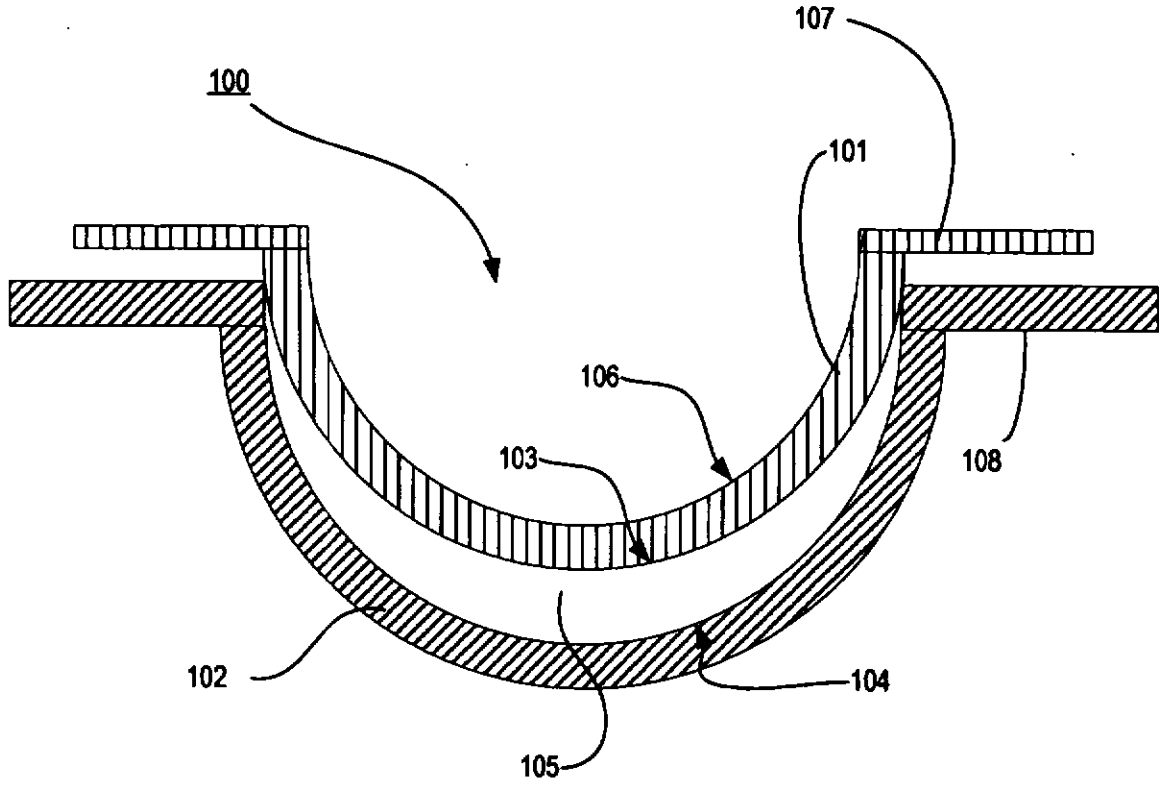


FIG. 1

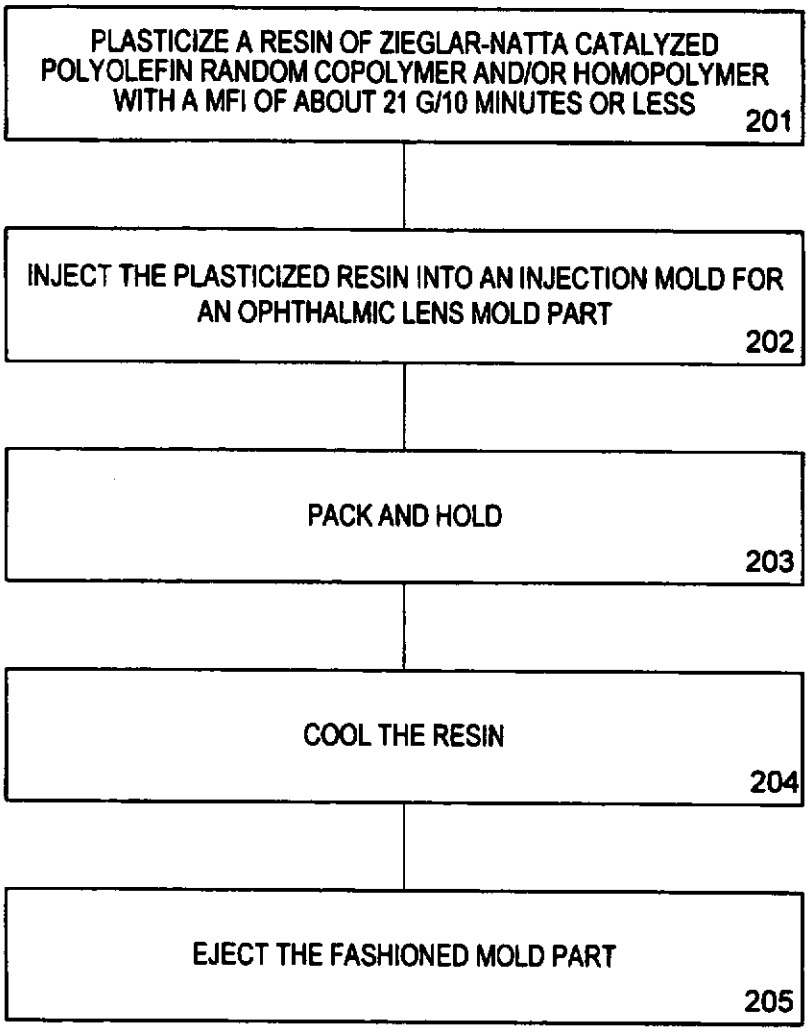

PLASTICIZE A RESIN OF ZIEGLAR-NATTA CATALYZED POLYOLEFIN RANDOM COPOLYMER AND/OR HOMOPOLYMER WITH A MFI OF ABOUT 21 G/10 MINUTES OR LESS
201
INJECT THE PLASTICIZED RESIN INTO AN INJECTION MOLD FOR AN OPHTHALMIC LENS MOLD PART
202
PACK AND HOLD
203
COOL THE RESIN
204
EJECT THE FASHIONED MOLD PART
205

