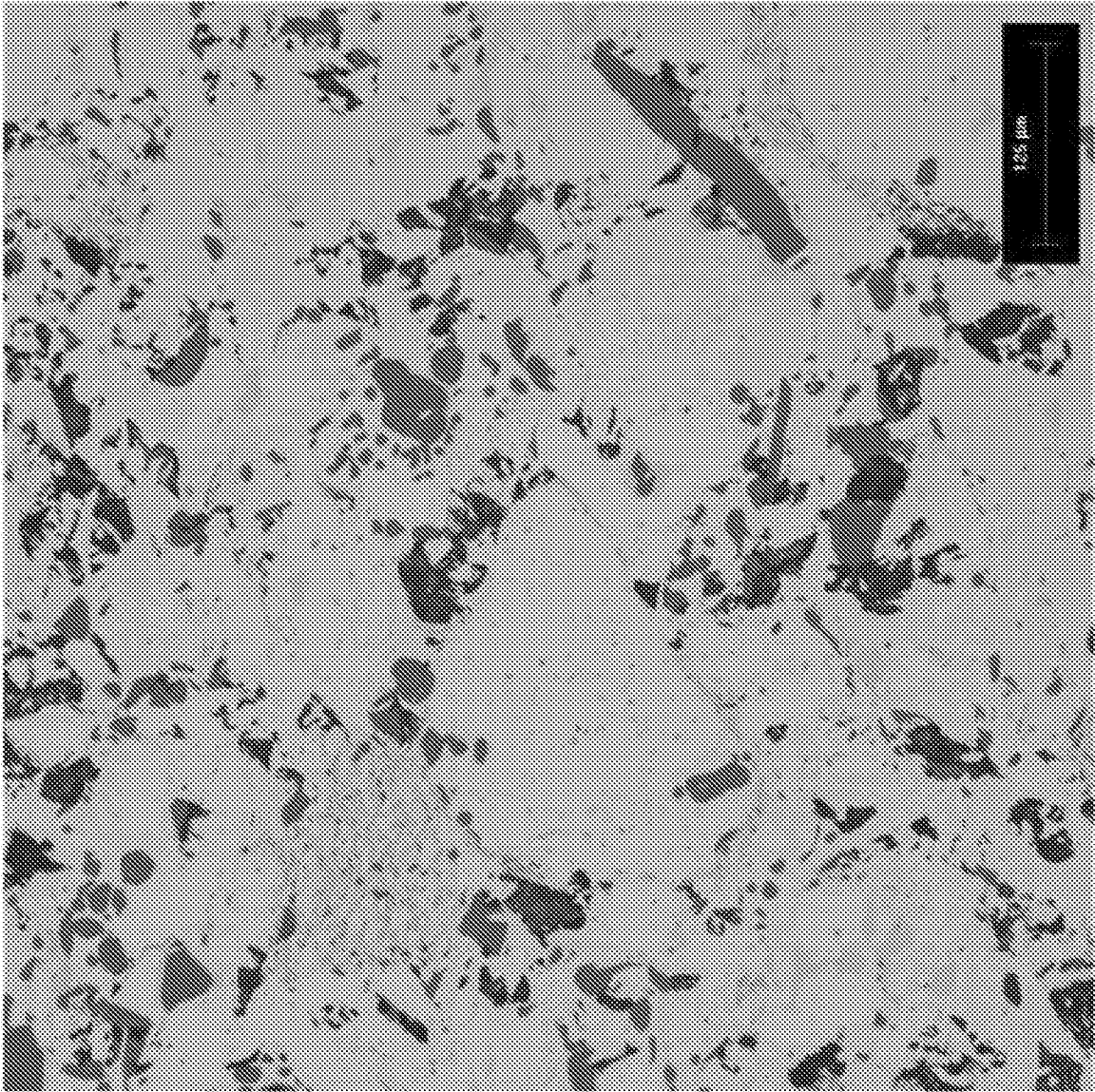


3

FIG. 1



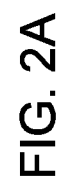


FIG. 2A

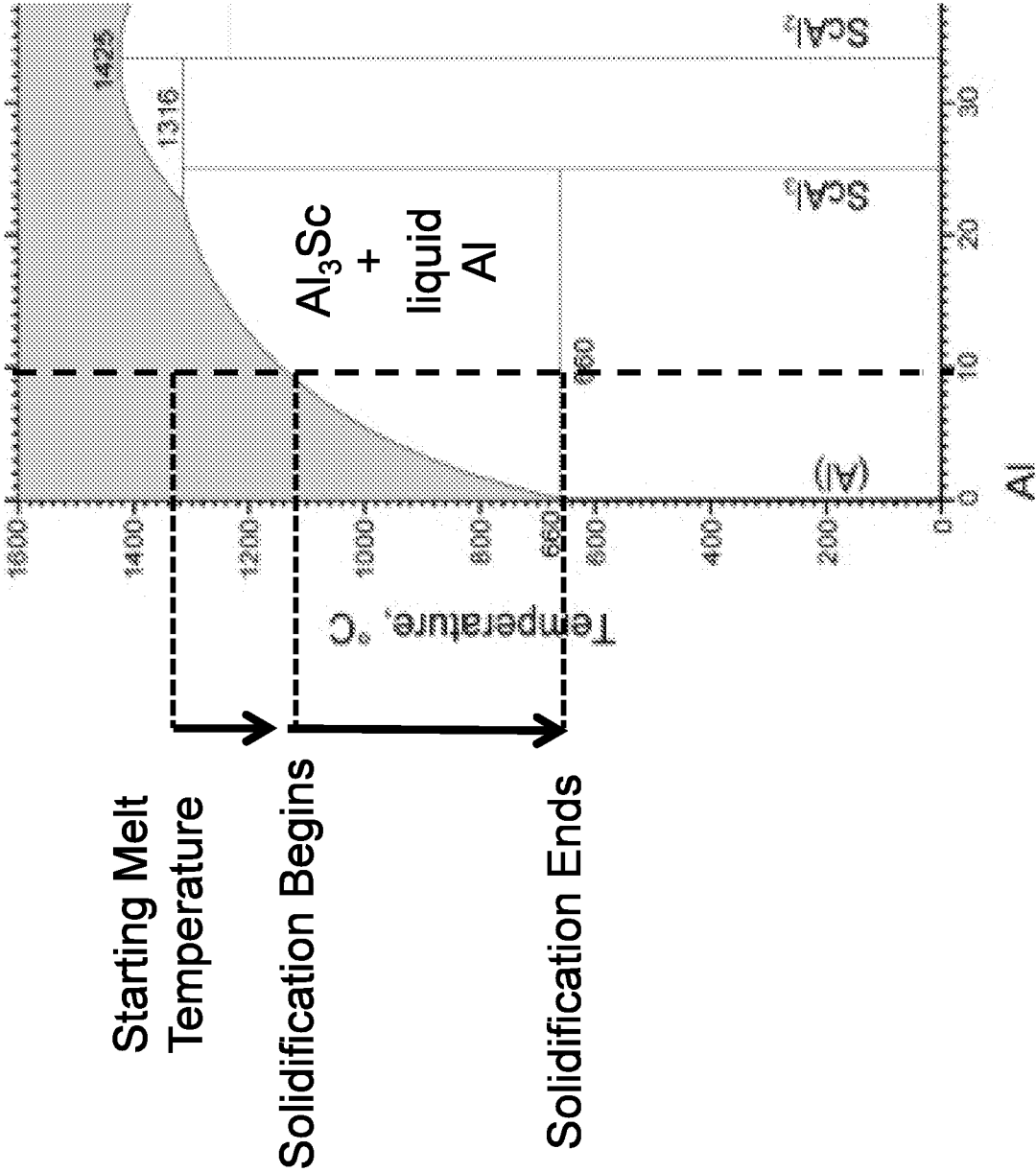


FIG. 2B

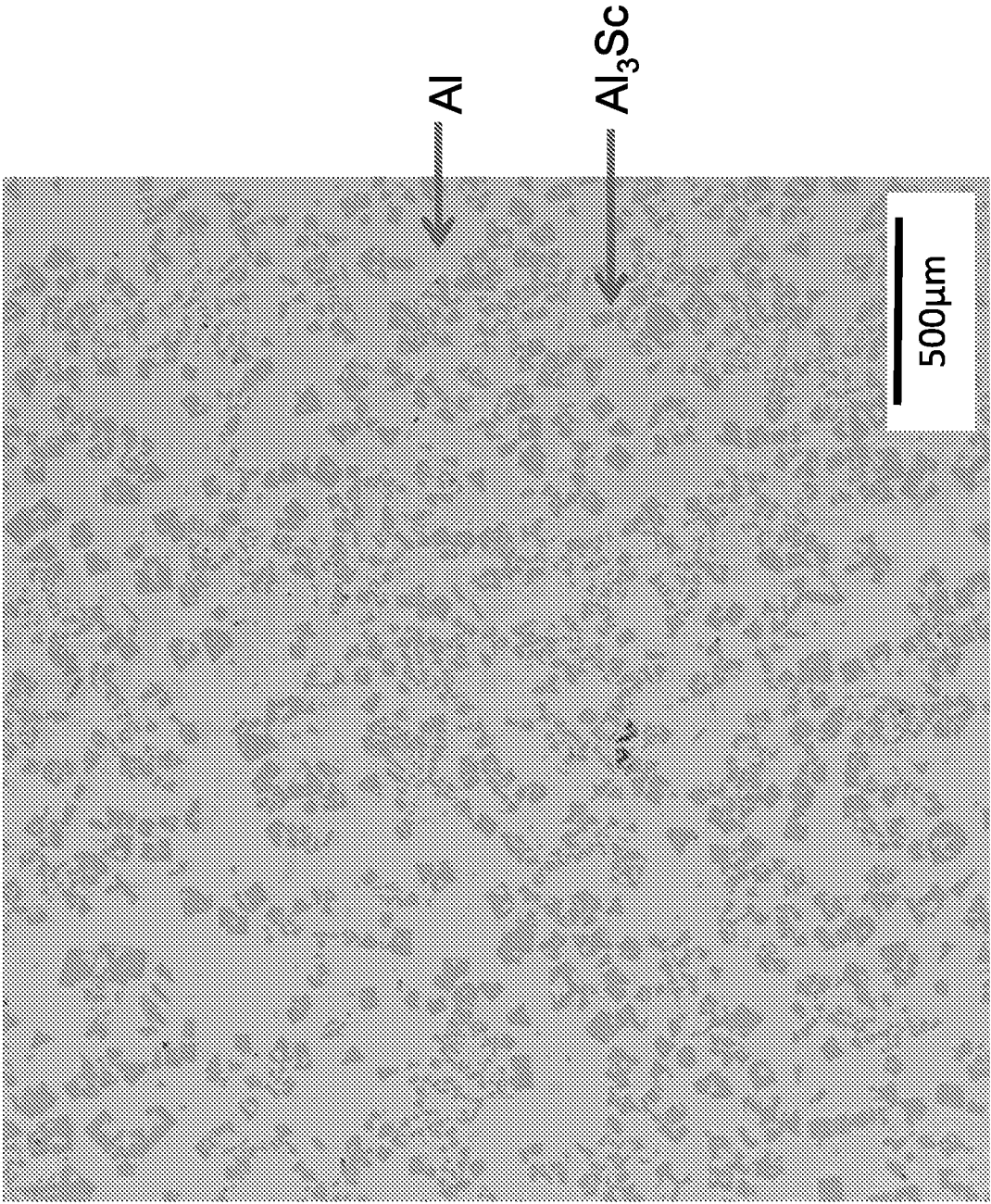


