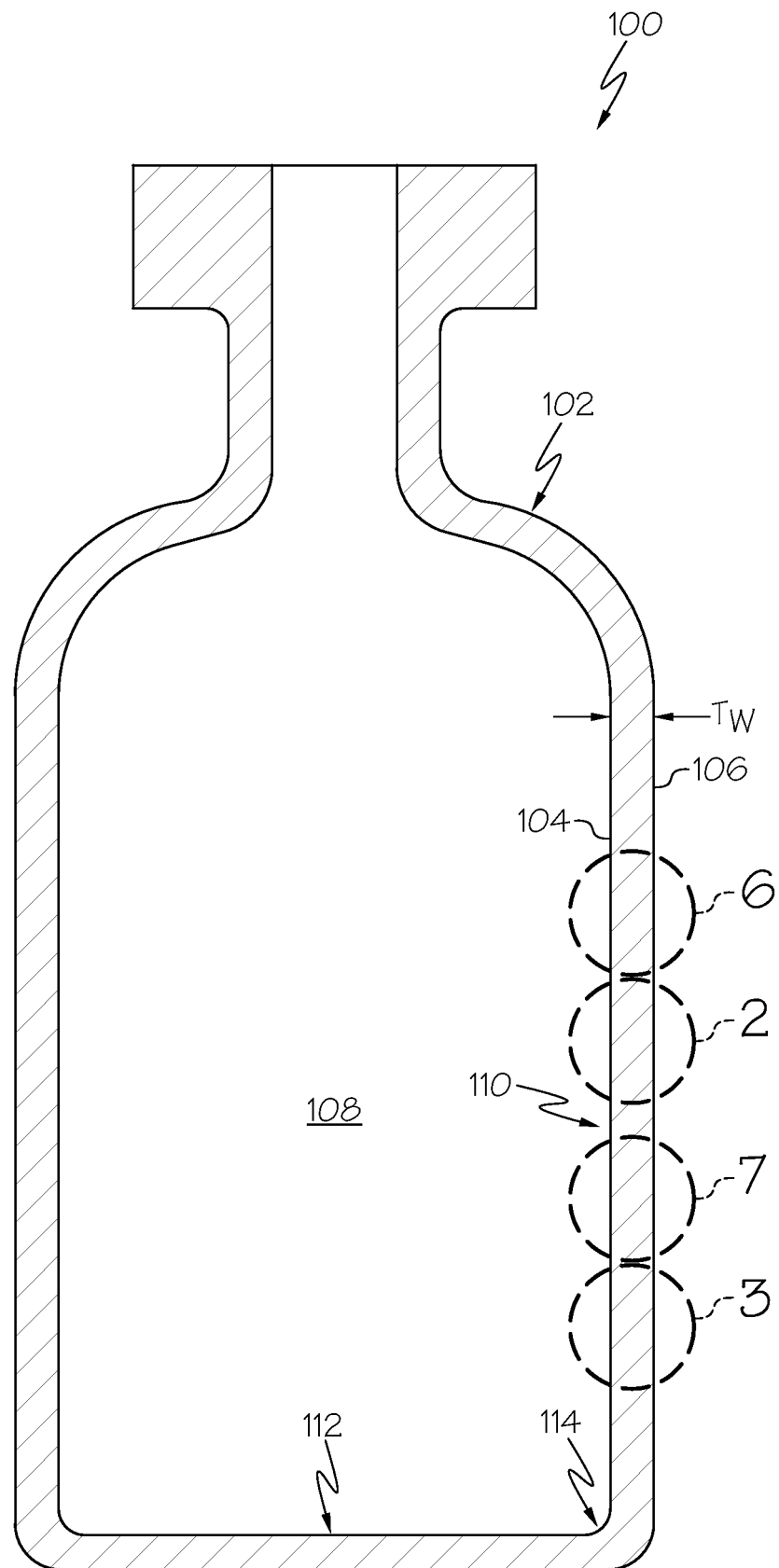


FIG. 1

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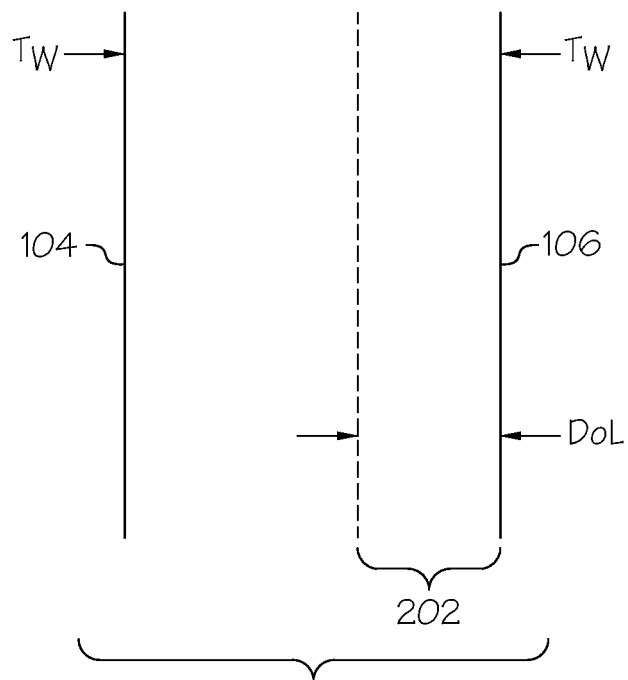


FIG. 2

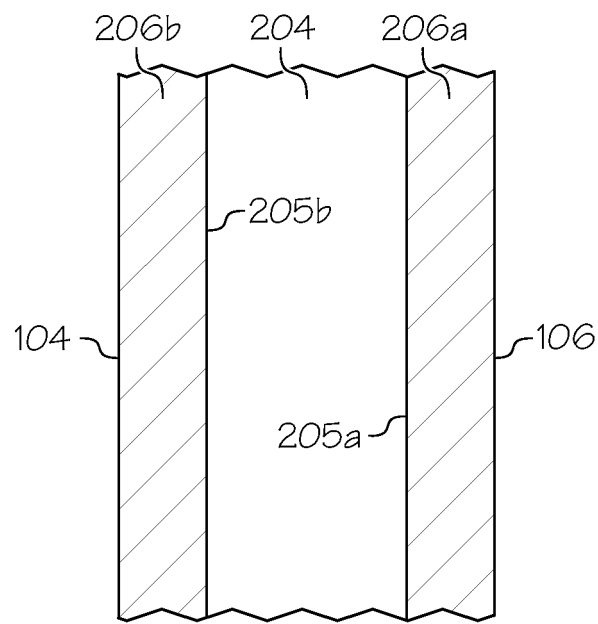


FIG. 3

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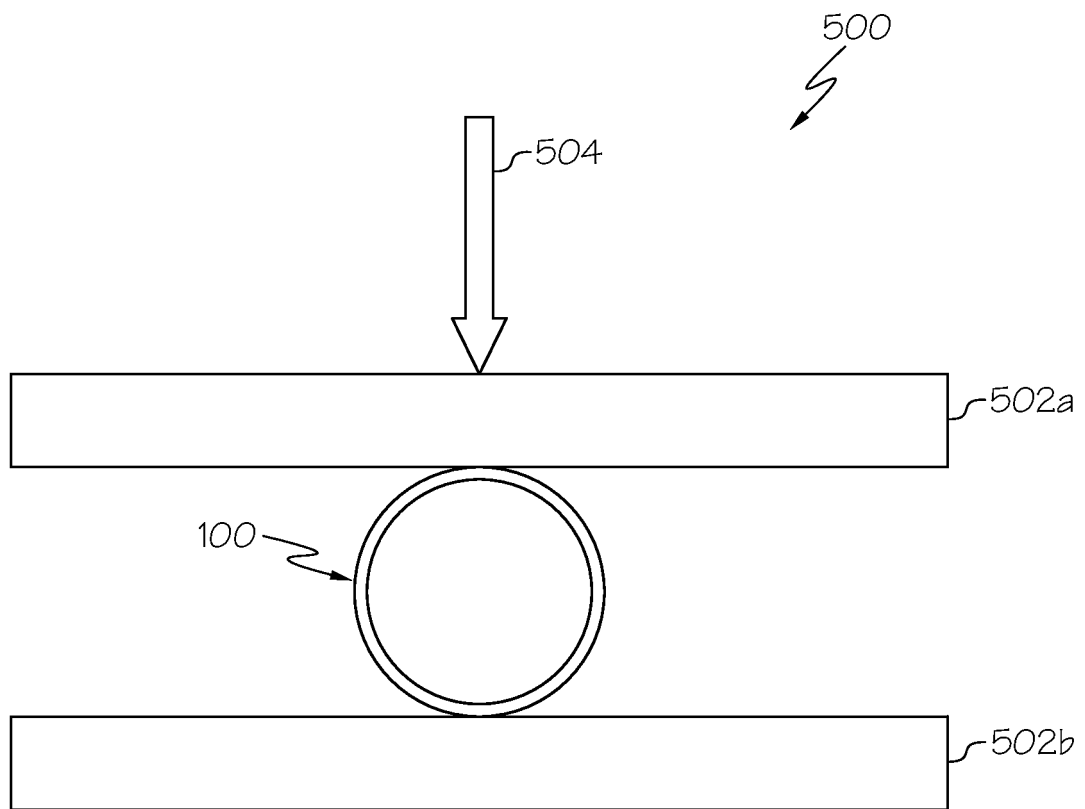


FIG. 4

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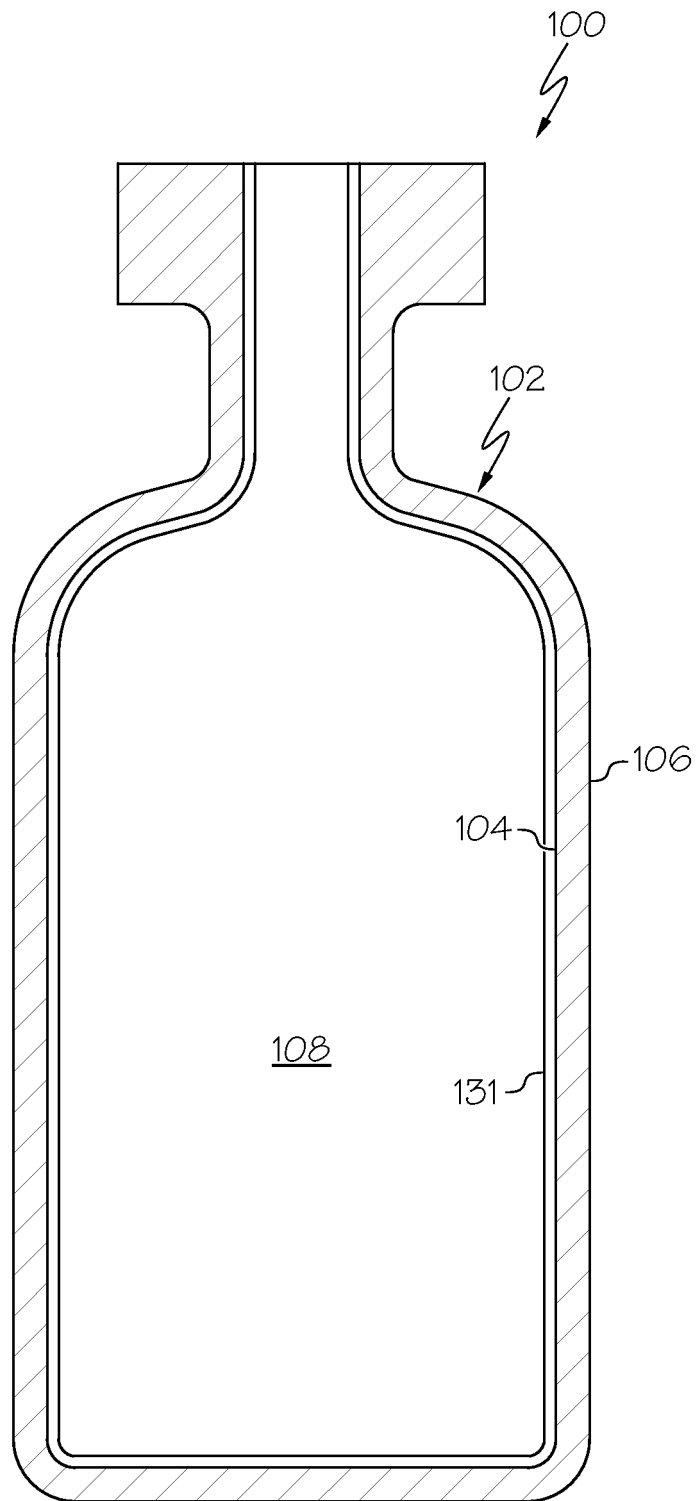


FIG. 5

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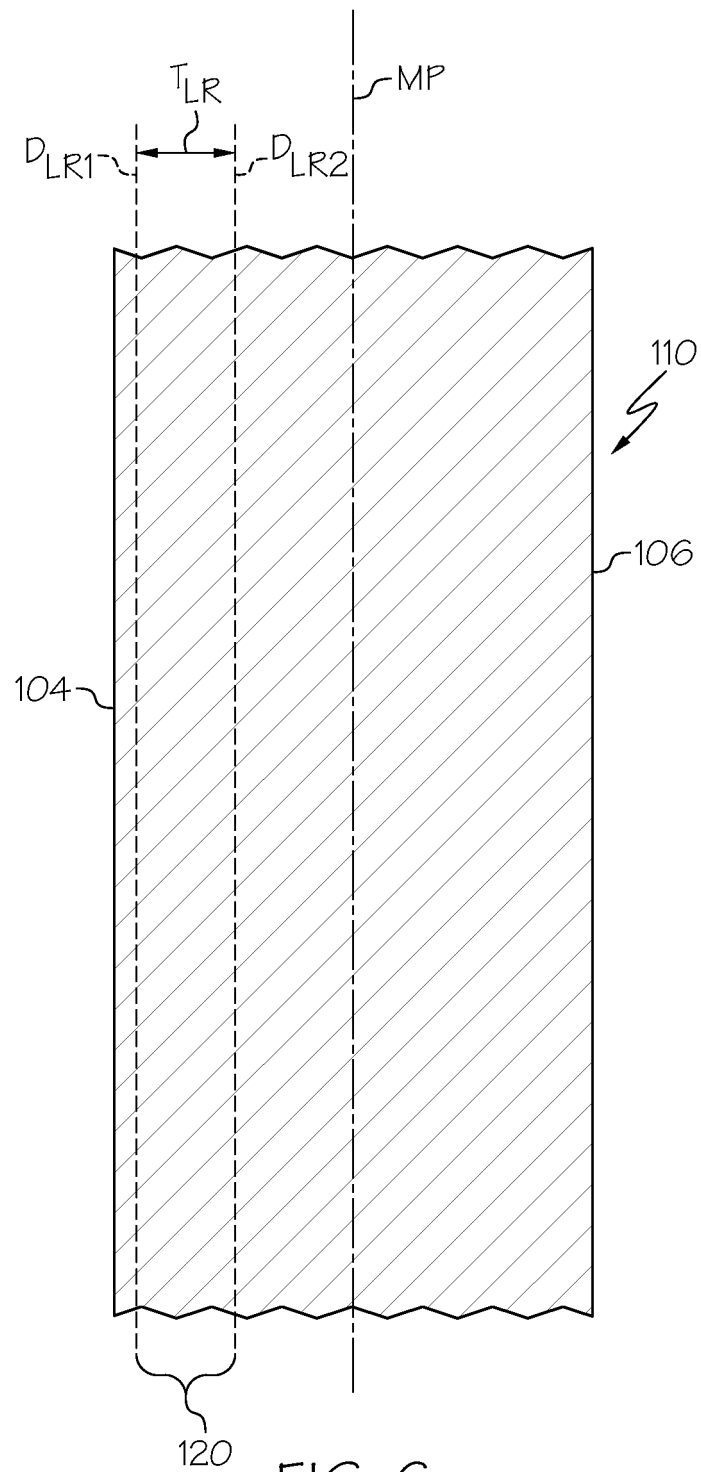


FIG. 6

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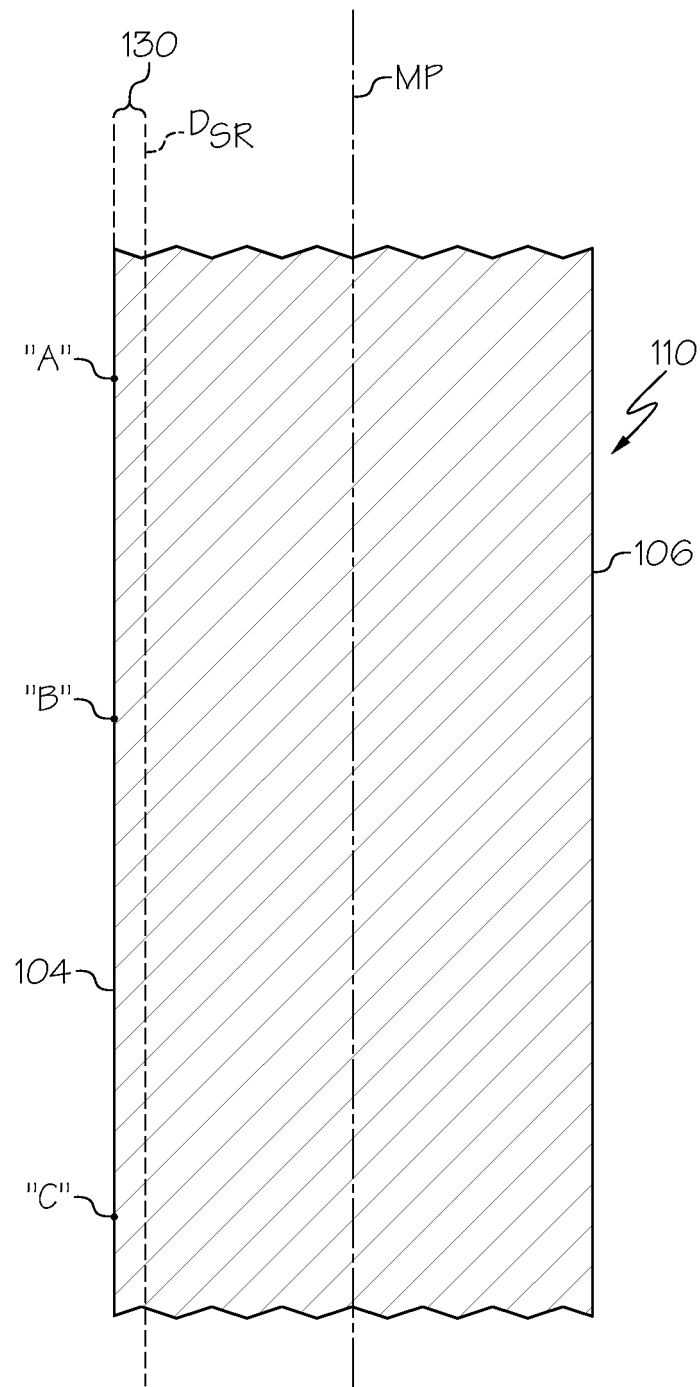


FIG. 7

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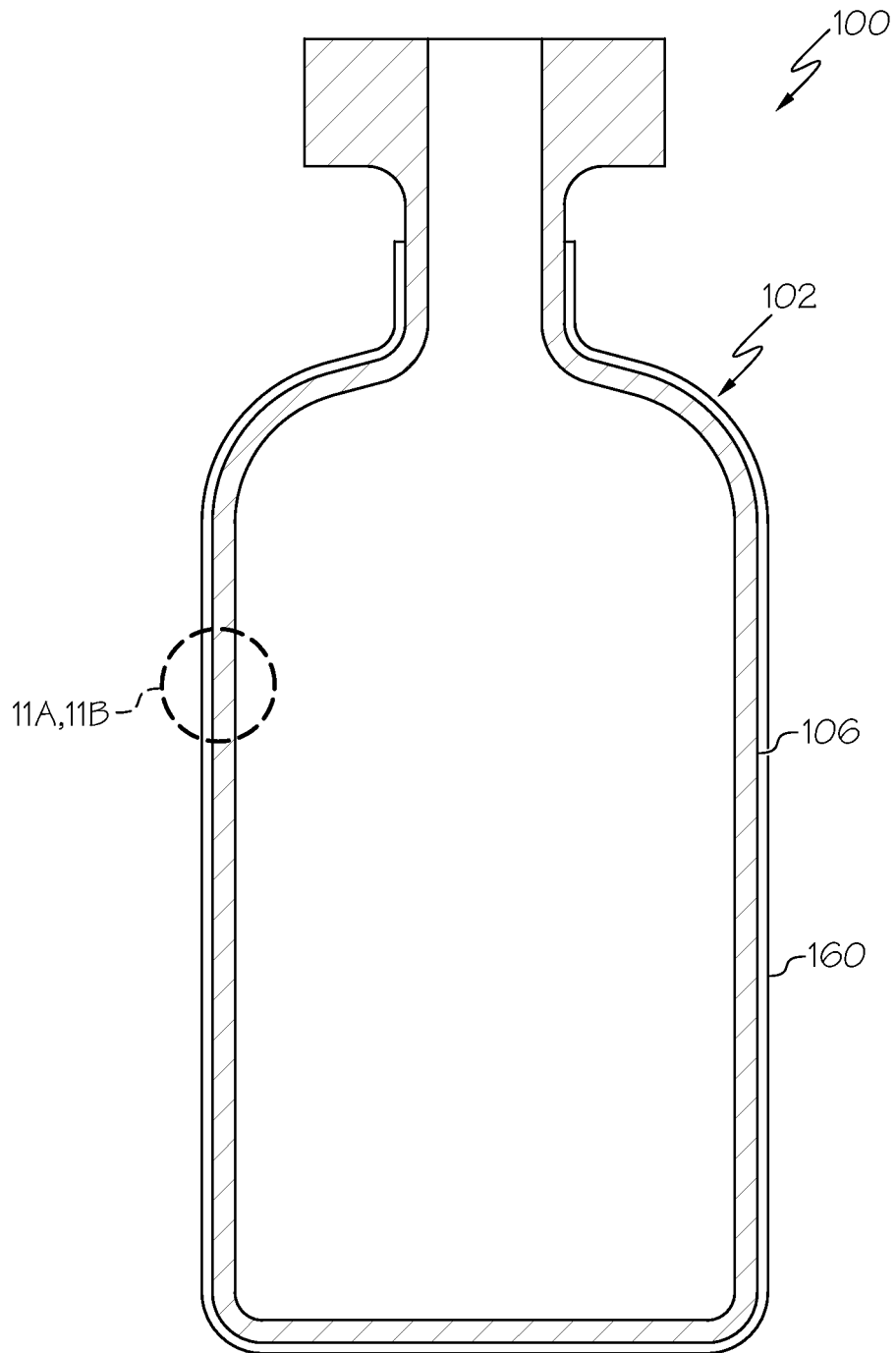


