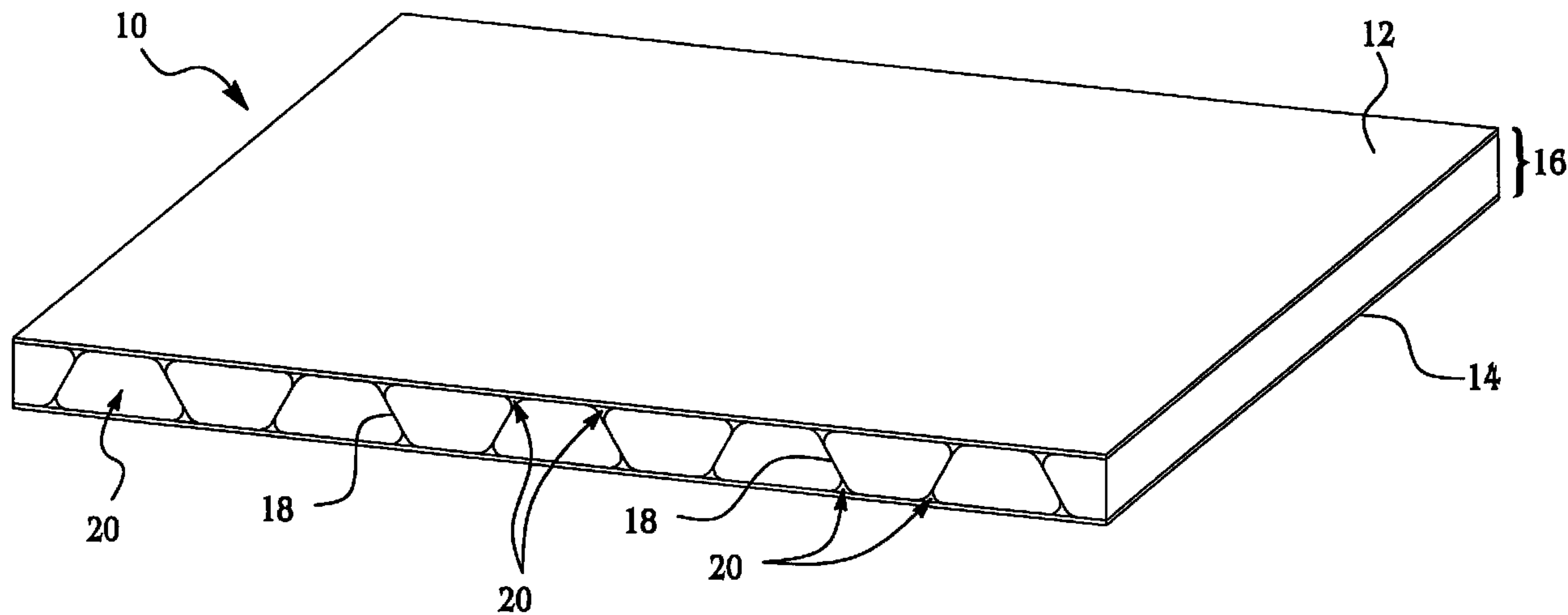




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(54) Titre : STRUCTURE COMPOSITE DE MATRICE CERAMIQUE POURVUE D'UN NOYAU STRIE ET PROCEDE DE FABRICATION
 (54) Title: CERAMIC MATRIX COMPOSITE STRUCTURE HAVING FLUTED CORE AND METHOD OF MAKING THE SAME



(57) Abrégé/Abstract:

A ceramic matrix composite structure includes a load carrying fluted core formed from a ceramic matrix composite. The fluted core includes a plurality of nested flute members laminated between a pair of ceramic matrix composite facesheets. The flute members are fabricated by wrapping ceramic resin fabric around a mandrel, curing the flute members and then removing the mandrels. The structure may include reinforced areas in which the facesheets are laminated directly together to receive fasteners for mounting the structure. The structure may include both flat and curved portions.

ABSTRACT OF THE DISCLOSURE

A ceramic matrix composite structure includes a load carrying fluted core formed from a ceramic matrix composite. The fluted core includes a plurality of nested flute members laminated between a pair of ceramic matrix composite facesheets. The flute members are fabricated by wrapping ceramic resin fabric around a mandrel, curing the flute members and then removing the mandrels. The structure may include reinforced areas in which the facesheets are laminated directly together to receive fasteners for mounting the structure. The structure may include both flat and curved portions.

CERAMIC MATRIX COMPOSITE STRUCTURE HAVING
FLUTED CORE AND METHOD FOR MAKING THE SAME

Technical Field

[001] This disclosure generally relates to ceramic matrix composite structures, and deals more particularly with a sandwich construction having a load-carrying fluted core, as well as a method for making the structure.

Background

[002] Ceramic matrix composite (CMC) structures are often used in aerospace and other applications because of their ability to withstand relatively high operating temperatures. For example, CMC structures may be used to fabricate parts subjected to high temperature exhaust gases in aircraft applications. Various CMC's have been employed to fabricate either monocoque structures or structures that employ a combination of tile and/or foam sandwich constructions, but neither of these types of structures may be well suited for carrying loads. In the case of CMC monocoques, the materials must be relatively thick in order for the structure to carry a load, but the additional material thickness adds weight to the aircraft. CMC tile/foam sandwich materials have not been

widely used in load carrying applications, in part because of their relatively weak core materials.