FIG. 3

Center of Casting

Mold Wall

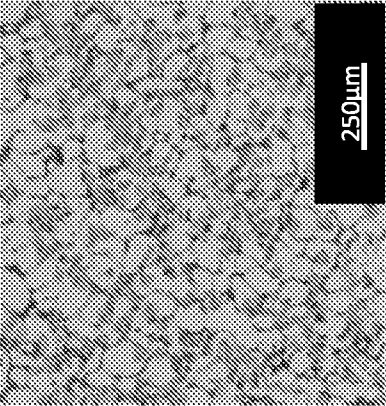
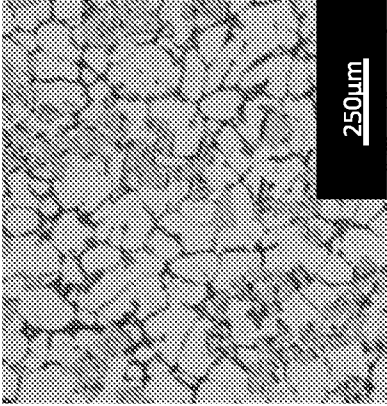
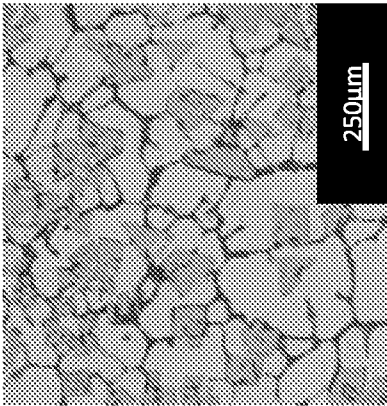