FIG. 8

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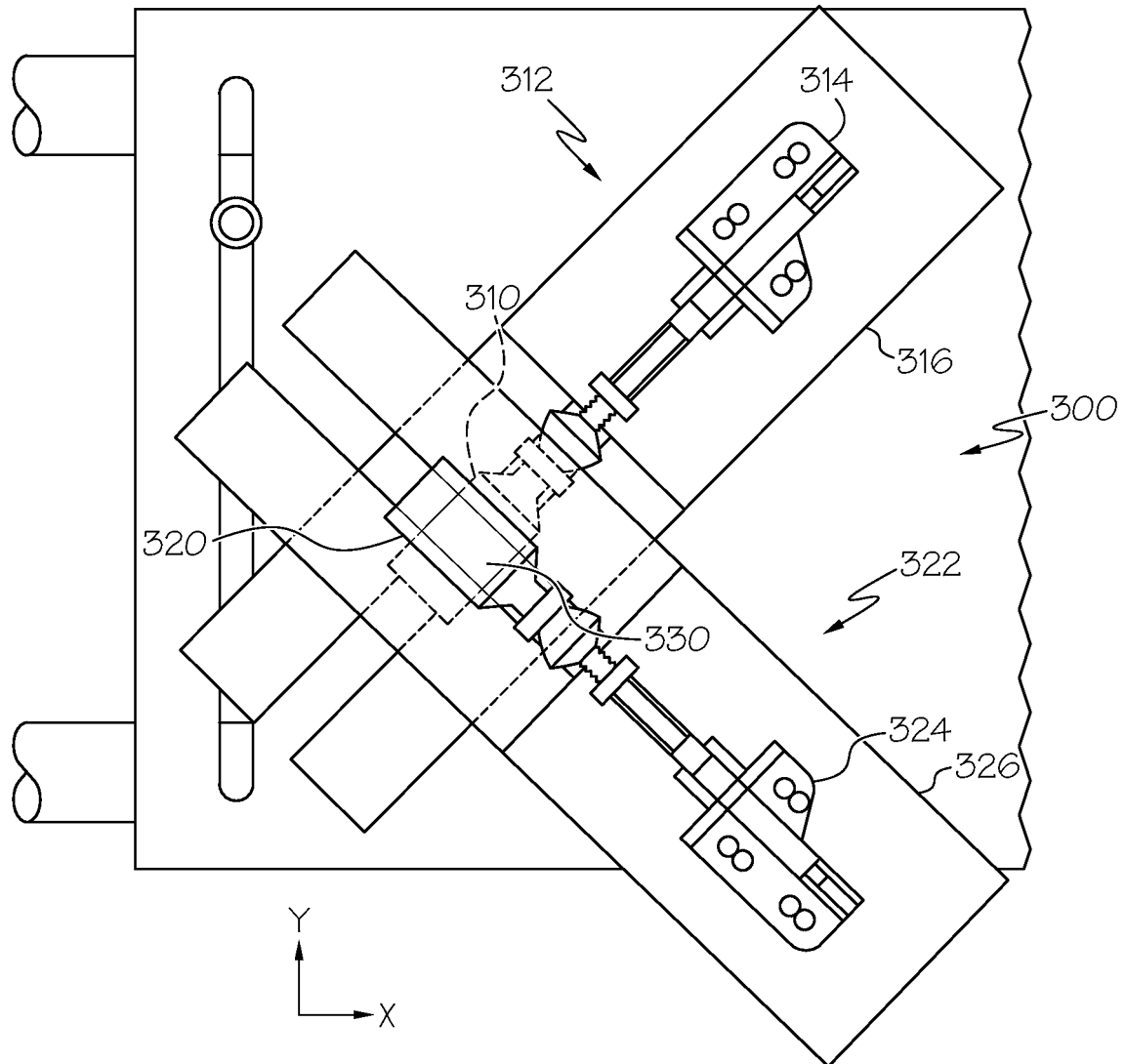


FIG. 9

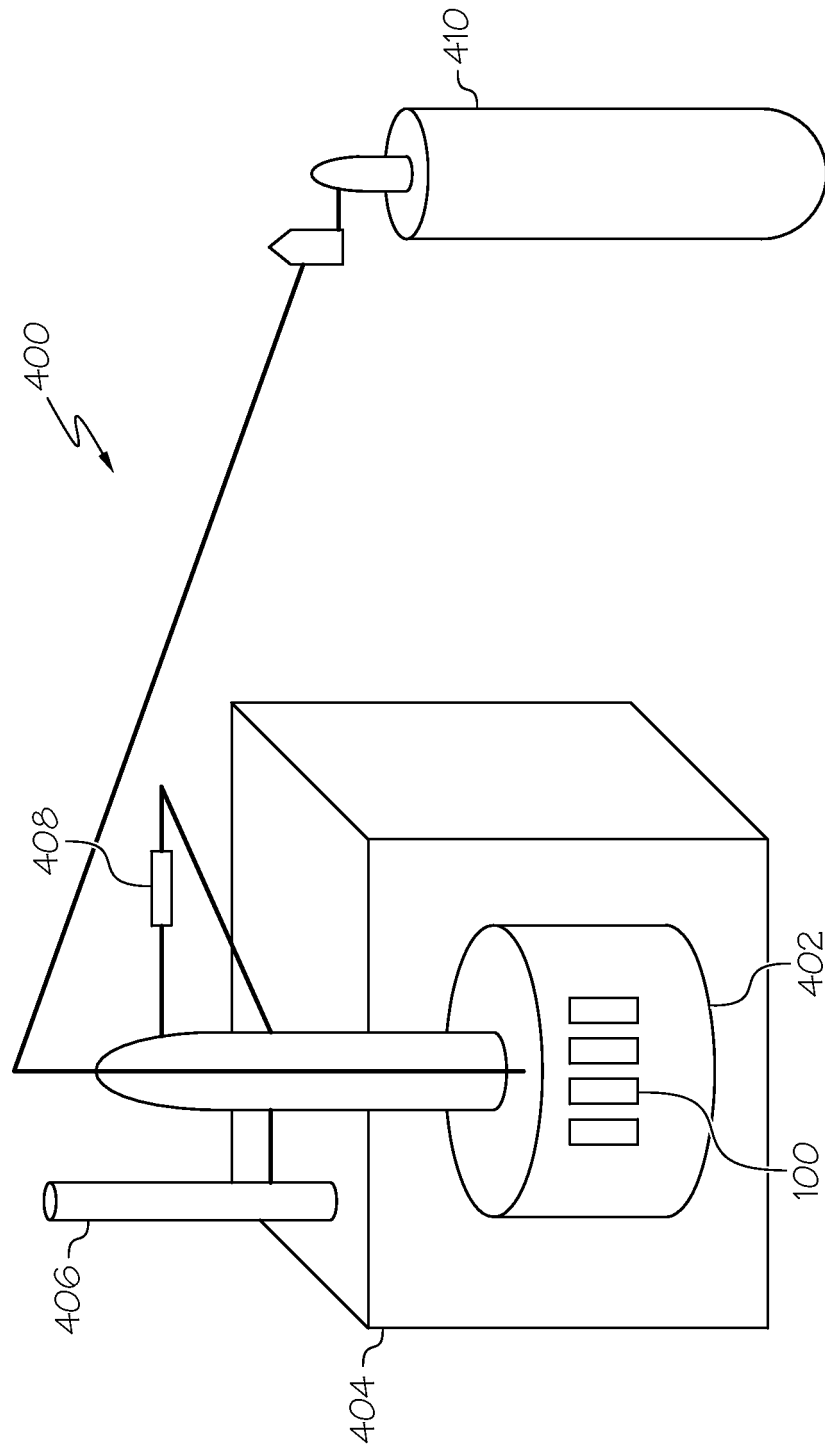


FIG. 10

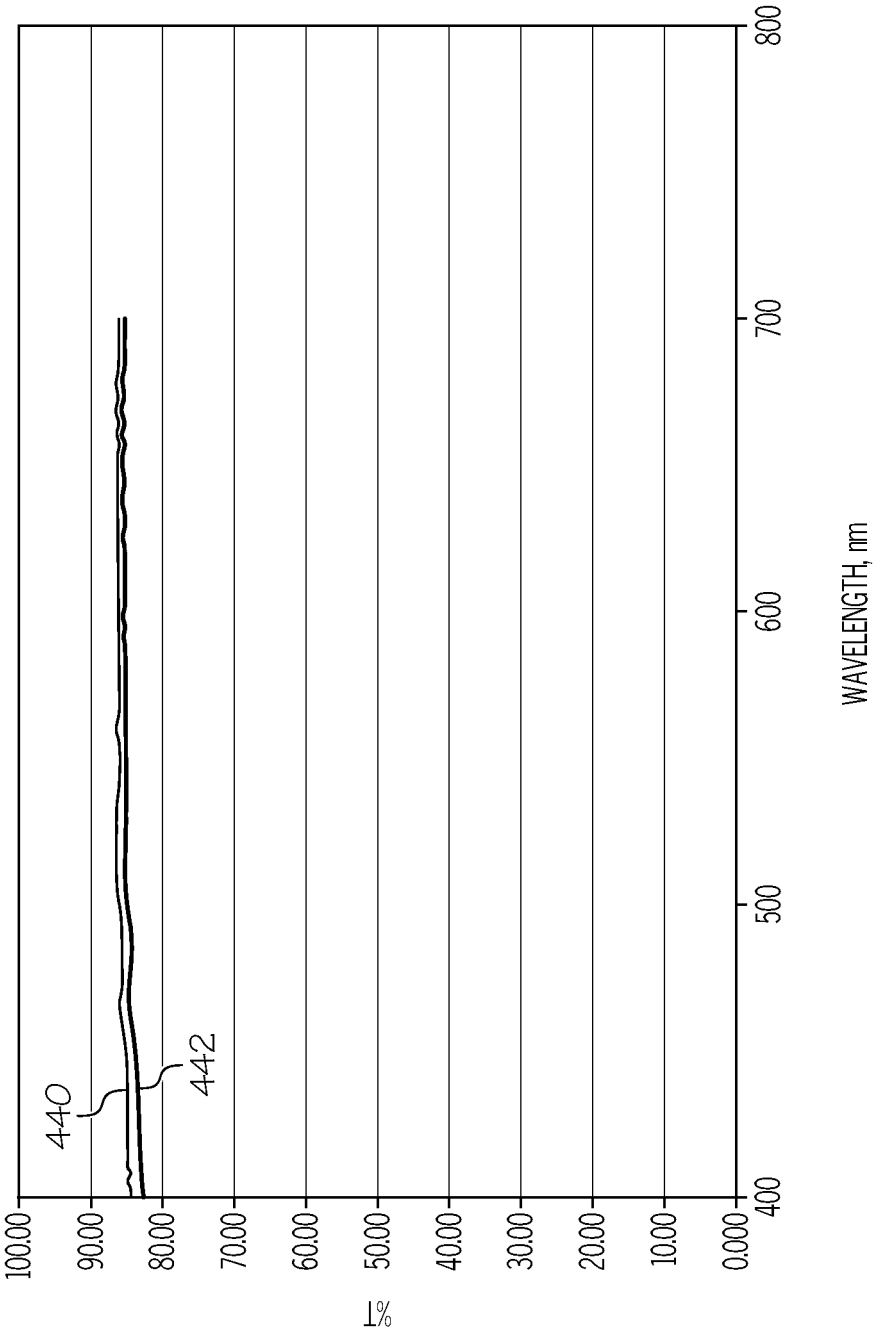


FIG. 11

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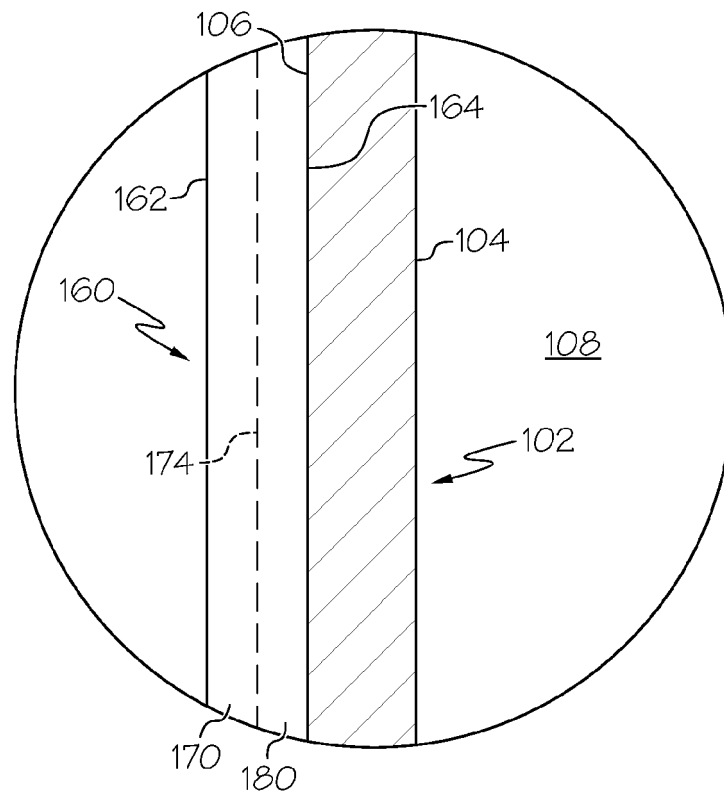


FIG. 12A

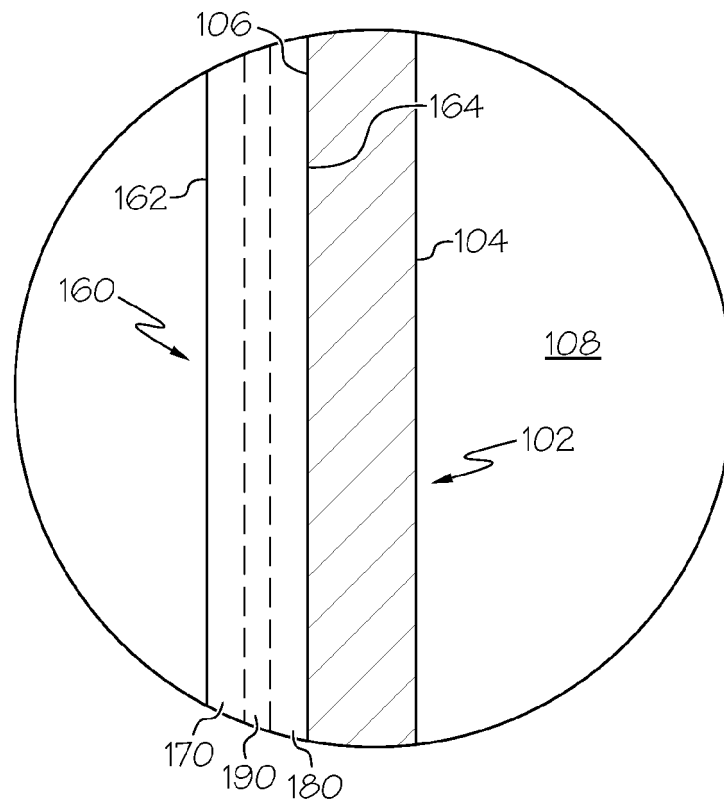


FIG. 12B

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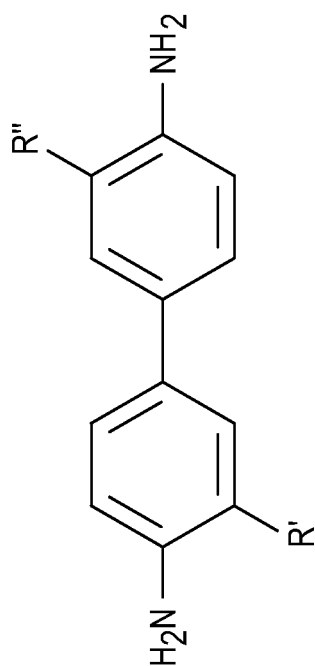


FIG. 13

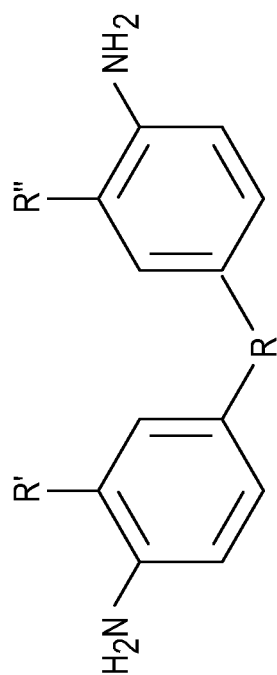


FIG. 14

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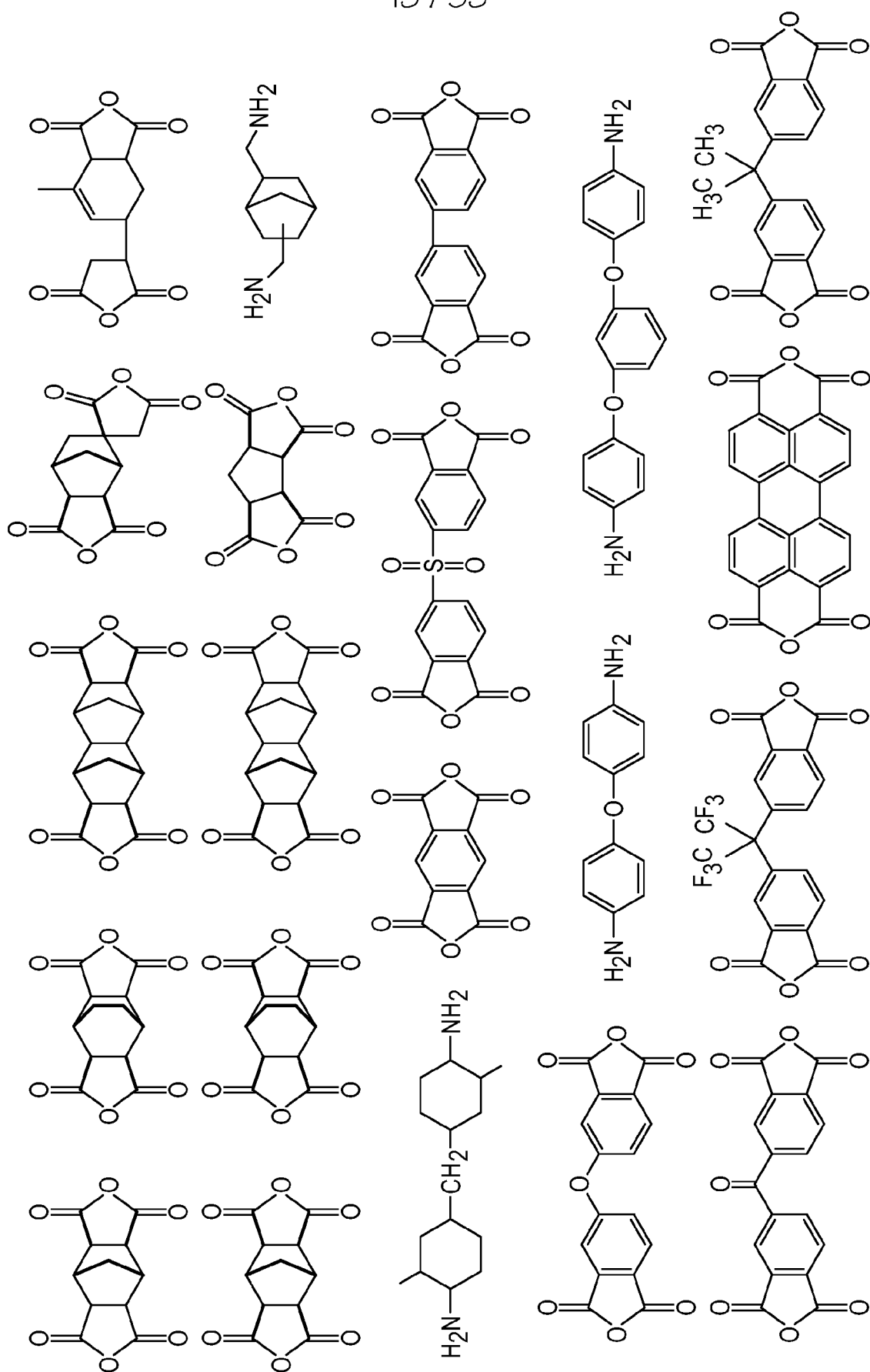