[003] Accordingly, there is a need for a CMC structure that is relatively light weight, but yet has sufficient structural strength to be self-supporting and capable of carrying loads. It would also be desirable to provide a CMC structure that may be formed into various shapes, including those possessing curvature. Additionally, it would be desirable to provide a simple, cost effective method of fabricating these CMC structures. Embodiments of the disclosure are intended to satisfy these needs.

SUMMARY

[004] Embodiments of the disclosure provide a CMC sandwich construction that allows fabrication of structures having various geometries, including curved surfaces and reinforced features that allow the structures to be mounted using the fasteners. The disclosed embodiments employ a CMC sandwich incorporating a fluted core formed of a CMC that strengthens the structure and allows it to carry loads. The CMC fluted core structure may be fabricated using commercially available materials and well known polymer layup techniques to produce a wide variety of parts, components and assemblies, especially those used in the aircraft industry.

[005] According to one disclosed embodiment, a ceramic matrix composite structure is provided, comprising a pair of spaced apart, CMC facesheets, and a load carrying core between at least a portion of the facesheets, wherein the core includes CMC flute members. The flute members may form a closed cell that may or may not be filled with any of a variety of high temperature materials. The flute members may be formed of ceramic matrix composite material having a wall cross section in the shape of an isosceles trapezoid, or other geometric shape. The flute members are arranged in side-by-side, nested relationship between the CMC facesheets.

[006] According to another embodiment, a CMC sandwich is provided, comprising a pair of spaced apart, CMC facesheets, and a plurality of CMC flutes between at least a portion of the facesheets for transmitting compression and shear loads between the facesheets. The facesheets may include both flat and curved sections, and the flutes may include walls conforming to the curvature of the facesheets. Portions of the facesheets may be directly laminated together to provide a reinforced structural area suitable for being pierced by mounting fasteners.

[007] Accordingly, in one aspect of the present invention there is provided a method of fabricating a ceramic matrix composite structure, comprising the steps of:

5 (A) forming a plurality of flutes using a ceramic matrix composite (CMC);

(B) placing the flutes formed in step (A) between a pair of ceramic matrix composite facesheets wherein voids are filled between adjacent ones of said
10 flutes with a filler material prior to said placing between said facesheets, said voids at the intersection of adjacent contacting flutes and a respective facesheet, said filler material comprising an elongate shaped material, said elongate shape existing prior to said
15 placing between said facesheets; and

(C) bonding the flutes to the facesheets.

[008] According to another aspect of the present invention there is provided a method of fabricating a ceramic matrix composite sandwich structure for use in
20 aerospace structures, comprising the steps of:

(A) forming a load bearing structural core using ceramic matrix composite (CMC) material, the core comprising a plurality of flutes;

(B) placing the core between a pair of ceramic matrix composite facesheets wherein a filler material is placed to fill voids between adjacent ones of said flutes prior to said placing between said facesheets, said voids
5 at the intersection of contacting adjacent closed cells comprising said core and a respective facesheet, said filler material comprising an elongate shaped material, said elongate shape existing prior to said placing between said facesheets; and,

10 (C) fusing the facesheets with the core.

[008a] According to yet another aspect of the present invention there is provided a method of fabricating a ceramic matrix composite structure, comprising the steps of:

15 (A) forming a plurality of flutes using a ceramic matrix composite (CMC) where said flutes are formed by wrapping ceramic matrix prepreg fabric over a tool, and curing the prepreg;

(B) placing the flutes formed in step (A)
20 between a pair of ceramic matrix composite facesheets wherein a filler material is placed to fill voids between adjacent ones of said flutes prior to said placing between said facesheets, said voids at the intersection

of adjacent contacting flutes and a respective facesheet,
said filler material having a cross sectional shape
substantially the same as a cross sectional shape of each
of said voids, said filler material comprising an elongate
5 shaped material selected from the group consisting of
ceramic matrix composite (CMC) prepreg material, tape,
tows, and filaments, said elongate shape existing prior to
said placing between said facesheets; and

(C) bonding the flutes to the facesheets.

10 [008b] A ceramic matrix composite sandwich, comprising:
a pair of spaced apart, ceramic matrix composite
facesheets; and,
a plurality of ceramic matrix composite flutes
between at least a portion of the facesheets for carrying
15 compression and shear loads between the facesheets.

[008c] The ceramic matrix composite sandwich wherein each of the flutes includes four walls forming substantially an isosceles trapezoid in cross section.

[008d] The ceramic matrix composite sandwich wherein:

5 the facesheets include a flat section and a curved section, and

the flutes include walls conforming to the curvature of the facesheets in the curved section.

[008e] The ceramic matrix composite sandwich wherein the

10 flutes are filled with a rigid ceramic foam.

[008f] The ceramic matrix composite sandwich wherein portions of the facesheets are laminated together.