FIG. 4C

FIG. 4B

FIG. 4A

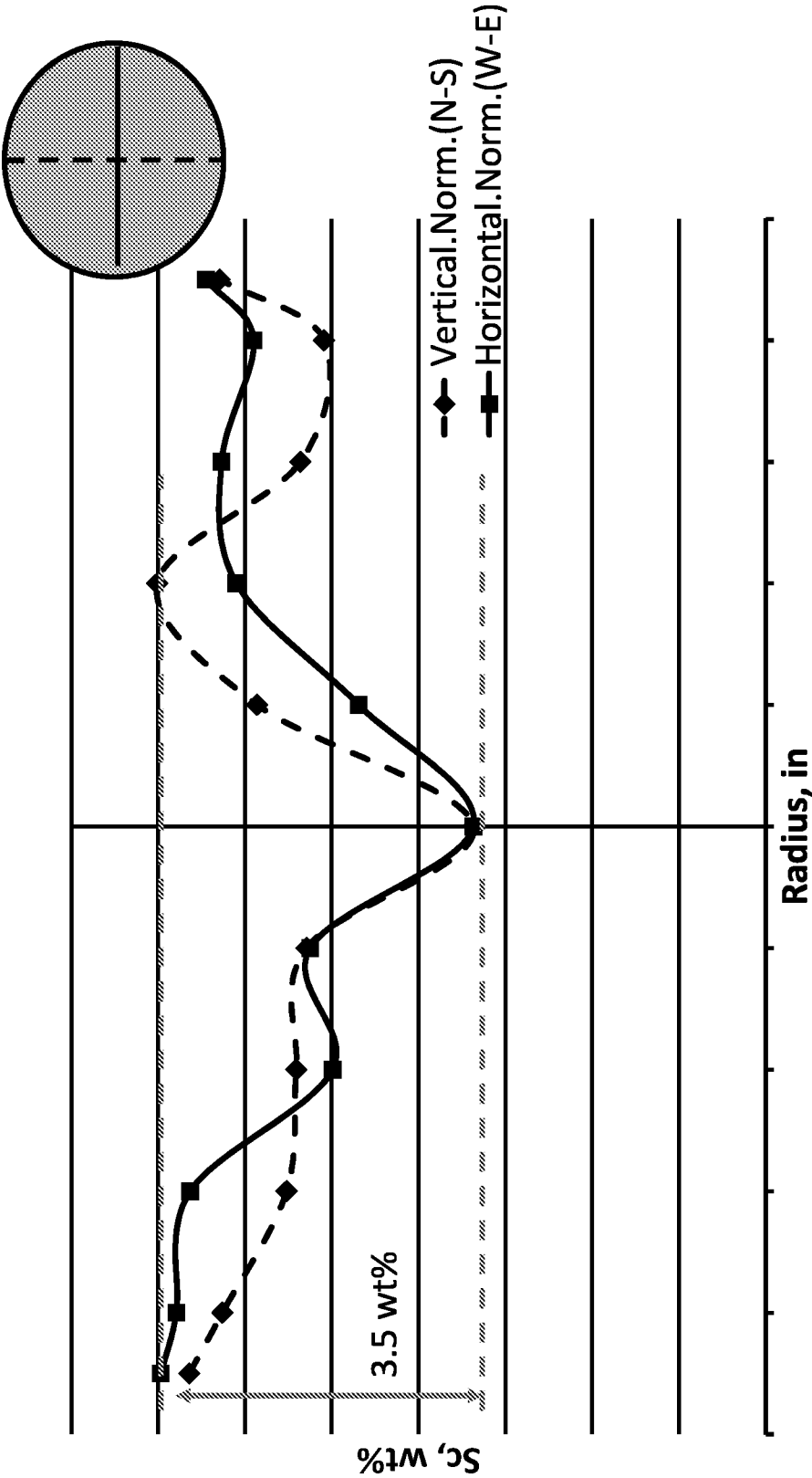


FIG. 5

FIG. 6B 18-23 at%

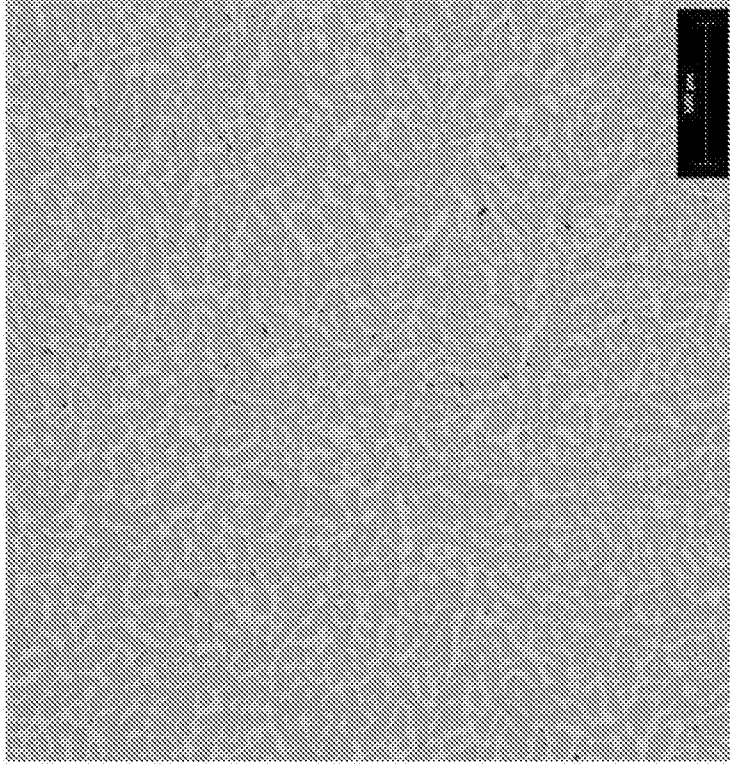
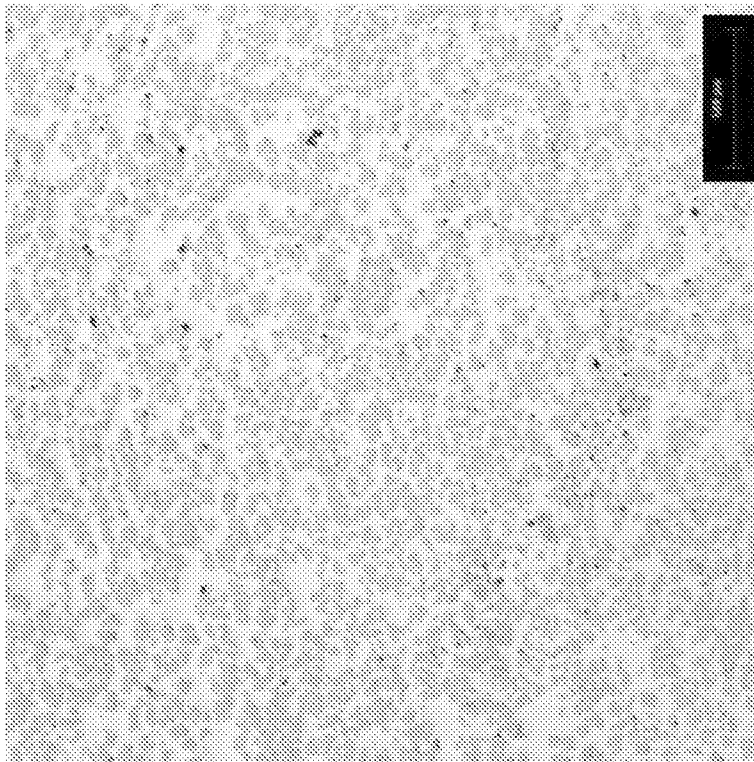


