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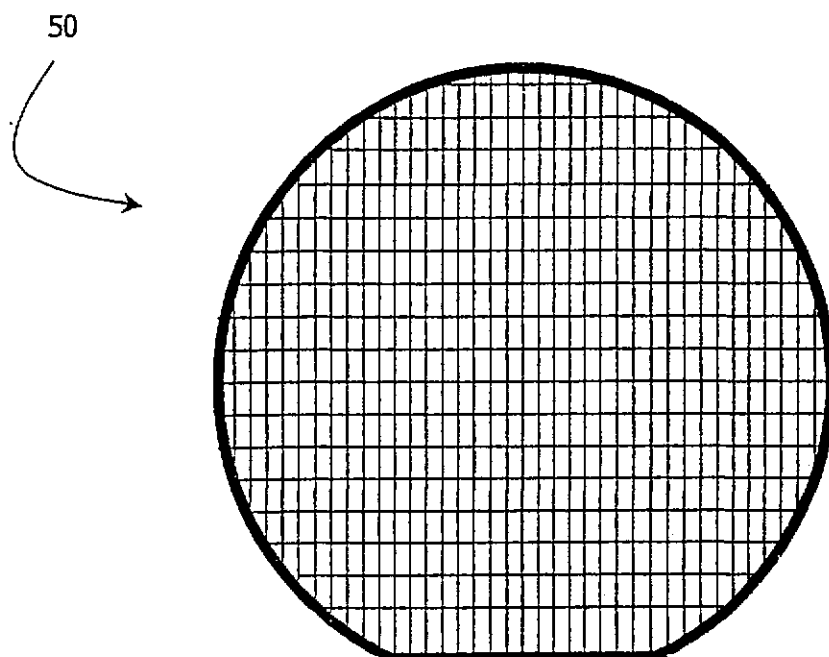


Fig. 1

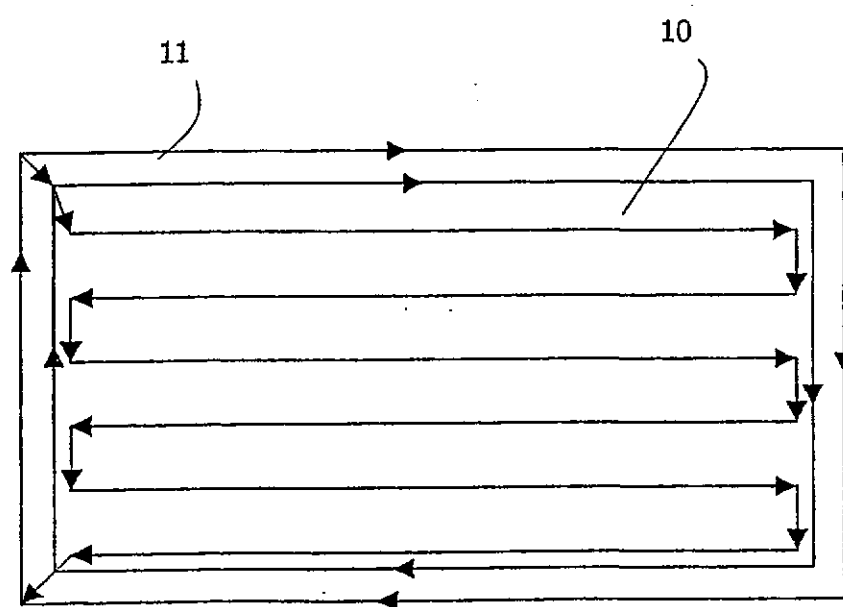
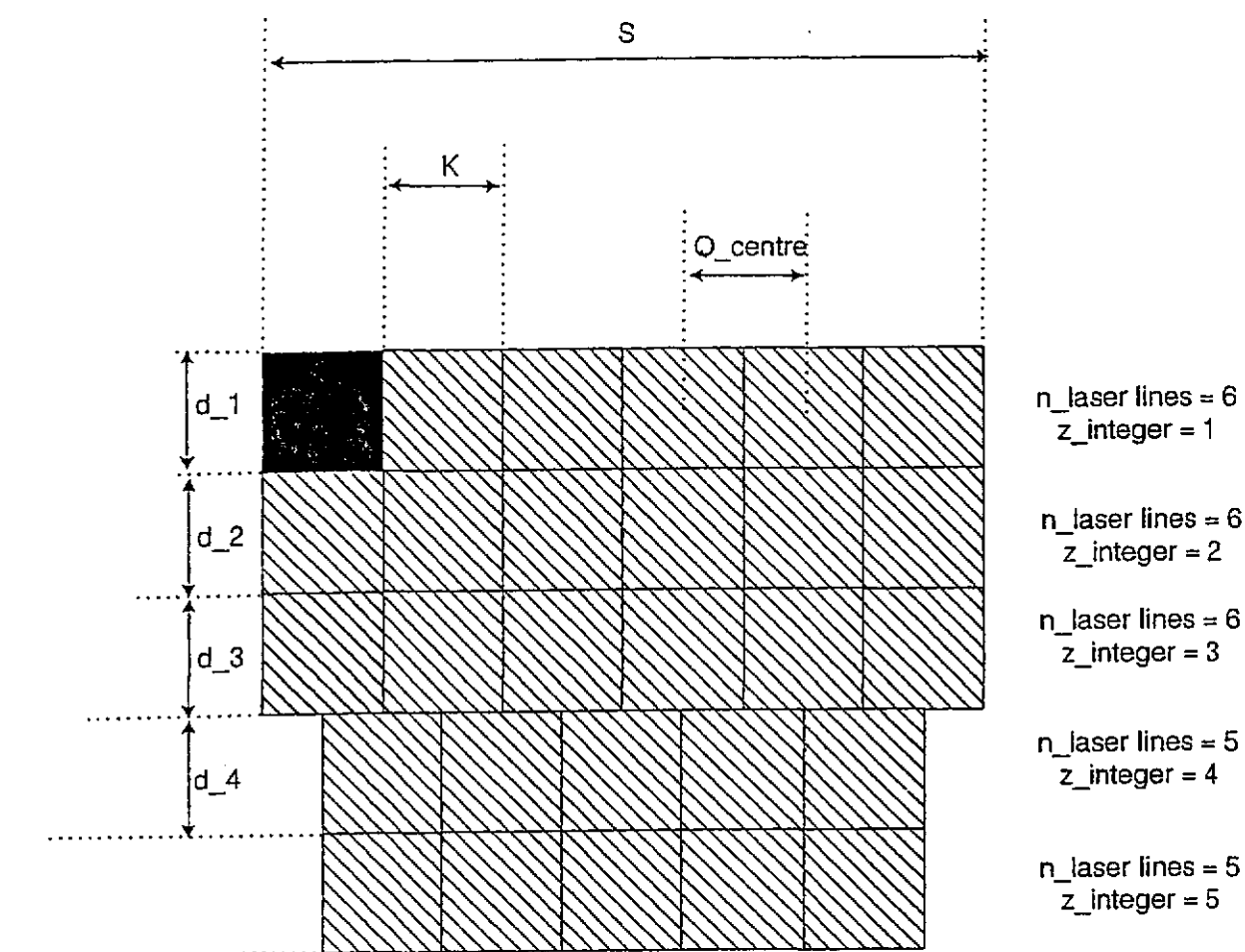