FIG. 15

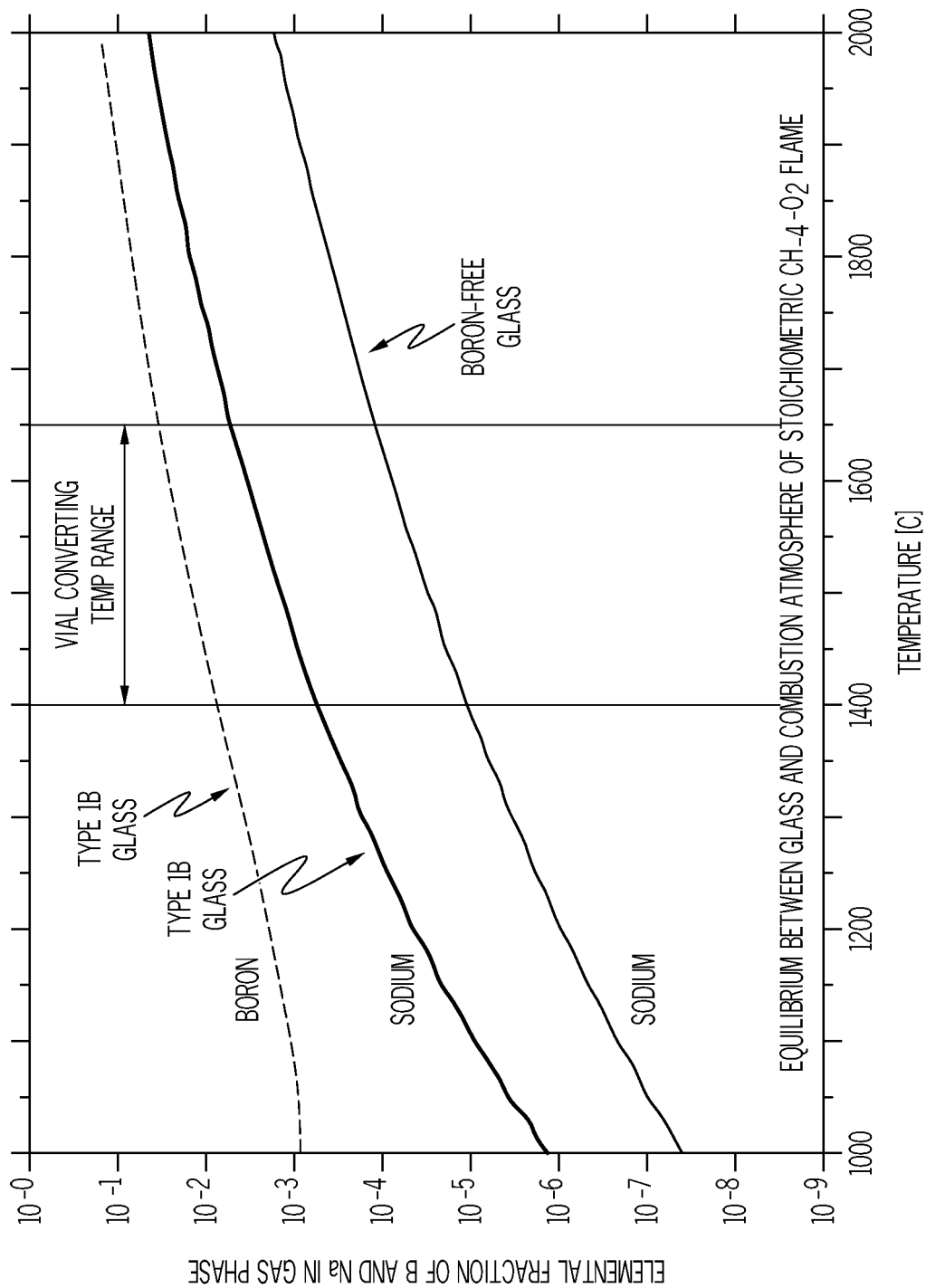


FIG. 16

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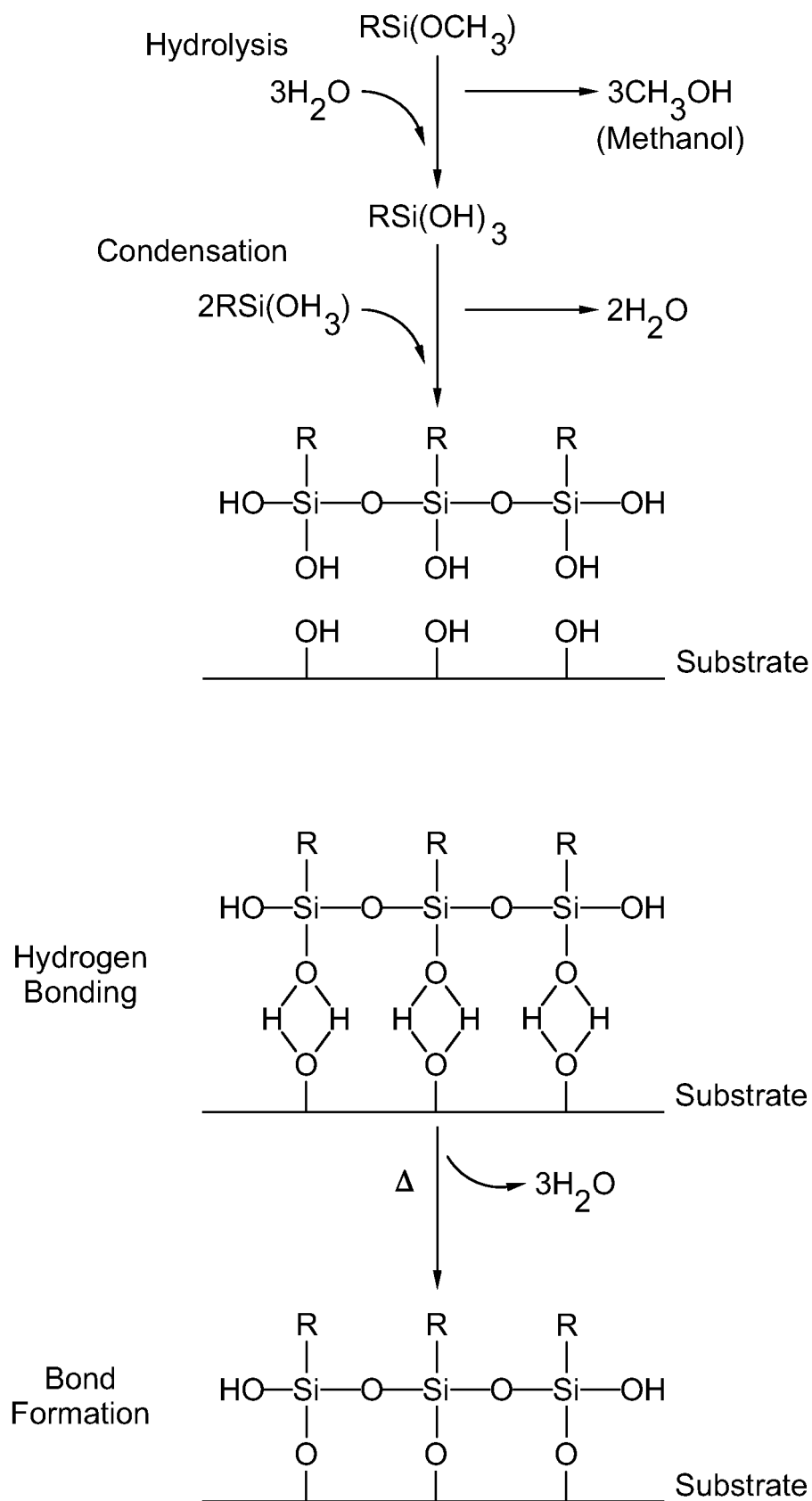


FIG. 17

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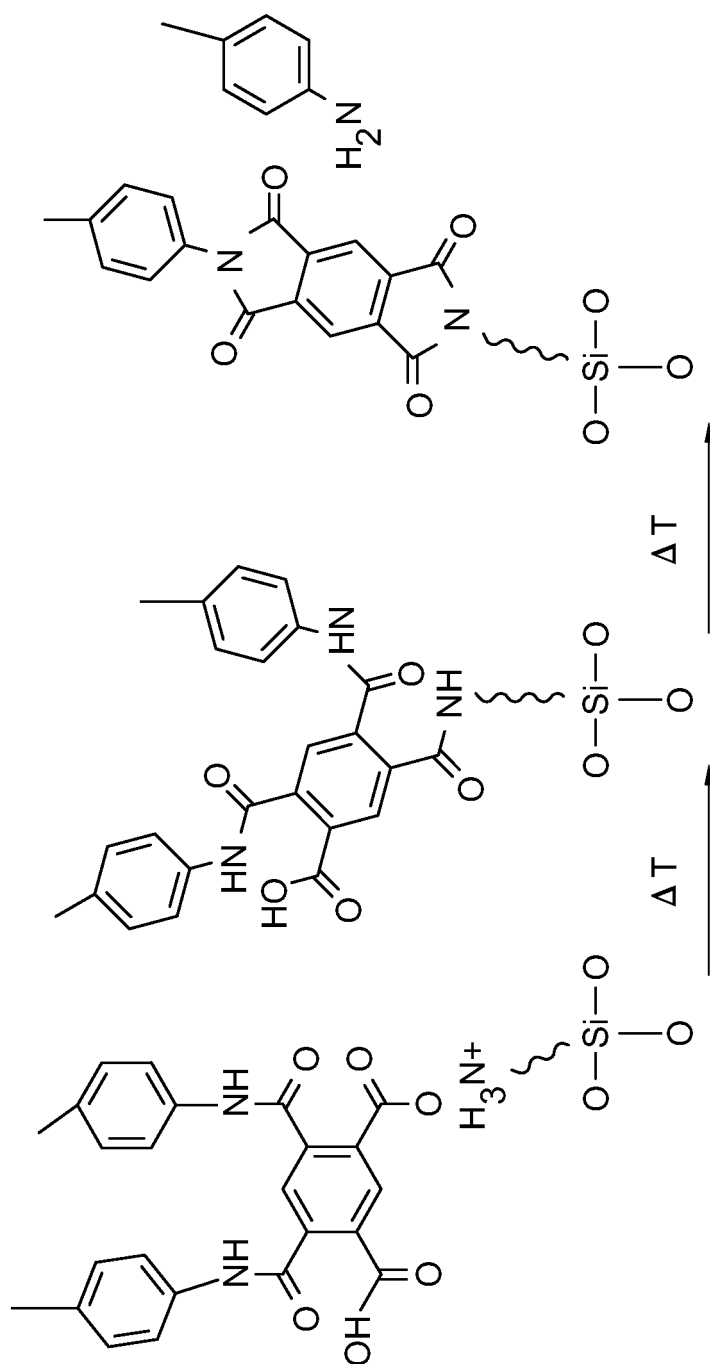


FIG. 18

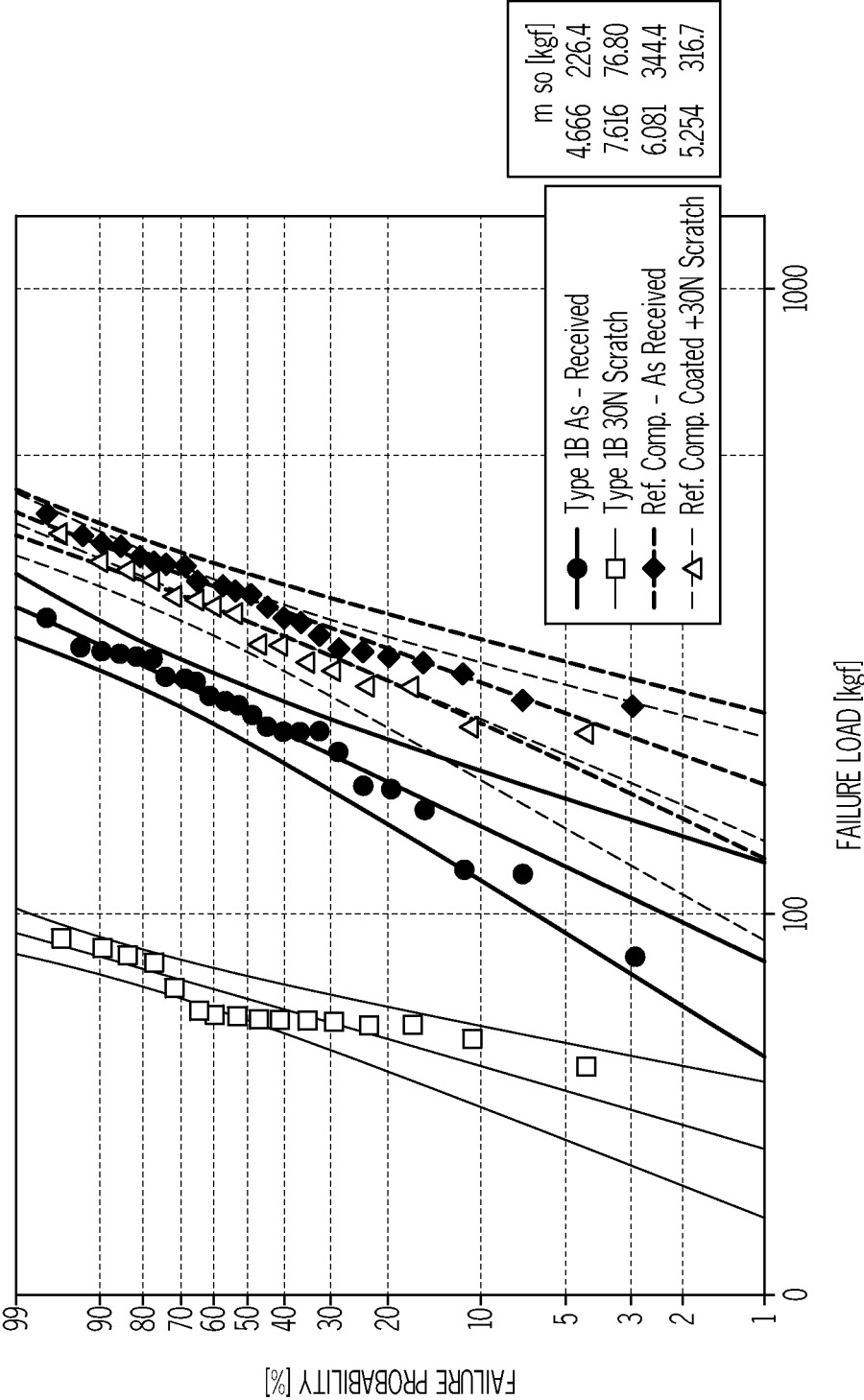


FIG. 19

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30N SCRATCH ON TWO VIAL TYPES

SAMPLE TYPE	VIAL #S	NORMAL LOAD (N)		AVG	COF	
		MIN	MAX		ST. DEV.	MAX
UNCOATED TYPE IB	1&2	28	34	31	0.42	0.18
	3&4	29	36	31	0.45	0.18
	5&6	28	34	30	0.45	0.11
	7&8	26	32	29	0.33	0.14
	9&10	28	33	30	0.16	0.15
	11&12	25	33	28	0.16	0.09
	12&14	29	33	30	0.22	0.16
	15&16	28	35	31	0.53	0.11
	AVERAGE	28	34	30	0.38	0.14
						0.63
REF. COMP. IX@450 COATED 0.1/0.1 APS/NOV.800	1&2	28	31	30	0.12	0.04
	3&4	24	31	28	0.16	0.08
	5&6	30	44	40	0.08	0.02
	7&8	27	31	30	0.08	0.05
	9&10	28	30	30	0.08	0.03
	11&12	30	33	31	0.12	0.04
	12&14	29	32	30	0.15	0.07
	15&16	28	32	30	0.09	0.02
	AVERAGE	28	33	31	0.11	0.04
						0.29

FIG. 20

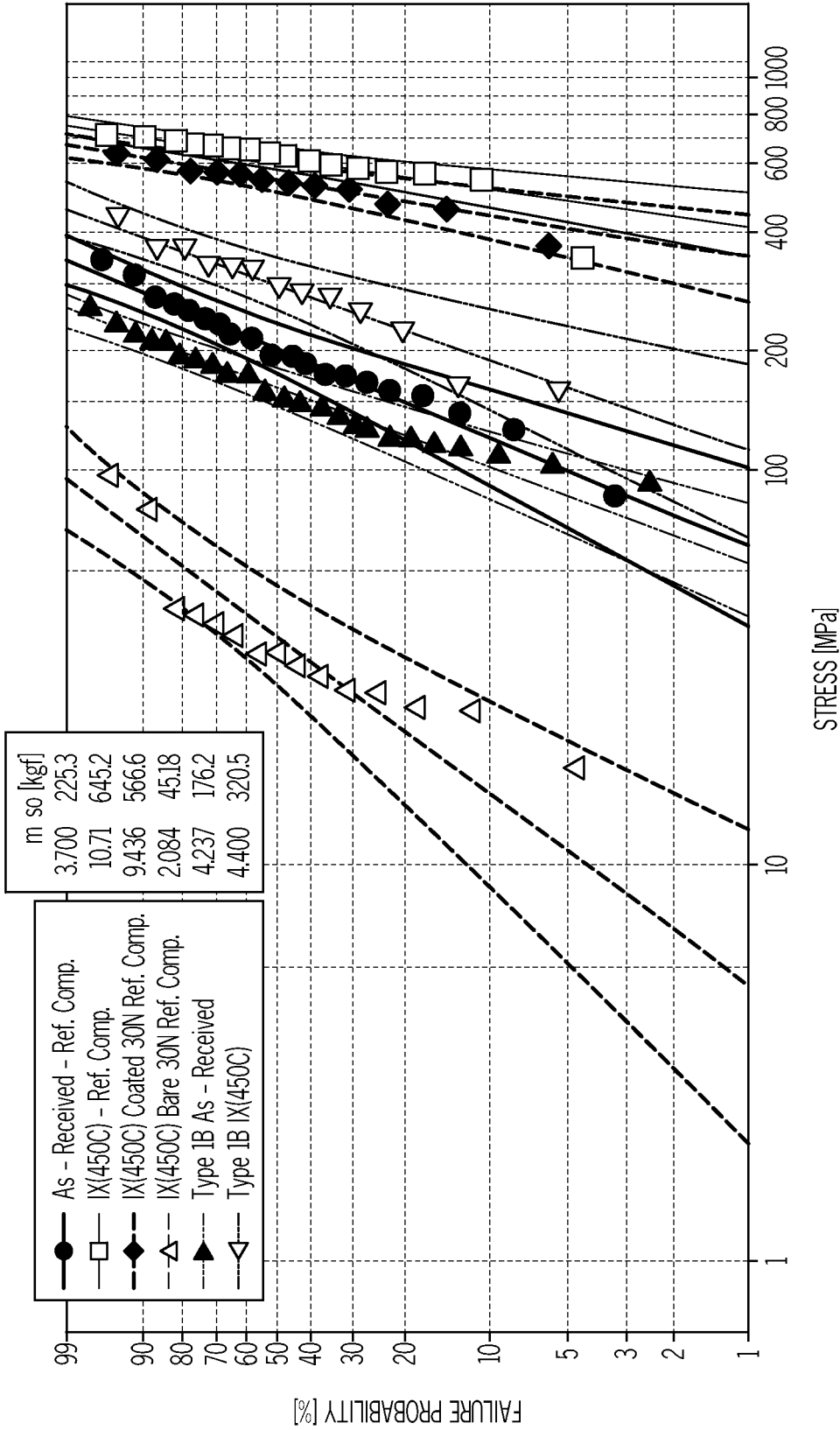


FIG. 21

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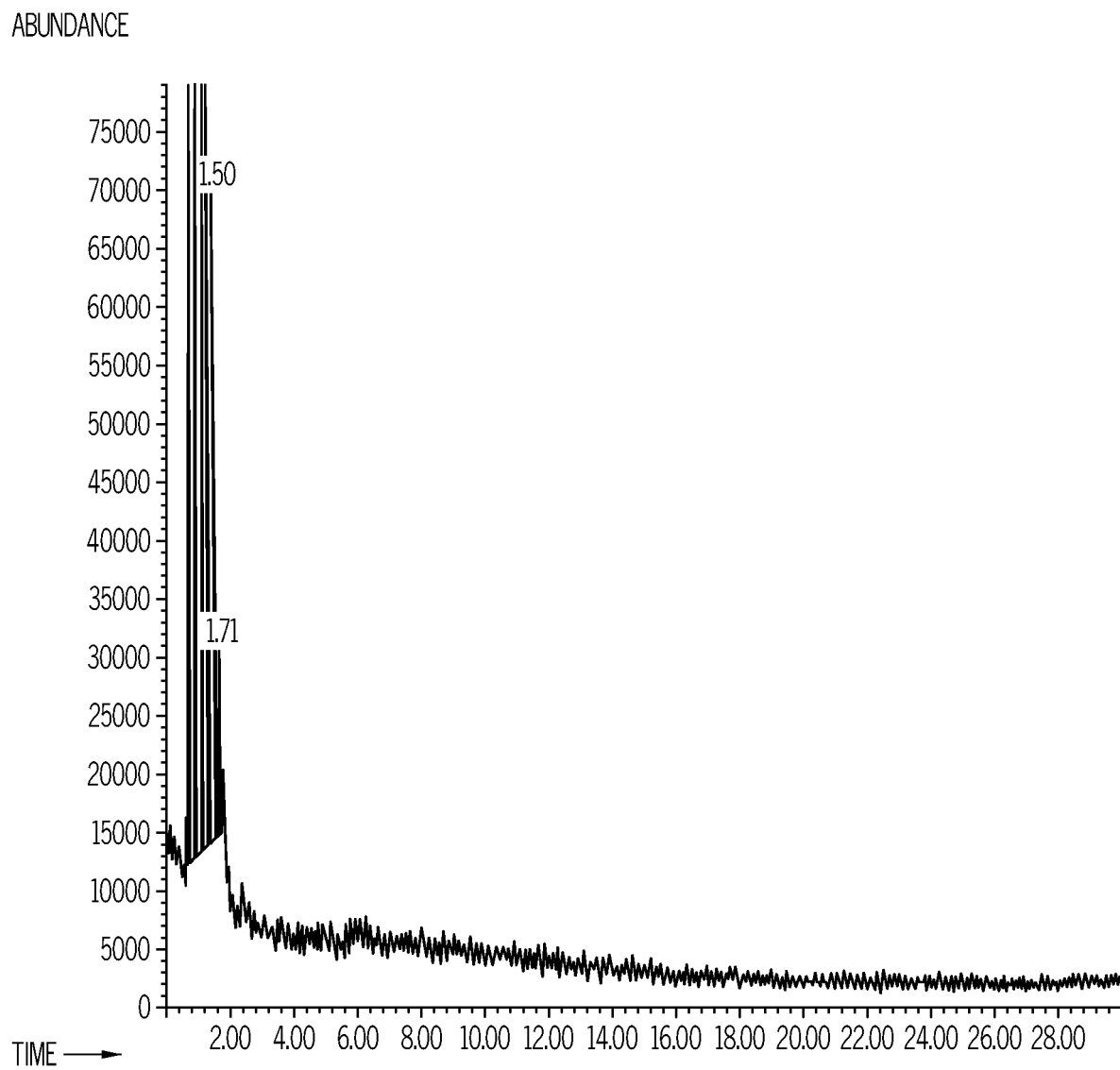