FIG. 6A 10-15 at%



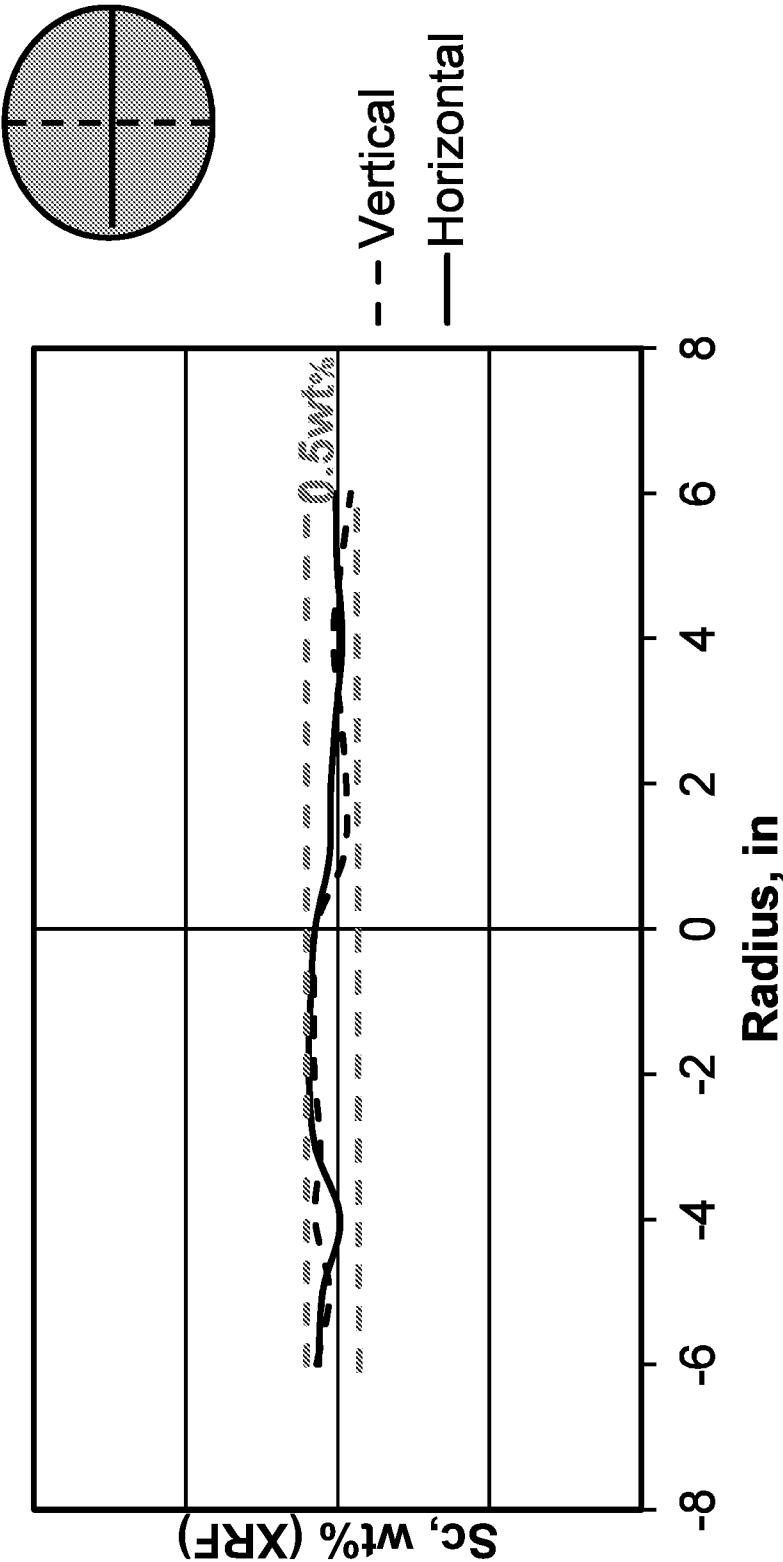


FIG. 7

FIG. 8B 33-50 at%

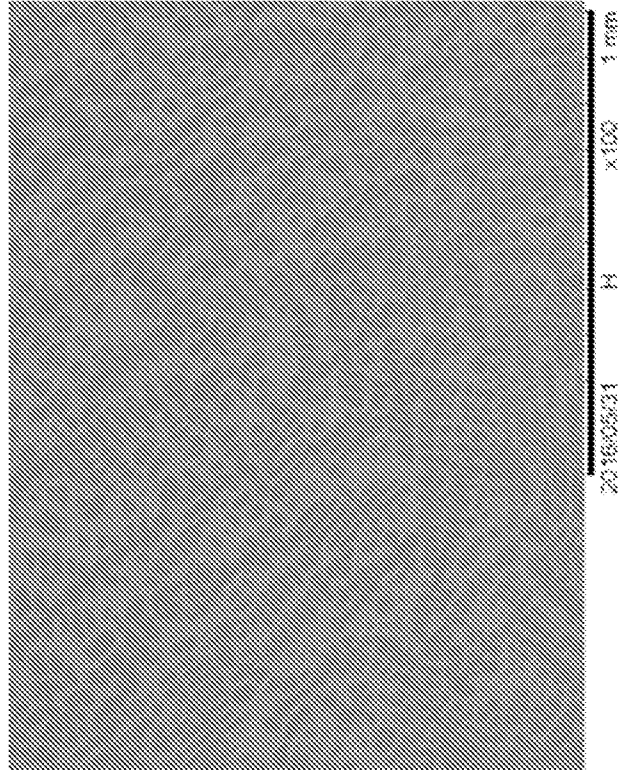
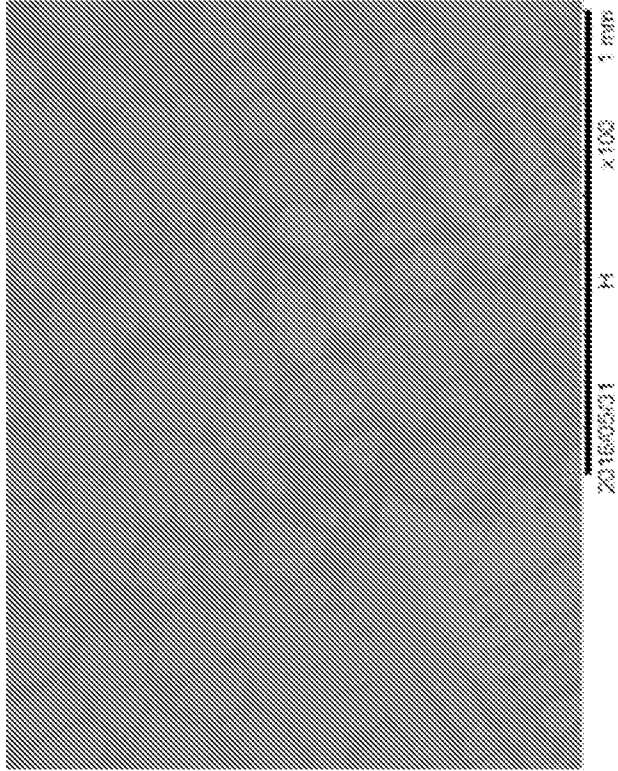


