

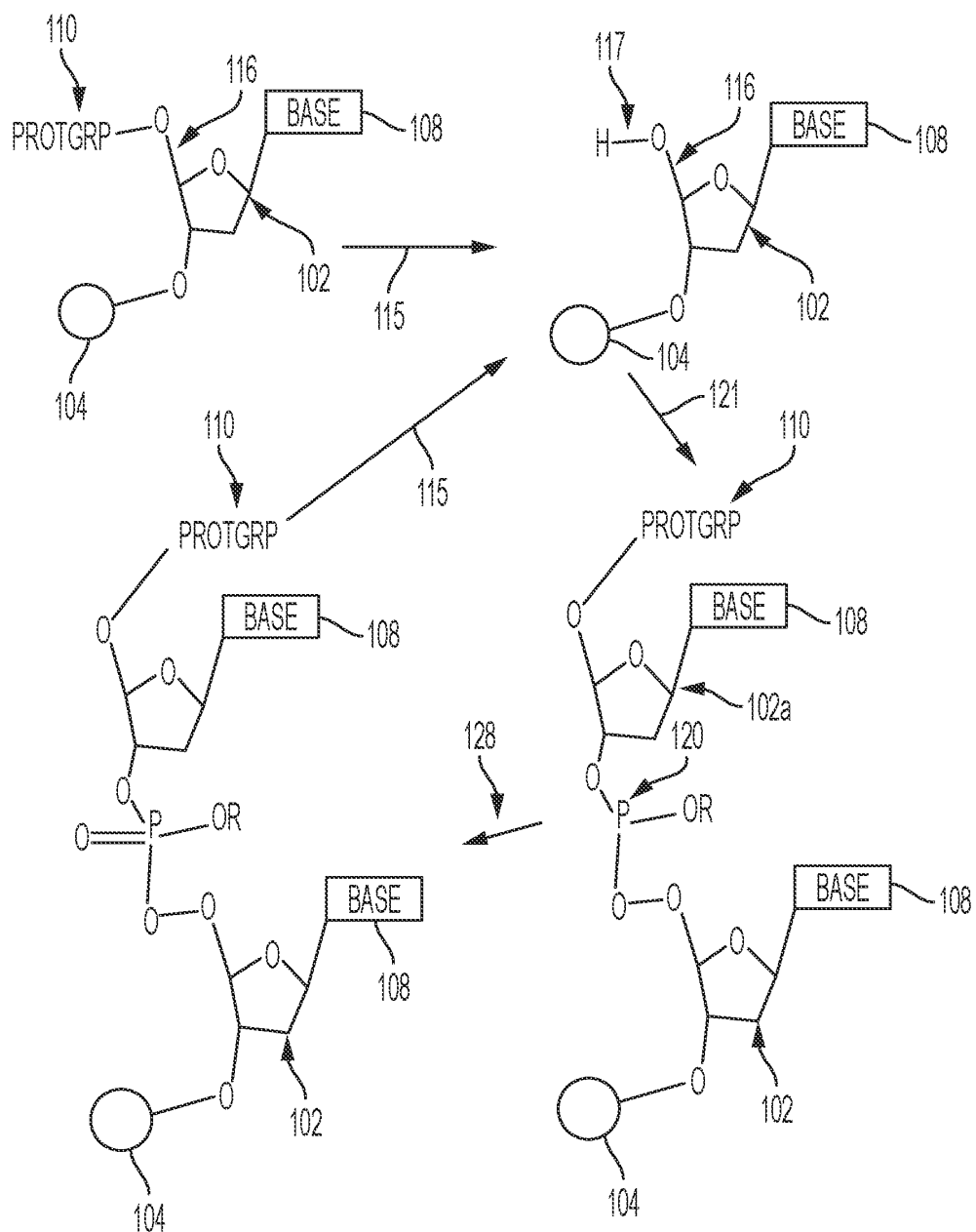


FIG. 1

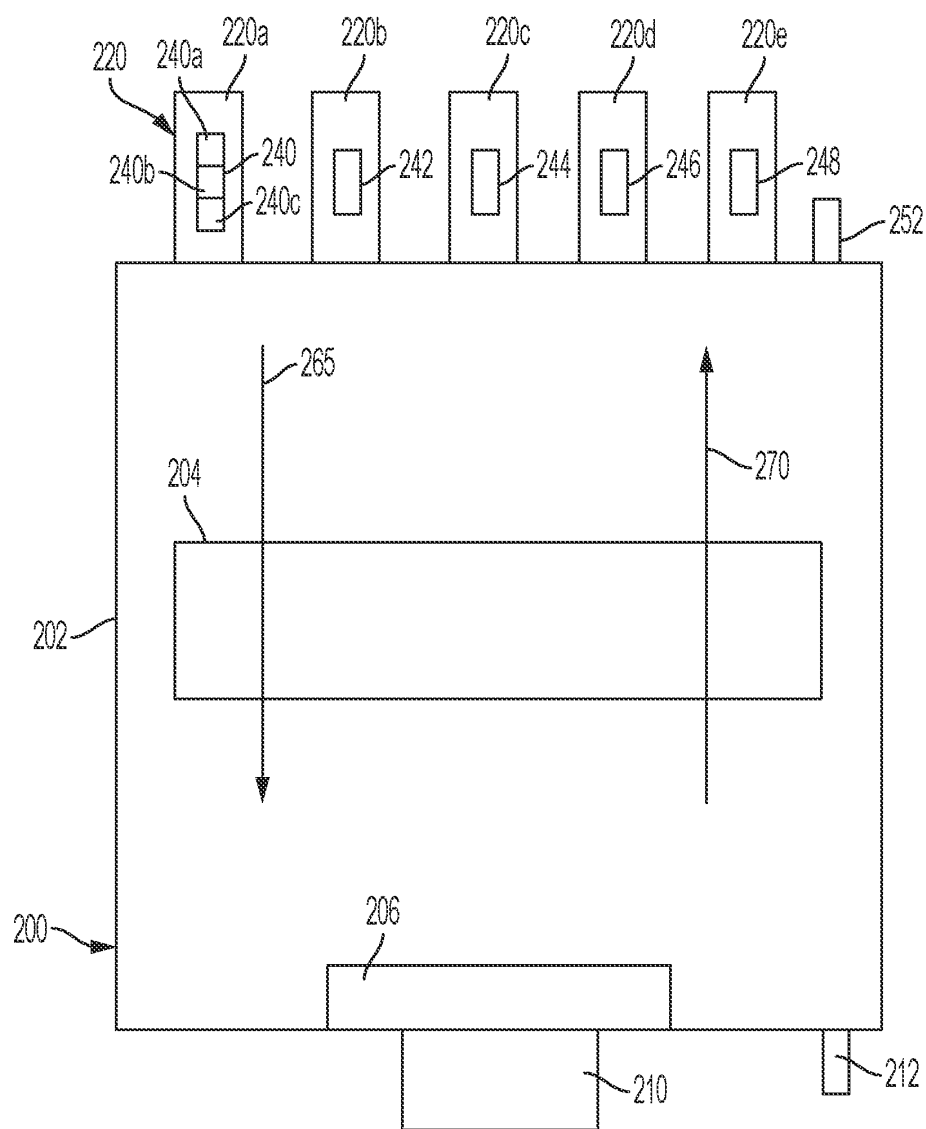


FIG. 2

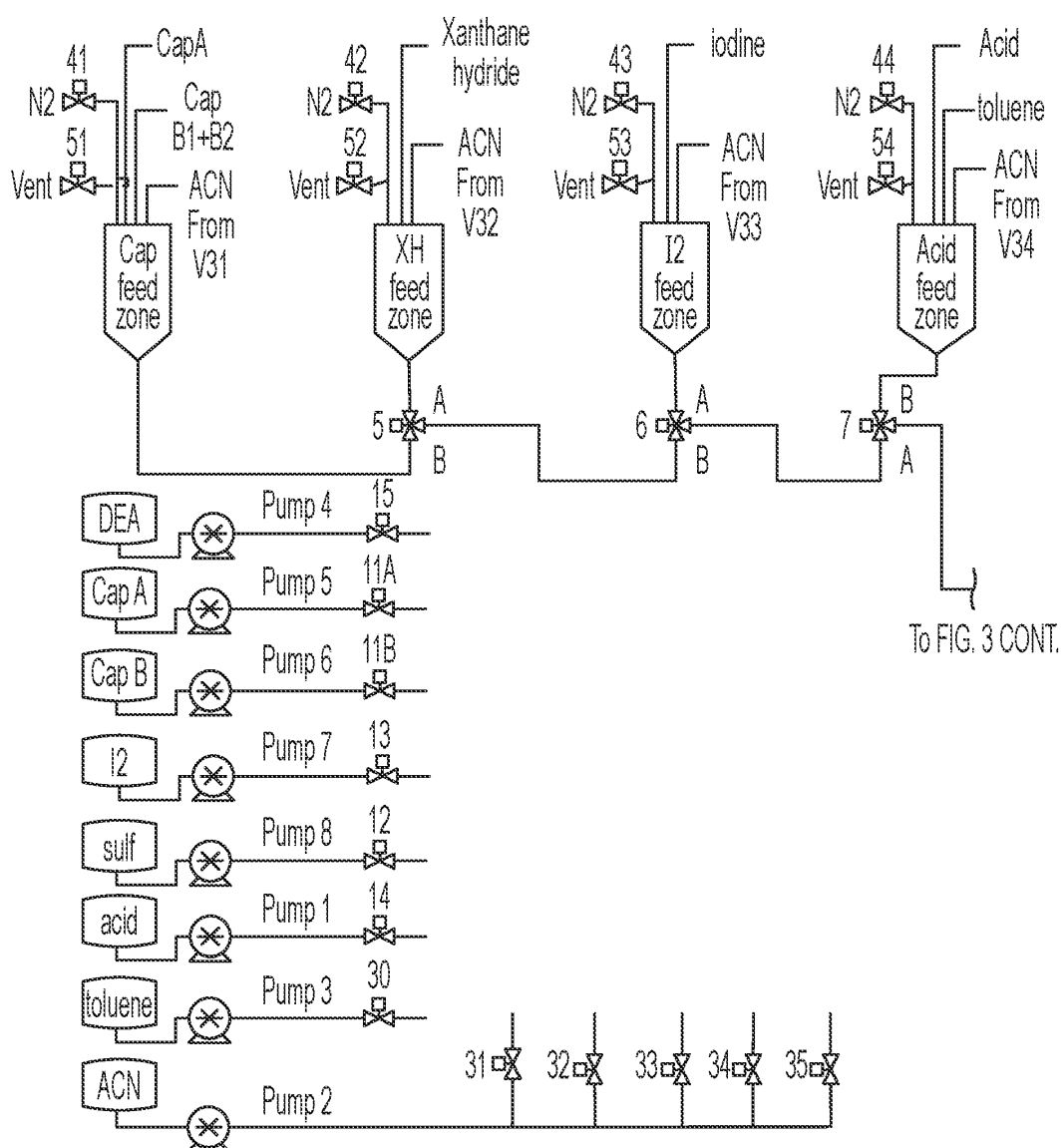


FIG. 3

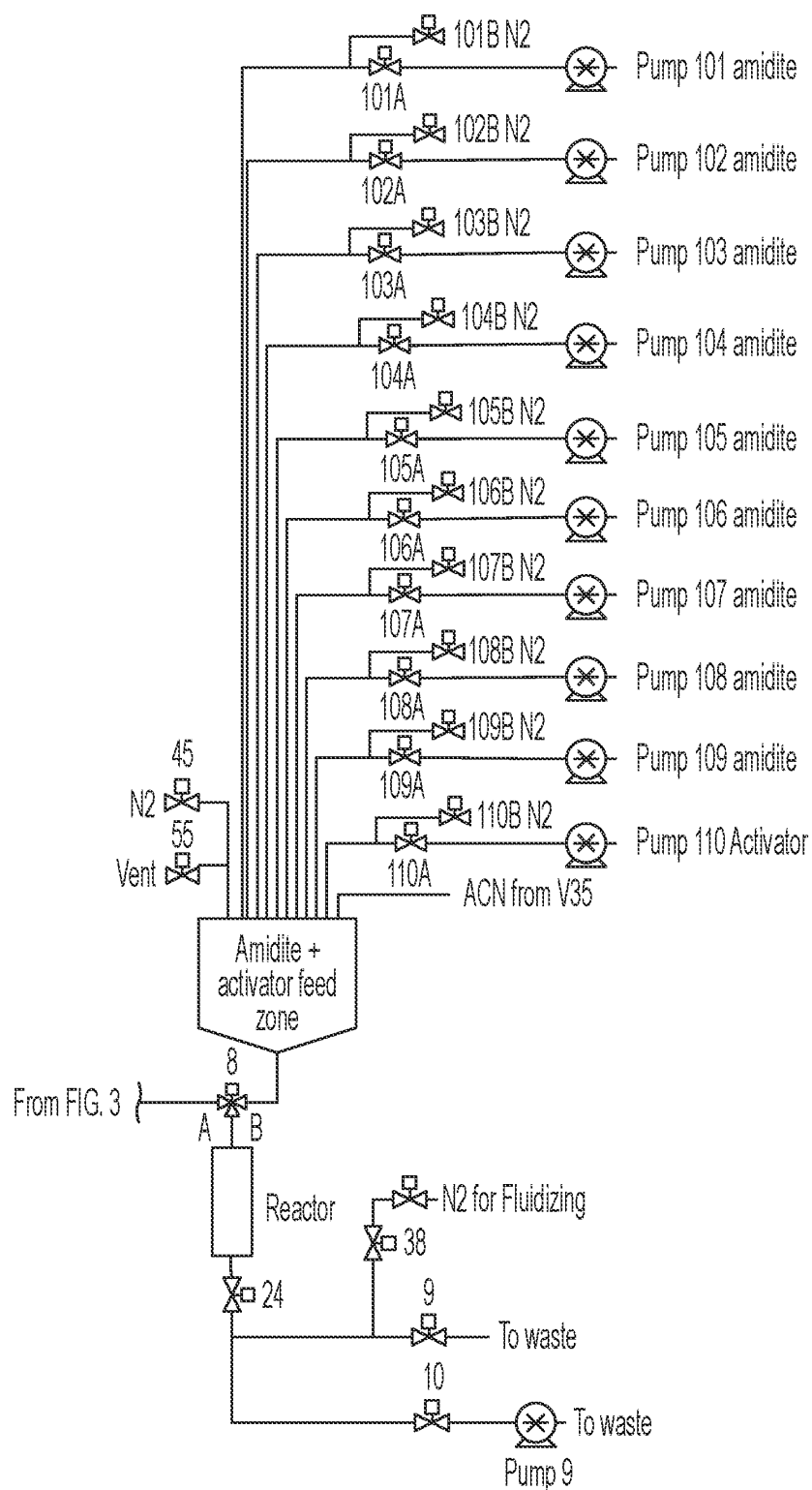


FIG. 3 CONT.