Fig. 2

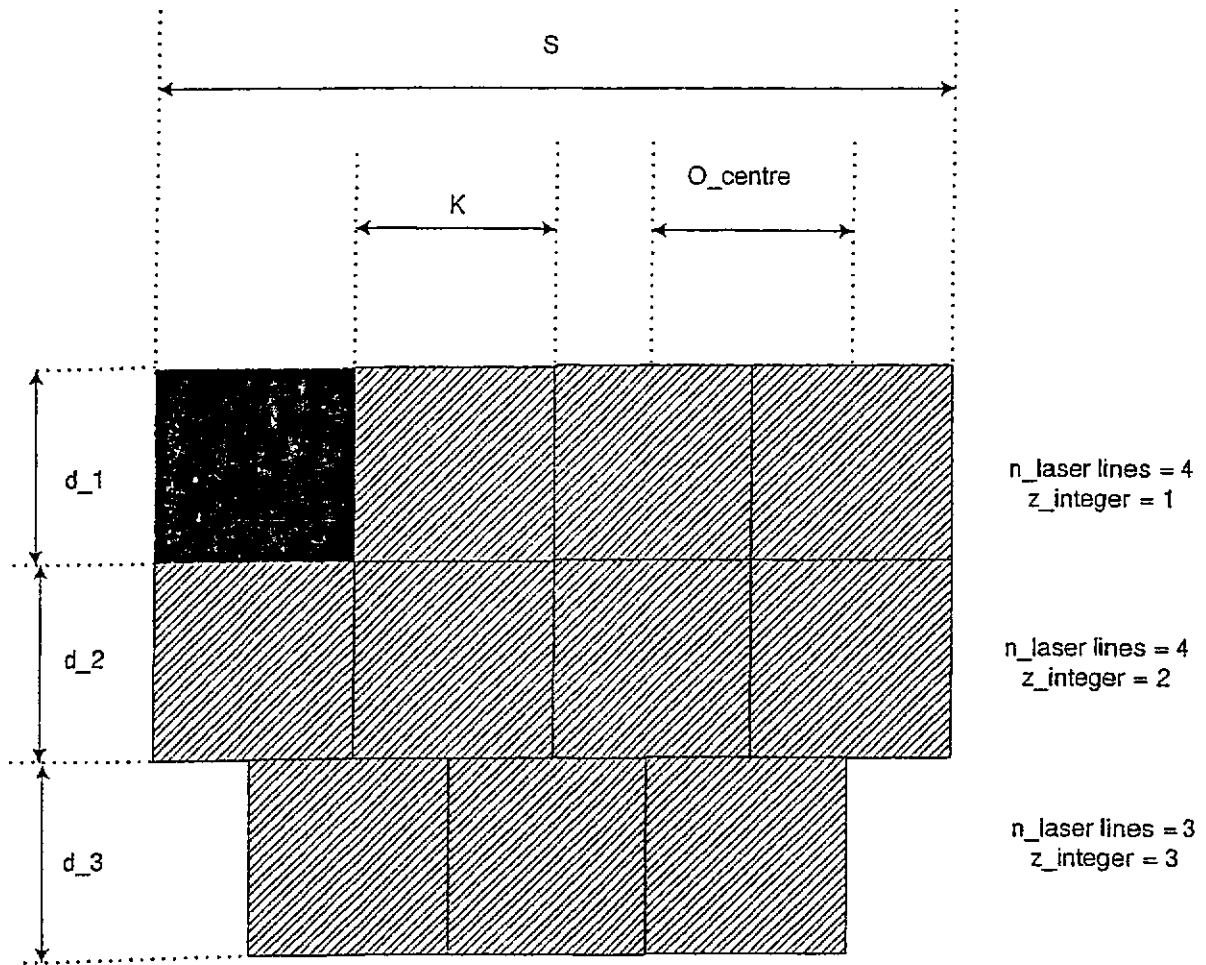
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*A five step machining strategy requiring a total of 28 laser scans.*

Fig. 3

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*Three step machining strategy for a similar volume as figure 6 requiring a total of 11 laser scans*

Fig. 4

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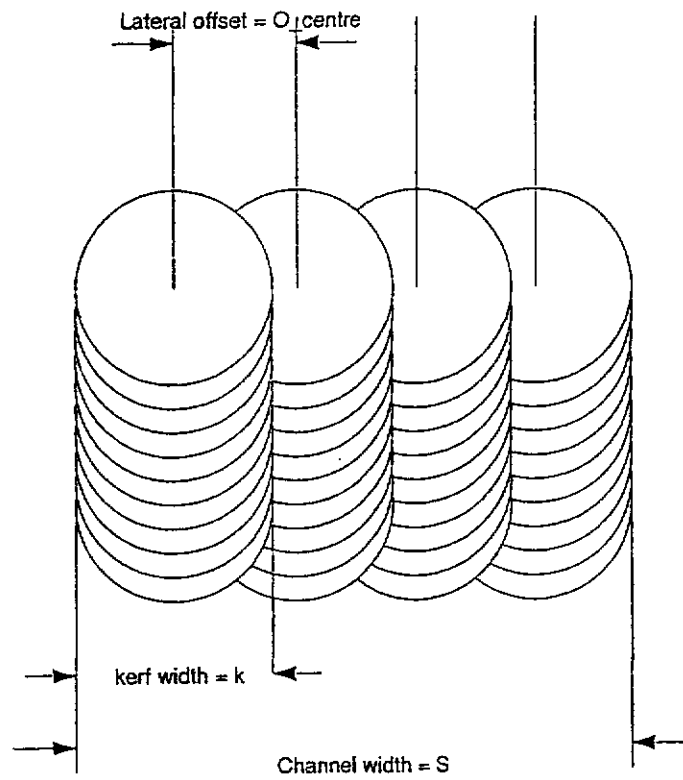


