

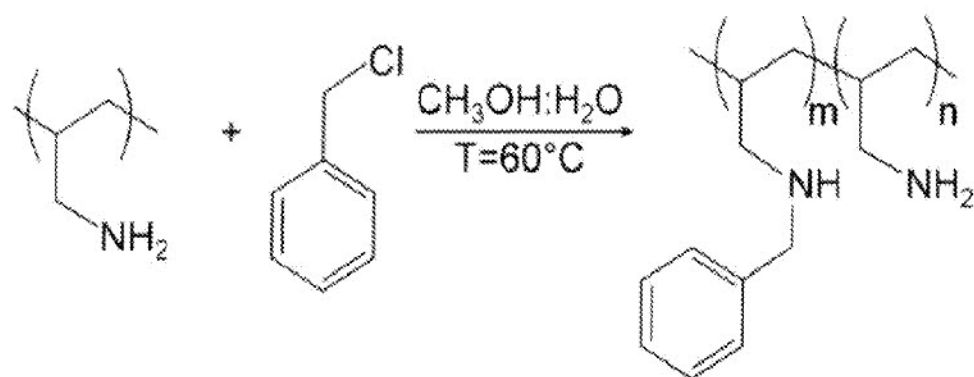


Figure 1

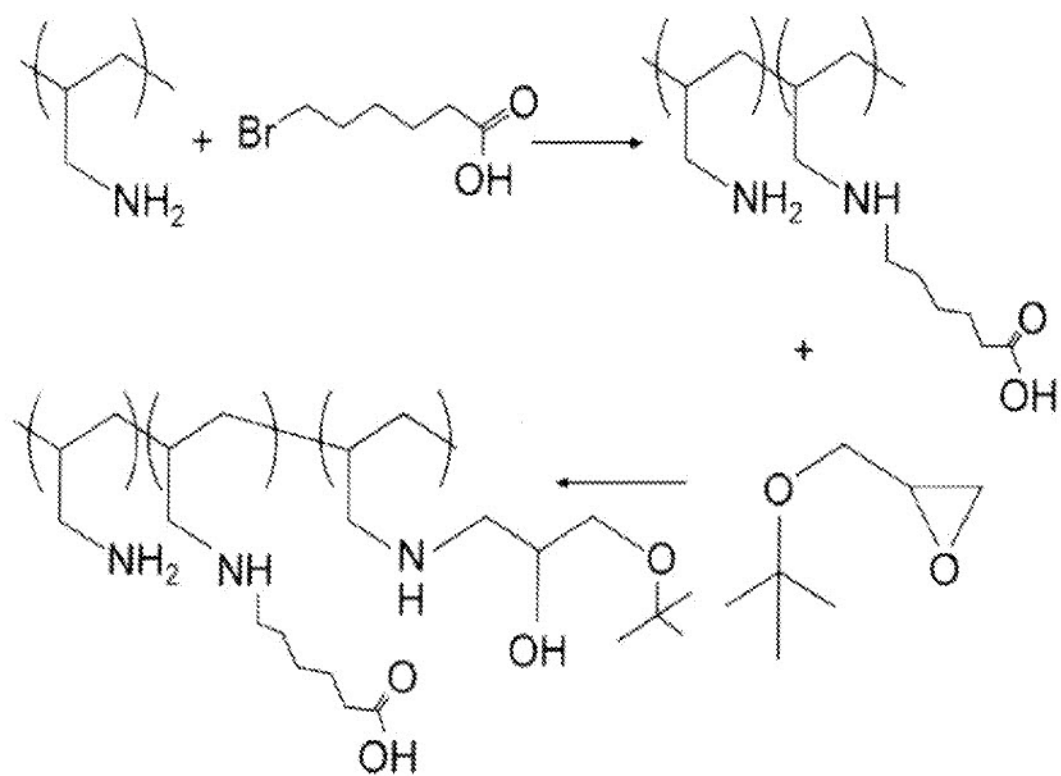


Figure 2