[008g] The ceramic matrix composite sandwich further comprising a solid ceramic core bonded between a portion of

15 the facesheets.

[008h] The ceramic matrix composite sandwich wherein each of the flutes includes:

a first pair of spaced apart walls respectively engaging the facesheets, and

20 a second part of spaced apart walls connected to the first pair of walls and extending between the facesheets.

[008i] The ceramic matrix composite sandwich wherein:

the flutes are nested together and include voids therebetween, and

core further includes foam insulation filling the space between the first and second composite sheets.

[008j] A method of fabricating a ceramic matrix composite structure, comprising the steps of:

5 (A) forming a plurality of flutes using a ceramic matrix composite;

(B) placing the flutes formed in step (A) between a pair of ceramic matrix composite facesheets; and

(C) bonding the flutes to the facesheets.

10 The method further comprising the step of:

(D) designing an aircraft assembly incorporating the structure.

[008k] The method further comprising the step of:

15 (D) procuring the material used to fabricate the structure.

[008l] The method of fabricating a ceramic matrix composite structure wherein fabricating the structure forms part of an operation for manufacturing an aircraft assembly.

[008m] An aircraft assembly using the structure fabricated
20 in according to the method of fabricating a ceramic matrix composite structure.

[008n] A method of fabricating a ceramic matrix composite sandwich for use in aerospace structures, comprising the steps of:

(A) forming a load bearing structural core using ceramic matrix composite material;

(B) placing the core between a pair of ceramic matrix composite facesheets; and,

5 (C) fusing the facesheets with the core.

[008o] The method wherein step (A) includes:

fabricating a plurality of flutes, and

placing the flutes in side-by-side relationship.

[008p] The method of fabricating a ceramic matrix composite sandwich for use in aerospace structures wherein the flutes are fabricated by:

10 wrapping ceramic matrix prepreg over a tool, and curing the prepreg.

[008q] The method of fabricating a ceramic matrix composite sandwich for use in aerospace structures wherein step (A) includes placing fillers in voids between the face sheets and the core.

[008r] The method of fabricating a ceramic matrix composite sandwich for use in aerospace structures wherein step (C) is performed by co-curing the core and the facesheets.

[009] Other features, benefits and advantages of the disclosed embodiments will become apparent from the following description of embodiments, when viewed in accordance with the attached drawings and appended claims.

BRIEF DESCRIPTION OF THE ILLUSTRATIONS

[0010] Figure 1 is a perspective illustration of a CMC sandwich according to one embodiment.

[0011] Figure 2 is an enlarged, cross sectional illustration of a portion of the sandwich shown in Figure 1.

[0012] Figure 3 is a perspective illustration showing a section of another embodiment of a CMC structure, incorporating both curved and flat sections.

[0013] Figure 4 is a cross sectional illustration of the CMC structure shown in Figure 3.

[0014] Figure 5 is a cross sectional illustration of the area designated as "A" in Figure 4.

[0015] Figure 6 is a cross sectional illustration of the area designated as "B" in Figure 4.

[0016] Figure 7 is a simplified block diagram illustrating the steps of a method for fabricating a CMC structure.

[0017] Figure 8 is a flow diagram of an aircraft production and service methodology.

[0018] Figure 9 is a block diagram of an aircraft.

DETAILED DESCRIPTION

[0019] Referring first to Figures 1 and 2, a CMC structure 10 is formed from a sandwich of materials comprising an inner, load carrying core 16 sandwiched between a pair of outer, CMC facesheets 12, 14. In the illustrated example, the facesheets 12, 14 are flat and extend substantially parallel to each other, however as will be discussed below, other geometries are possible, including without limitation non-parallel curvilinear, and combinations of curvilinear and rectilinear.

[0020] Each of the facesheets 12, 14 may comprise multiple layers or plies of ceramic fiber material impregnated with a matrix material or "prepreg". As used herein, the term "ceramic" refers to the conventionally known and commercially available ceramic materials that are fabricated in a fiber form. The ceramic fibers may include, but are not limited to, silicon carbide, silica, TYRANNO[®], alumina, aluminoborosilicate, silicon nitride, silicon boride, silicon boronitride, and similar materials.

[0021] The load carrying core 16 may function to transmit compressive, tensile and shear loads between the

facesheets 12, 14, allowing the CMC structure 10 to be both self-supporting and load carrying. The CMC structure 10 is particularly well suited to high temperature applications since all of the composite materials in the CMC structure 10 are ceramic-based. The core 16 comprises a plurality of elongate flute members 18 which are bonded together in nested, side-by-side relationship between the facesheets 12, 14. The flute members 18 may be hollow, or may be filled with any of a variety of ceramic materials, including, without limitation, rigid ceramic tile or foam, ceramic felt, other fibrous ceramic insulation (soft or rigid), monolithic ceramics, etc.

[0022] One rigid foam suitable for use in filling the flute members 18 is disclosed in US Patent 6,716,782 issued April 6, 2002 and assigned to The Boeing Company. The rigid foam insulation described in this prior patent is a combination of ceramic fibers which are sintered together to form a low density, highly porous material with low thermal conductivity. This foam exhibits high tensile strength and good dimensional stability. As used herein, "high temperature" material is generally intended to refer to temperatures above which polymeric materials exhibit diminished capacity.