Fig. 5

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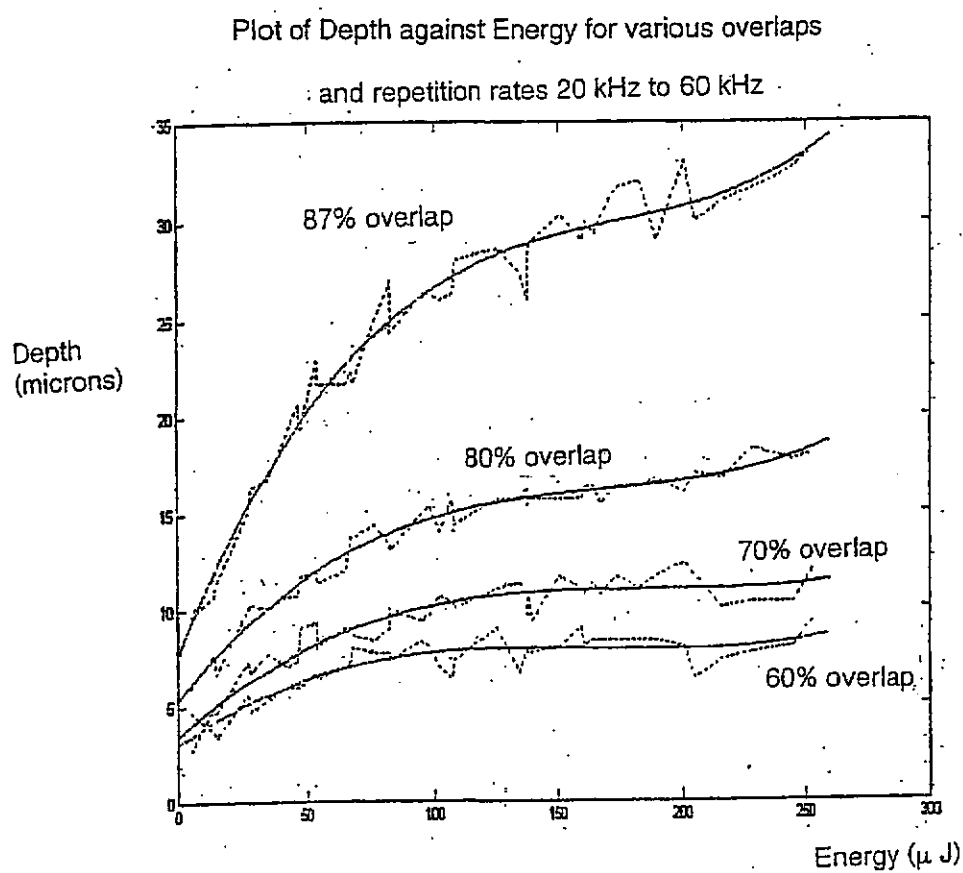


Fig. 6

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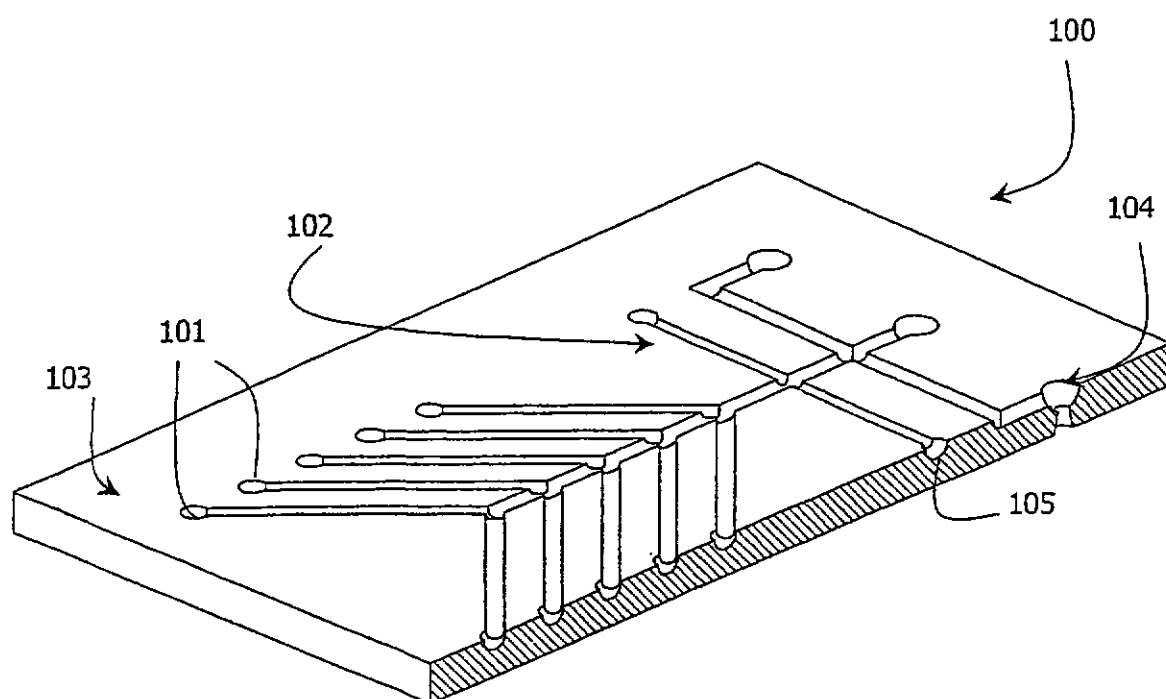