FIG. 8A 25-33 at%



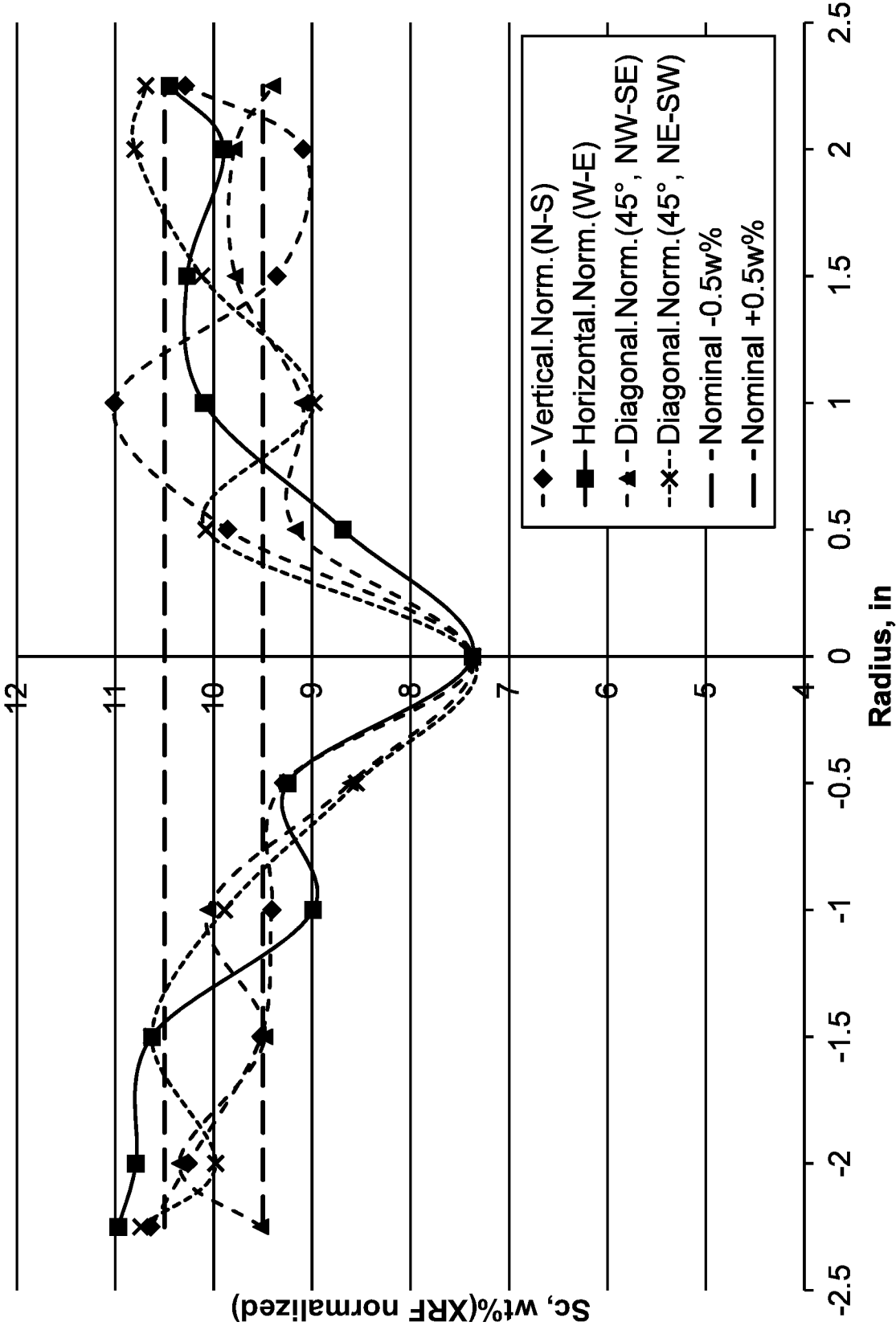


FIG. 9

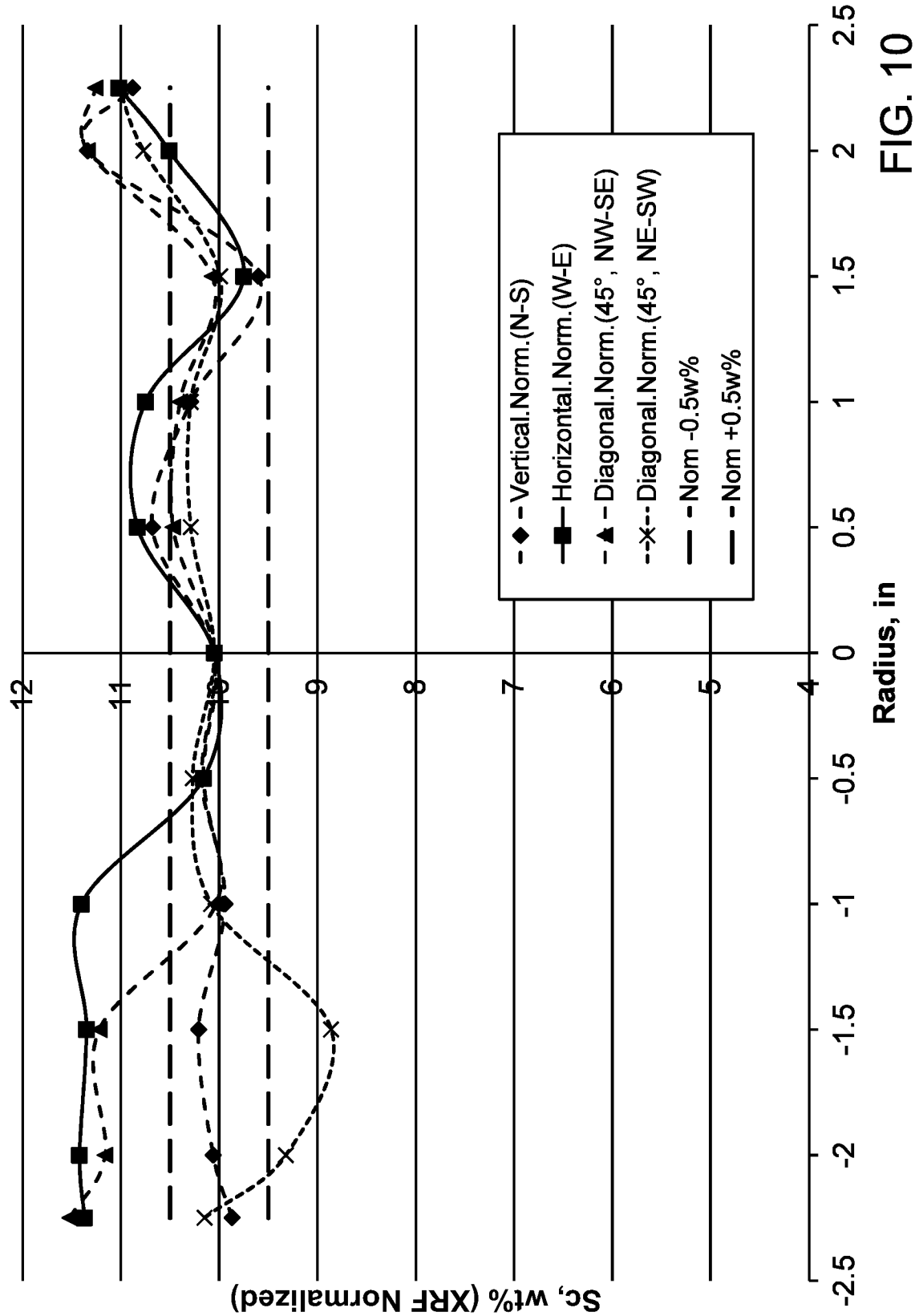


