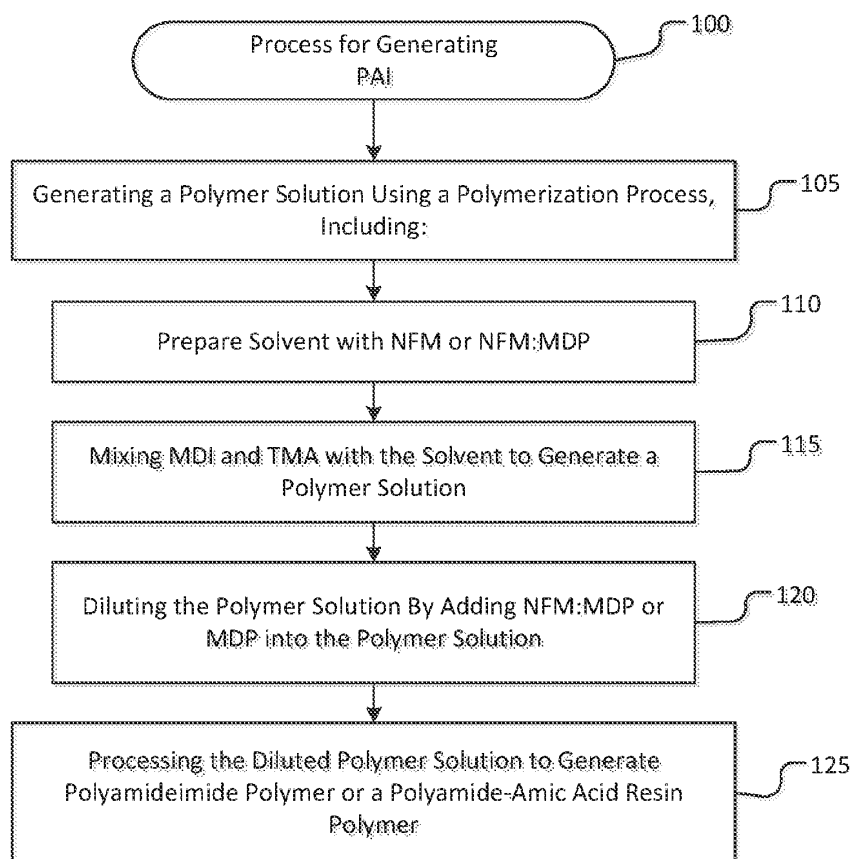


*Fig. 1*

Title	PAI Polymerization Solution	NFM (g)	MDP (g)	TMA (g)	MDI (g)	TMA:MDI Mole Ratio	Percent rxn Solids	Prepolymer	
								Temp (°C)	Time (hrs)
Mfr Ex. 1	90:10 NFM:MDP	192.20	21.35	64.30	79.30	1.01	34.5	90	2
Mfr Ex. 2	70:30 NFM:MDP	149.50	64.05	61.26	79.35	1.01	34.5	90	2
Mfr Ex. 3	30:70 NFM:MDP	64.05	149.45	61.26	79.35	1.01	34.5	90	2
Mfr Ex. 4	10:90 NFM:MDP	21.35	192.15	61.26	79.35	1.01	34.5	90	2
Mfr Ex. 5	100% NFM Diluted to 70:30 NFM:MDP	213.50	0.00	61.26	79.35	1.01	34.5	90	2
Mfr Ex. 6	70:30 NFM:MDP to Water-Based	149.50	64.05	61.26	79.35	1.01	34.5	90	2
Mfr Ex. 7	100% NFM Diluted to Water-Based	213.50	0.00	61.26	79.35	1.01	34.5	90	2
Comp Ex. 1	100% NFM Diluted to 70:30 NFM:CHN	213.50	0.00	61.26	79.35	1.01	34.5	90	2
Comp Ex. 2	100% NFM Diluted to 70:30 NFM:PC	213.50	0.00	61.26	79.35	1.01	34.5	90	2

Fig. 2A

Title	Polymerization		Final Mass %		Turpid. NTUS	Visual Haze	Visc. Cps DV III 23C	% Solids (MB)	Acid # mg KOH/g	GPC Data			Coating Film Thickness (μ m)	Coating Cracking (cm)
	Temp (C)	Time (h)	% Amine	% Water						Mn	MW	PD		
Mfr Ex. 1	160	8	-	-	2.60	Clear	15,320	28.54	10.60	6,242	17,235	2.76	135	Pass
Mfr Ex. 2	160	8	-	-	1.30	Clear	20,590	26.42	9.05	11,944	32,192	2.70	140/160	Pass
Mfr Ex. 3	160	8	-	-	2.40	Clear	12,540	26.98	8.34	14,829	41,392	2.80	130	Pass
Mfr Ex. 4	160	8	-	-	11.40	Hazy	7,797	25.98	9.51	15,330	46,352	3.02	-	-
Mfr Ex. 5	160	8	-	-	5.60	Clear	27,128	28.16	6.41	17,054	31,459	1.84	80	Pass
Mfr Ex. 6	160	8	10	11	2.70	Clear	6,366	28.10	127.80	6,460	23,400	3.62	-	-
Mfr Ex. 7	160	8	6	17	2.32	Clear	6,549	28.00	129.00	7,340	25,600	3.49	-	-
Comp Ex. 1	160	10	-	-	3.04	Clear	17,370	27.62	10.60	14,392	26,330	1.83	157	Pass
Comp Ex. 2	160	8	-	-	4.20	Clear	55,710	27.52	6.41	16,927	31,273	1.85	73	0.2

Fig. 2B