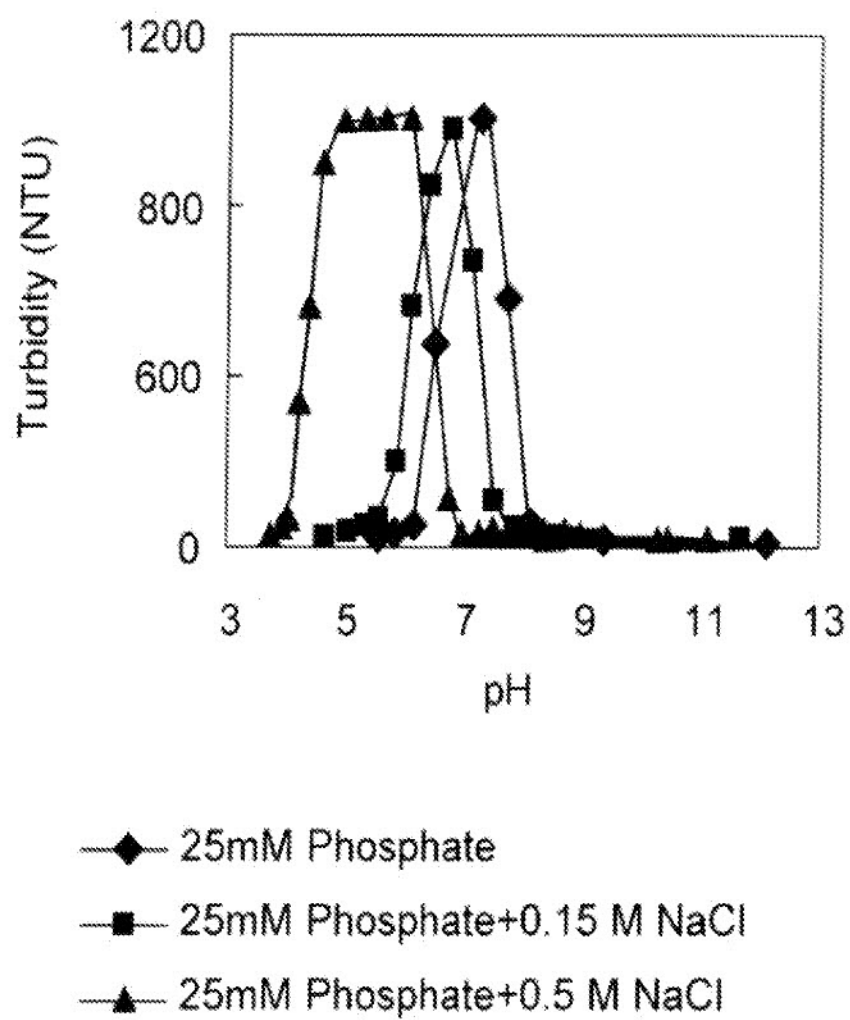


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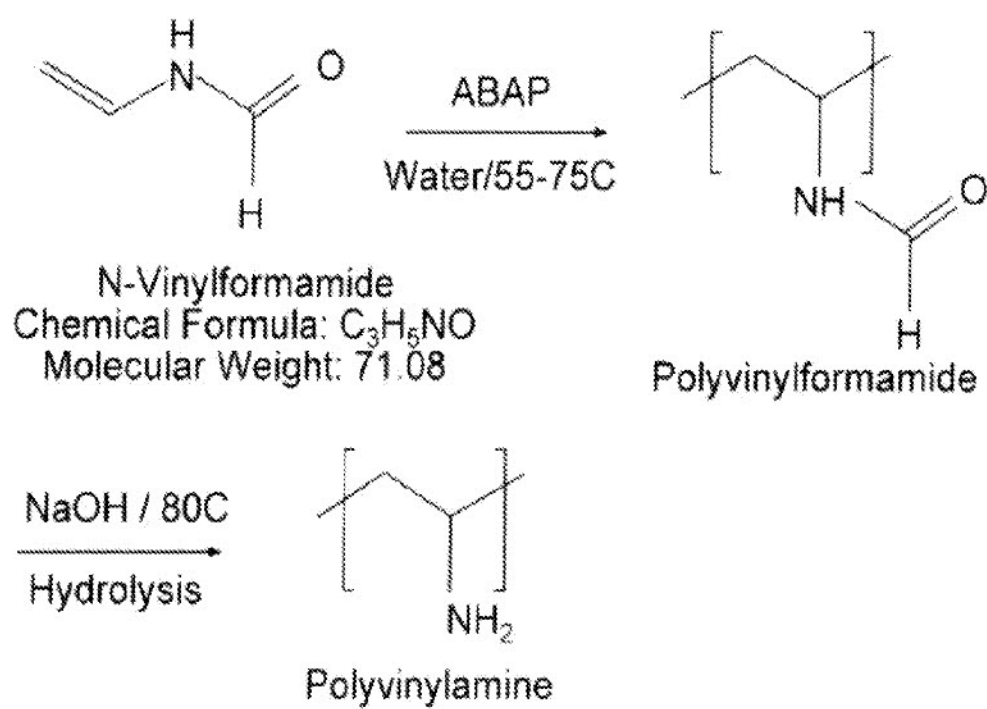