[0023] In the particular embodiment illustrated in Figures 1 and 2, the flute members 18 include walls 18a, 18b form, in cross section, an isosceles trapezoid, however other shapes are possible, including for example, without limitation, rectangular, triangular, square, and any of various trapezoidal shapes. The size and shape of the flute members 18 may vary from one end of the CMC structure 10 to the other. The flute members may extend in the direction of the length and/or the width of the CMC structure 10, depending on the application and the load requirements.

[0024] . The walls 18a, 18b form bridging elements that provide load paths between the facesheets 12, 14. As best seen in Figure 2, one pair of the walls 18a of the flute member 18 extend parallel to each other and are bonded to the facesheets 12, 14, respectively. The other pair of walls 18b are inclined in opposite directions and extend transverse to the facesheets 12, 14 so as to transmit both shear and compression force components between the facesheets 12, 14.

[0025] The walls 18b of adjacent flute members 18 may be bonded together in face-to-face contact. The intersection of adjacent flute members 18 and facesheets 12, 14 form voids that may be filled with fillers 20 in the form of elongate "noodles" that have a cross

sectional shape matching that of the void; in the illustrated example, the voids, and the noodle fillers 20 are triangular in cross section. The noodle fillers 20 may be made with CMC prepreg, tape, tows, or filaments, and function to more evenly distribute and transmit loads between the facesheets 12, 14.

[0026] Referring now to Figures 3-6 an alternate embodiment CMC structure 10a includes first and second CMC facesheets 12a, 14a. One section 15 of the CMC structure 10a includes a fluted core defined by flute members 18a having cavities 20a which may or may not be filled with a suitable low density, high temperature rigid foam such as a ceramic foam previously described. Unlike the CMC structure 10 shown in Figures 1 and 2, section 15 in the CMC structure 10a is curved. Accordingly, the flute members 18a have top and bottom walls 18c (Figure 5) that may be slightly curved to match the curvature of facesheets 12a, 14a. On one end of the structure 12a, the facesheets 12a, 14a may taper inwardly, also called a ramp down, at 24 and may be laminated directly together to form a solid section 22 of the CMC structure 10a. A ceramic structural member, such as a solid ceramic insert 26 may be sandwiched between facesheets 12a, 14a in the solid section 22 of the structure 10a to provide additional strength and stiffness. The solid section 22 provides a reinforced

area having sufficient strength and stiffness to allow fasteners (not shown) to pierce the structure 10a in order to attach the structure 10a.

[0027] Multiple flat or curved structures 10, 10a may be bonded together or interconnected using, for example, a bayonet-like interconnection shown in Figure 4 in which the facesheets 12a, 14a taper at 24 to form a female socket 25 that receives a solid male projection 27 forming part of an adjacent structure 10, 10a.

[0028] A method for fabricating the structures 10, 10a is illustrated in Figure 7. Beginning at step 30, the flute members 18 are formed by wrapping one or more plies of CMC prepreg or tape around or over a mandrel tool (not shown). The tool may comprise, without limitation, solid metal, permanent tooling, or a rigid foam member which may or may not be fugitive, but possesses the shape of the flute member 18 to be formed. The mandrel tool may be formed of other materials such as ceramic tile, ceramic foam or organically rigidized ceramic batting.

[0029] Next, at step 32, the wrapped flute members 18 are assembled together by nesting them in side-by-side relationship, following which the assembled flute members 18 are cured at step 34 normally at elevated temperature and pressure. At step 36, the prepreg noodle fillers 20

are installed in the voids between adjacent flute members 18.

[0030] At step 38, the facesheets 12, 14 are applied to each side of the assembled flute members 18, and the resulting sandwich assembly is then cured in the normal manner which may involve, for example, placing the sandwich assembly in an autoclave (not shown). The facesheets 12, 14 may be formed using a layup of woven fabric prepreg, tape/tow placement or filament winding.

[0031] Following the curing step at 40, the mandrels are removed at step 42 if they comprise permanent tooling. Otherwise the fugitive foam mandrels are left in place, and the entire sandwich assembly is post-cured at elevated temperatures, as shown at step 44. Depending on the type of rigid foam used as the mandrel tool, the elevated temperatures during the post-curing step 44 may be sufficient to incinerate the mandrel tools. Subsequently, non-destructive inspection techniques such as thermography or CT scanning can be used at step 46 (see Figure 7) to verify that the facesheets 12, 14 do not contain delaminations, and that good adhesion has been obtained between the flute members 18.

[0032] Where a CMC structure 10a is to be fabricated having curved sections, appropriate layup tooling (not

shown) may be provided for forming the facesheets 12a, 14a into the desired shapes. The flute members 18 may be filled with a flexible, organic fugitive foam mandrel (not shown) so that the flute members 18 conform to the curved shape of the facesheets 12a, 14a. The fugitive foam mandrel may be either be washed out or pyrolyzed during the CMC post curing step 44.