Fig. 7

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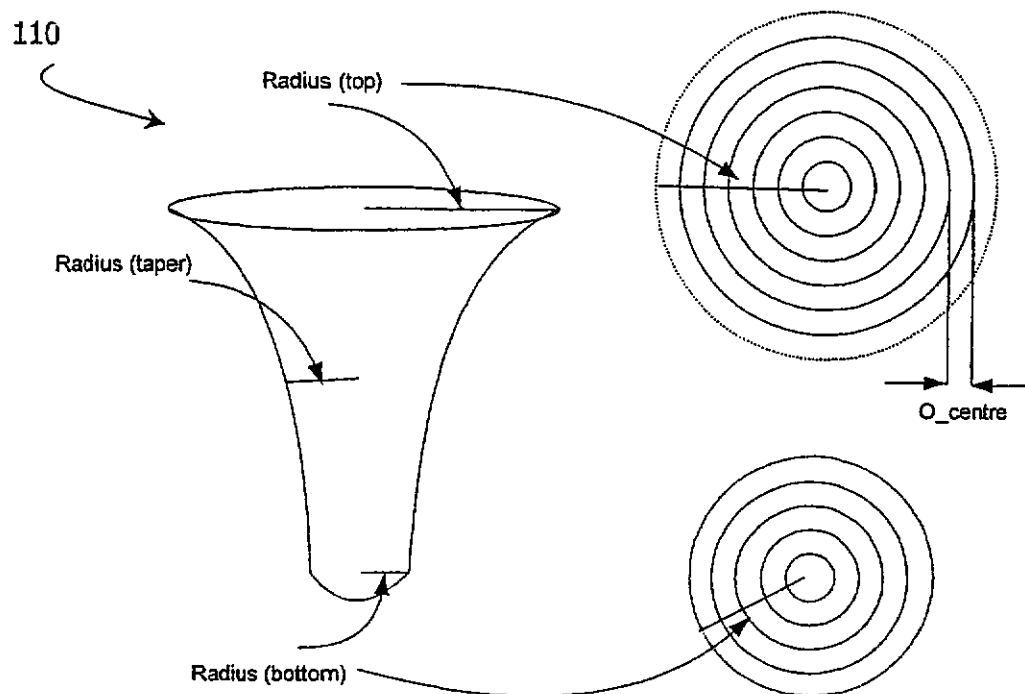


Fig. 8

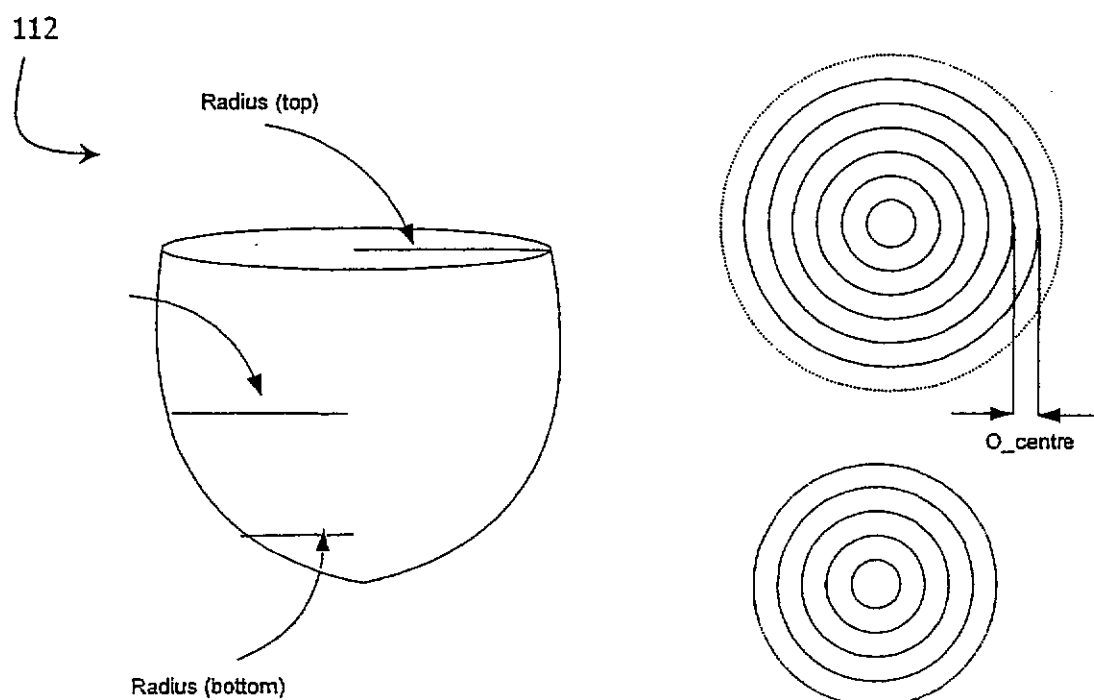


Fig. 9

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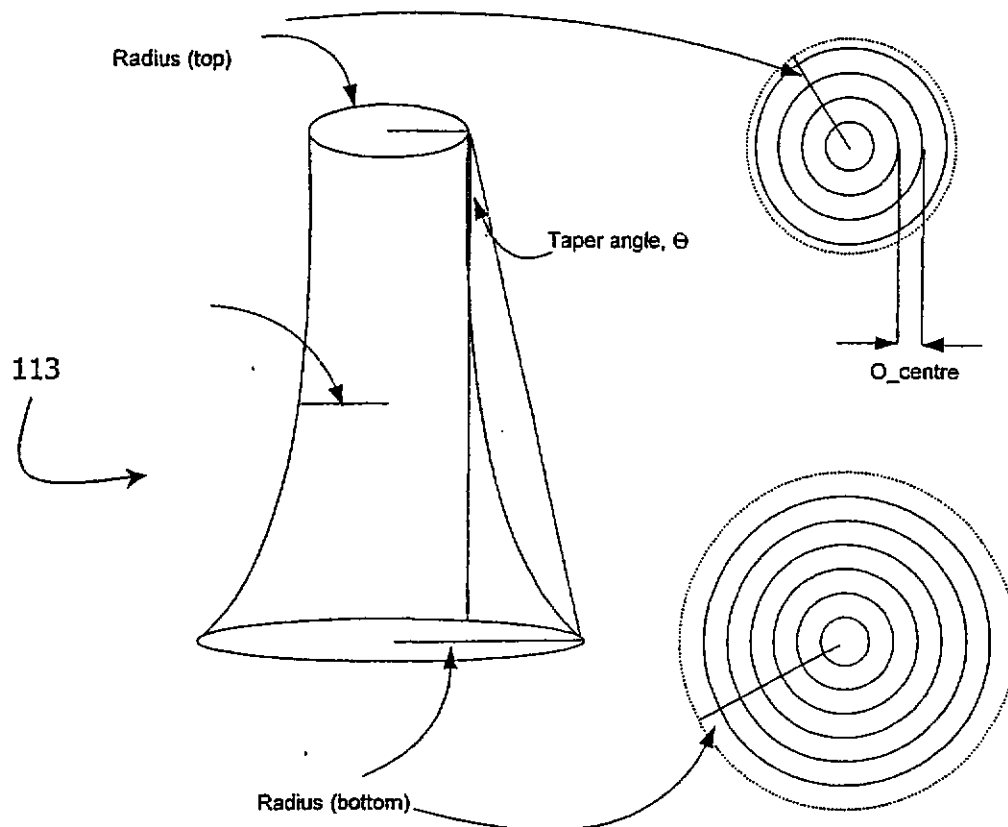