Figure 4

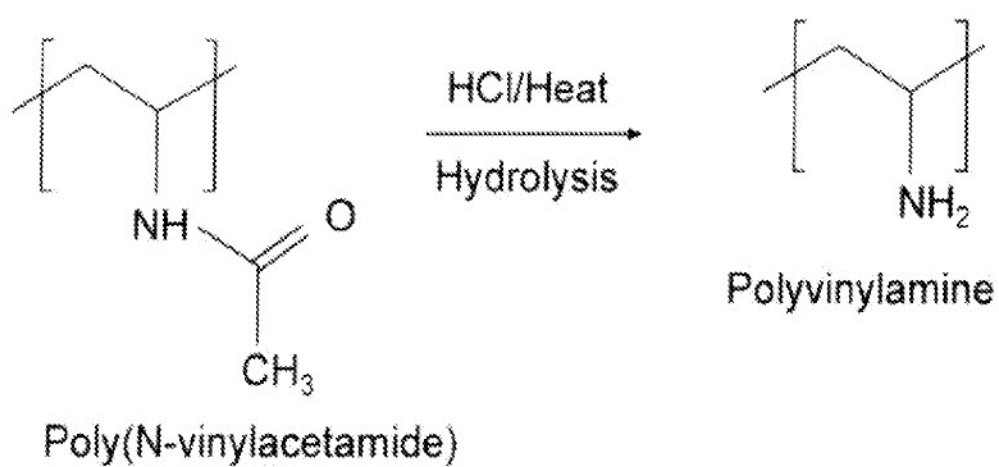


Figure 5

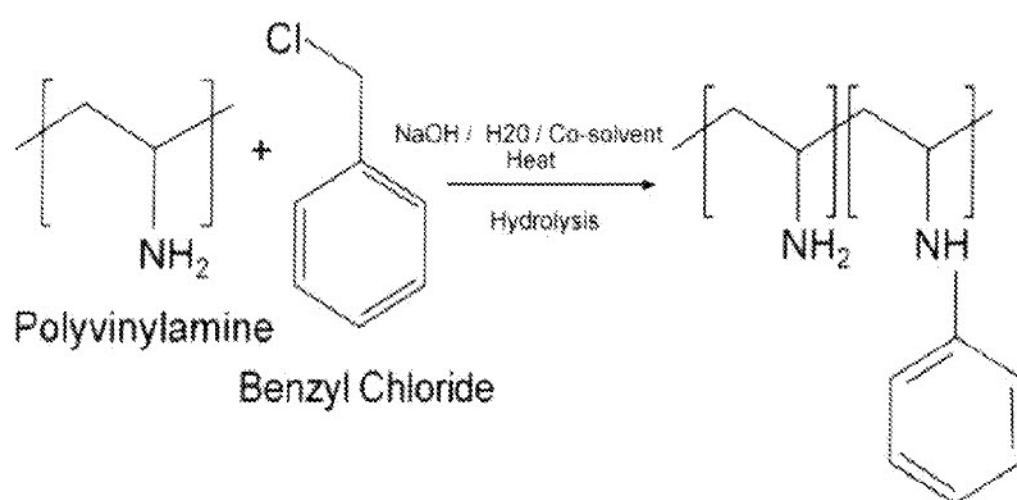
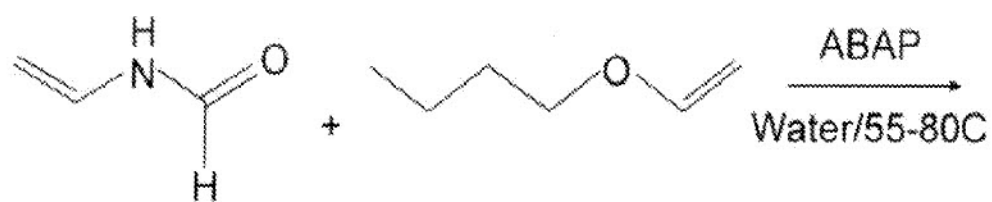


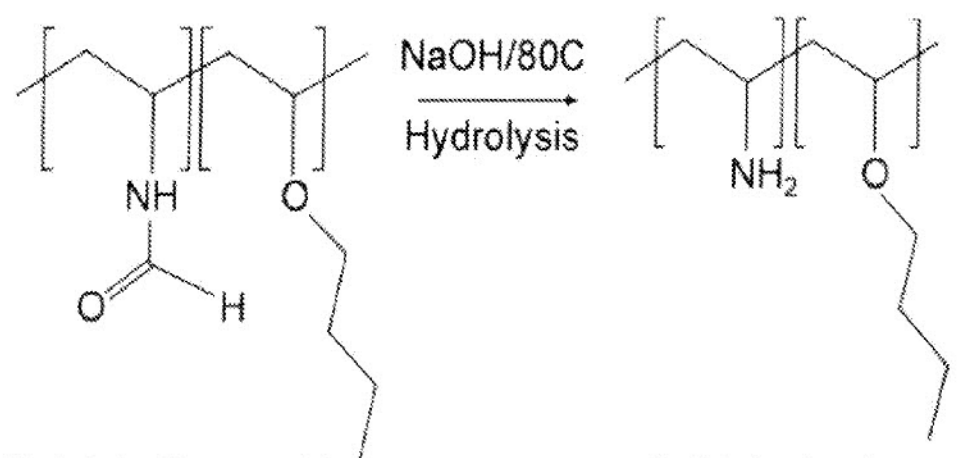
Figure 6

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N-vinylformamide

vinylbutylether



Poly(vinylformamid
-co-butylvinylether)

Poly(vinylamine
-co-butylvinylether)