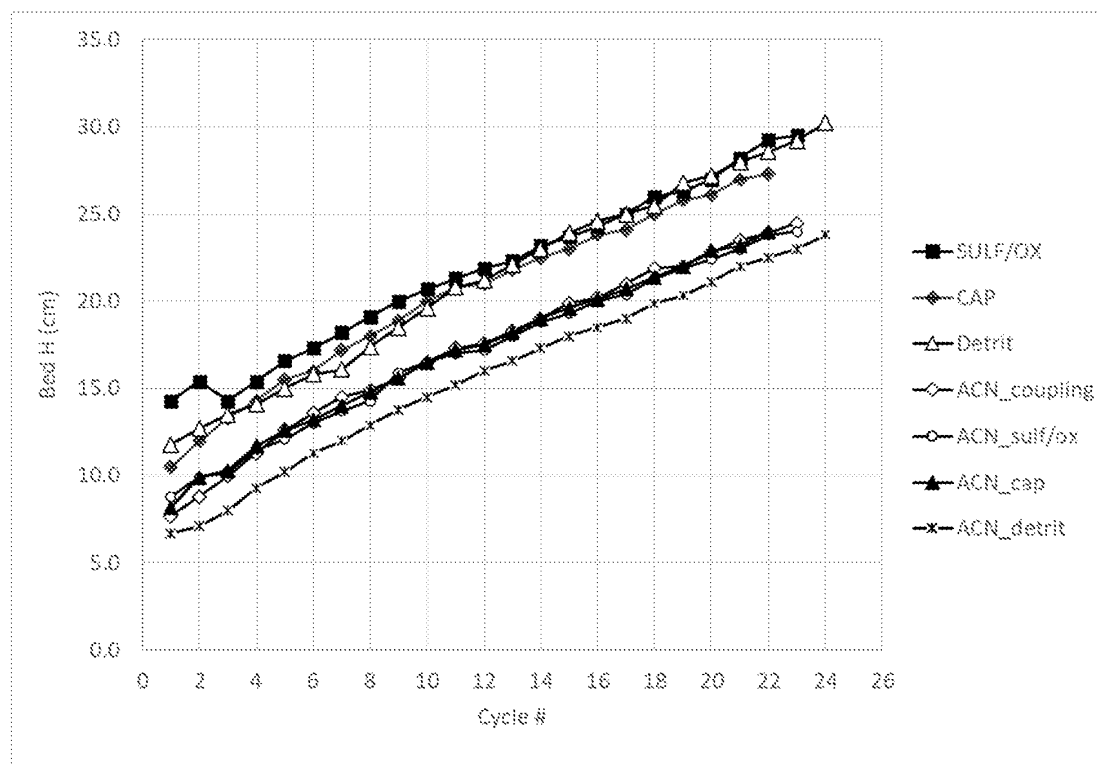


FIGURE 4

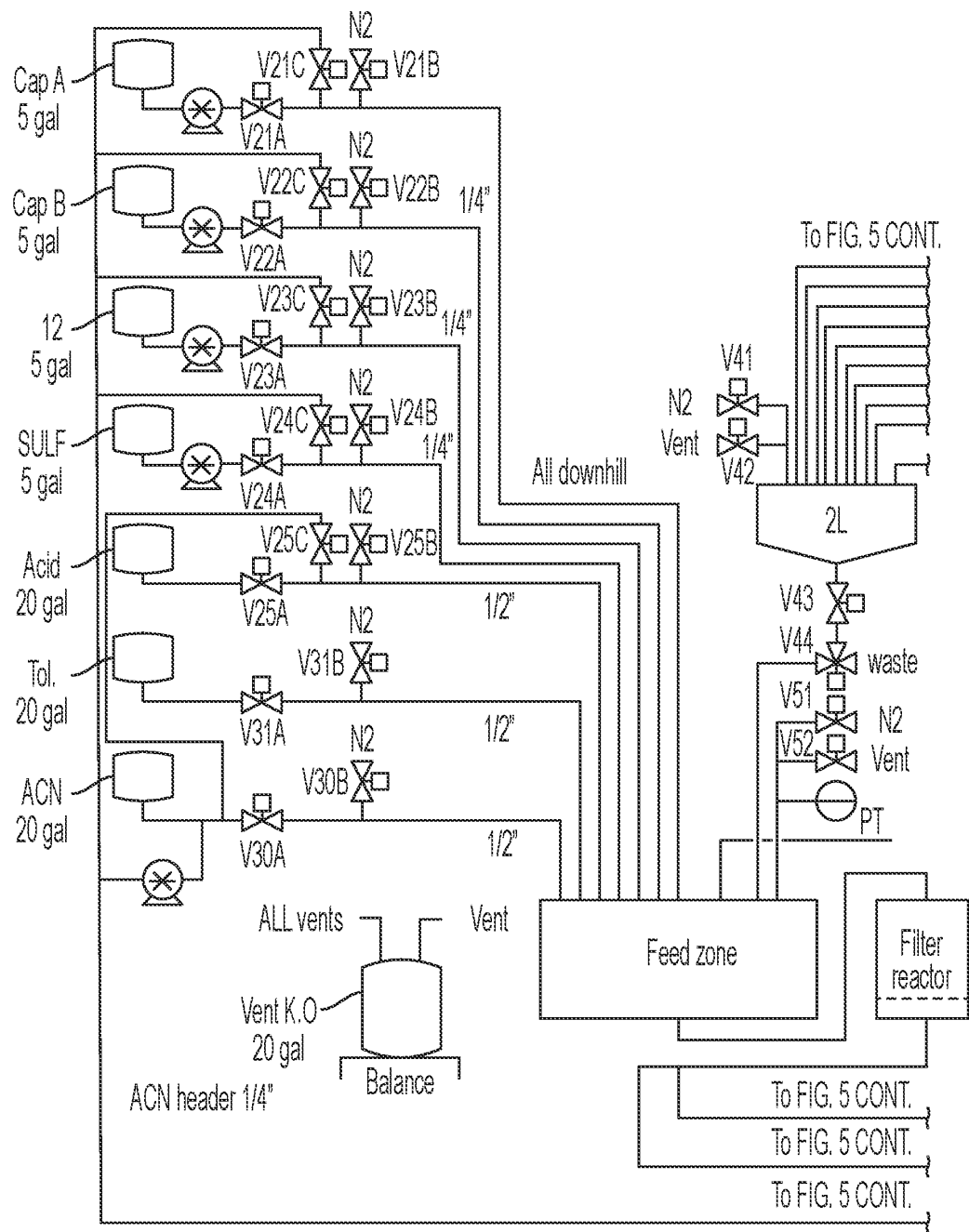
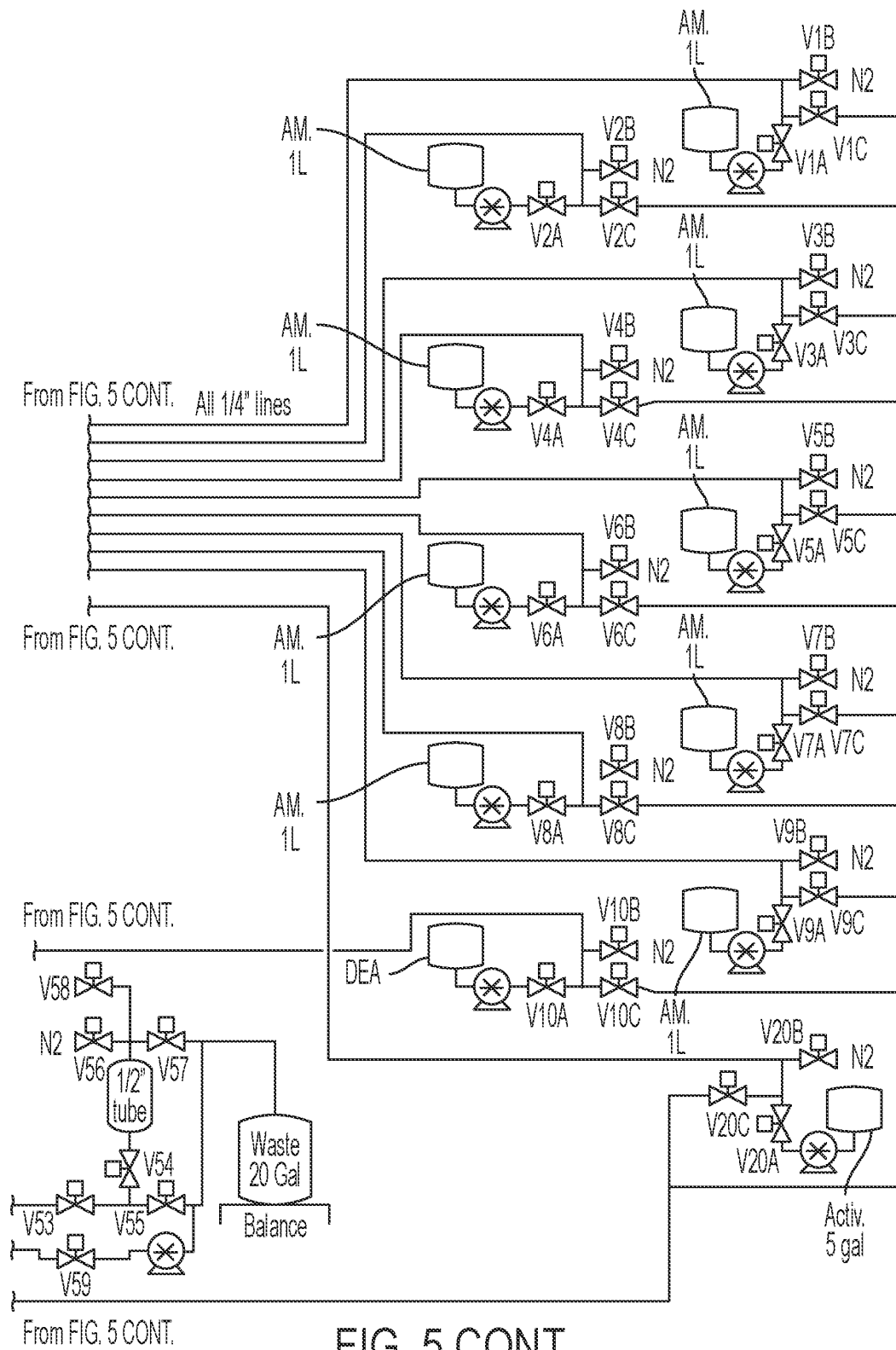