FIG. 22

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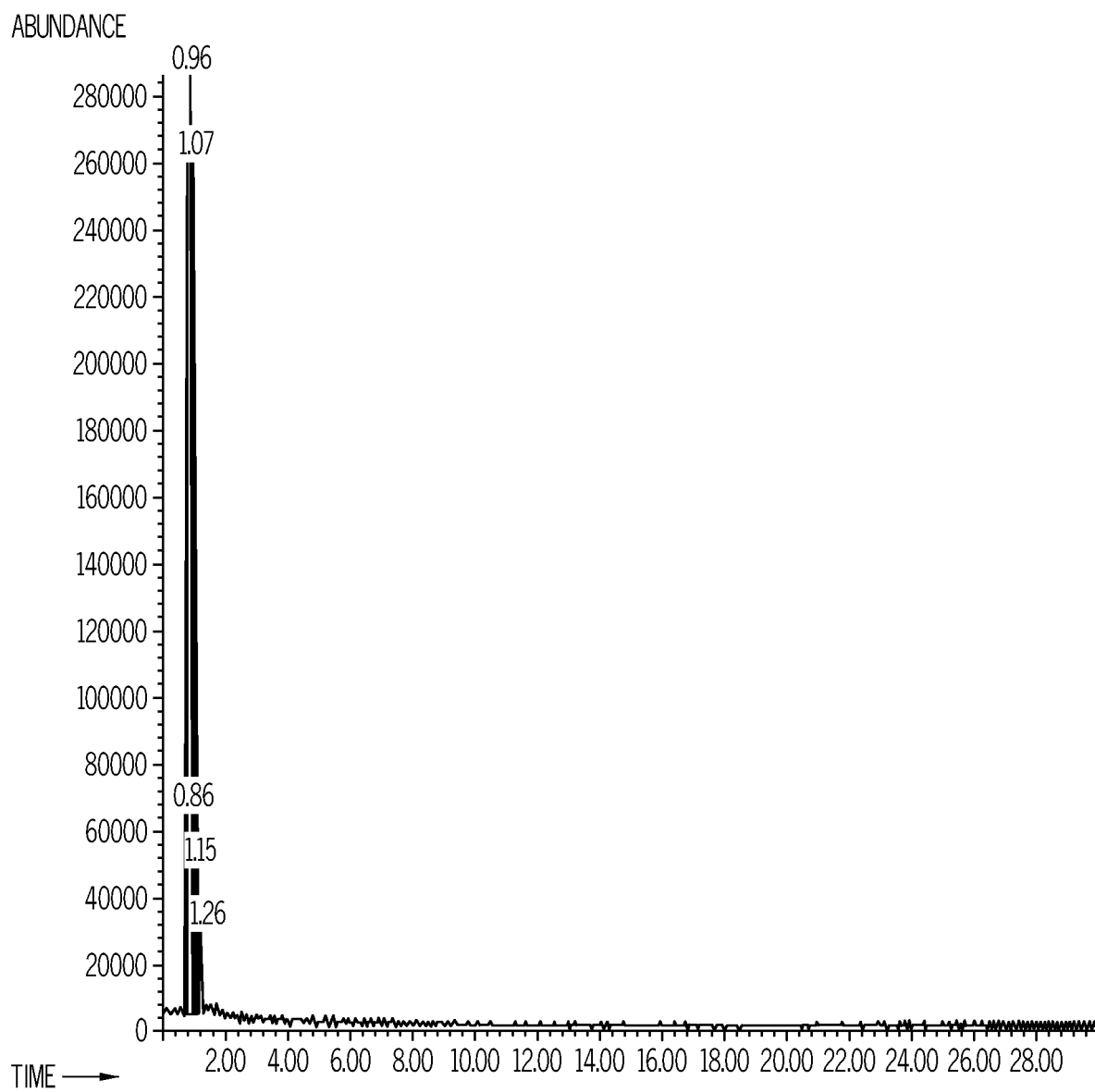


FIG. 23

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FORMULATION	RELATIVE THICKNESS	CONDITION
0.1% APS/1.0% PMDA-ODA	10	AS IS
0.1% APS/0.1% PMDA-ODA	1	AS IS
0.1 APS 0.5 DC806A	5	1 H TUMBLE
0.1 APS 0.1 DC806A	1	1 H TUMBLE
0.1 APS 0.1 PMDA-ODA	1	1 H TUMBLE
0.1 APS 0.5 PMDA-ODA	5	1 H TUMBLE
1.0% DC255	10	0.5 H TUMBLE
1.0% DC255	10	1 H TUMBLE
1.0% DC255	10	2 H TUMBLE
1.0% DC255	10	AS IS
1.0% PMDA-ODA	10	DURHAM FILING LINE
0.1 APS 0.1 NOVA800	1	6 MIN TUMBLE
0.1 APS 0.1 NOVA800	1	15 MIN TUMBLE
1.0 GAPS/1.0 DC806A	10	6 MIN TUMBLE
1.0 GAPS/1.0 DC806A	10	15 MIN TUMBLE
1.0 GAPS/1.0 DC806A	10	AS IS
0.1 APS 0.1 NOVA800	1	AS IS
TYPE 1B BARE	0	30N (3), 50N (1)
1.0 GAPS/1.0 DC806A	10	30N SCRATCH 3
1.0 GAPS/1.0 DC806A	10	50N_SCRATCH 1
0.1 APS 0.1 NOVA800	1	30N SCRATCH 3
0.1 APS 0.1 NOVA800	1	50N_SCRATCH 1

FIG. 24

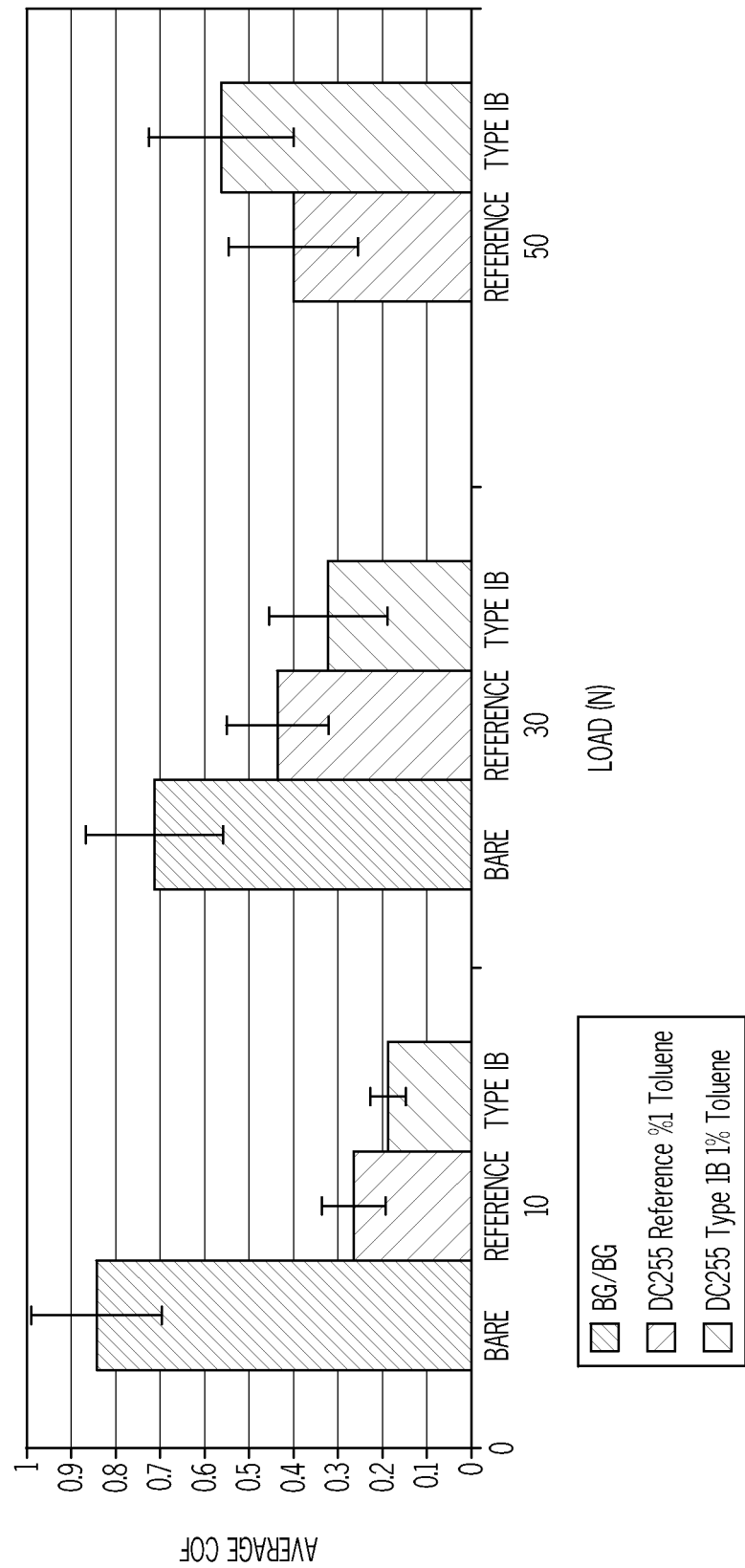


FIG. 25

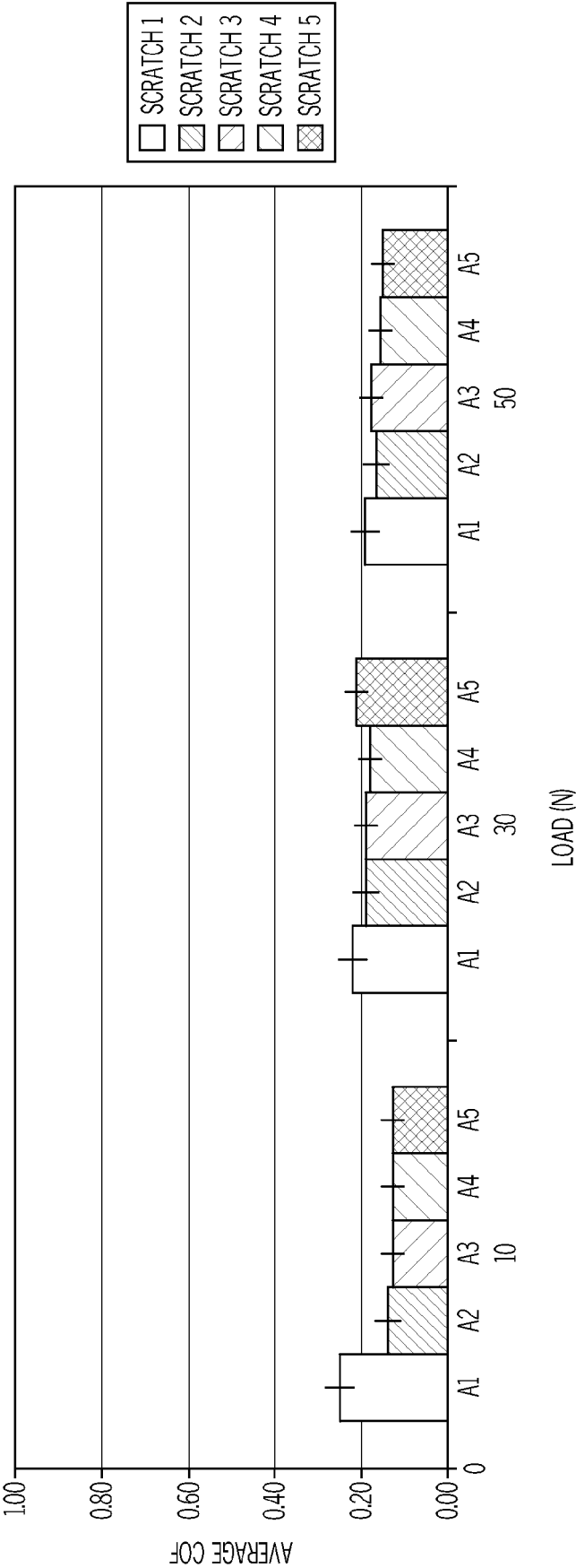


FIG. 26

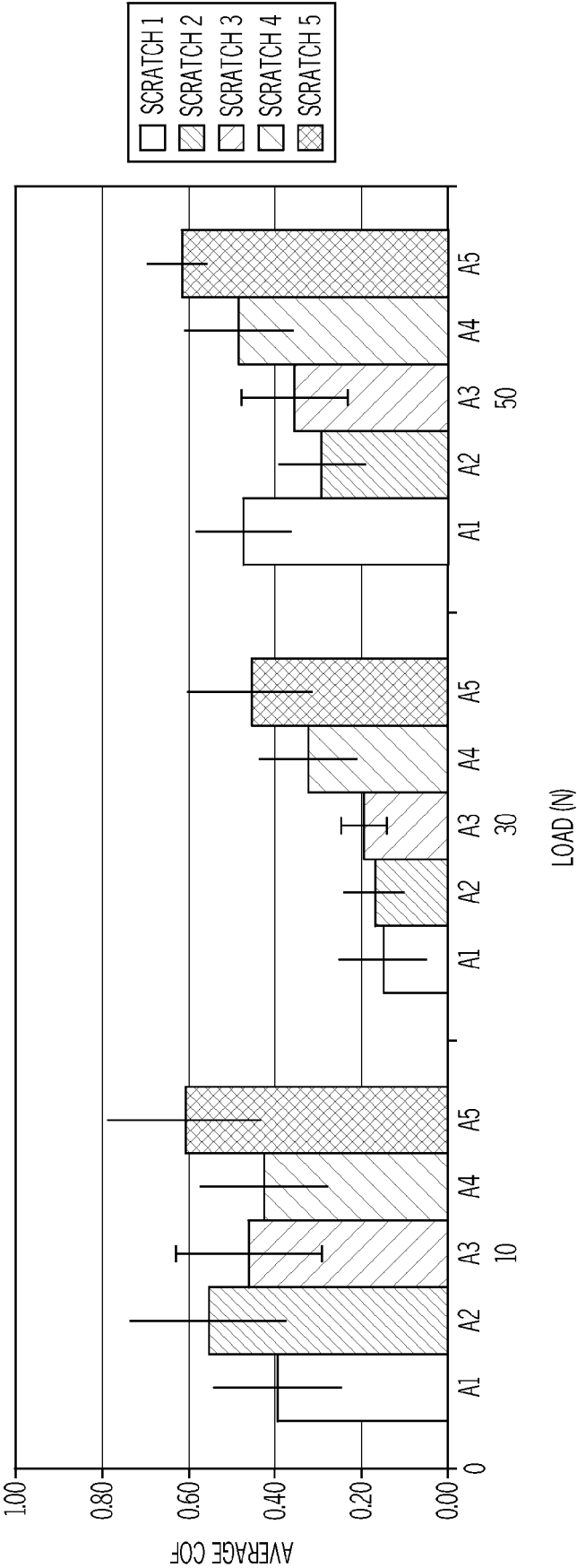


FIG. 27

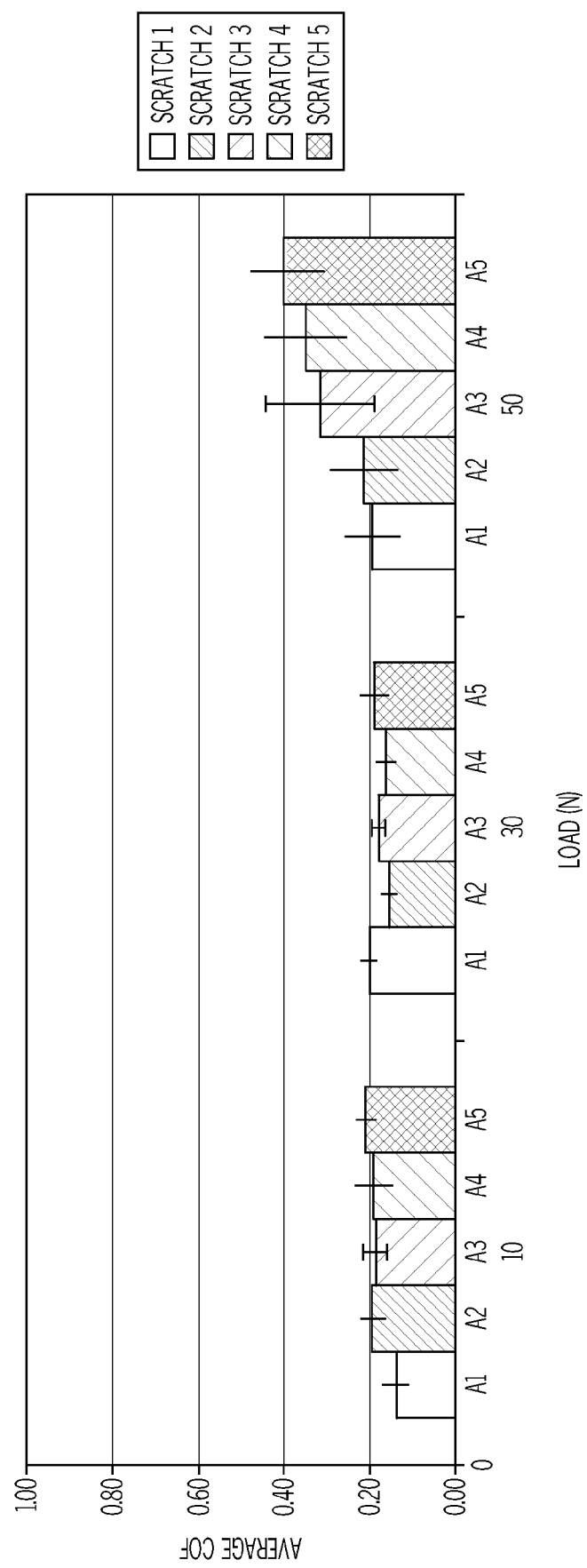


FIG. 28

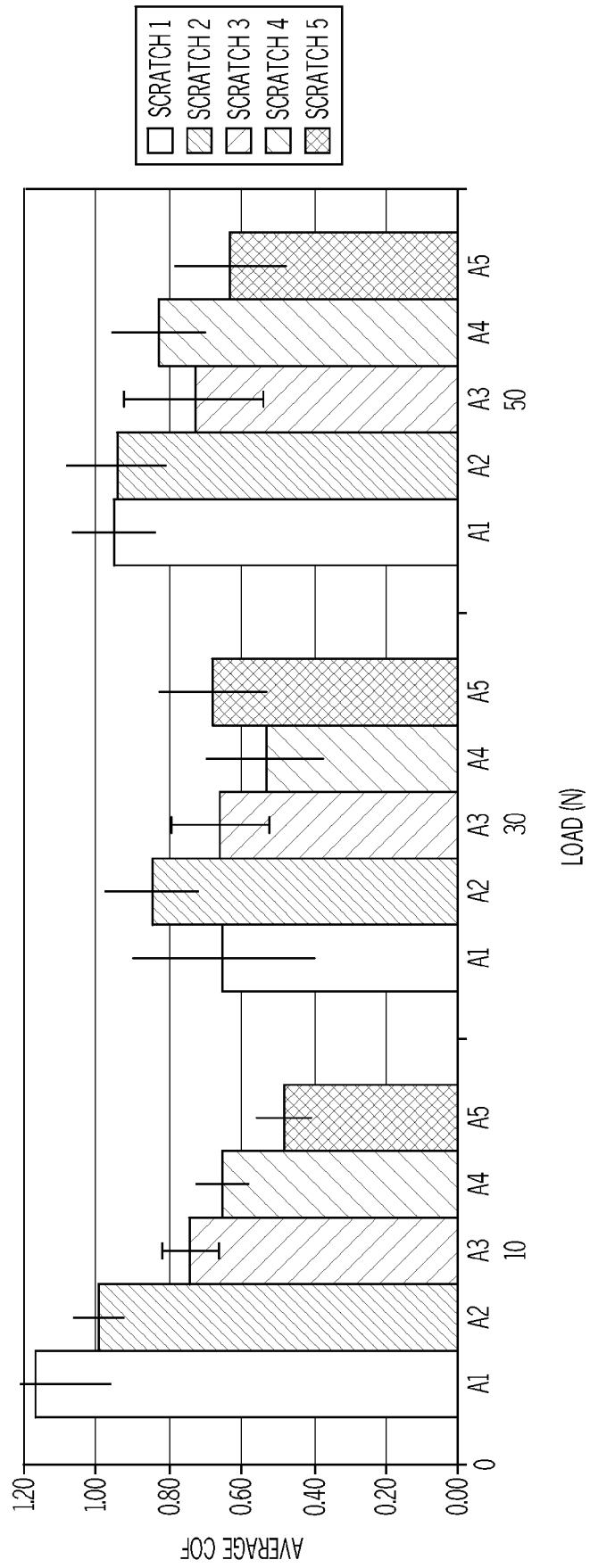


FIG. 29

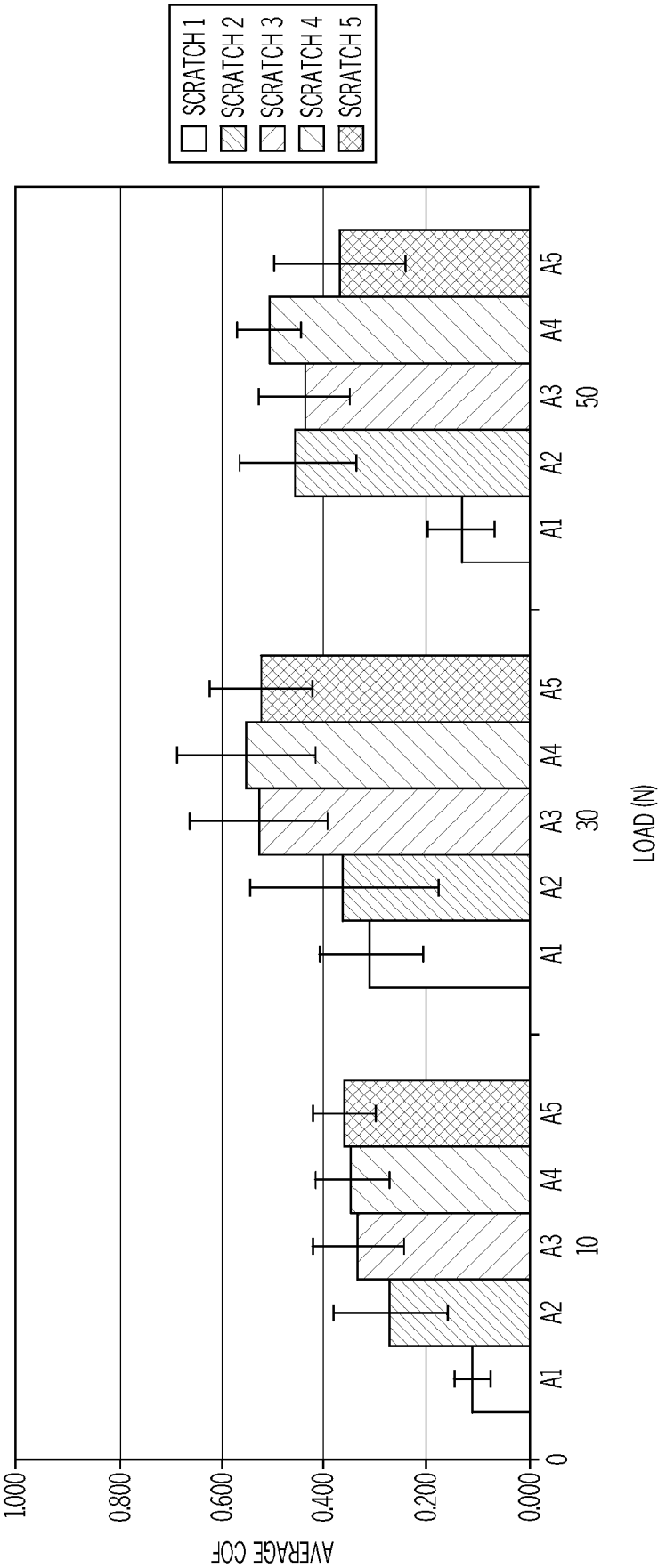


FIG. 30

BEFORE						
VIALS	Z-LOAD		COF		FX MAX	
	AVG	MAX	AVG	ST. DEV.	MAX	
1&2	34	36	0.11	0.03	0.23	8
3&4	30	32	0.14	0.02	0.18	5
5&6	34	36	0.09	0.02	0.19	6
7&8	31	33	0.07	0.01	0.02	4
9&10	31	33	0.08	0.01	0.14	4