Figure 7

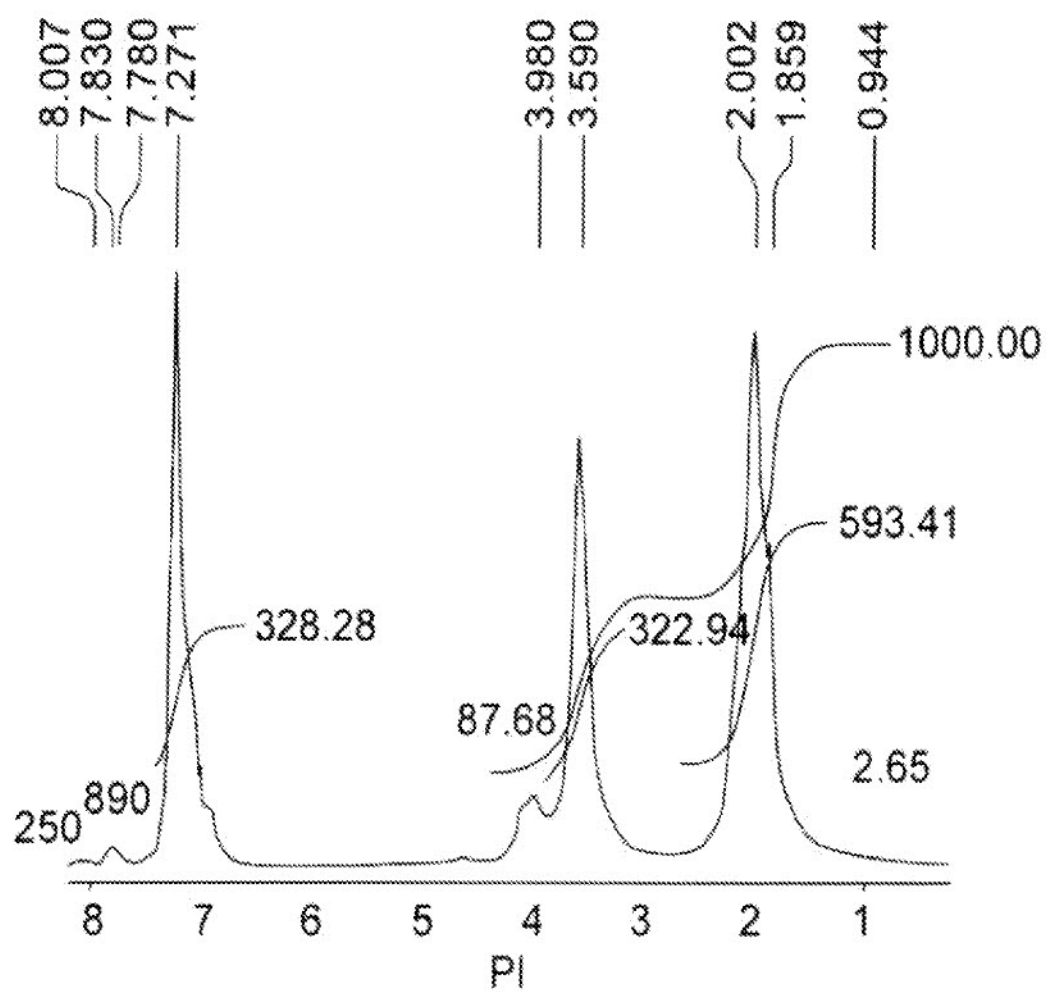


Figure 8

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