FIG. 5



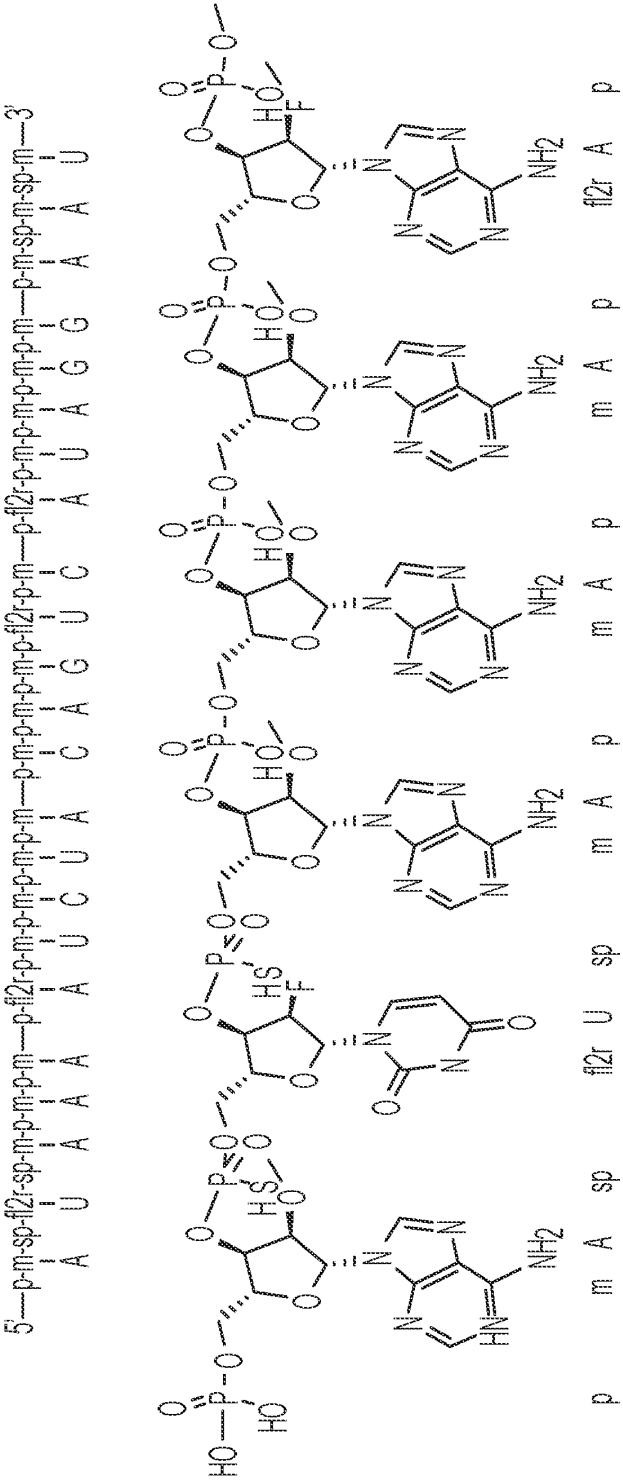
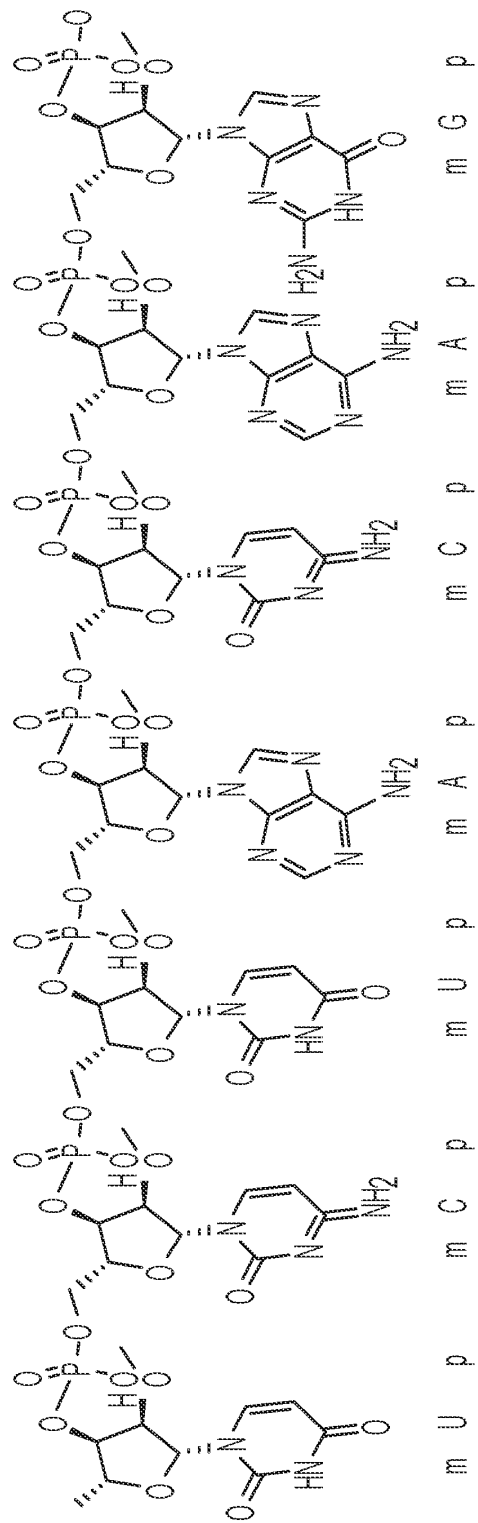