FIG. 10

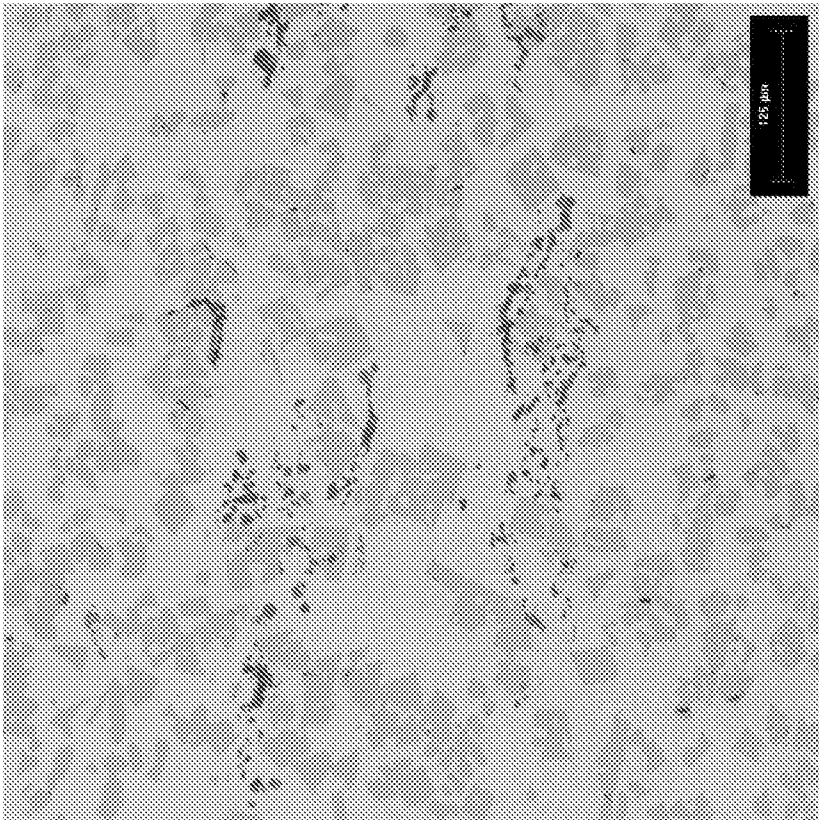


FIG. 12

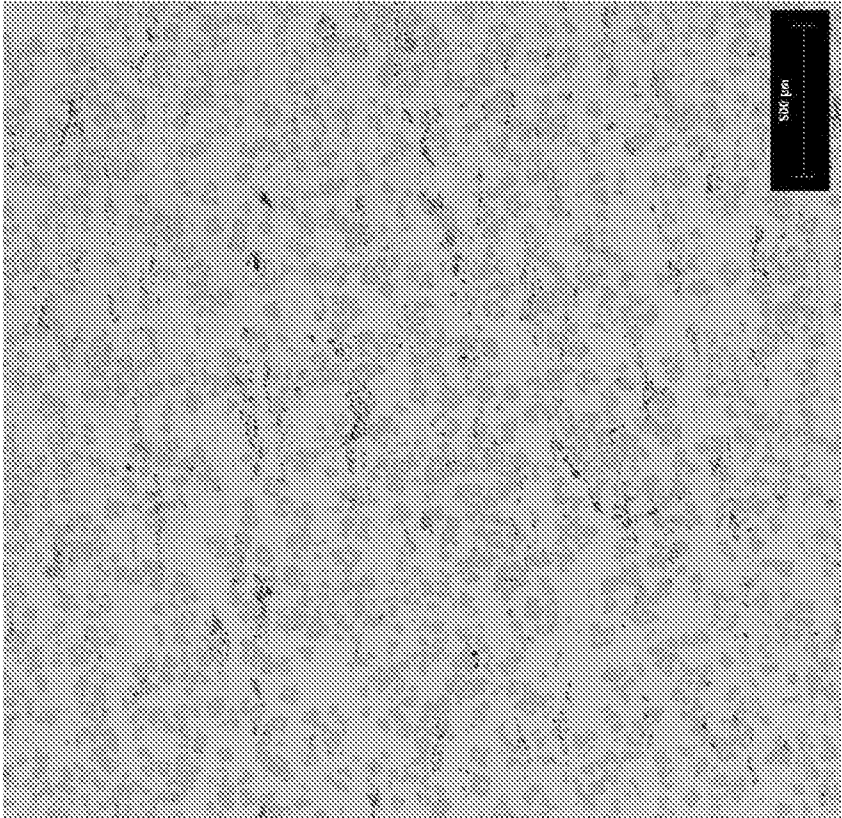