3) APS/NOVA LYOPHILLIZED

VIALS	Z-LOAD		COF		FX MAX	
	AVG	MAX	AVG	ST. DEV.	MAX	
1&2	37	39	0.06	0.01	0.09	3
3&4	40	43	0.06	0.01	0.14	6
5&6	30	31	0.05	0.01	0.09	3
7&8	30	31	0.05	0.01	0.07	2
9&10	30	32	0.05	0.01	0.16	5

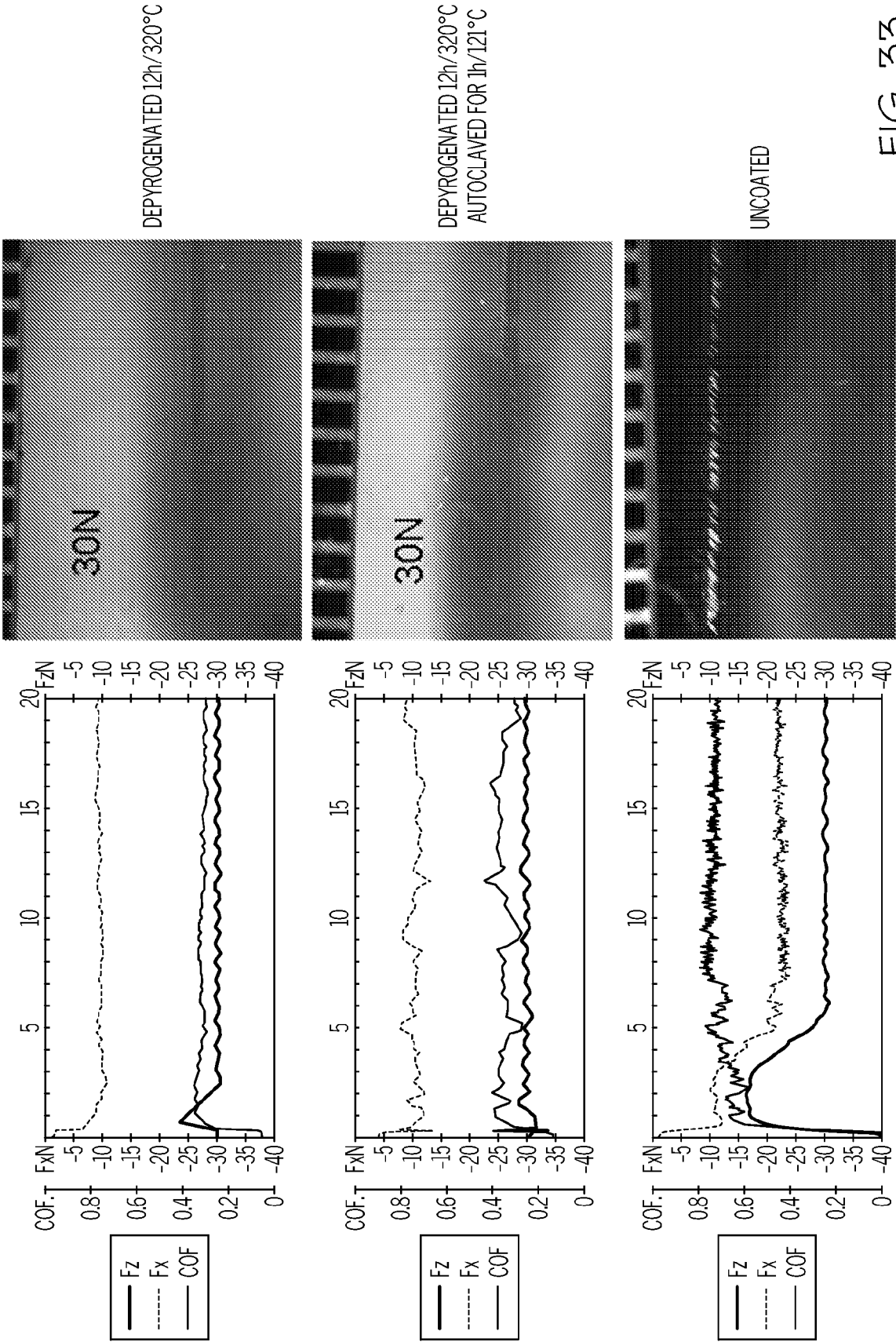
FIG. 31

VIALS	Z-LOAD		COF	FX MAX
	AVG	MAX	ST. DEV.	
1&2	34	36	0.03	8
3&4	30	32	0.02	5
5&6	34	36	0.02	6
7&8	31	33	0.01	4
9&10	31	33	0.01	4

2) APS/NOVA AUTOCLAVED

VIALS	Z-LOAD		COF	FX MAX
	AVG	MAX	ST. DEV.	
1&2	36	39	0.02	6
3&4	37	40	0.01	5
5&6	30	31	0.01	3
7&8	30	31	0.01	3
9&10	30	31	0.01	4

FIG. 32



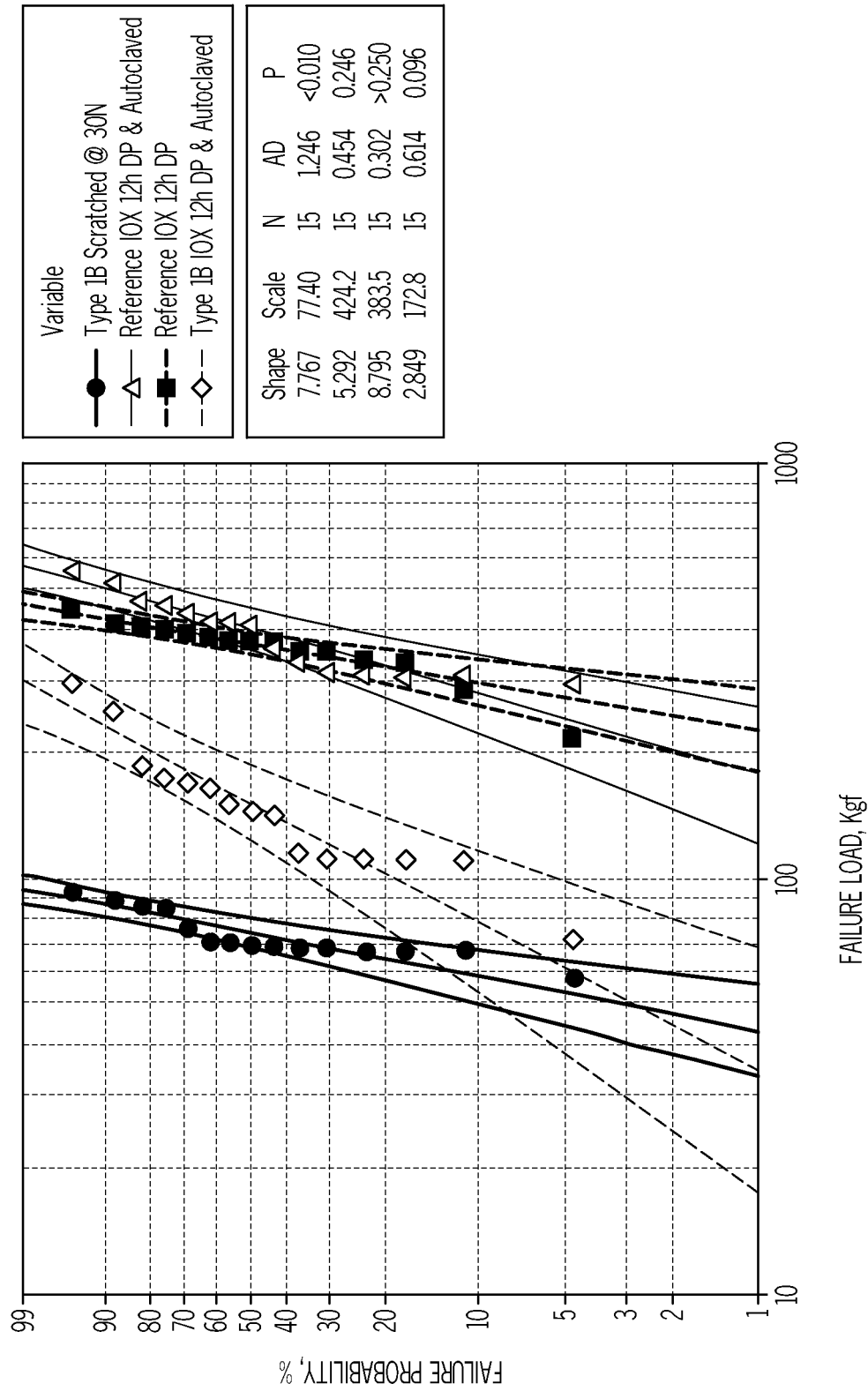
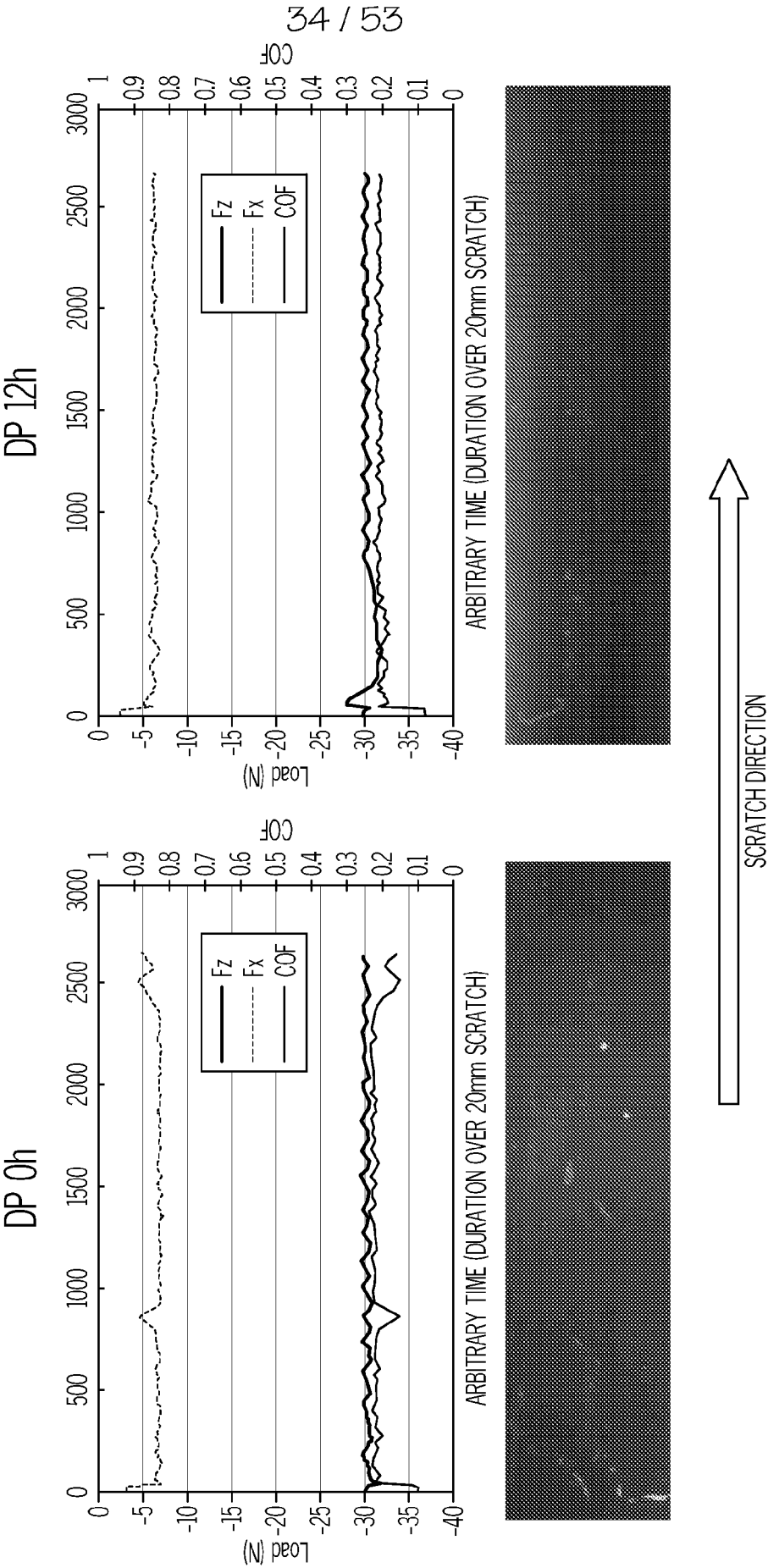


FIG. 34

12h DP Sample	Silanes ratio	Coating composition
540 #1	1:1	0.5 GAP/0.5 Aminophenyltrimethoxysilane + 1.0% Nova
540 #2	1:0.5	0.5 GAP/0.25 Aminophenyltrimethoxysilane + 1.0% Nova
540 #3	1:0.2	0.5 GAP/0.1 Aminophenyltrimethoxysilane + 1.0% Nova

540 Target Load	Vial Set	Fz (N)		COF Std. Dev.	Fx (N)	
		Avg	Max		Max	Max
30	1	30	32	0.02	0.26	8
	2	30	32	0.04	0.41	13
	3	30	33	0.1	0.68	19
20	1	20	22	0.02	0.24	5
	2	20	21	0.02	0.31	6
	3	21	23	0.1	0.61	13