FIG. 6



Exact Mass: 7762.19488

FIG. 6 CONT.

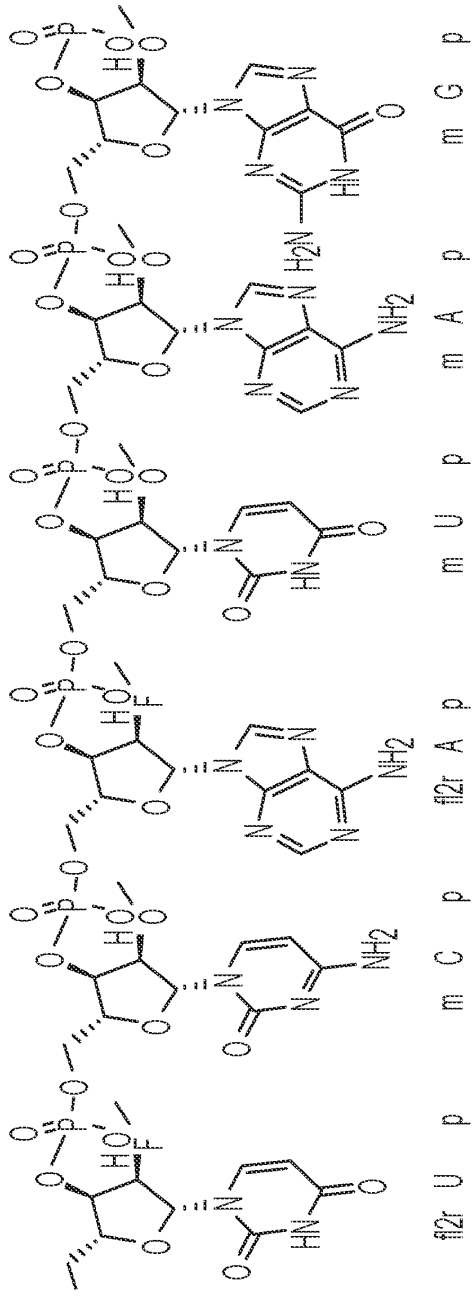


FIG. 6 CONT.

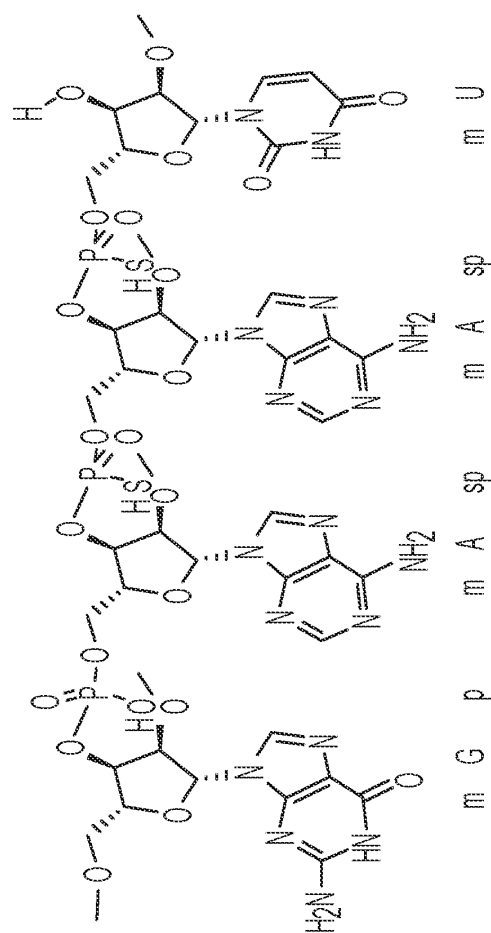
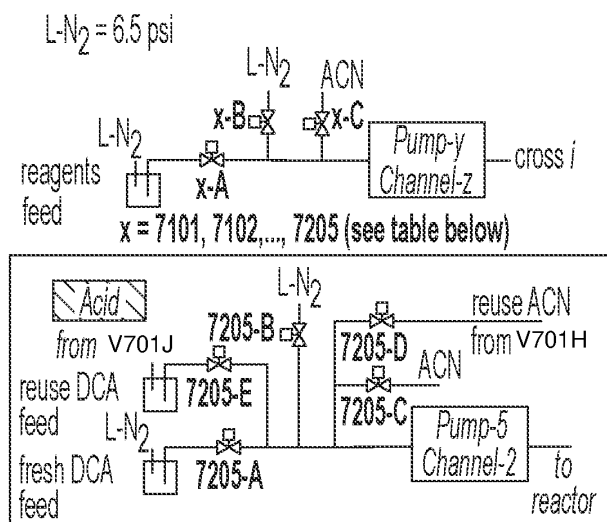


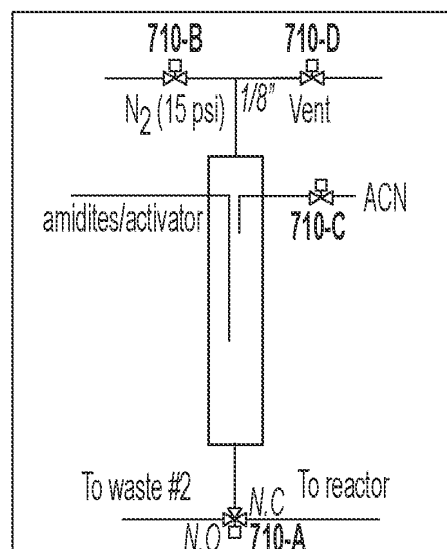
FIG. 6 CONT.

Cart 314 with ACID reuse...