FIG. 11

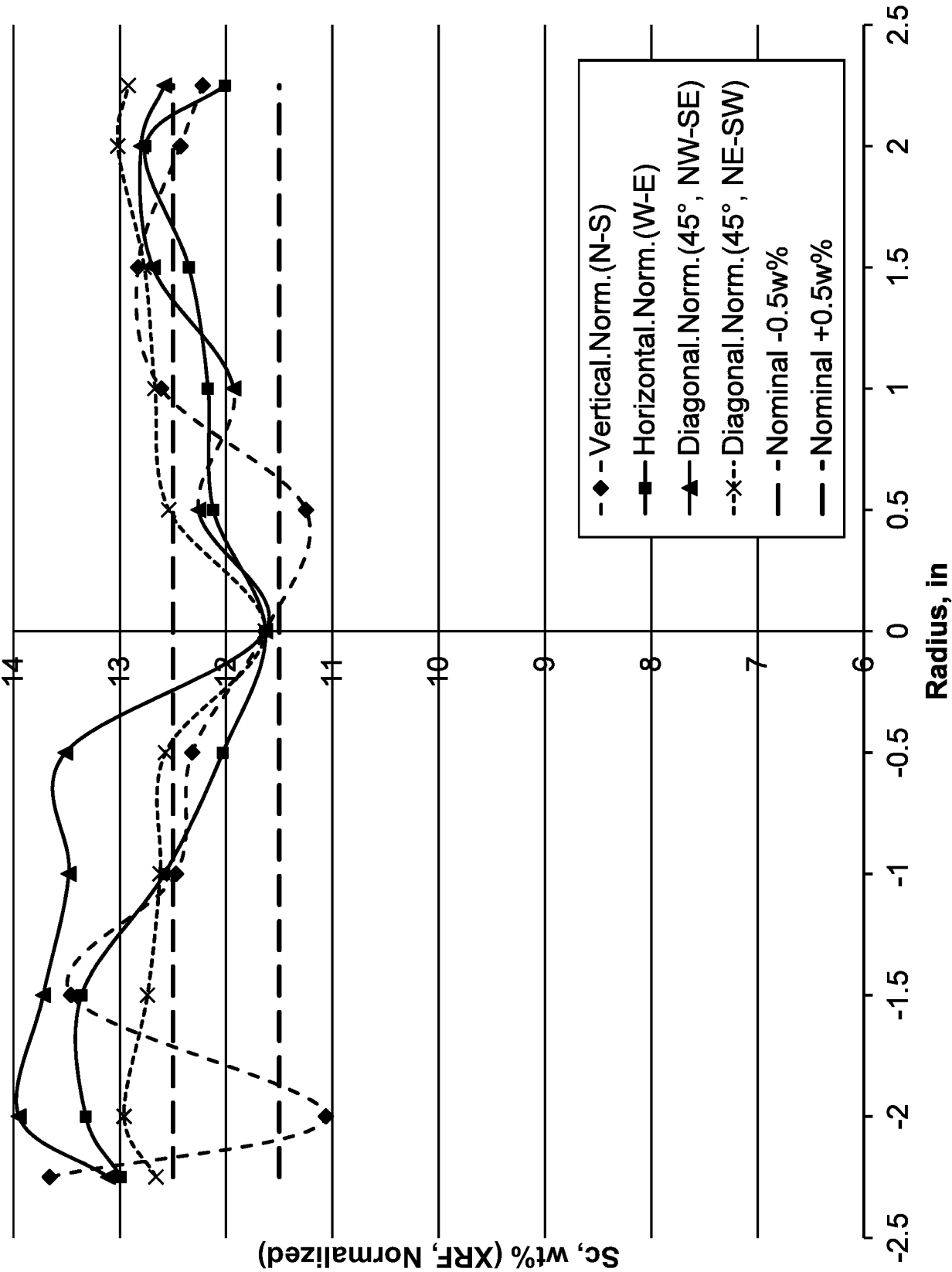


FIG. 13

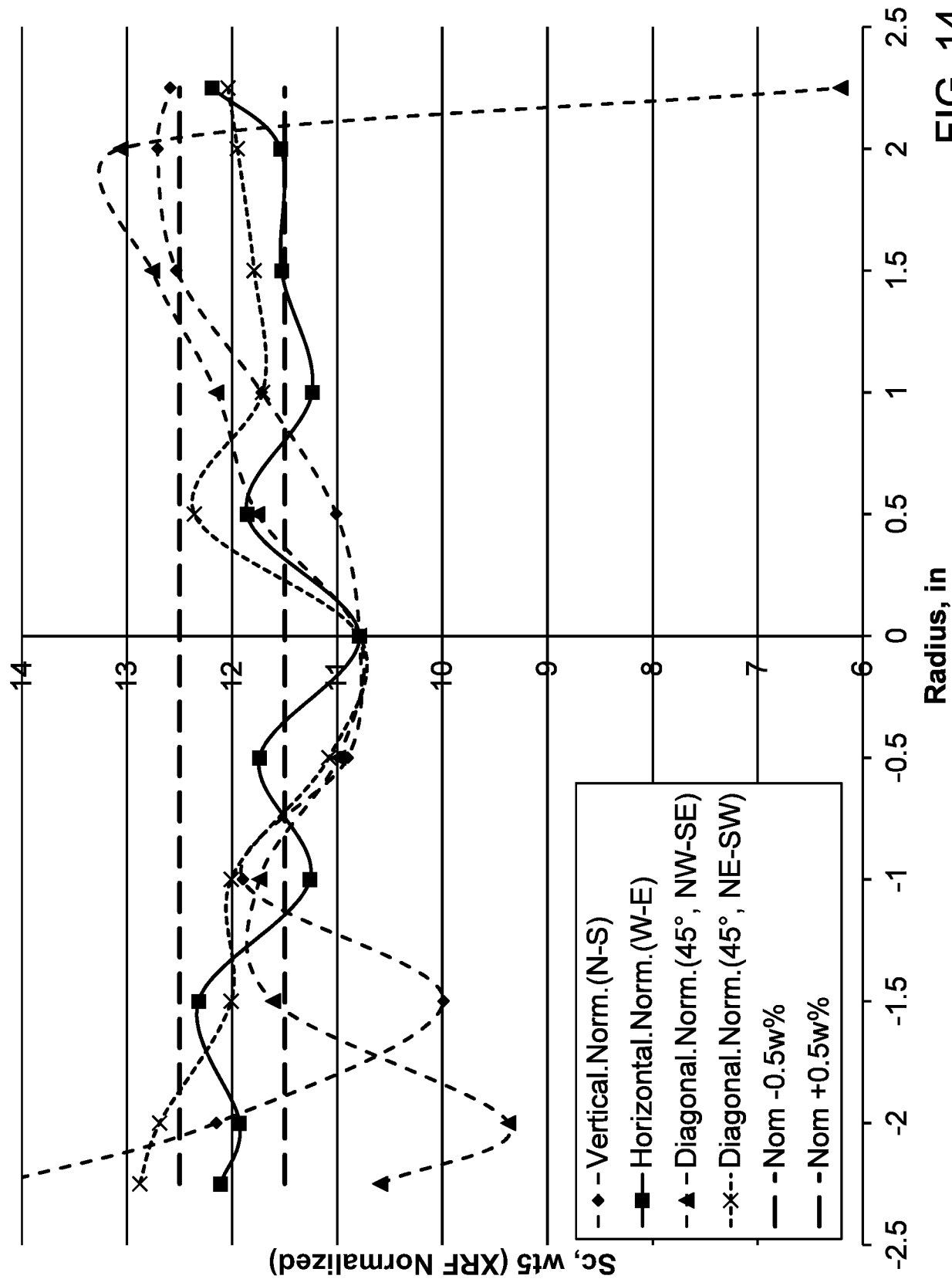