FIG. 35



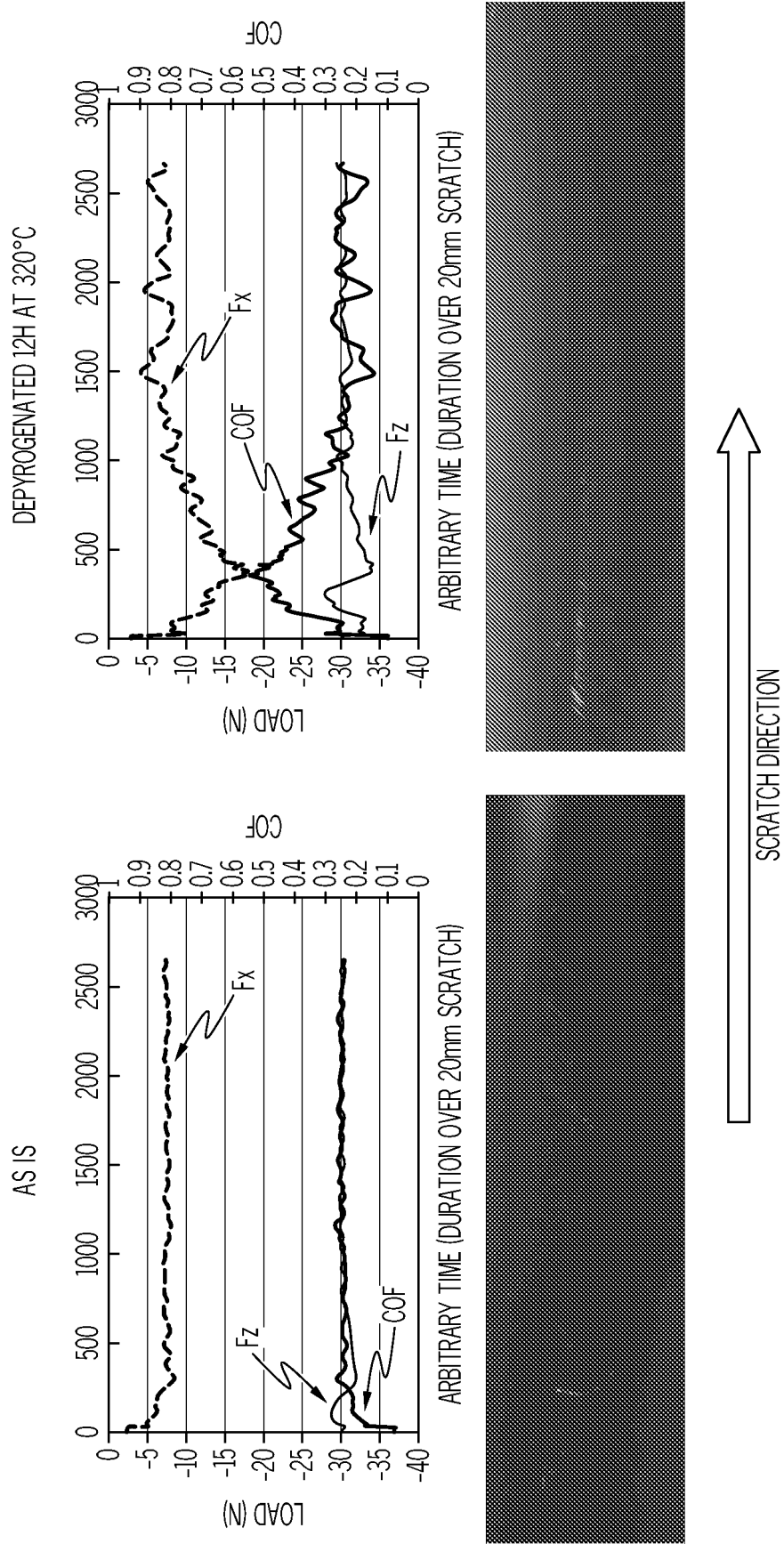


FIG. 37

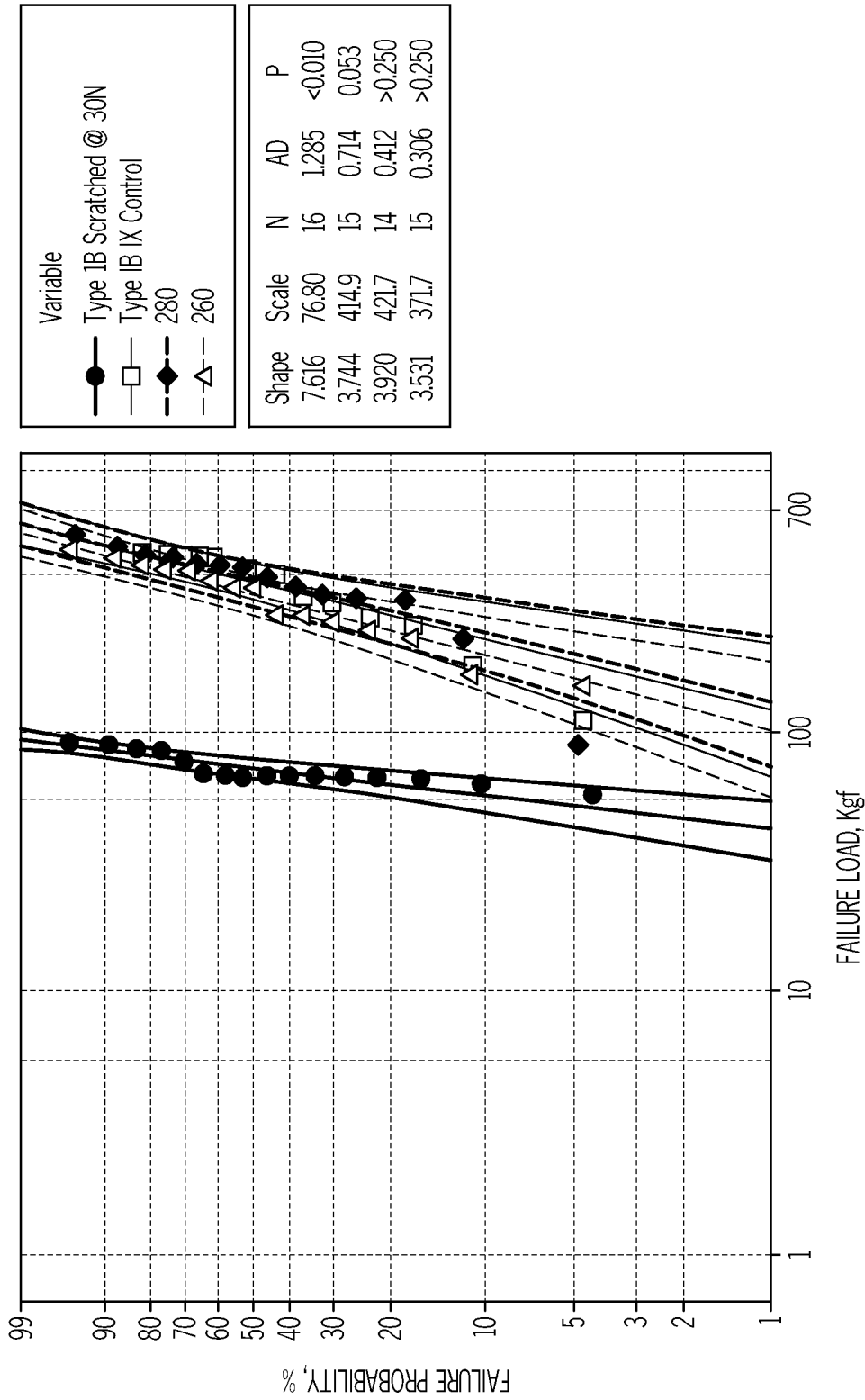
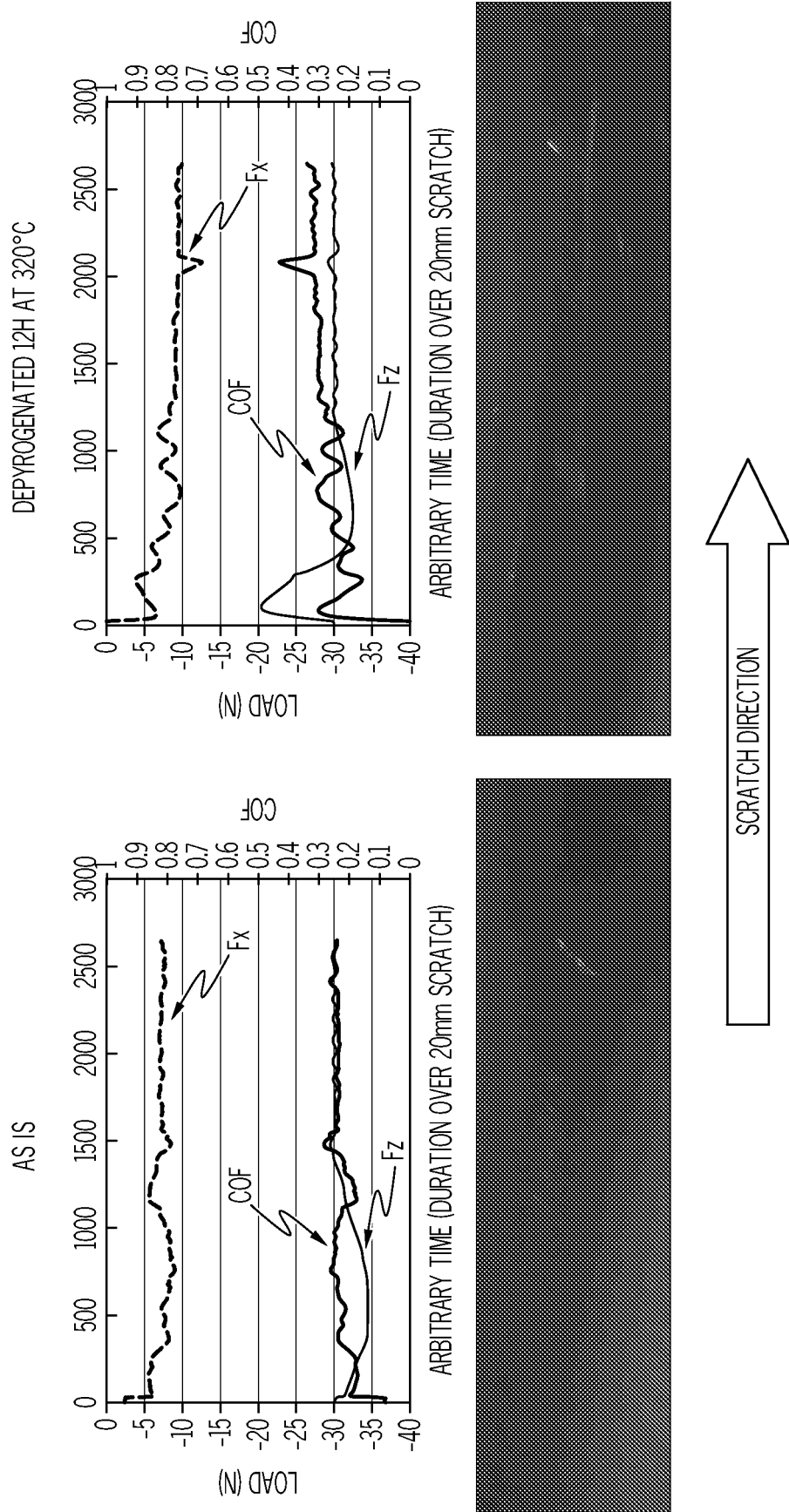