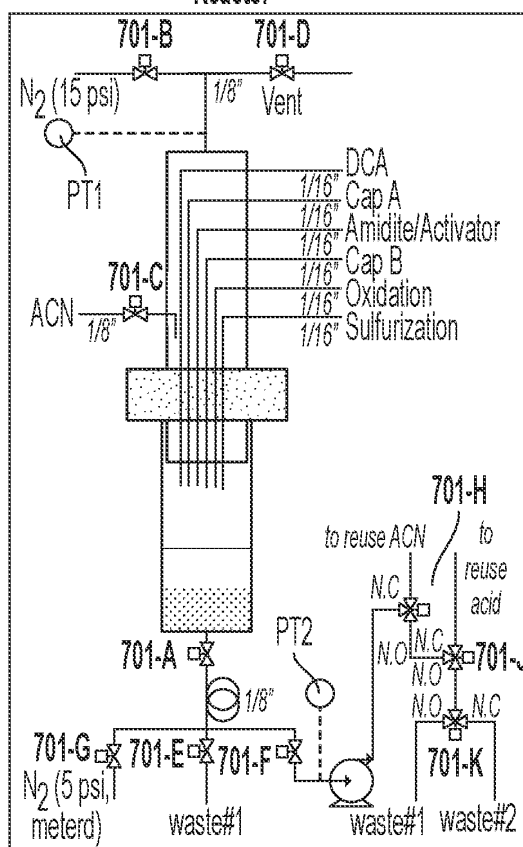
Reagents delivery



Amidite/Activator mixing zone



Reactor



from cross #1

x = 7101, 7102, 7103

from cross #2

x = 7104, 7105, 7106

from cross #3

x = 7107, 7108, 7110

to amidite/activator zone

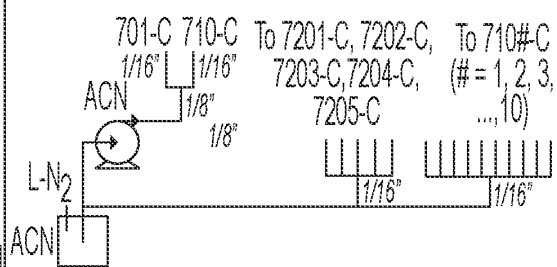


FIG. 7

Feed	x (feed num)	y (pump num)	z (channel num)	Tubing size OD
AM1	7101	P1	1	1/16"
AM2	7102	P1	2	1/16"
AM3	7103	P1	3	1/16"
AM4	7104	P2	1	1/16"
AM5	7105	P2	2	1/16"
AM6	7106	P2	3	1/16"
AM7	7107	P3	1	1/16"
AM8	7108	P3	2	1/16"
ACT	7110	P3	3	1/16"
Cap A	7201	P4	1	1/16"
Cap B	7202	P4	2	1/16"
OX	7203	P4	3	1/16"
SULF	7204	P5	1	1/16"
DCA	7205	P5	2	1/16"
ACN		P6	1	1/16"
WASTE		P7	1	1/16"

x (feed num)	il (cross num)	Tubing size OD
7101	1	1/16"
7102	1	1/16"
7103	1	1/16"
7104	2	1/16"
7105	2	1/16"
7106	2	1/16"
7107	3	1/16"
7108	3	1/16"
7110	3	1/16"

FIG. 7 CONT.

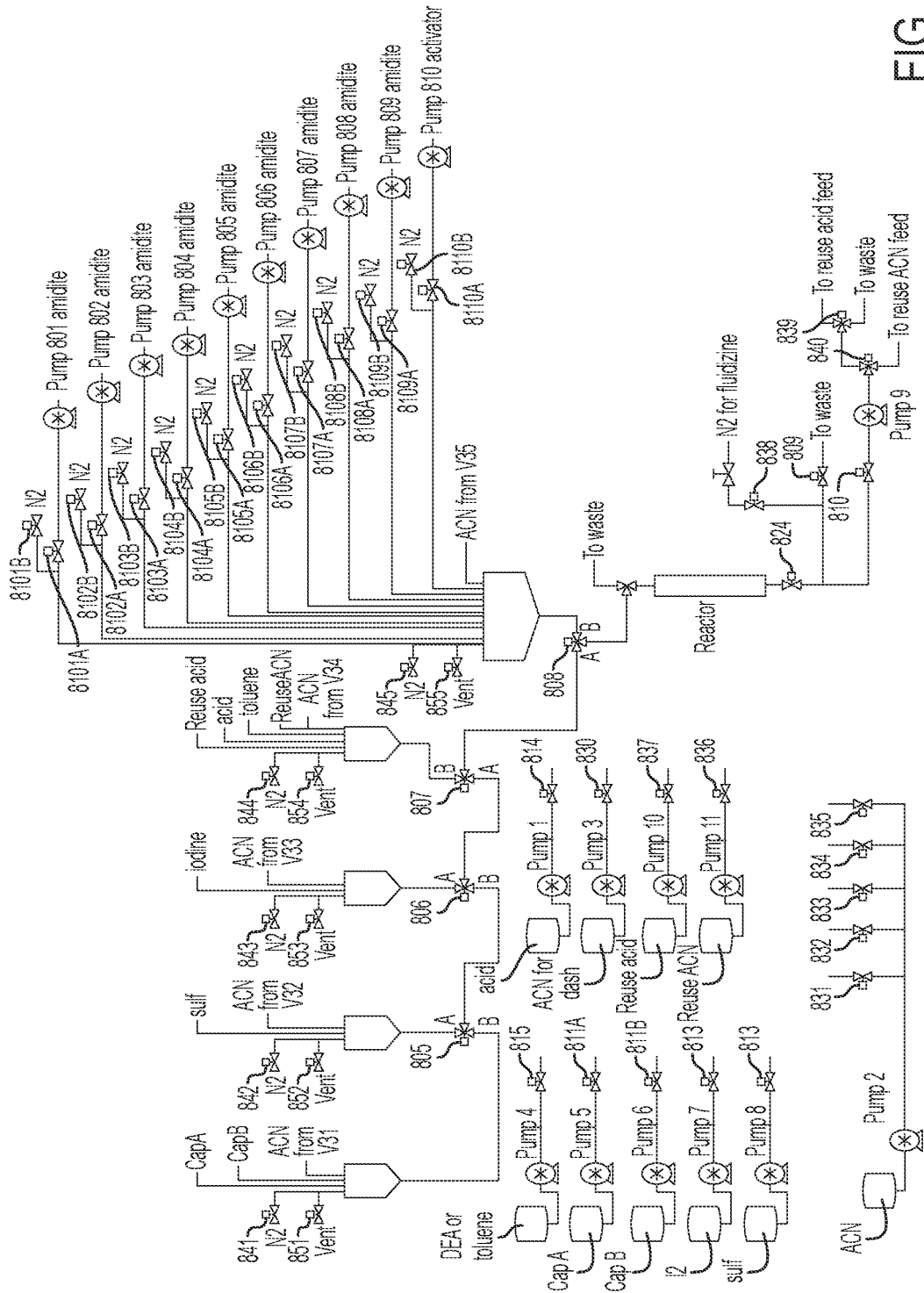


FIG. 8

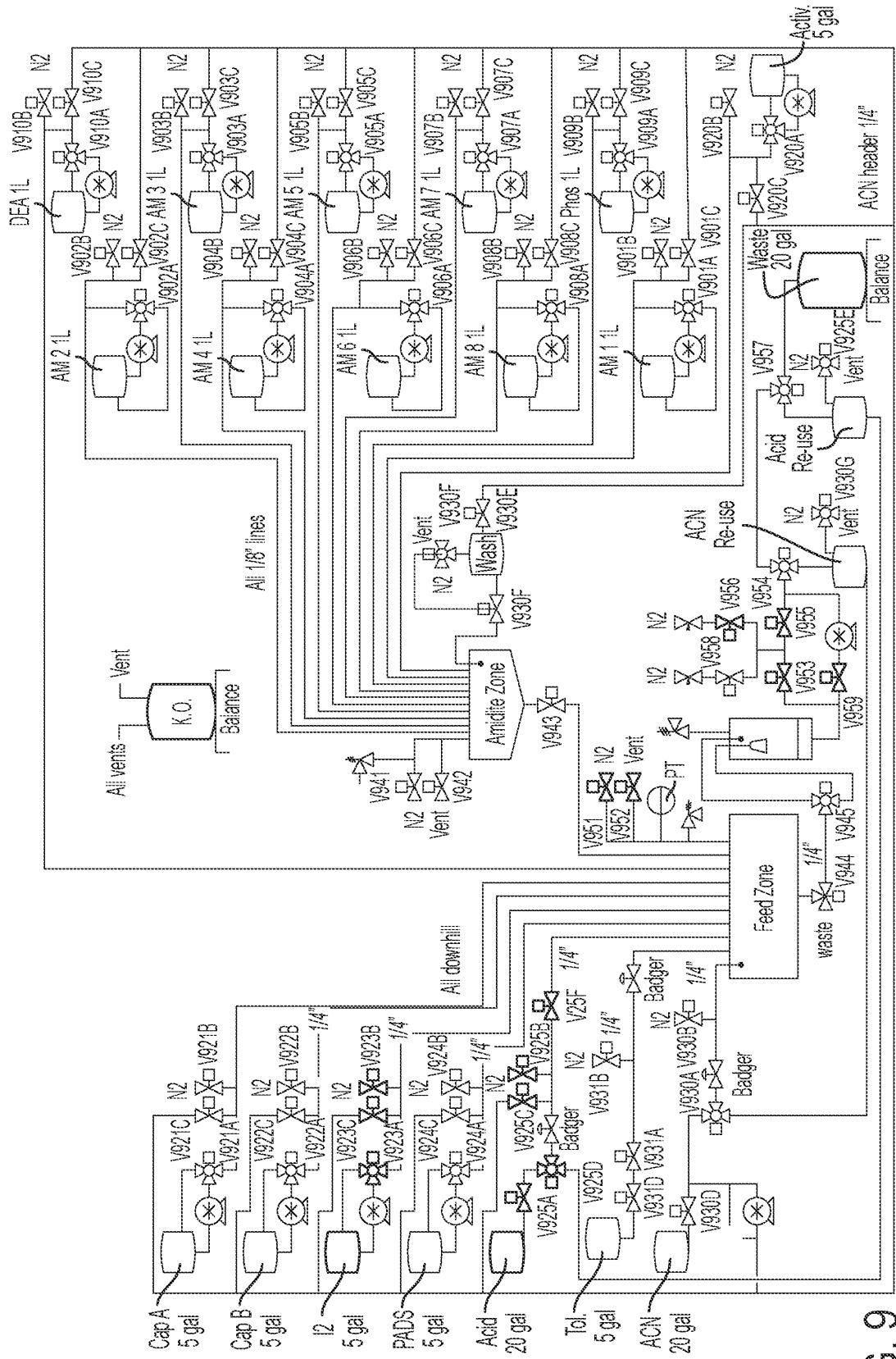
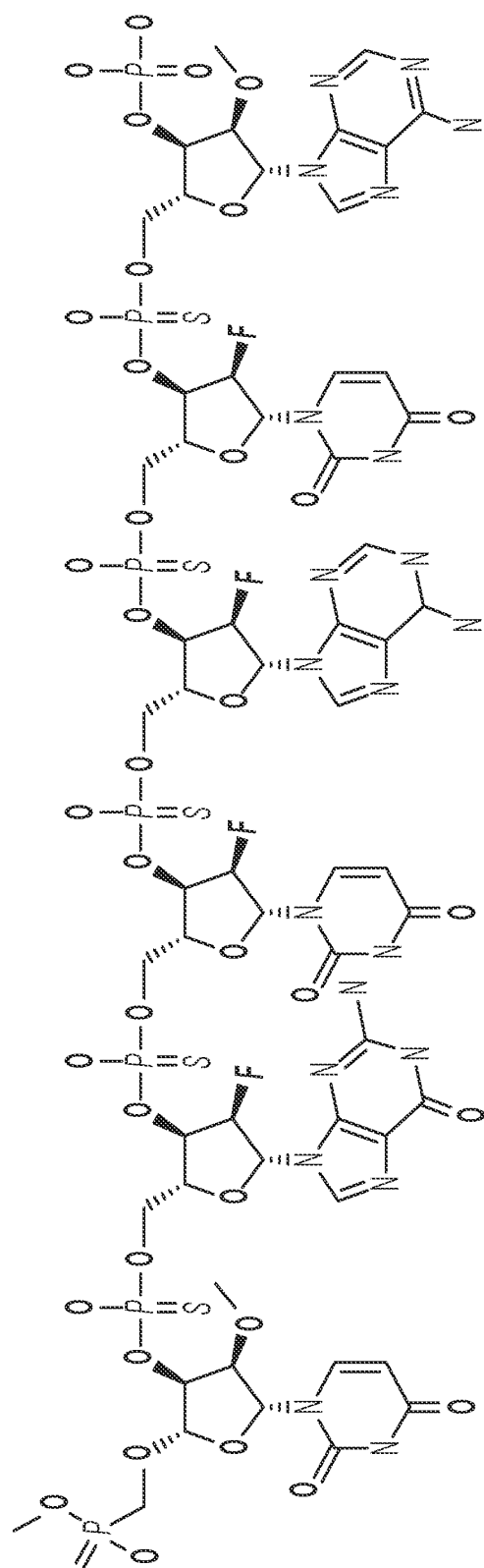