Fig. 10

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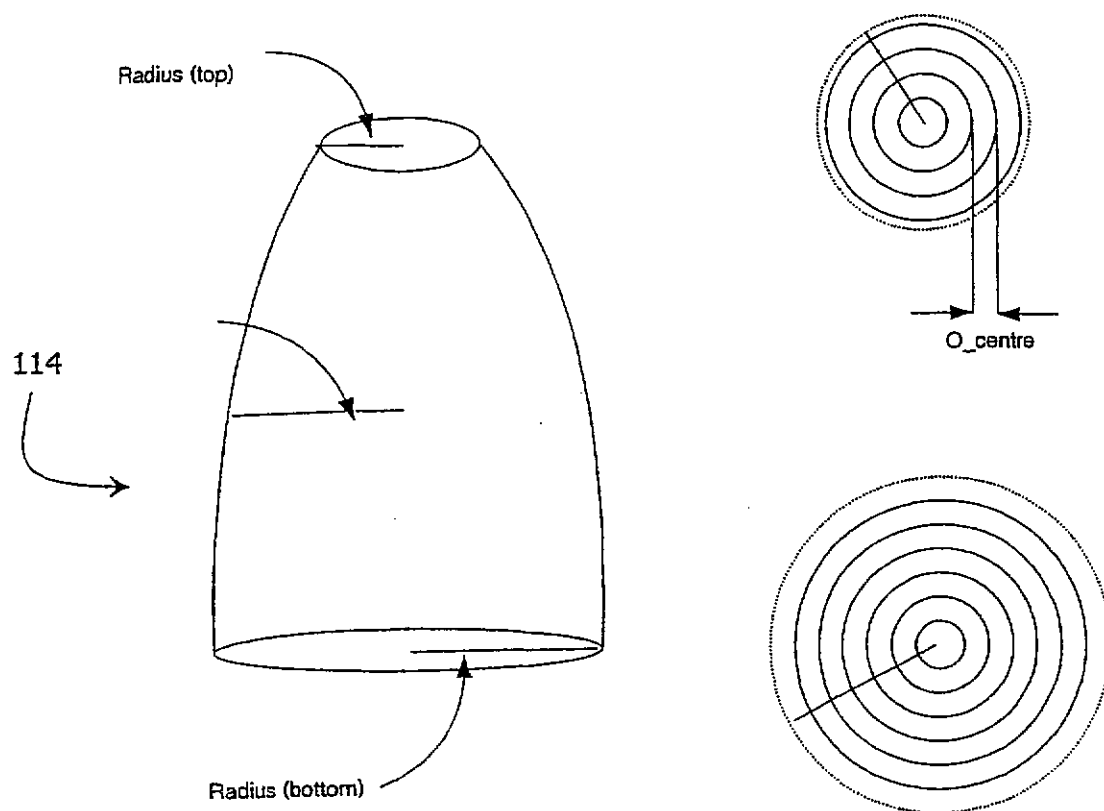


Fig. 11

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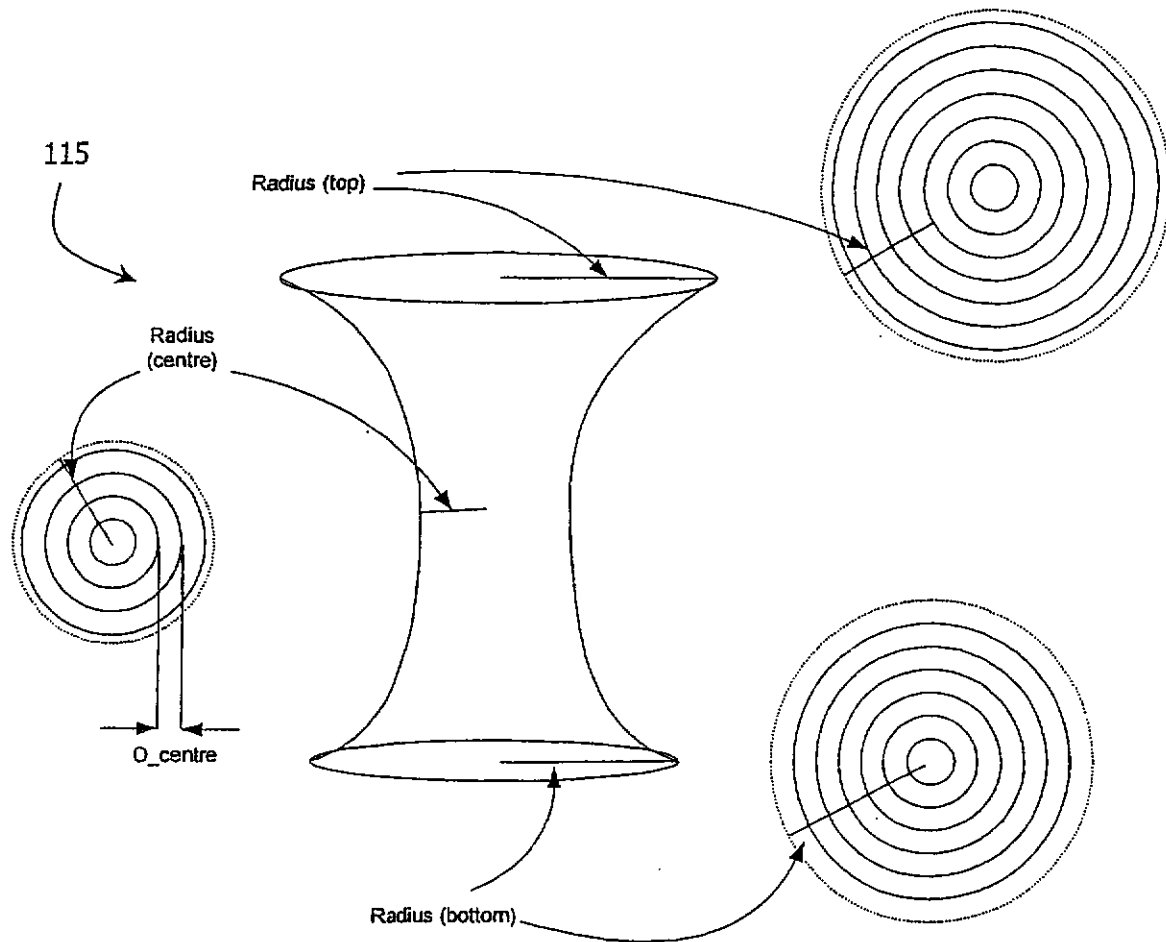