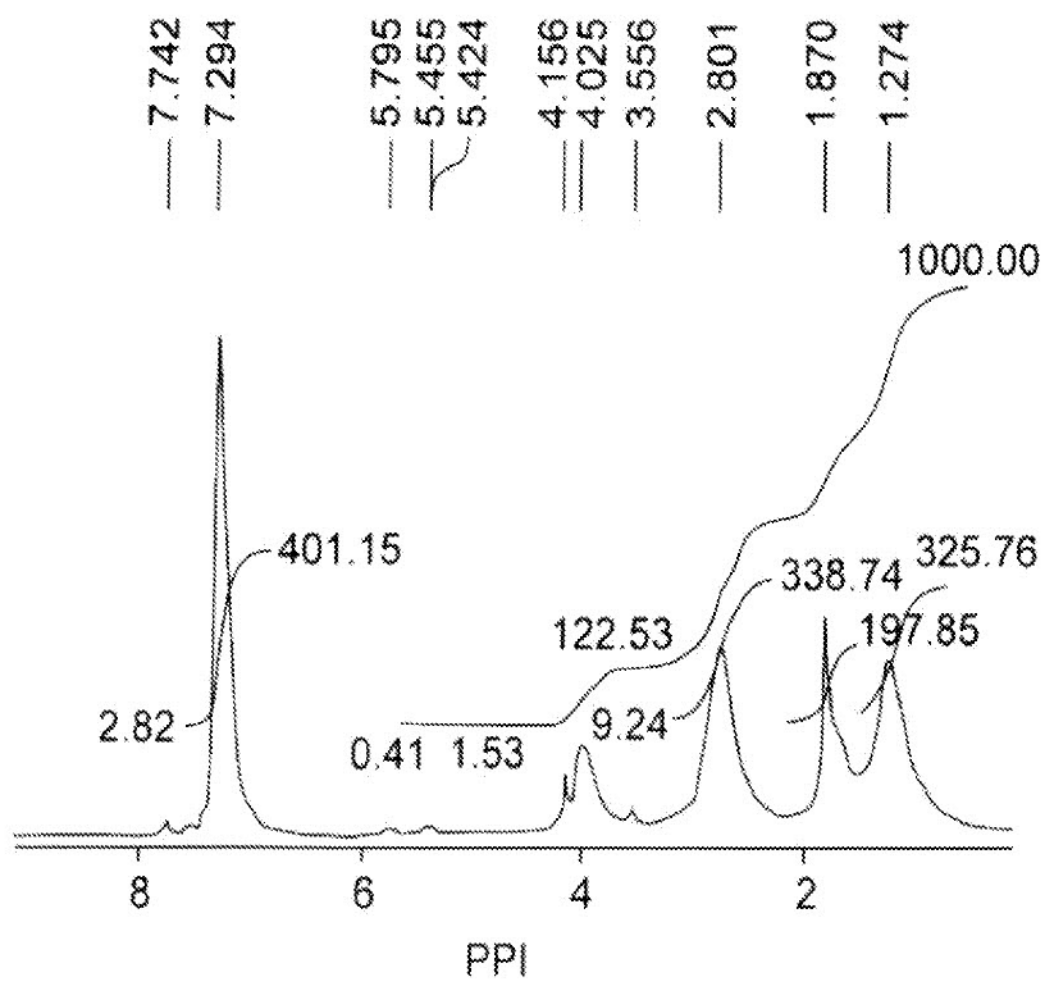


Figure 9

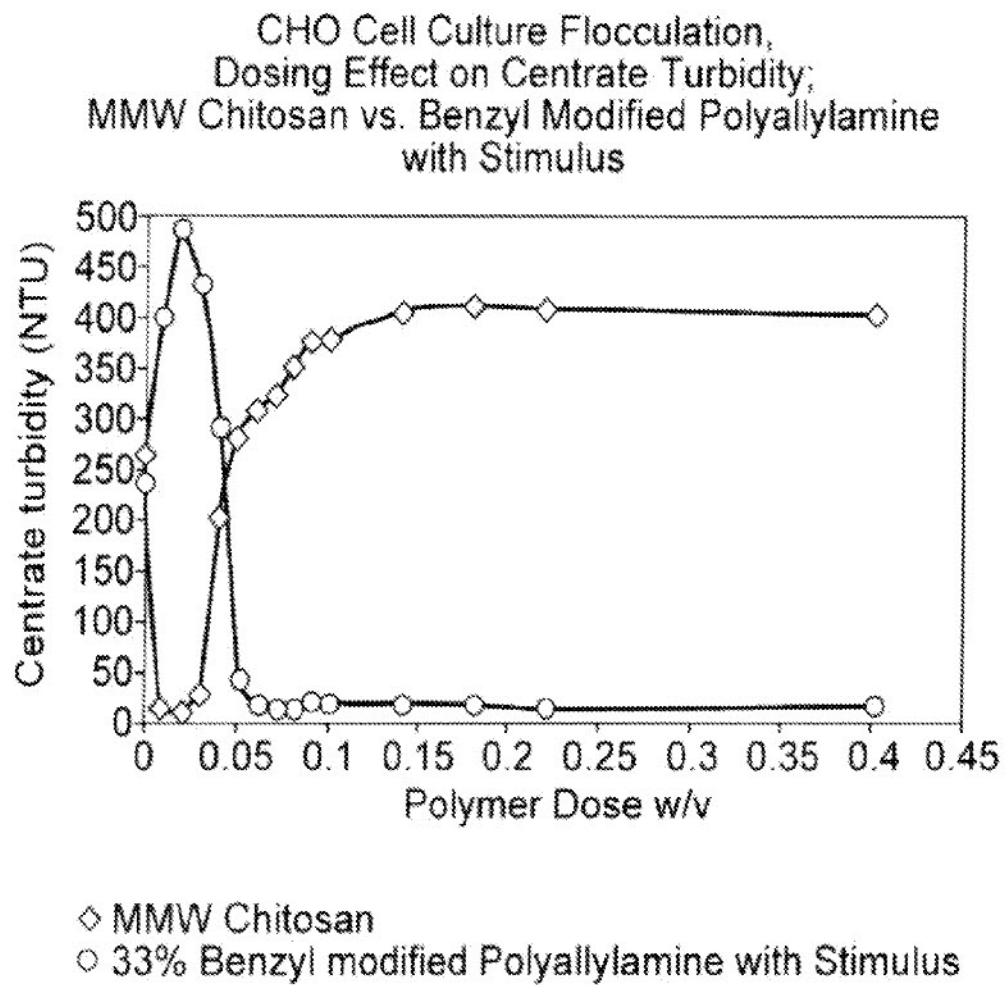
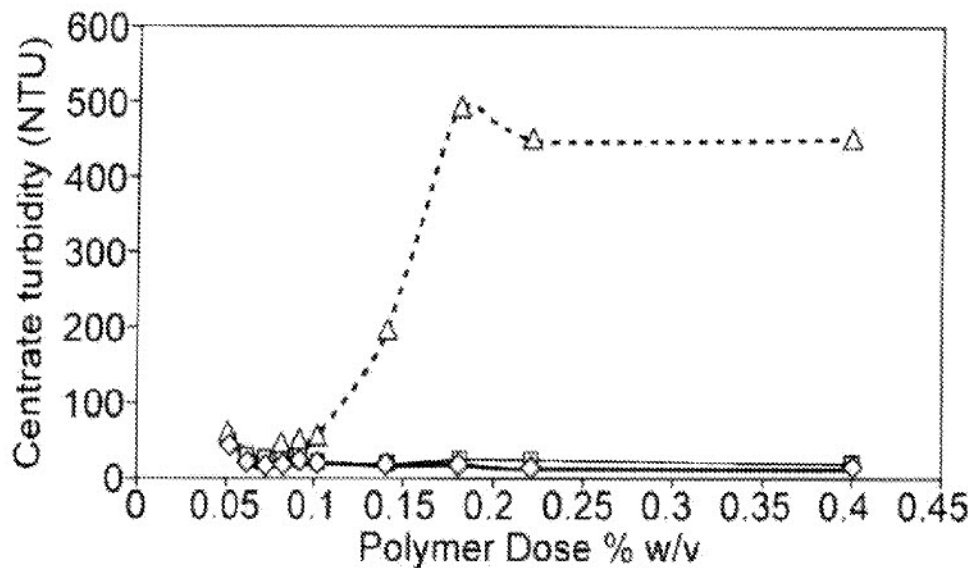