[0033] The embodiments of the disclosure described above may be described in the context of an aircraft manufacturing and service method 50 as shown in Figure 8 and an aircraft 80 as shown in Figure 9. During pre-production, exemplary method 50 may include specification and design 52 of the aircraft 80 and material procurement 54. During production, component and subassembly manufacturing 56 and system integration 58 of the aircraft 76 takes place. Thereafter, the aircraft 80 may go through certification and delivery 60 in order to be placed in service 62. While in service by a customer, the aircraft 80 is scheduled for routine maintenance and service 64 (which may include modification, reconfiguration, refurbishment, and so on).

[0034] Each of the processes of method 50 may be performed or carried out by a system integrator, a third party, and/or an operator (e.g., a customer). For the purposes of this description, a system integrator may

include without limitation any number of aircraft manufacturers and major-system subcontractors; a third party may include without limitation any number of vendors, subcontractors, and suppliers; and an operator may be an airline, leasing company, military entity, service organization, and so on.

[0035] As shown in Figure 9, the aircraft 80 produced by exemplary method 76 may include an airframe 66 with a plurality of systems 68 and an interior 70. Examples of high-level systems 68 include one or more of a propulsion system 72, an electrical system 74, a hydraulic system 76, and an environmental system 78. Any number of other systems may be included. Although an aerospace example is shown, the principles of the invention may be applied to other industries, such as the automotive industry.

[0036] Apparatus and methods embodied herein may be employed during any one or more of the stages of the production and service method 50. For example, components or subassemblies corresponding to production process 56 may be fabricated or manufactured in a manner similar to components or subassemblies produced while the aircraft 80 is in service. Also, one or more apparatus embodiments, method embodiments, or a combination thereof may be utilized during the production stages 56 and 58, for example, by substantially

expediting assembly of or reducing the cost of an aircraft 80. Similarly, one or more of apparatus embodiments, method embodiments, or a combination thereof may be utilized while the aircraft 80 is in service, for example and without limitation, to maintenance and service 64.

[0037] Although the embodiments of this disclosure have been described with respect to certain exemplary embodiments, it is to be understood that the specific embodiments are for purposes of illustration and not limitation, as other variations will occur to those of skill in the art.

What is claimed is:

1. A method of fabricating a ceramic matrix composite structure, comprising the steps of:

(A) forming a plurality of flutes using a ceramic matrix composite (CMC);

(B) placing the flutes formed in step (A) between a pair of ceramic matrix composite facesheets wherein voids are filled between adjacent ones of said flutes with a filler material prior to said placing between said facesheets, said voids at the intersection of adjacent contacting flutes and a respective facesheet, said filler material comprising an elongate shaped material, said elongate shape existing prior to said placing between said facesheets; and

(C) bonding the flutes to the facesheets.

2. The method of claim 1, wherein step (A) comprises:

wrapping ceramic matrix prepreg fabric over a tool, and curing the prepreg.

3. The method of claim 2, wherein step (A) further comprises forming the tool by shaping a rigid foam into a mandrel.

4. The method of claim 3, wherein step (A) further comprises incinerating the foam after the prepreg has been cured.

5. The method of claim 1, wherein step (A) comprises:
arranging the flutes in side-by-side nested relationship, and
curing the arranged flutes.

6. The method of any one of claims 1 to 5, further comprising the step of:

(D) laminating together portions of the facesheets.

7. The method of any one of claims 1 to 5, further comprising the steps of:

(D) placing a solid ceramic core between a portion of the facesheets; and

(E) bonding the portion of facesheets to the ceramic core.

8. The method of claim 1, wherein step (C) is performed by co-curing the facesheets and the flutes.

9. The method of any one of claims 1 to 8, wherein fabricating the structure forms part of an operation for manufacturing an aircraft assembly.

10. The method of any one of claims 1 to 9, wherein each of said flutes comprises a closed cell filled with ceramic foam.

11. The method of any one of claims 1 to 9, wherein each of said flutes comprises a continuous wall defined by compacted multiple plies of ceramic fiber reinforced resin.

12. The method of any one of claims 1 to 11, wherein each of the facesheets comprises compacted multiple plies of ceramic fiber reinforced resin.

13. The method of any one of claims 1 to 9, wherein each of the flutes comprises four walls forming substantially an isosceles trapezoid in cross section.

14. The method of any one of claims 1 to 13, wherein at least a section of each of the facesheets is curved, and each of the flutes conform to the curvature of the facesheet section.

15. The method of any one of claims 1 to 14, wherein the filler material has substantially the same cross sectional shape as said voids.

16. The method of any one of claims 1 to 8, wherein the filler material is selected from the group consisting of ceramic matrix composite (CMC) prepreg material, tape, tows, and filaments.

17. The method of claim 16, wherein fabricating the structure forms part of an operation for manufacturing an aircraft assembly.

18. The method of claim 1 wherein said step of bonding comprises bonding the flutes to the facesheets over a first portion of said structure, and laminating the facesheets to one another including an intervening solid ceramic layer over another portion of said structure.