Fig. 12

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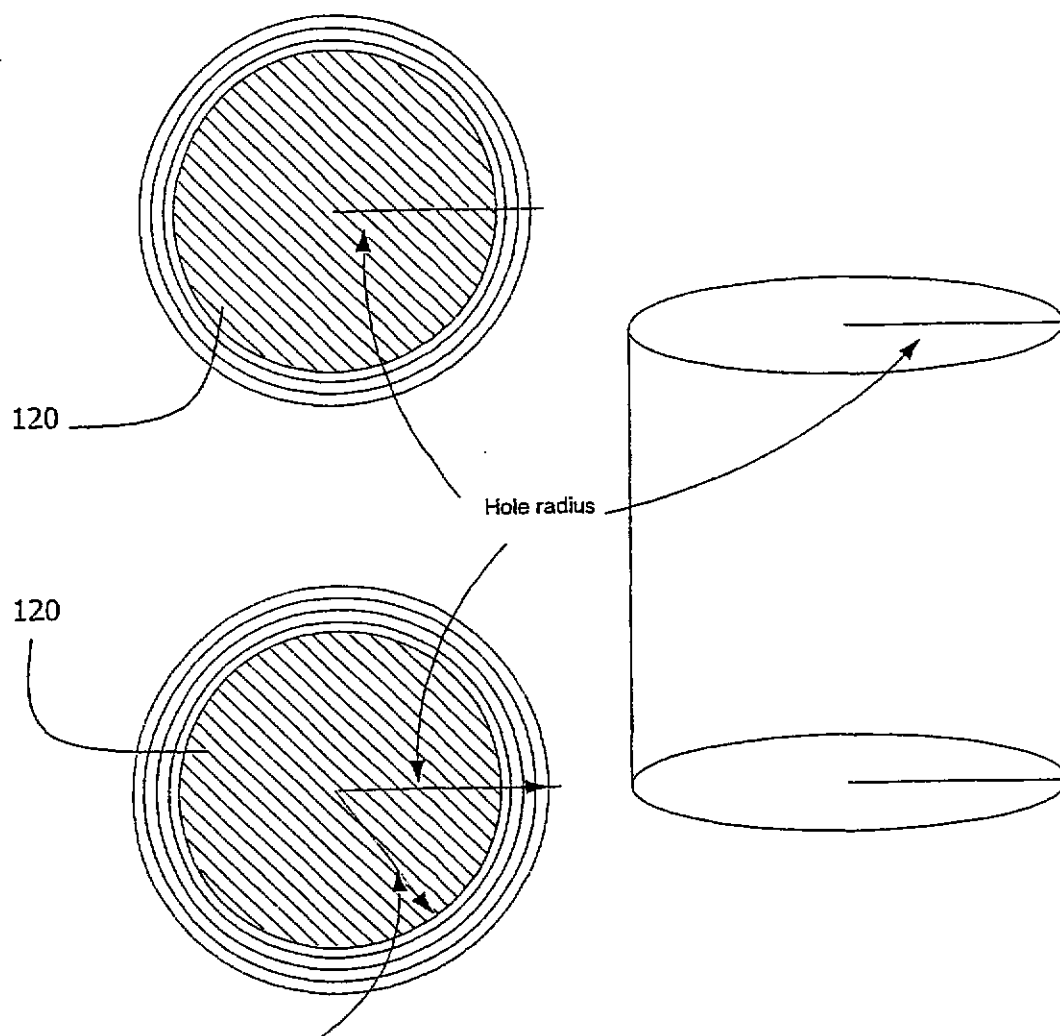