Figure 10

CHO Cell Culture Flocculation,
Dosing and Stimulus Effect on Centrate Turbidity;
Benzyl Modified Polyallylamine
with Phosphate Stimulus vs. Citrate Stimulus vs. No
Stimulus



* No polymer control centrate turbidity was 237 (NTU)

- ◇ 33% Benzyl modified Polyallylamine with phosphate stimulus
- 33% Benzyl modified Polyallylamine with citrate stimulus
- △ 33% Benzyl Modified Polyallylamine with no stimulus

Figure 11

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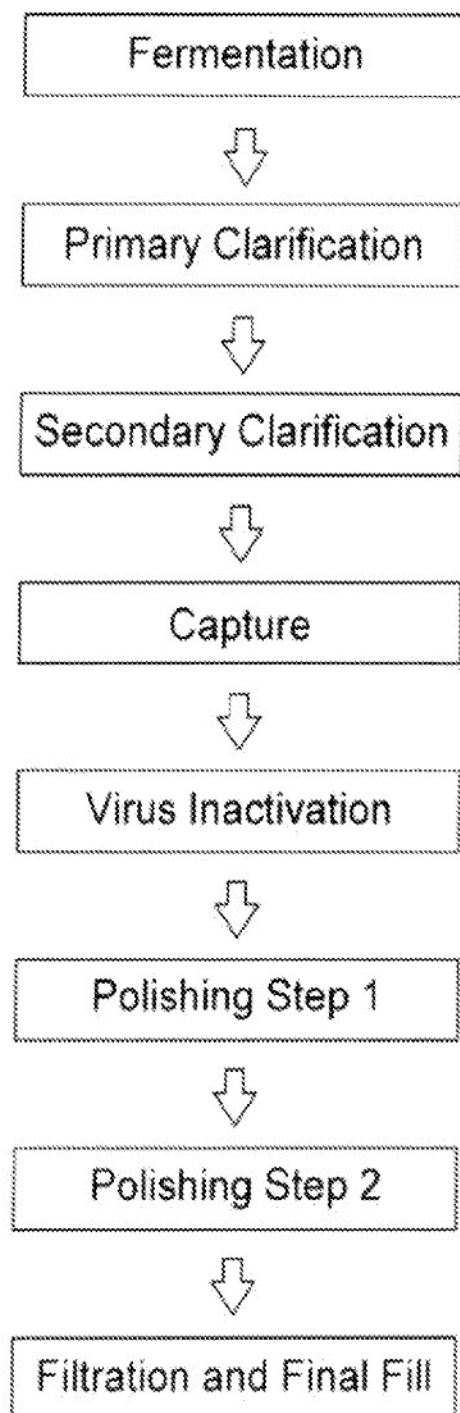