FIG. 9



10
11

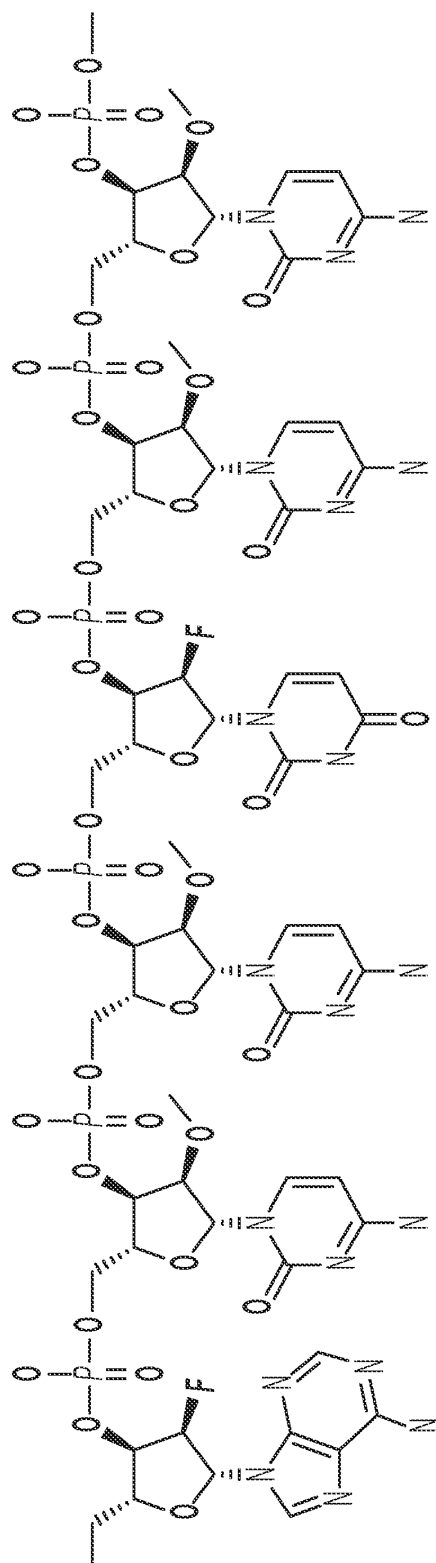


FIG. 10 CONT.

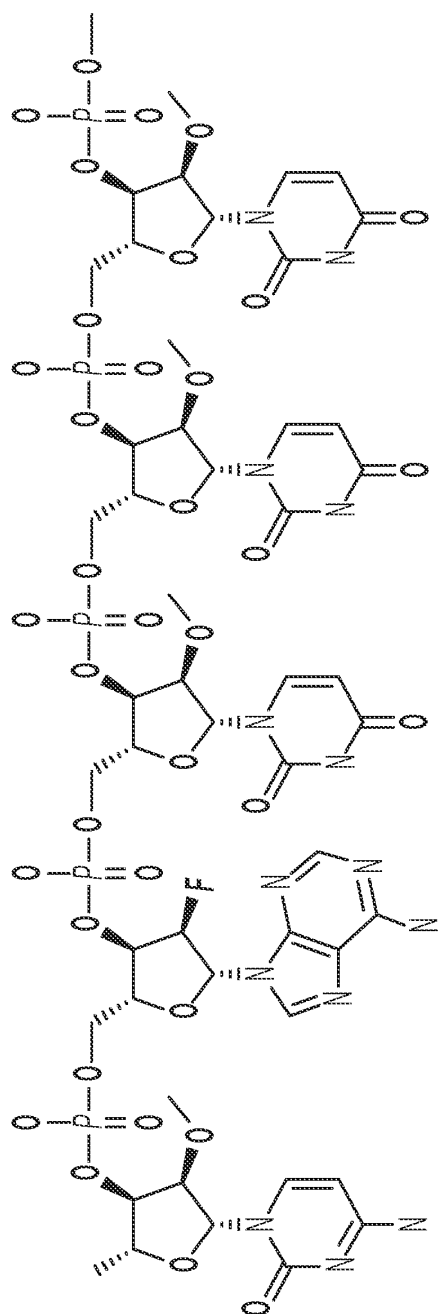


FIG. 10 CONT.

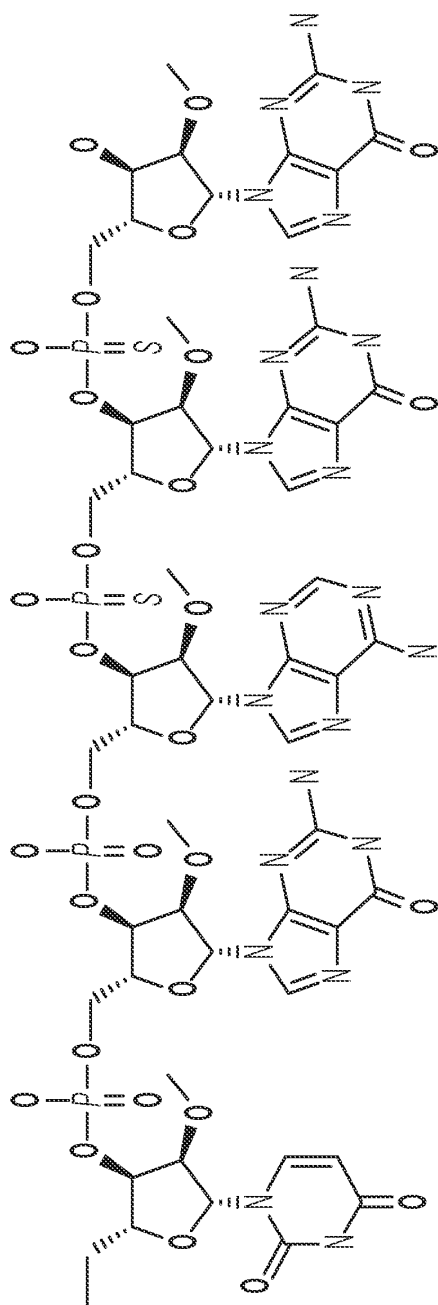


FIG. 10 CONT.