Fig. 13

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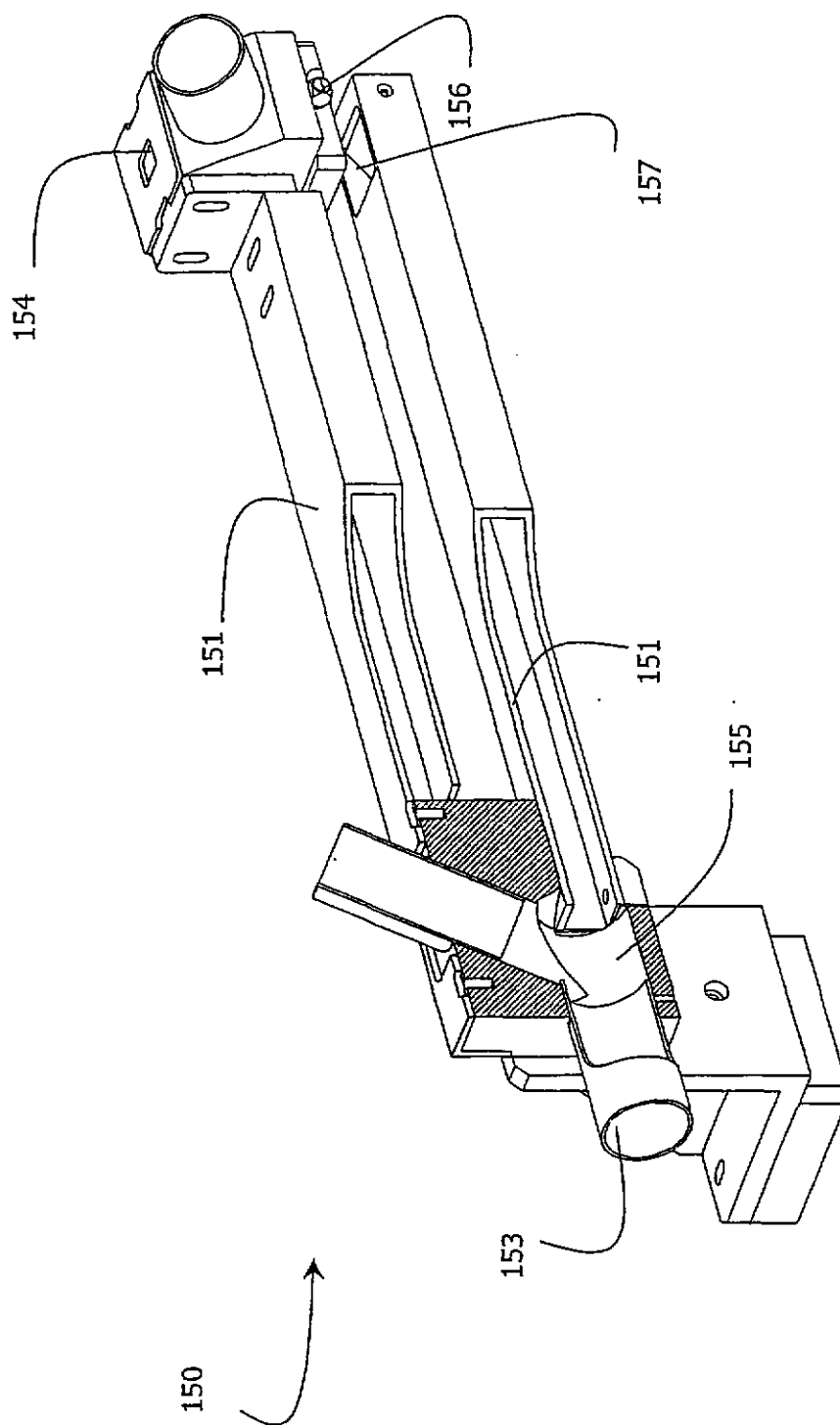


Fig. 14

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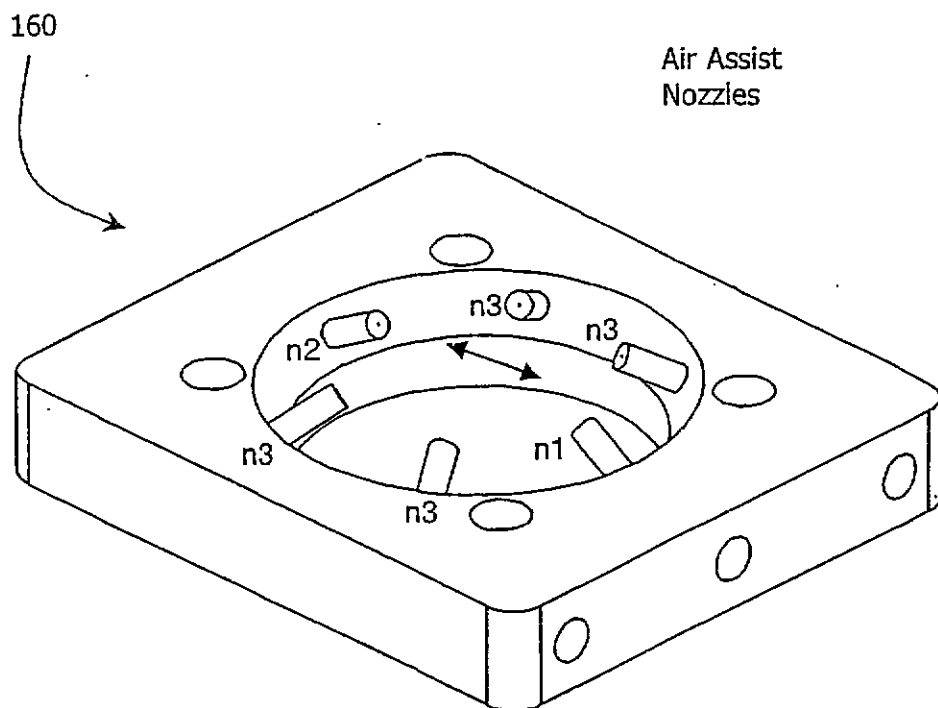
*Inverted Air Assist Plate*

Fig. 15

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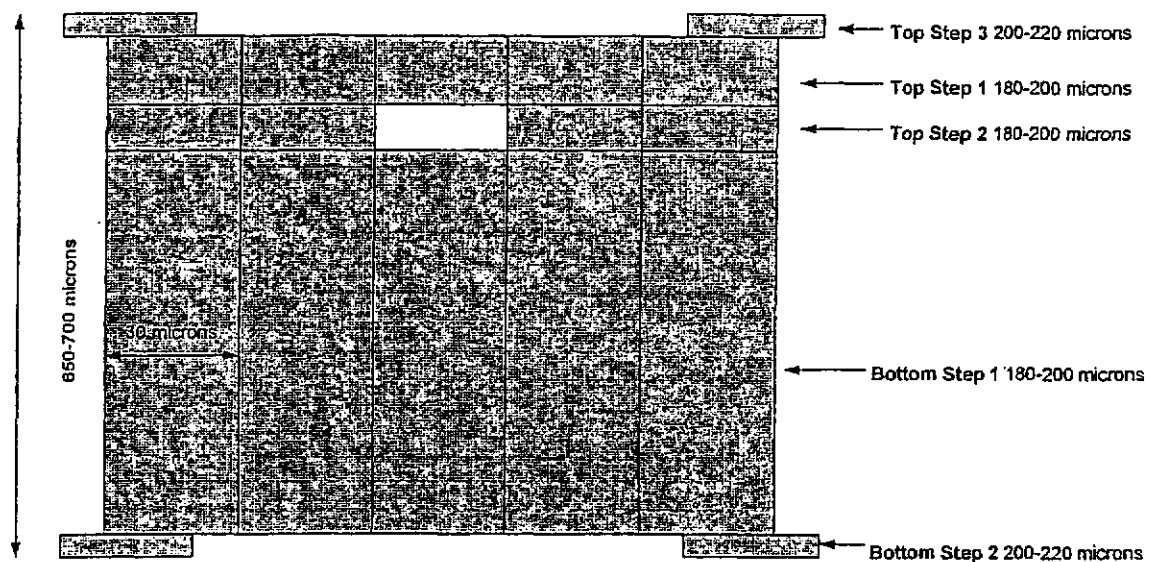