FIG. 38



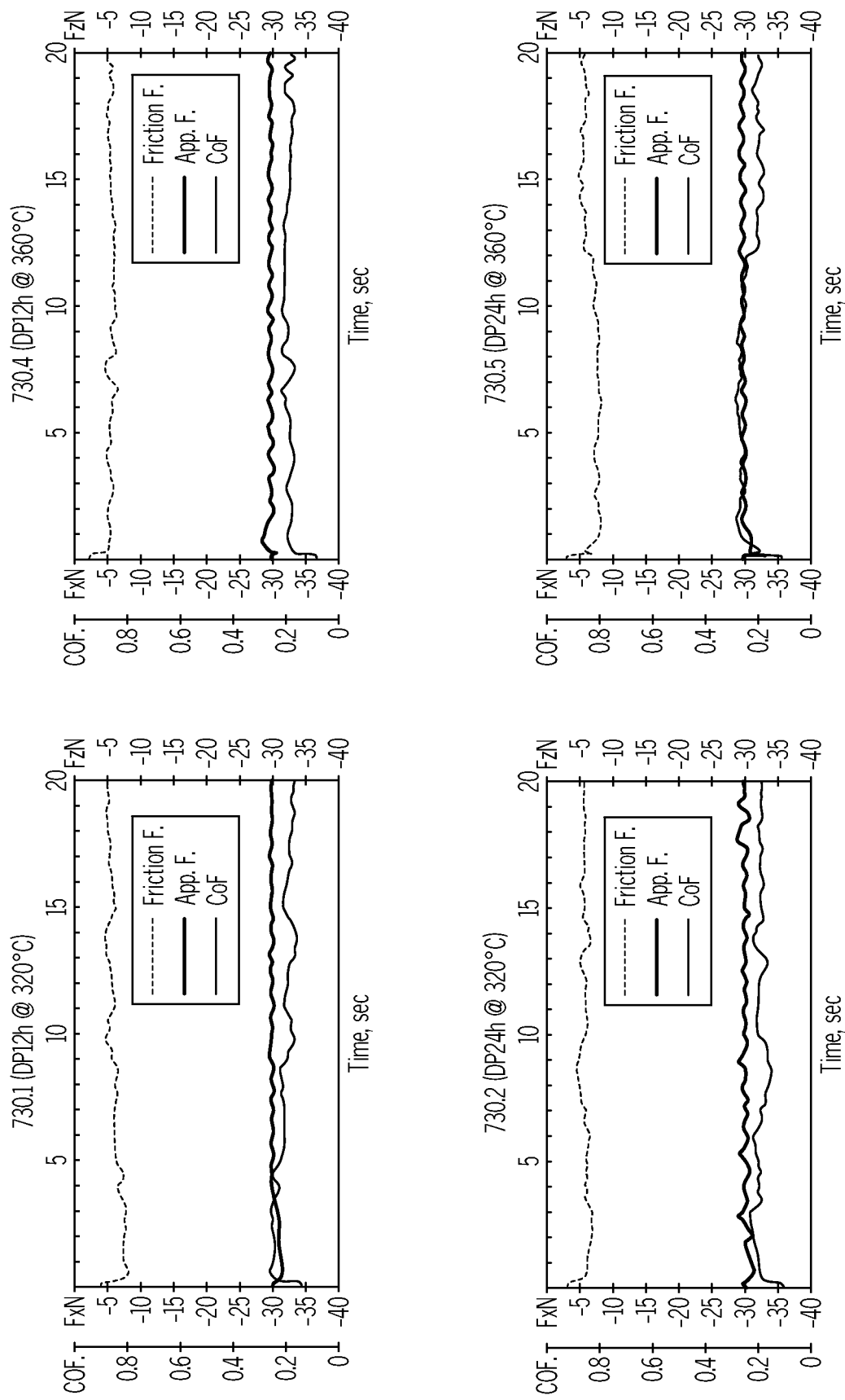


FIG. 40

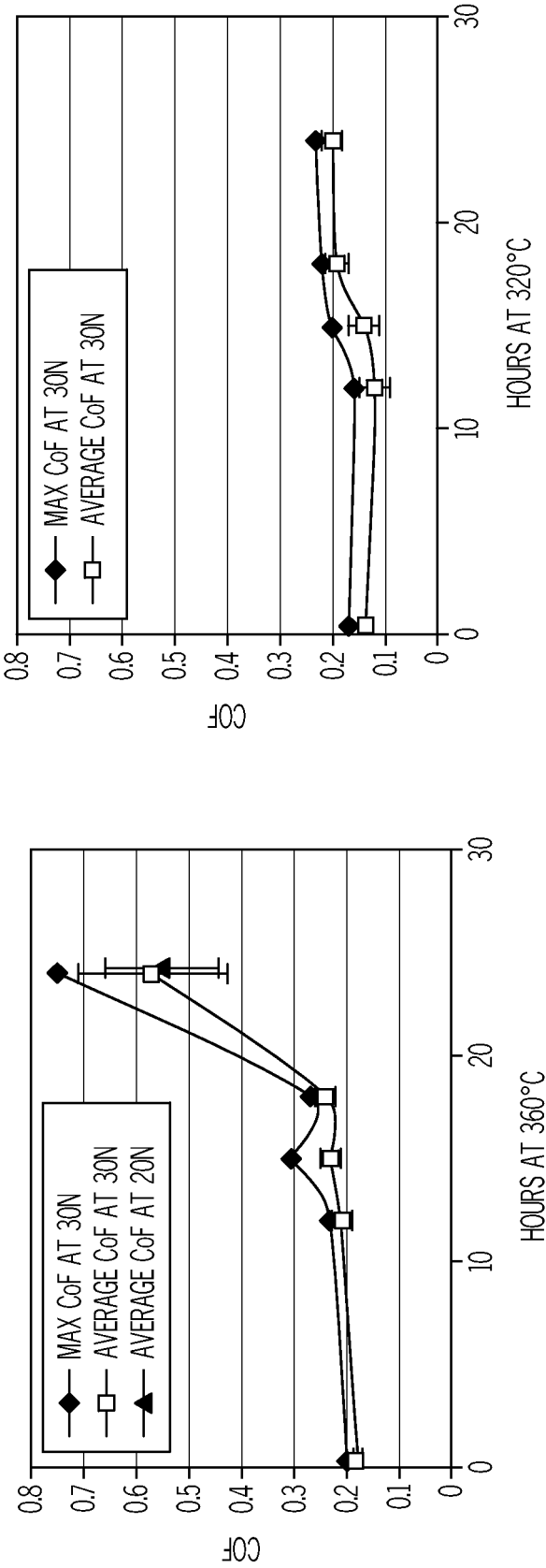


FIG. 41

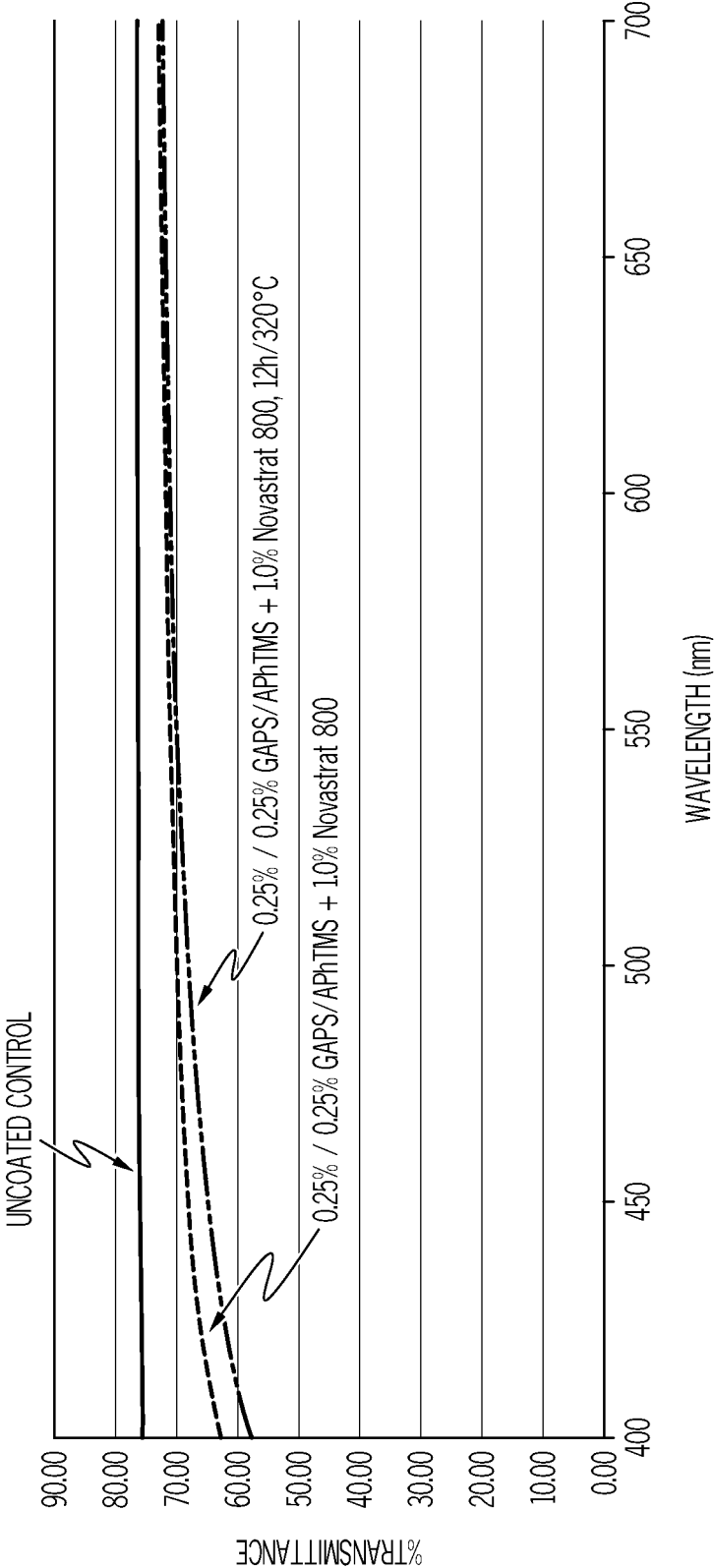


FIG. 42

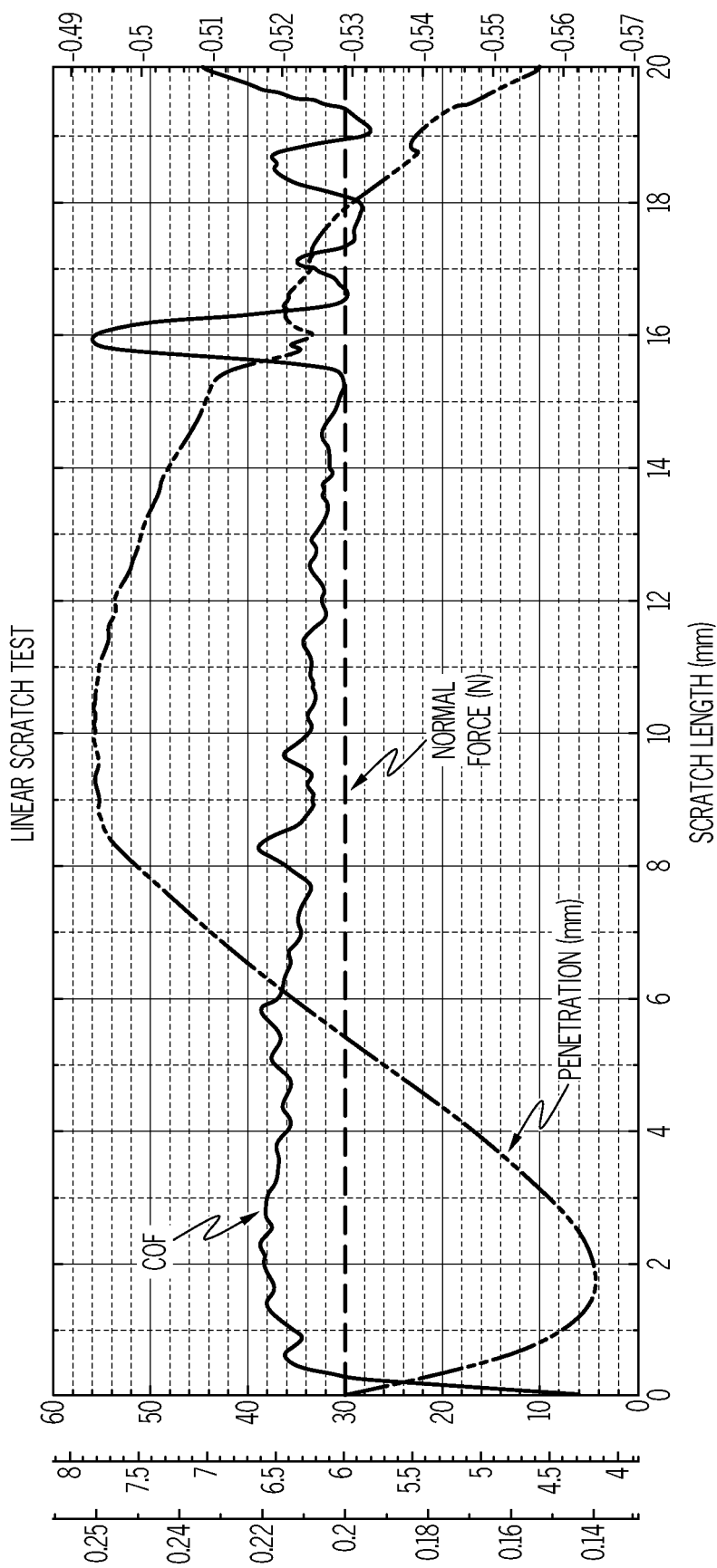


FIG. 43

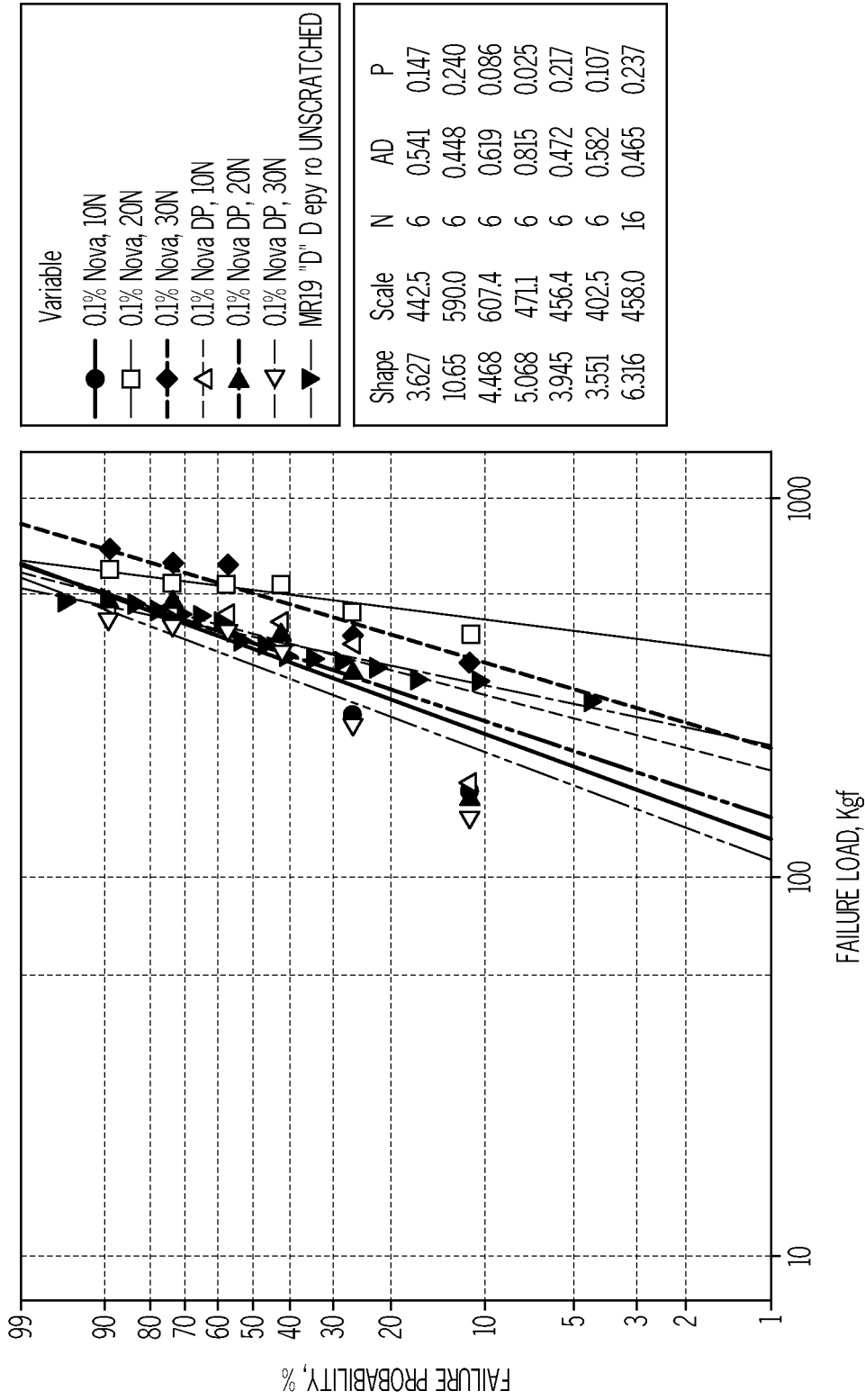


FIG. 44

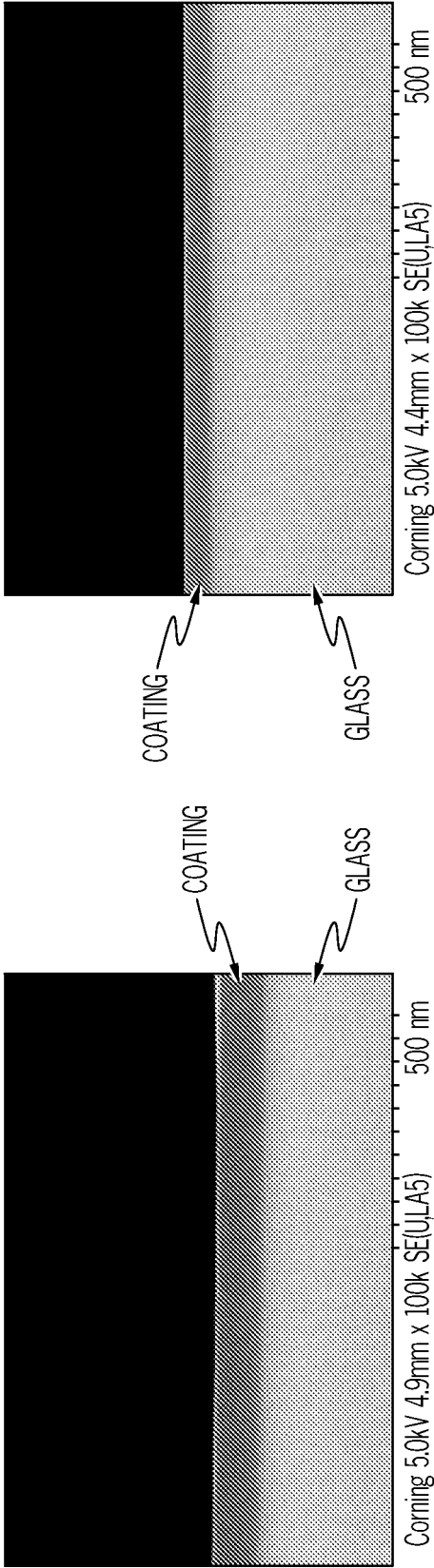


FIG. 45

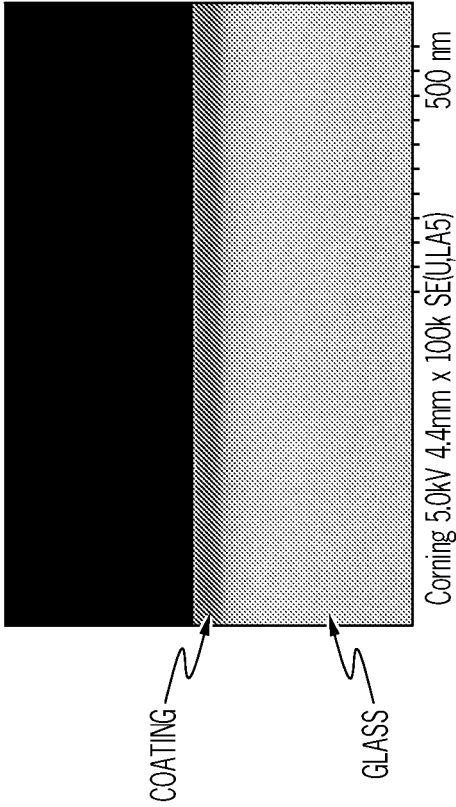


FIG. 46

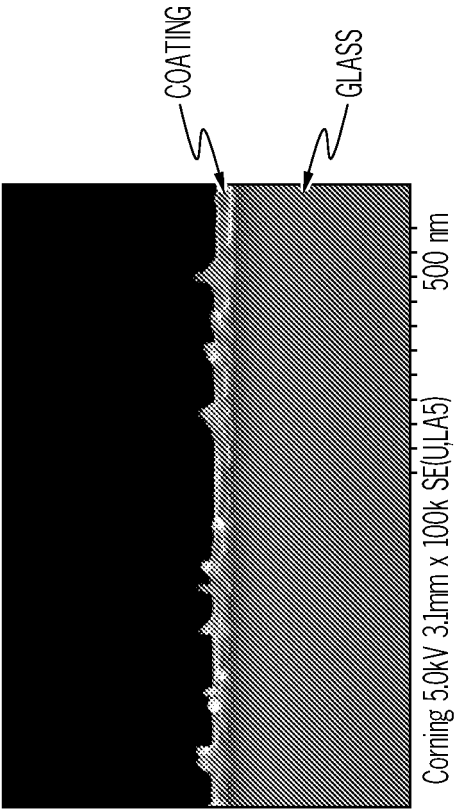


FIG. 47

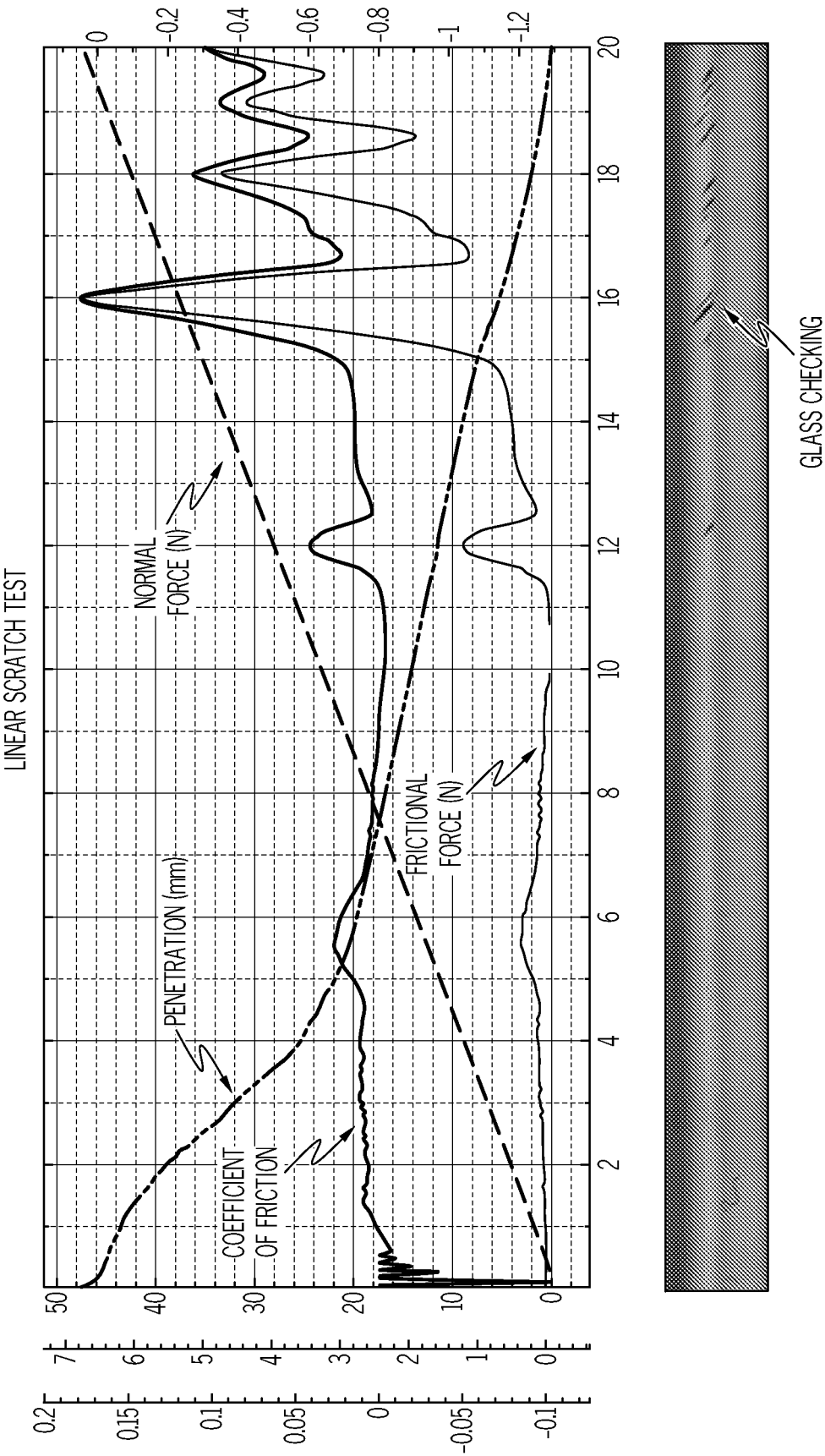


FIG. 48

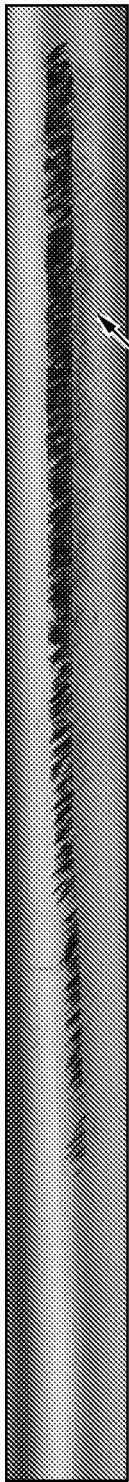
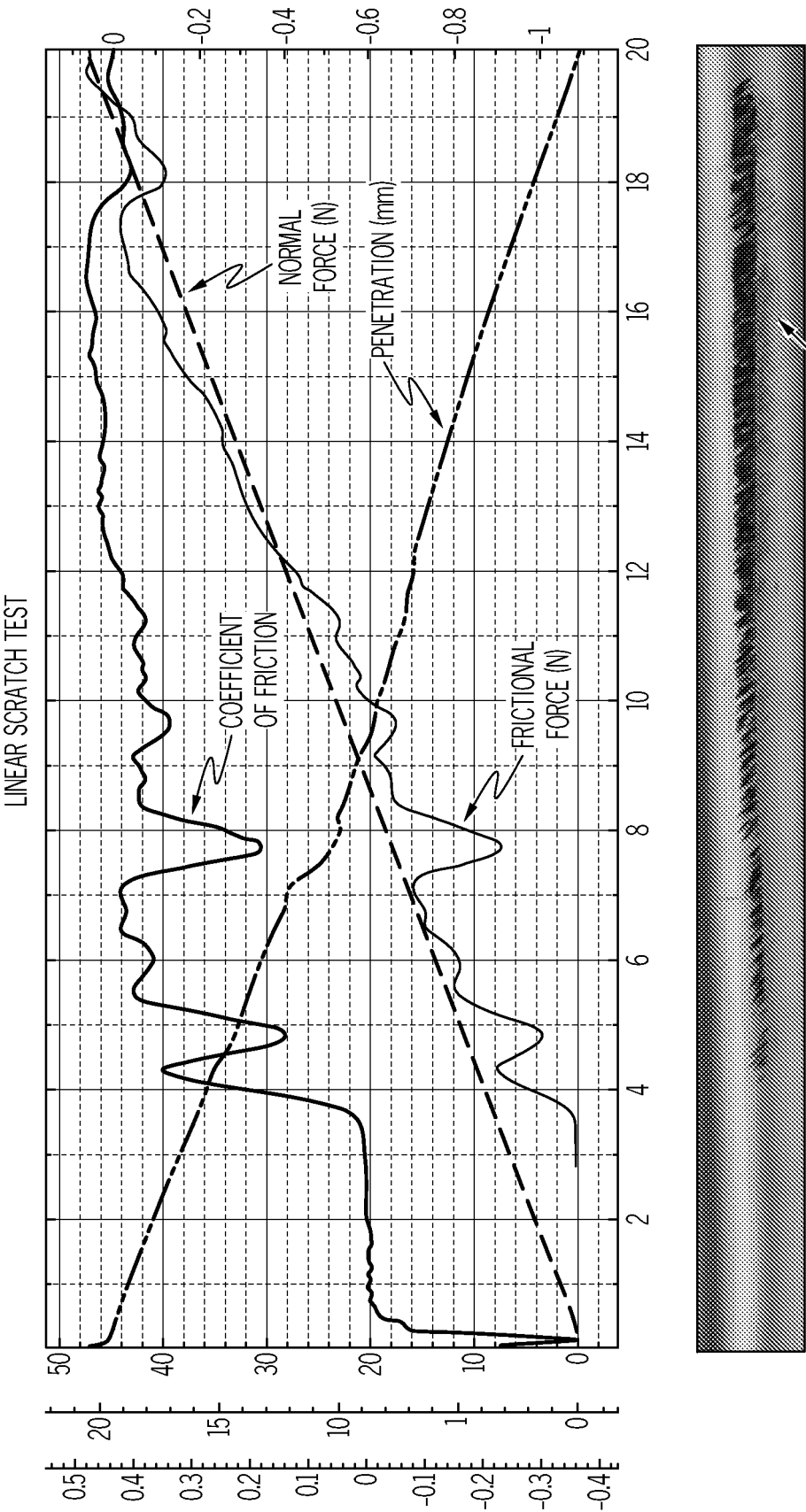