Figure 12

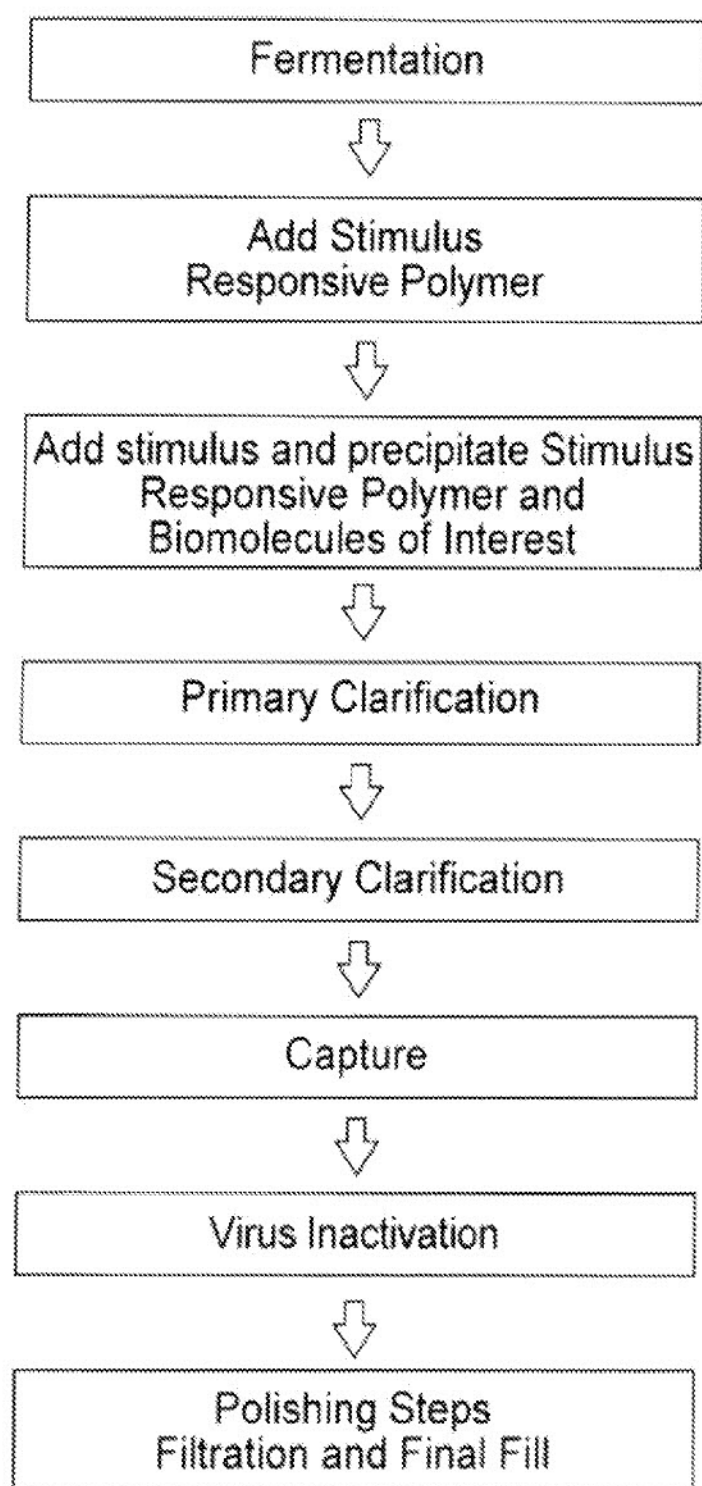


Figure 13

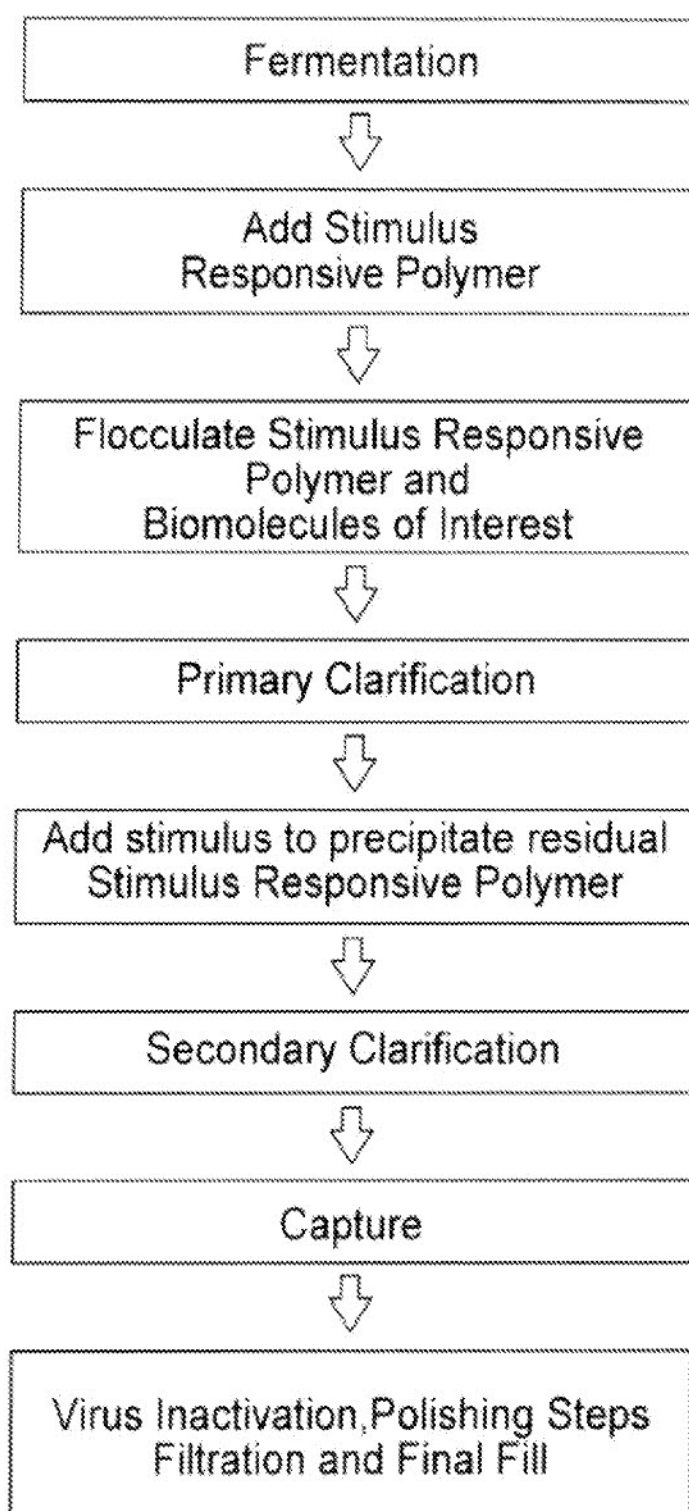