19. A method of fabricating a ceramic matrix composite sandwich structure for use in aerospace structures, comprising the steps of:

(A) forming a load bearing structural core using ceramic matrix composite (CMC) material, the core comprising a plurality of flutes;

(B) placing the core between a pair of ceramic matrix composite facesheets wherein a filler material is placed to fill voids between adjacent ones of said flutes prior to said placing between said facesheets, said voids at the intersection of contacting adjacent closed cells comprising said core and a respective facesheet, said filler material comprising an elongate shaped material, said elongate shape existing prior to said placing between said facesheets; and,

(C) fusing the facesheets with the core.

20. The method of claim 19, wherein step (A) comprises:

fabricating the plurality of flutes comprising said closed cells, and

placing the flutes in side-by-side relationship.

21. The method of claim 20, wherein the flutes are fabricated by:

wrapping ceramic matrix prepreg over a tool, and curing the prepreg.

22. The method of claim 19, wherein step (C) is performed by co-curing the core and the facesheets.

23. The method of claim 19, wherein said core comprises a plurality of said closed cells filled with ceramic foam.

24. The method of claim 23, wherein each of the cells comprises a continuous wall defined by compacted multiple plies of ceramic fiber reinforced resin.

25. The method of any one of claims 19 to 24, wherein each of the facesheets comprises compacted multiple plies of ceramic fiber reinforced resin.

26. The method of any one of claims 19 to 25, wherein each of the cells comprises four walls forming substantially an isosceles trapezoid in cross section.

27. The method of any one of claims 19 to 26, wherein at least a section of each of the facesheets is curved, and each of the cells conform to the curvature of the facesheet section.

28. The method of any one of claims 19 to 27, wherein the filler material has substantially the same cross sectional shape as said voids.

29. The method of any one of claims 19 to 27, wherein the filler material is selected from the group consisting of ceramic matrix composite (CMC) prepreg material, tape, tows, and filaments.

30. The method of any one of claims 19 to 29, wherein fabricating the structure forms part of an operation for manufacturing an aircraft assembly.

31. A method of fabricating a ceramic matrix composite structure, comprising the steps of:

(A) forming a plurality of flutes using a ceramic matrix composite (CMC) where said flutes are formed by wrapping ceramic matrix prepreg fabric over a tool, and curing the prepreg;

(B) placing the flutes formed in step (A) between a pair of ceramic matrix composite facesheets wherein a filler material is placed to fill voids between adjacent ones of said flutes prior to said placing between said facesheets, said voids at the intersection of adjacent

contacting flutes and a respective facesheet, said filler material having a cross sectional shape substantially the same as a cross sectional shape of each of said voids, said filler material comprising an elongate shaped material selected from the group consisting of ceramic matrix composite (CMC) prepreg material, tape, tows, and filaments, said elongate shape existing prior to said placing between said facesheets; and

(C) bonding the flutes to the facesheets.

32. The method of claim 31 wherein said step of bonding comprises bonding the flutes to the facesheets over a first portion of said structure, and laminating the facesheets to one another including an intervening solid ceramic layer over another portion of said structure.