FIG. 49

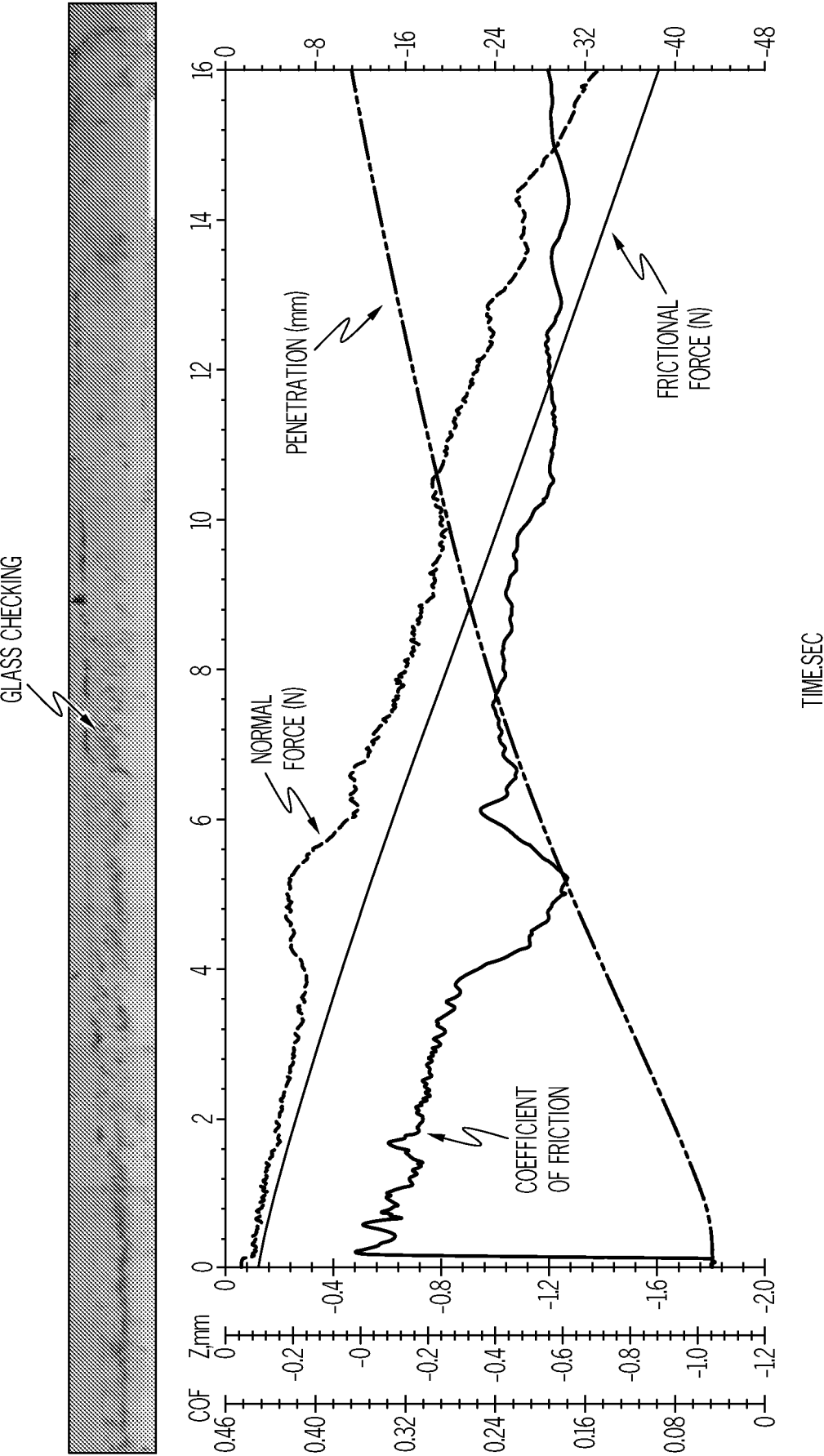


FIG. 50

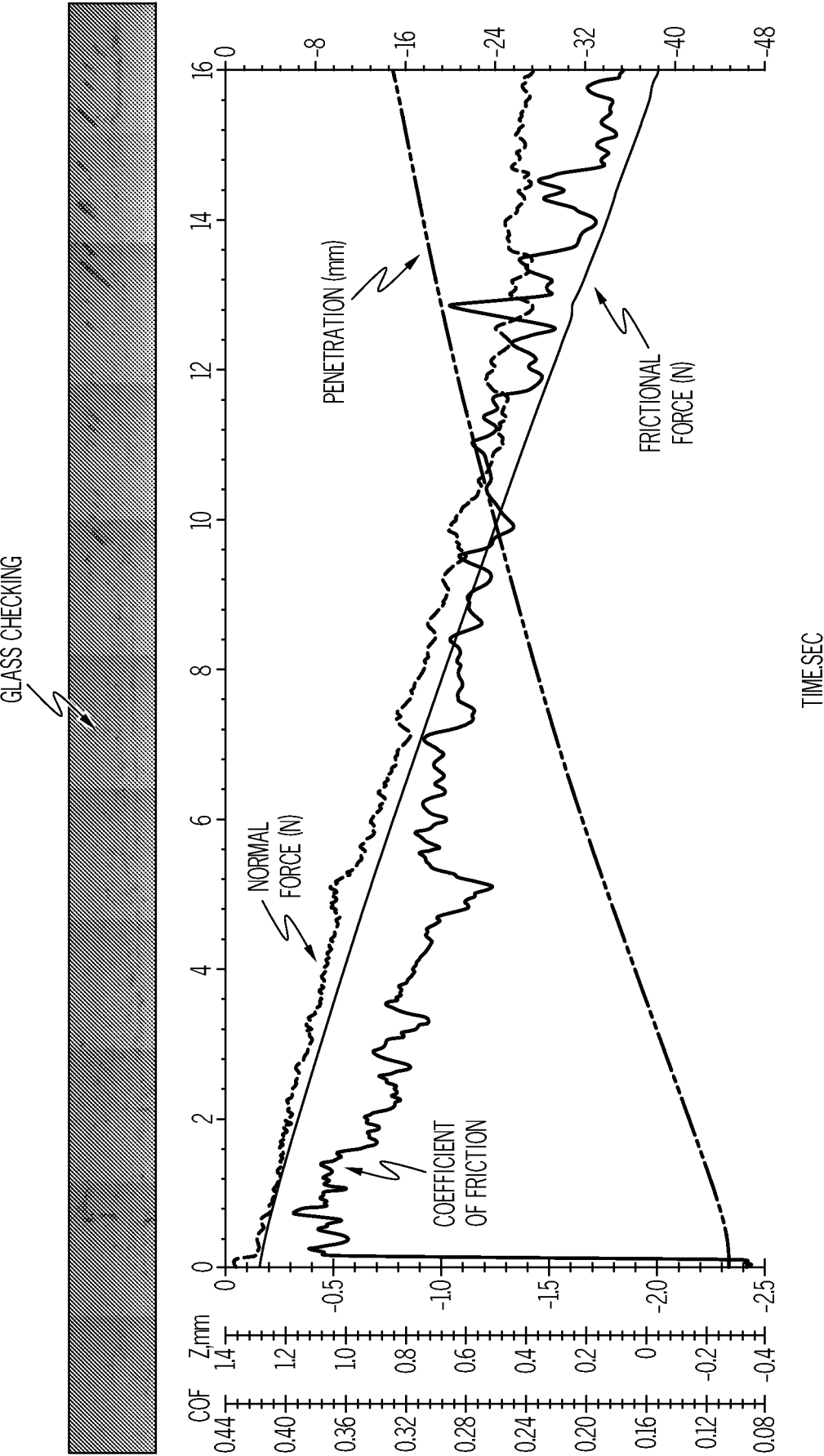
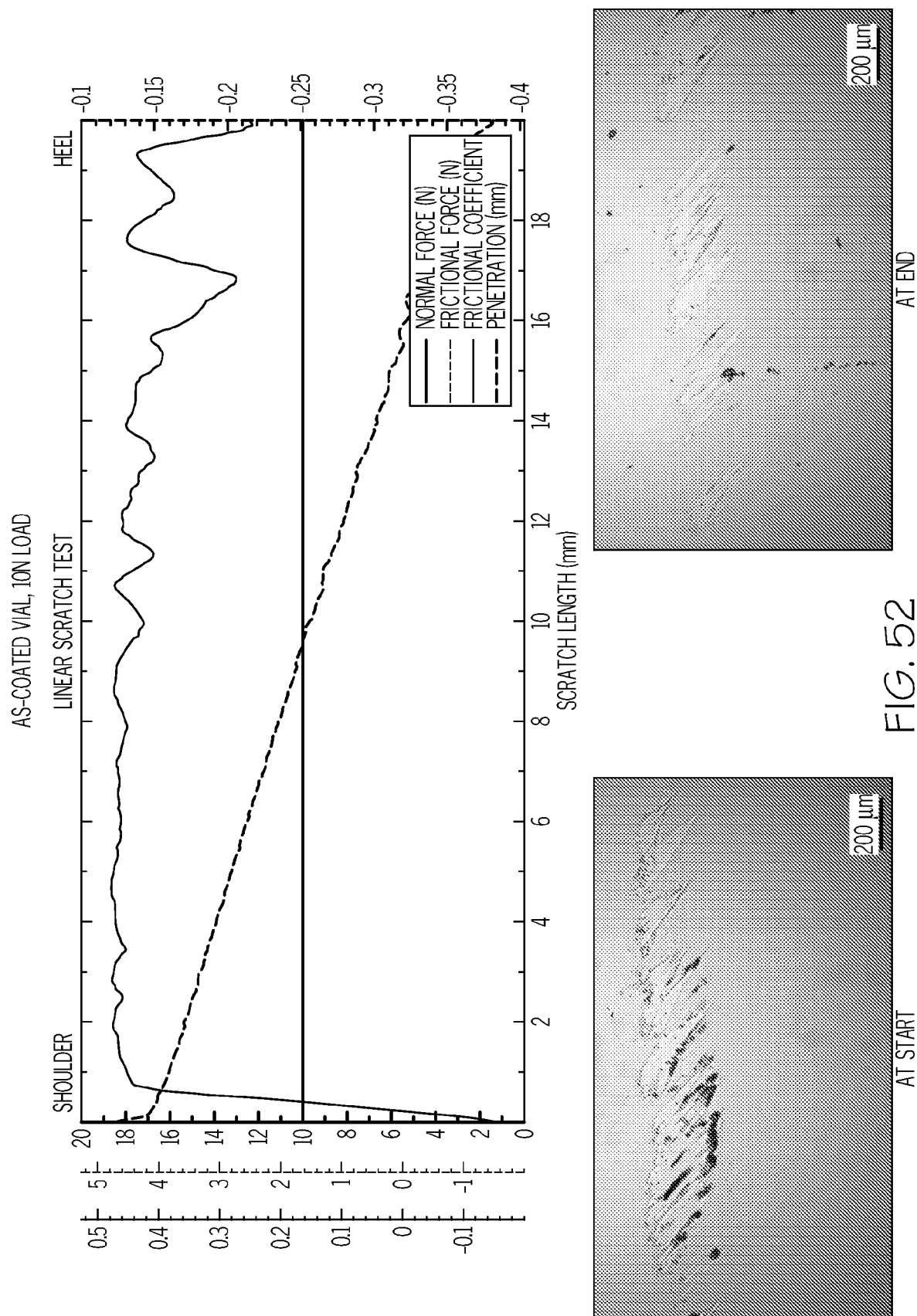
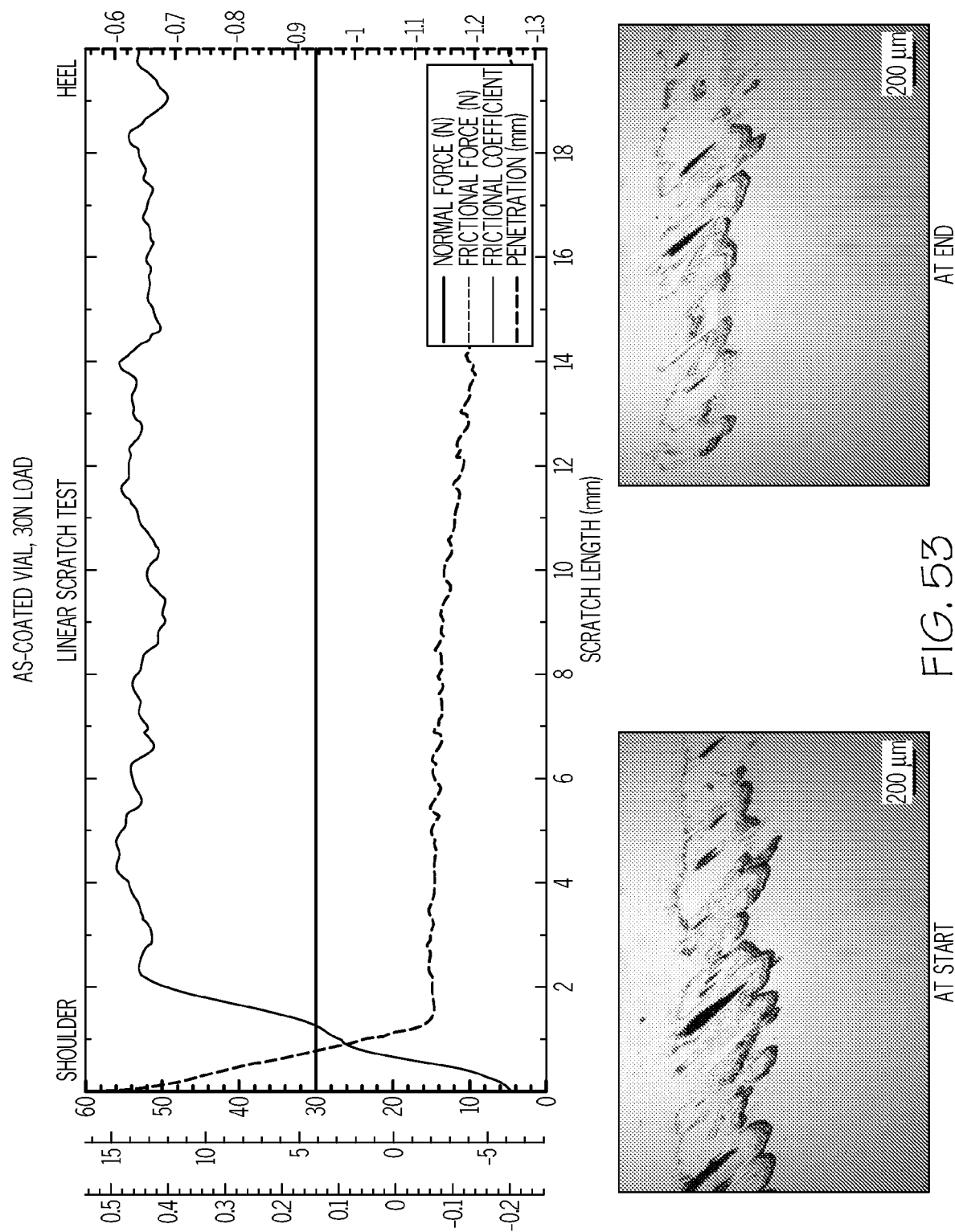


FIG. 51





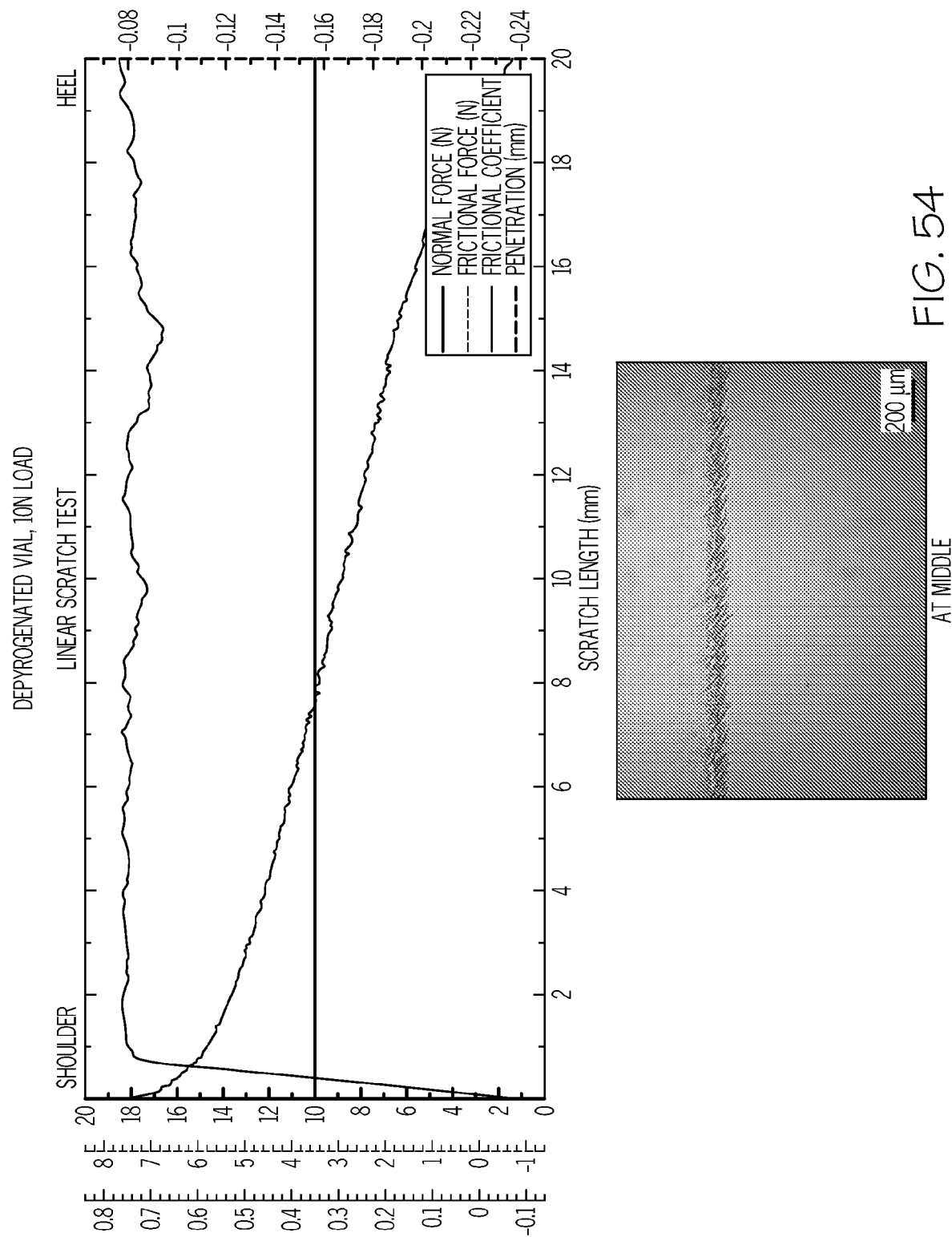


FIG. 54

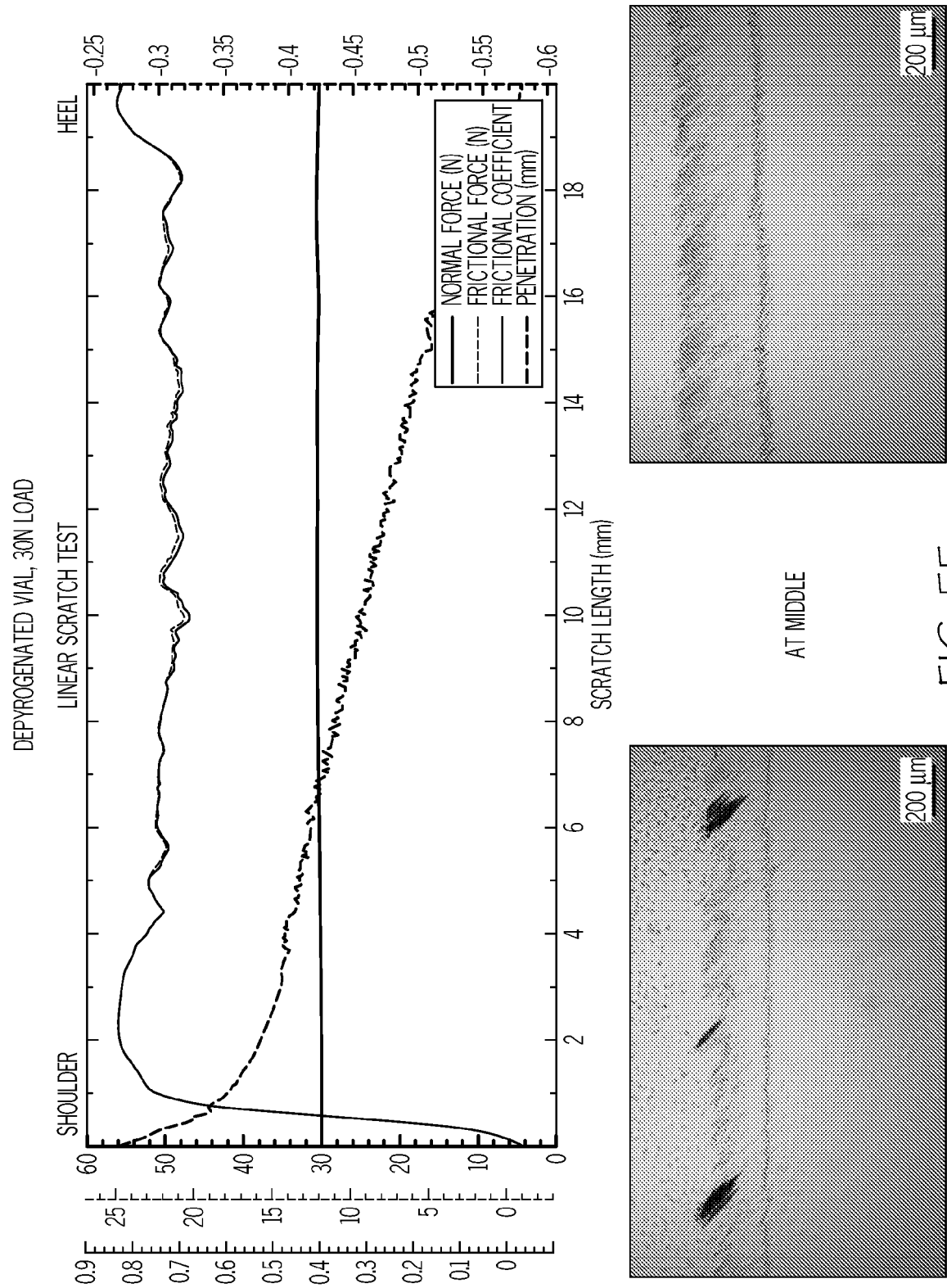


FIG. 55

HORIZONTAL COMPRESSION OF VARIED THICKNESS SILANE VIALS W/ 10N SCRATCH

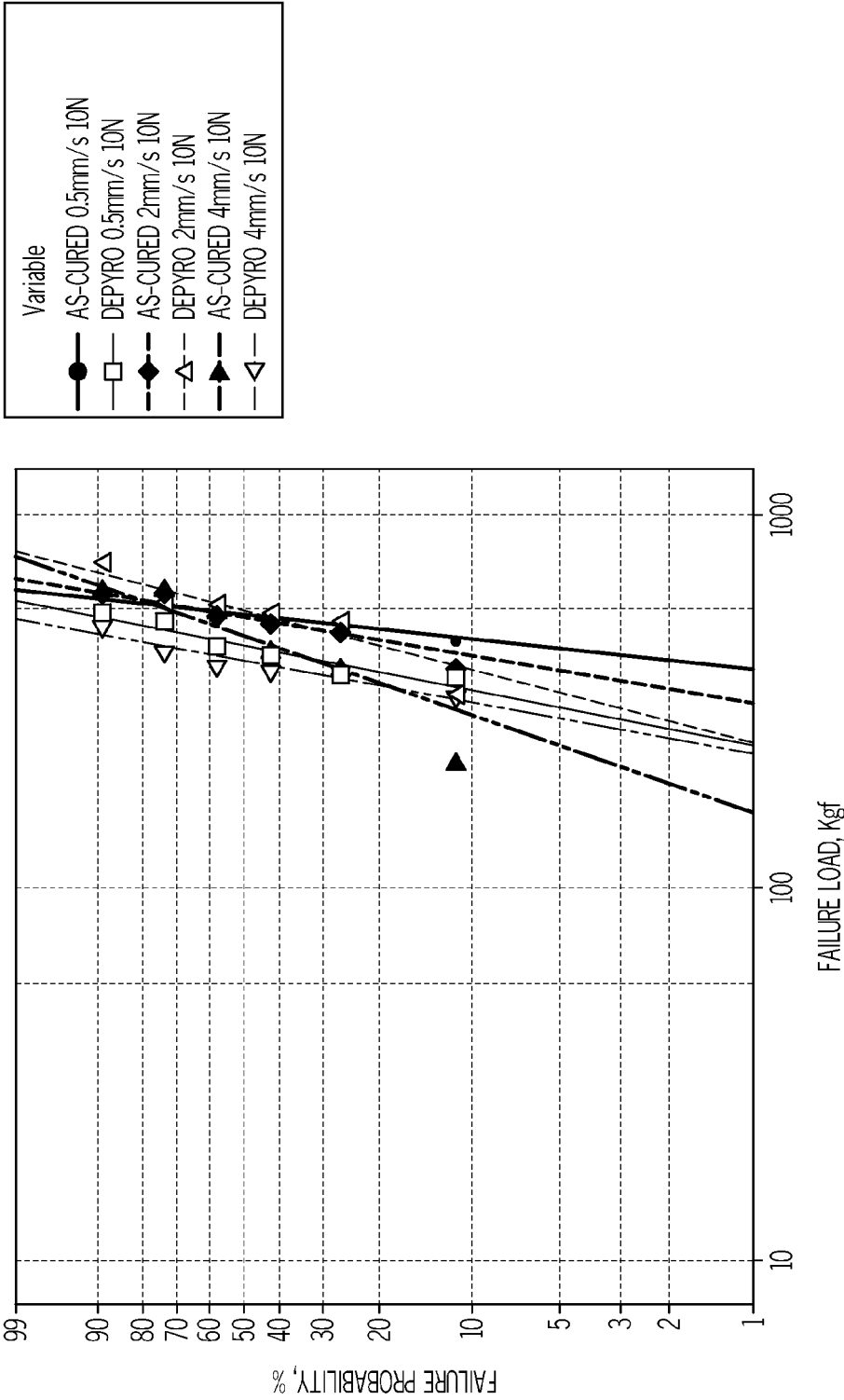


FIG. 56

HORIZONTAL COMPRESSION OF VARIED THICKNESS SILANE VIALS W/ 30N SCRATCH

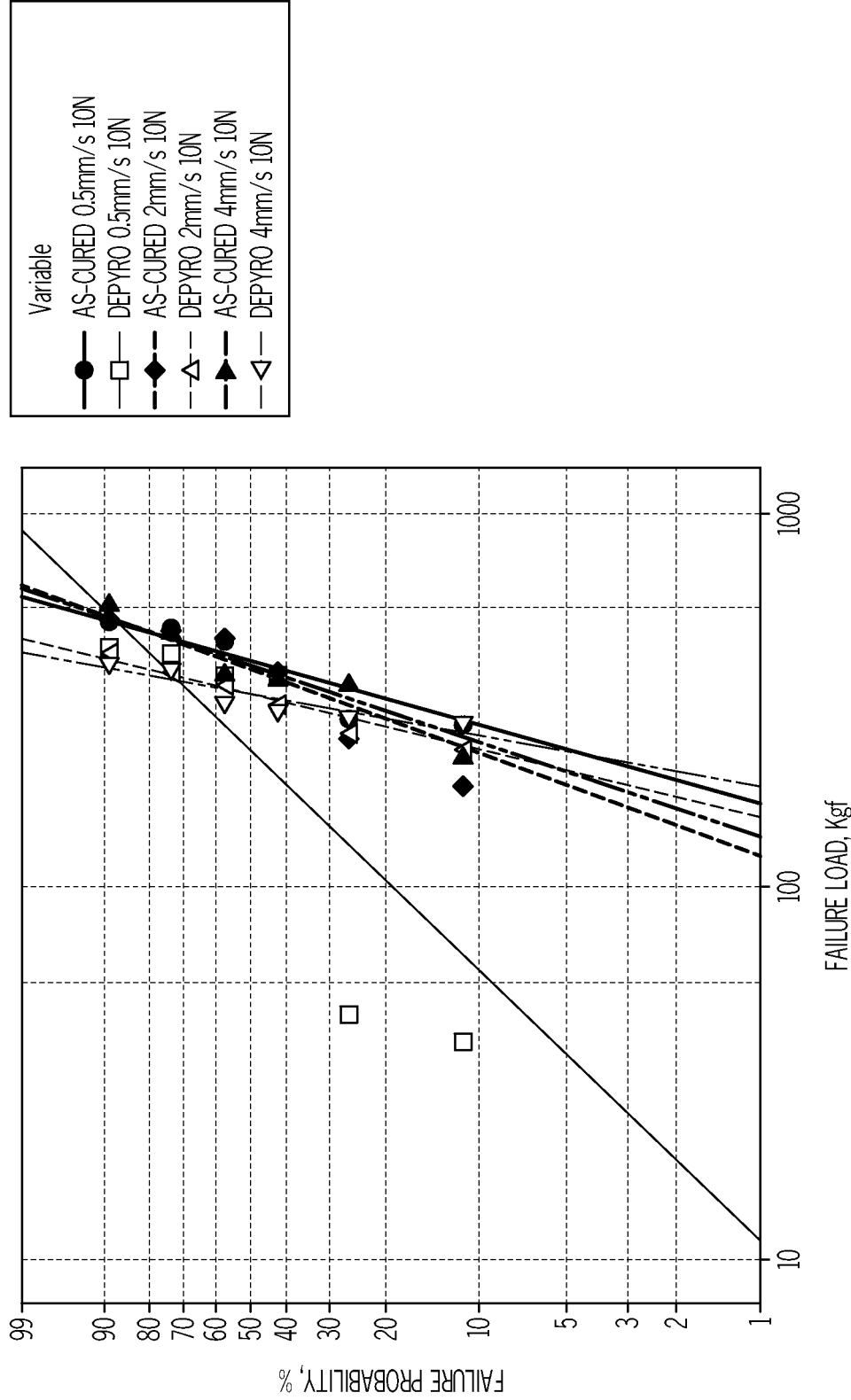


FIG. 57