Figure 14

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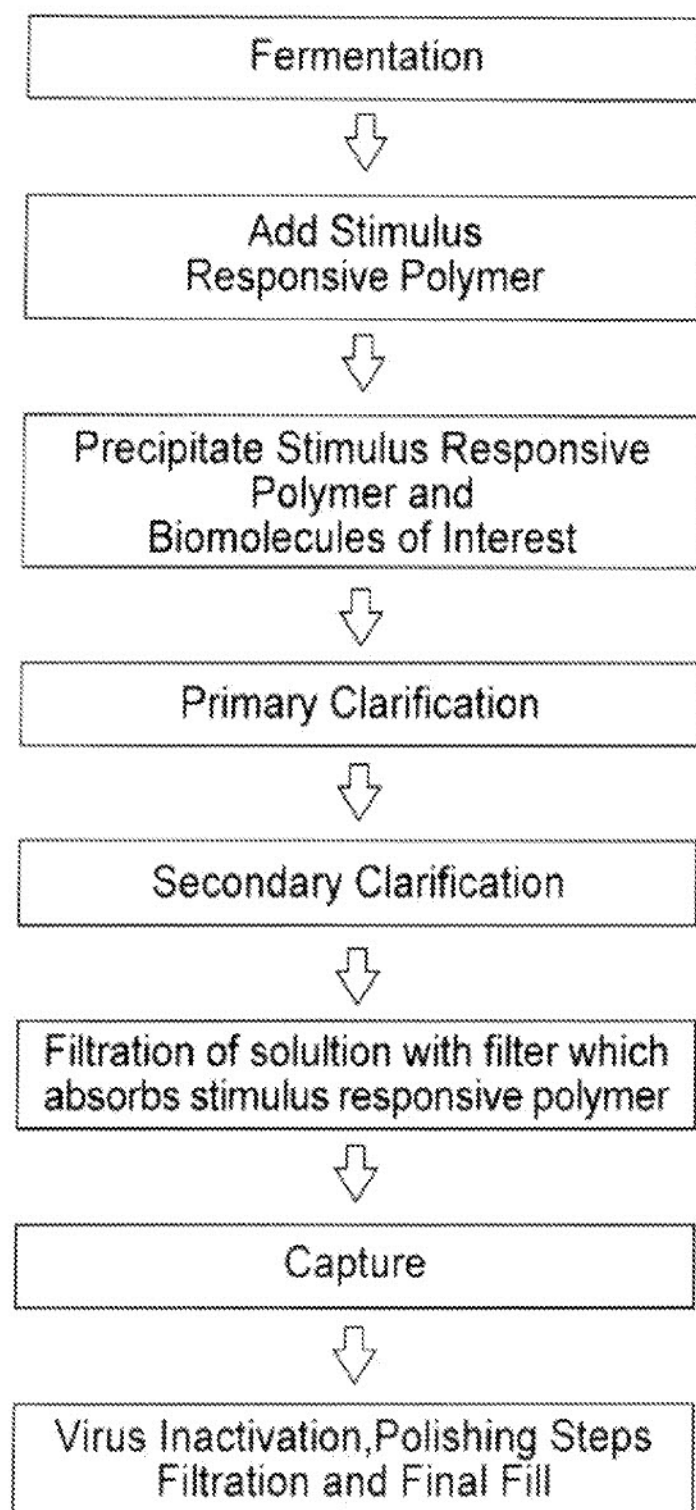


Figure 15