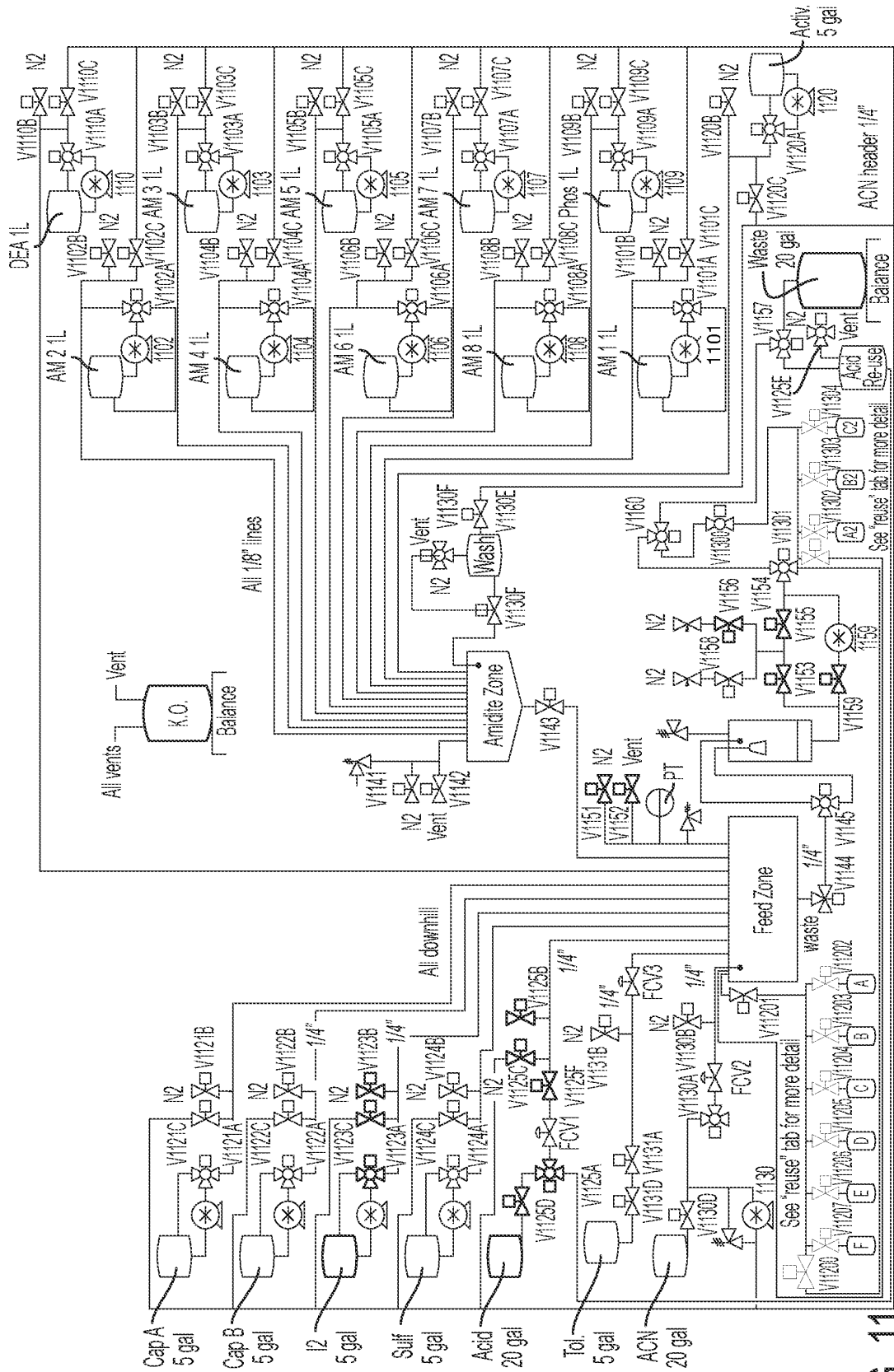


FIG. 11

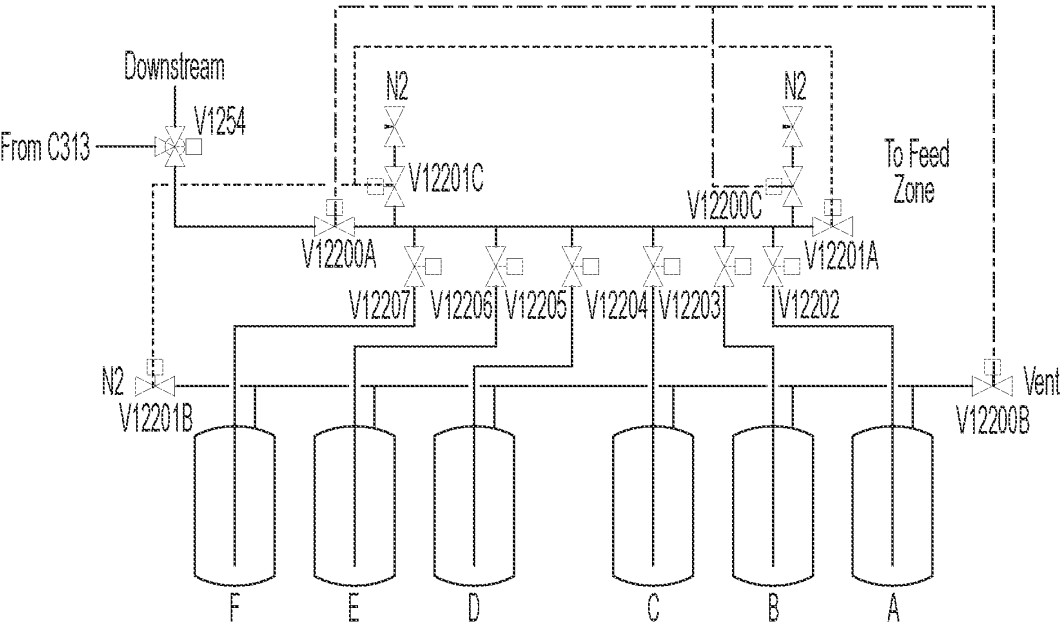


FIG. 12

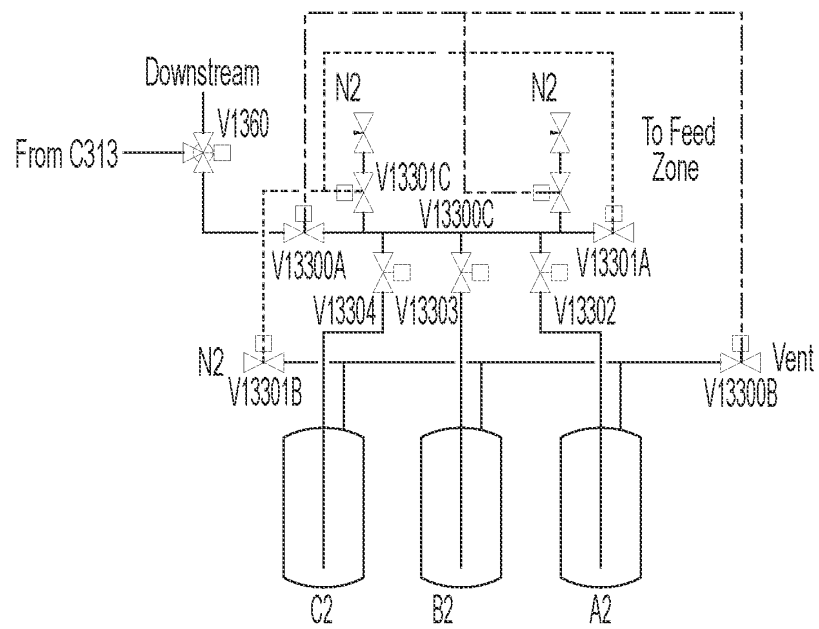


FIG. 13

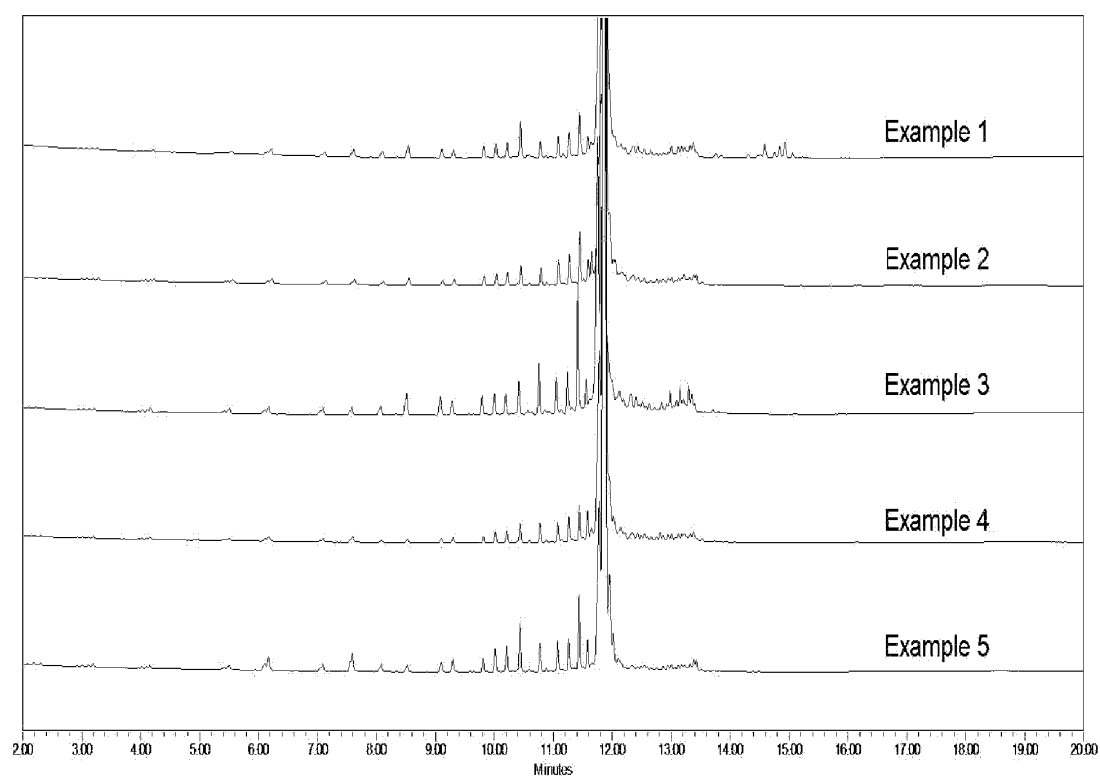
**FIGURE 14**

Figure 14. UPLC chromatogram overlays for examples 1-5, as listed in **Error! Reference source not found..**