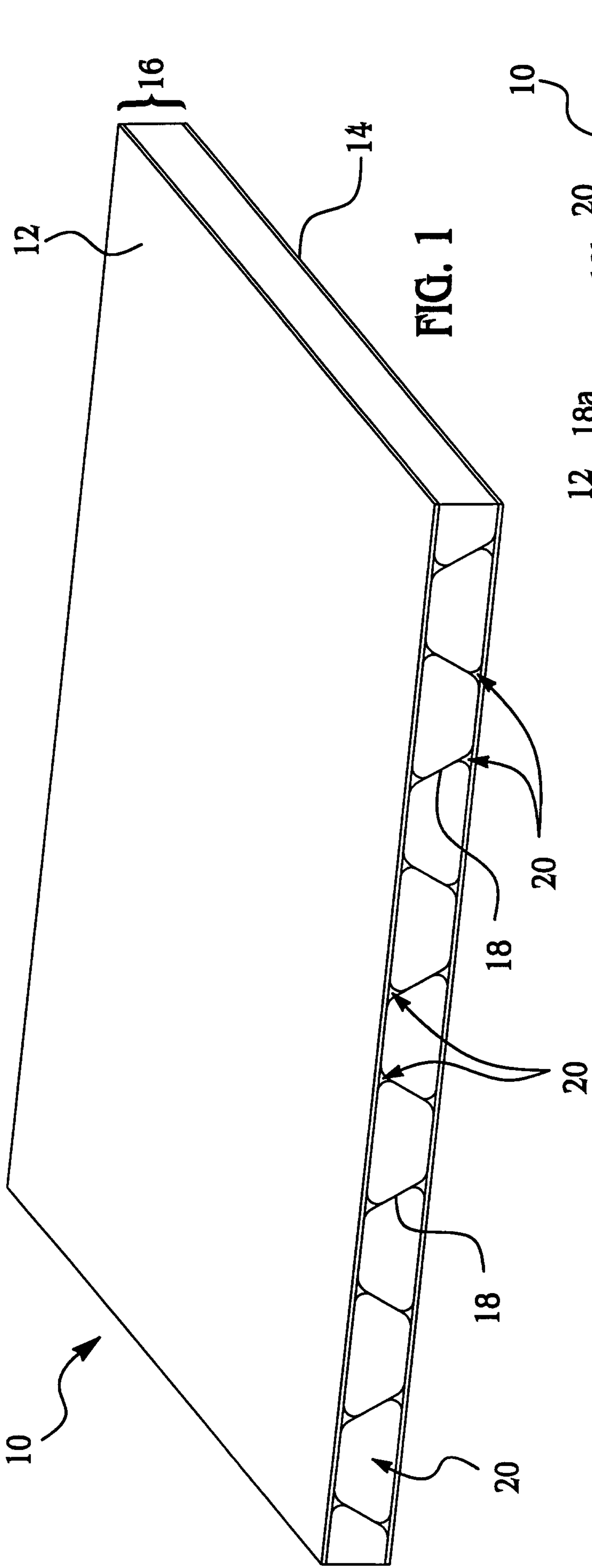


FIG. 1

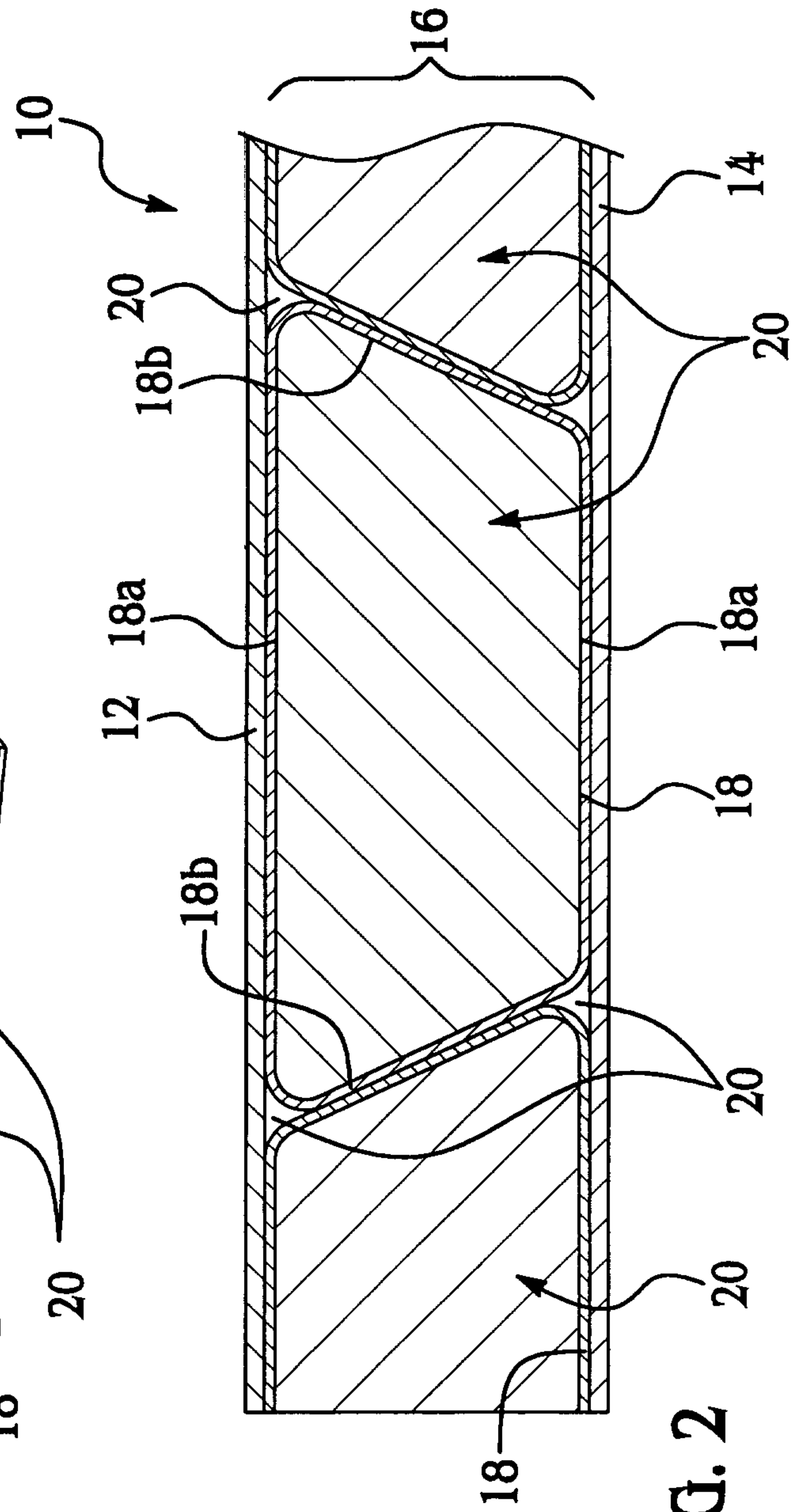