FIG. 2

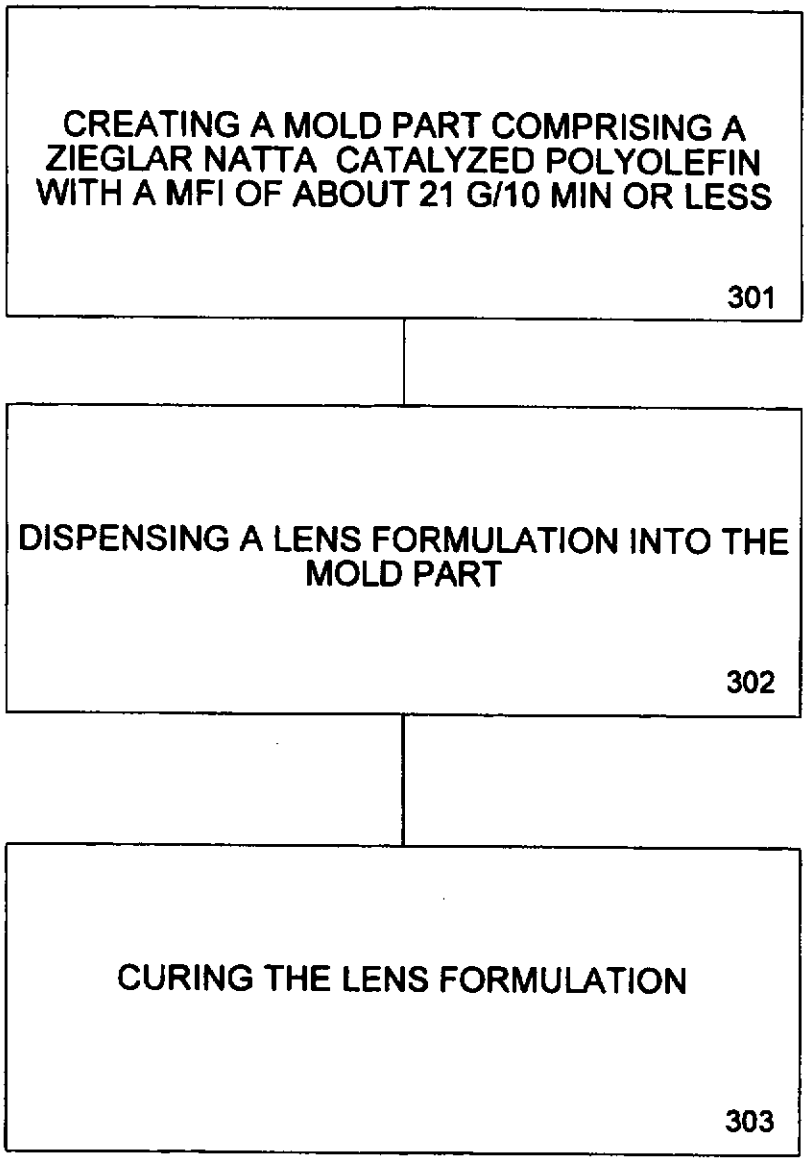
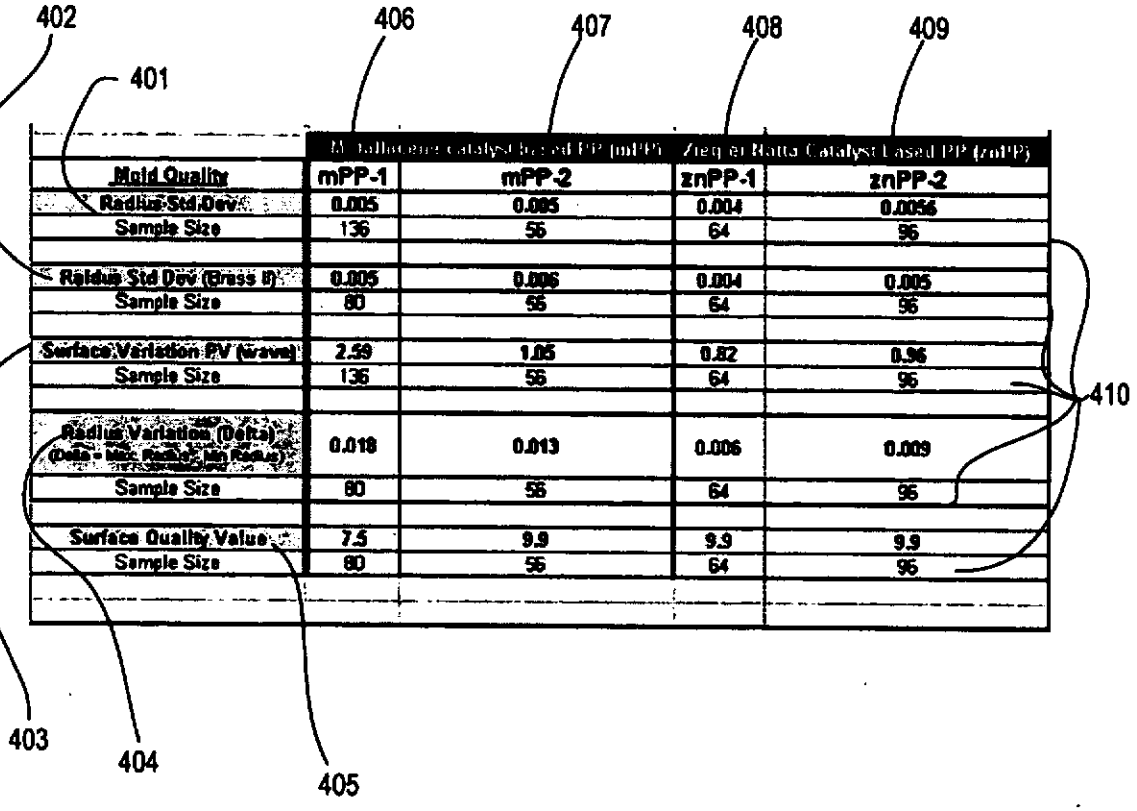

CREATING A MOLD PART COMPRISING A ZIEGLAR NATTA CATALYZED POLYOLEFIN WITH A MFI OF ABOUT 21 G/10 MIN OR LESS
301
DISPENSING A LENS FORMULATION INTO THE MOLD PART
302
CURING THE LENS FORMULATION
303

FIG. 3

400



	Metallocene catalyst based PP (mPP)		Ziegler Natta Catalyst based PP (znPP)	
Mold Quality	mPP-1	mPP-2	znPP-1	znPP-2
Radius Std.Dev	0.005	0.005	0.004	0.0056
Sample Size	136	56	64	96
Radius Std Dev (Brass II)	0.005	0.006	0.004	0.005
Sample Size	80	56	64	96
Surface Variation PV (waves)	2.59	1.05	0.82	0.96
Sample Size	136	56	64	96
Radius Variation (Delta) (Delta = Max. Radius - Min Radius)	0.018	0.013	0.006	0.009
Sample Size	80	56	64	96
Surface Quality Value	7.5	9.9	9.9	9.9
Sample Size	80	56	64	96

FIG. 4