FIG. 14

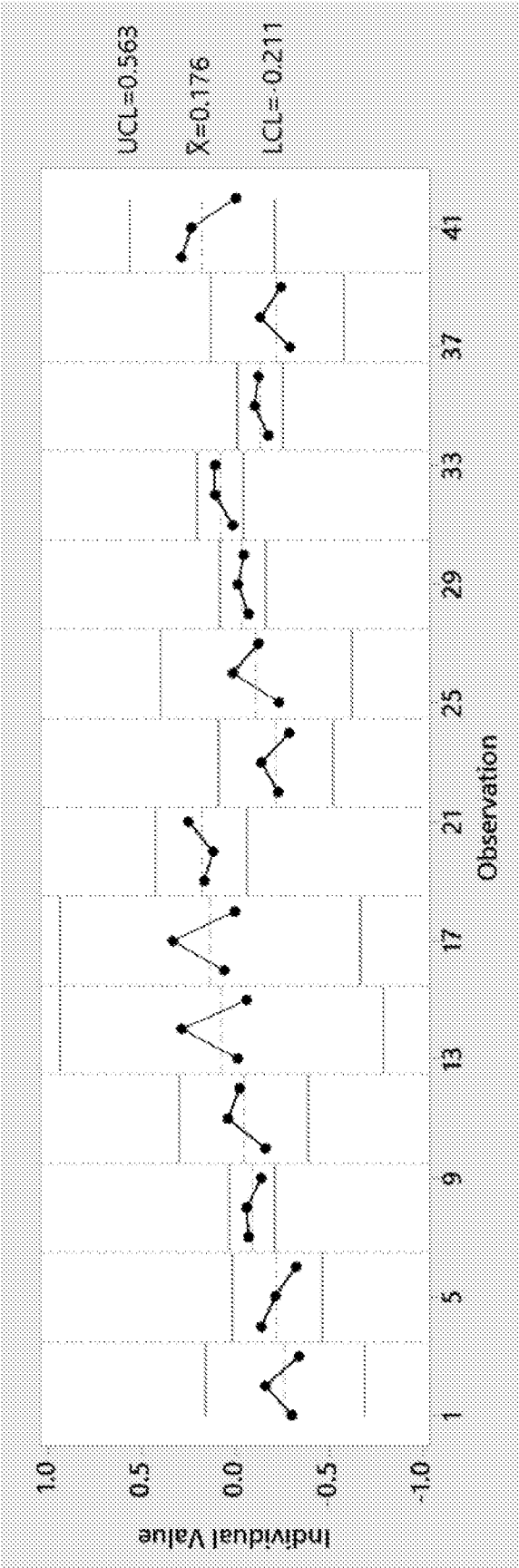


FIG. 15

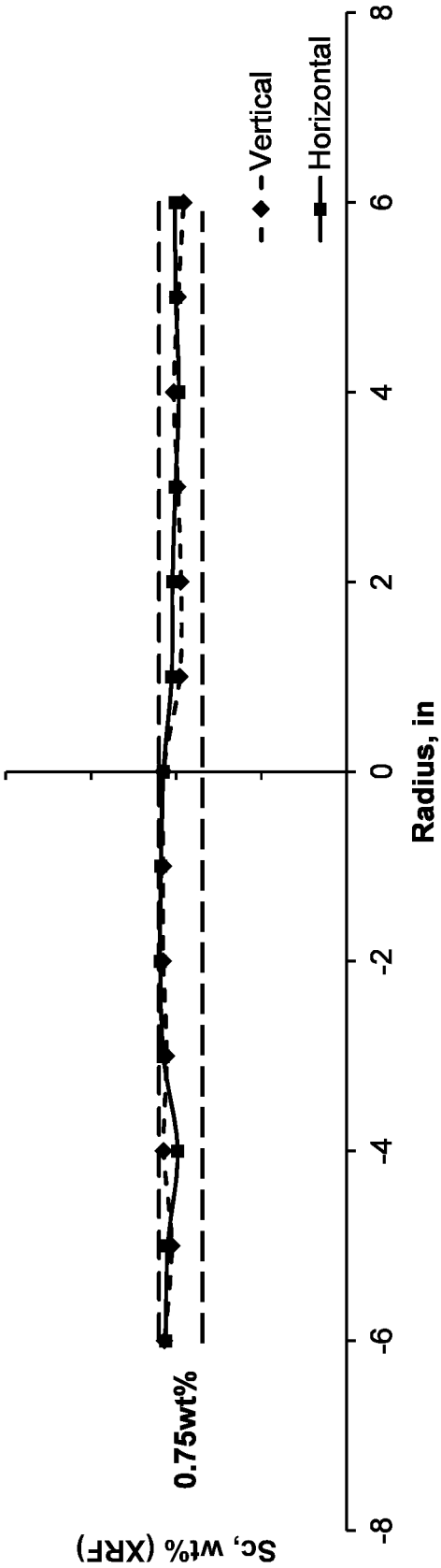


FIG. 16