Fig. 16

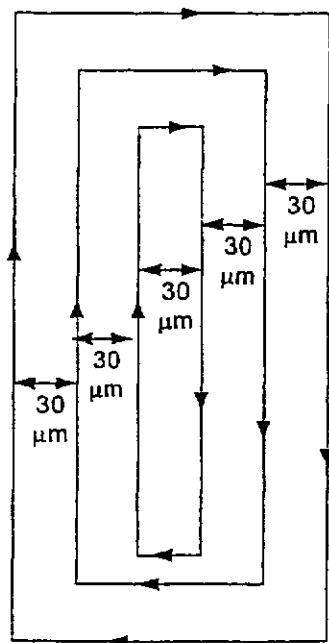


Fig. 17

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Fig. 18

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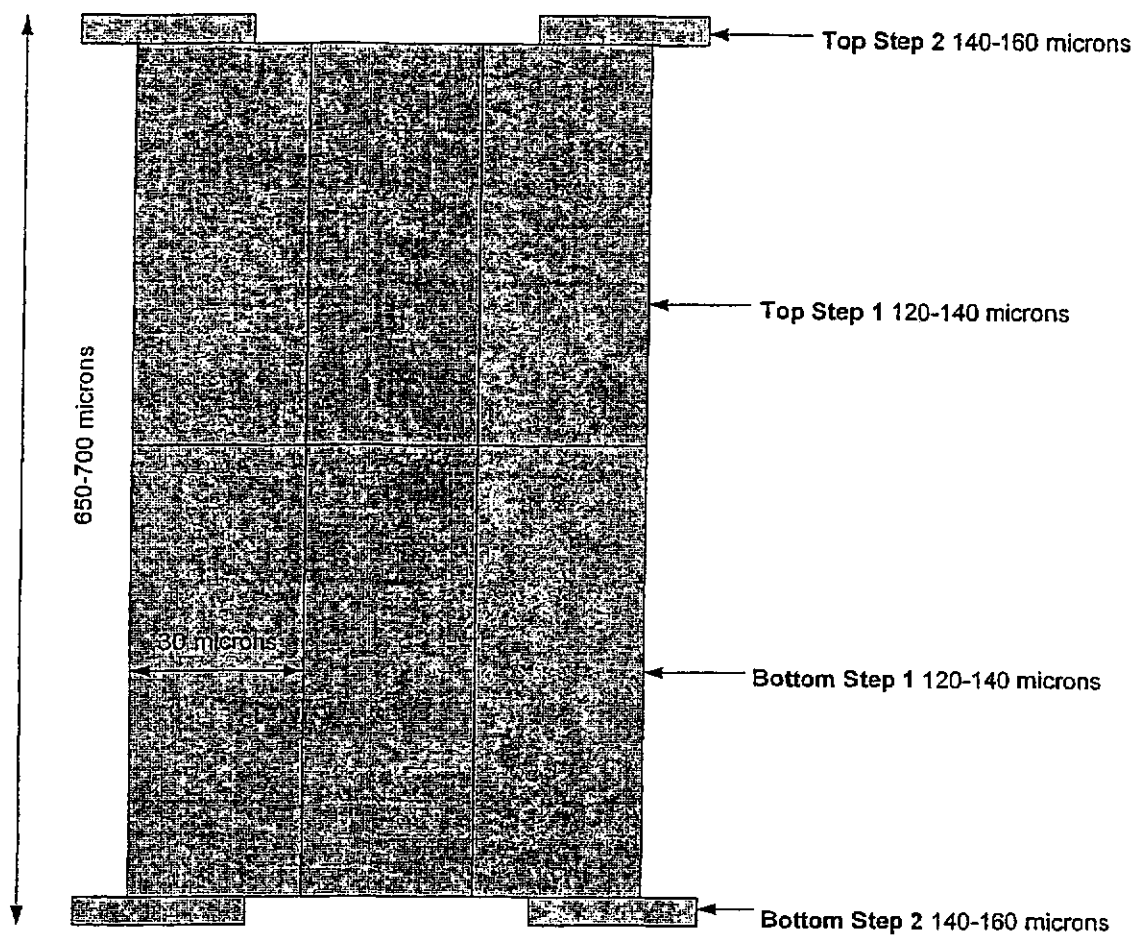


Fig. 19

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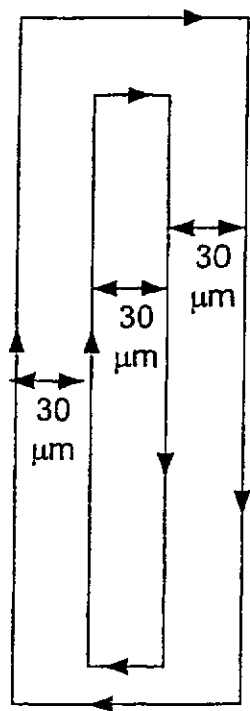


Fig. 20

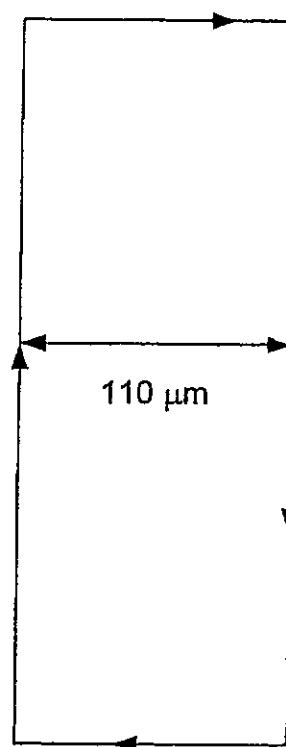


Fig. 21