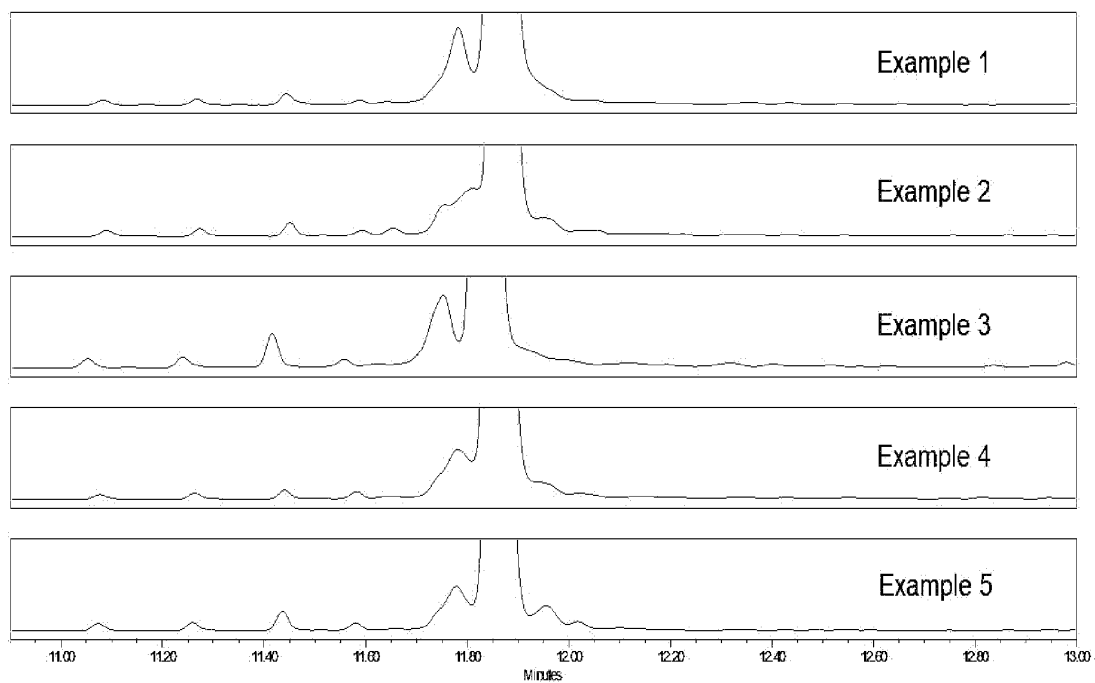


FIGURE 15

Figure 15. UPLC chromatograms for examples 1-5, as listed in **Error! Reference source not found.**, zoomed in around the main peak.

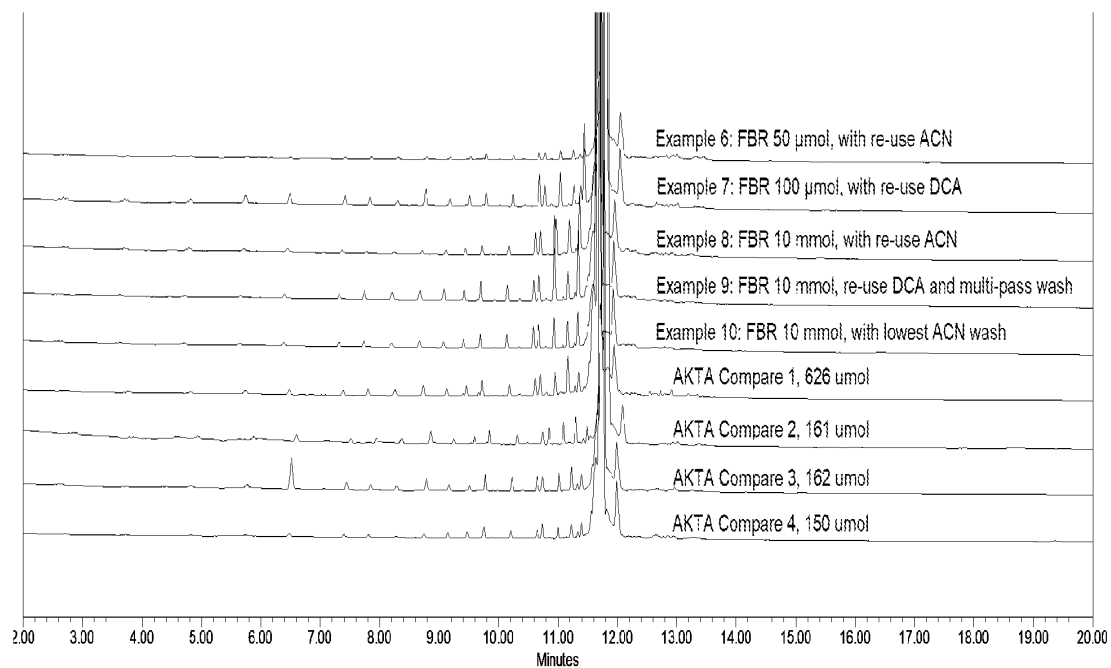


FIGURE 16

Figure 16. UPLC chromatogram overlays for examples 6-10, and "AKTA compare" 1-4, as listed in **Error!**
Reference source not found..

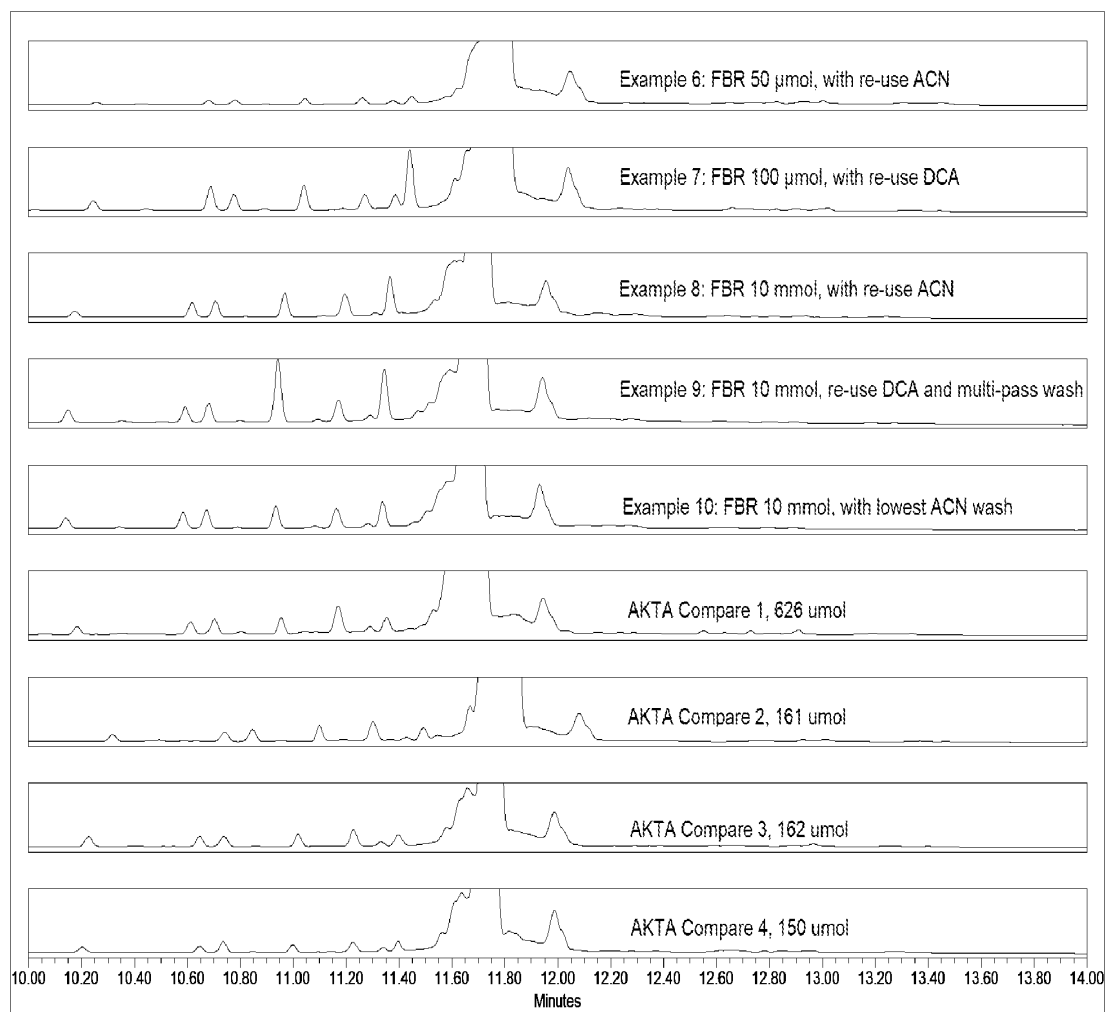
**FIGURE 17**

Figure 17. UPLC chromatograms for examples 6-10, and "AKTA compare" 1-4, as listed in **Error!**

Reference source not found., zoomed in around the main peak.