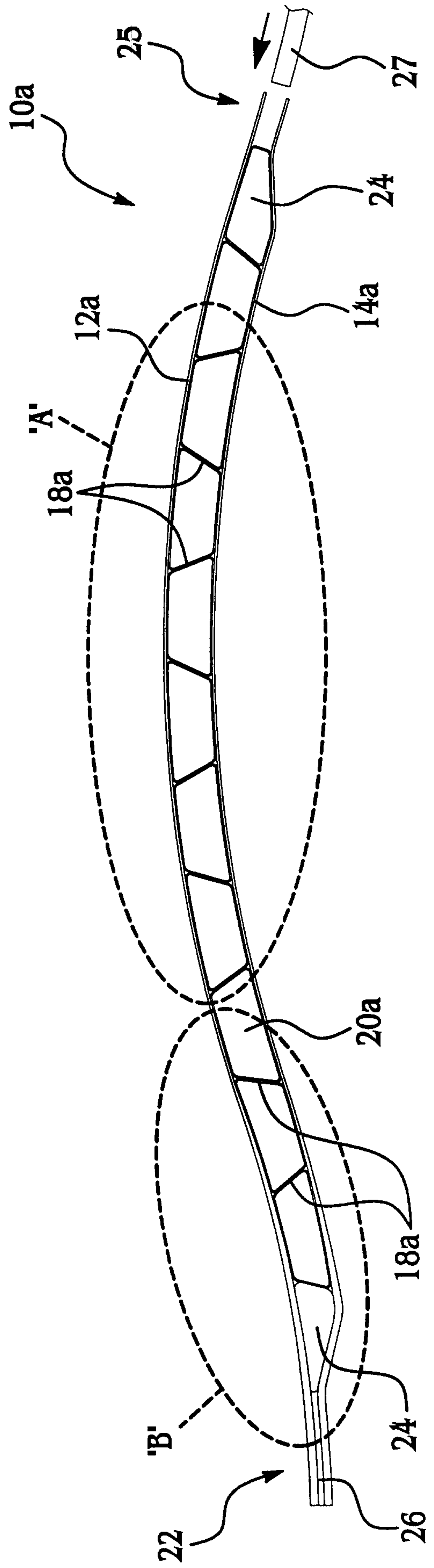
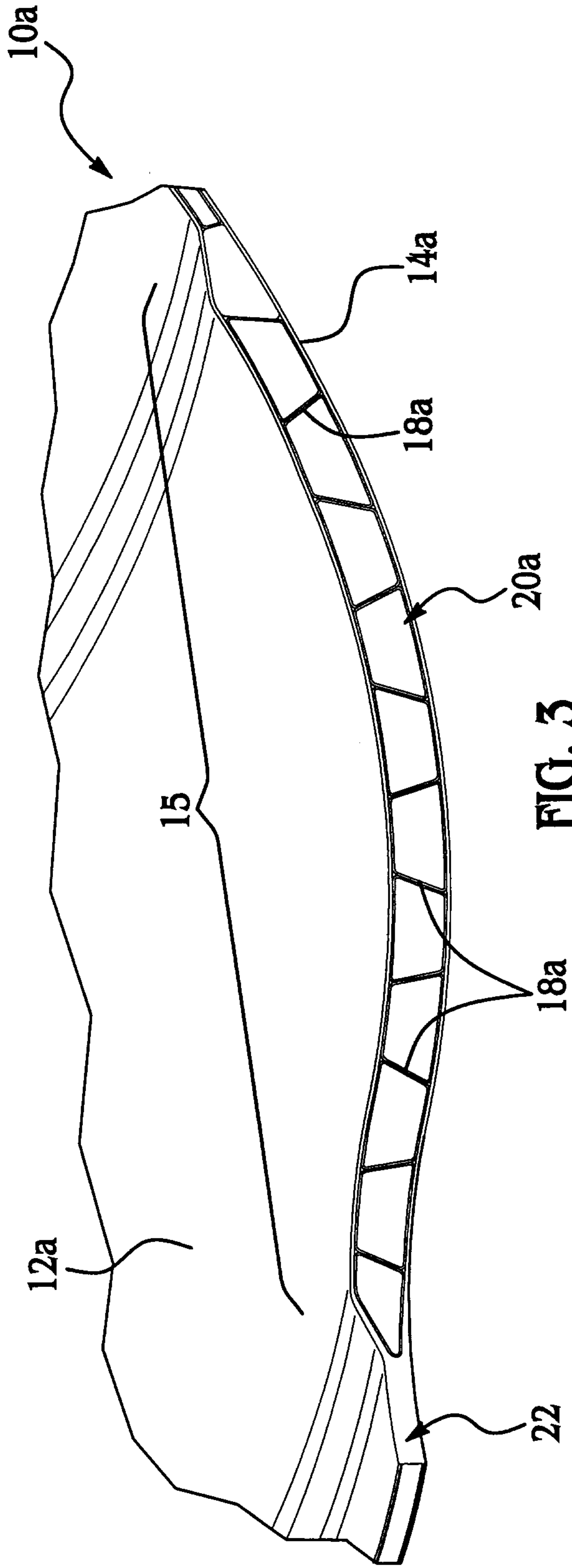
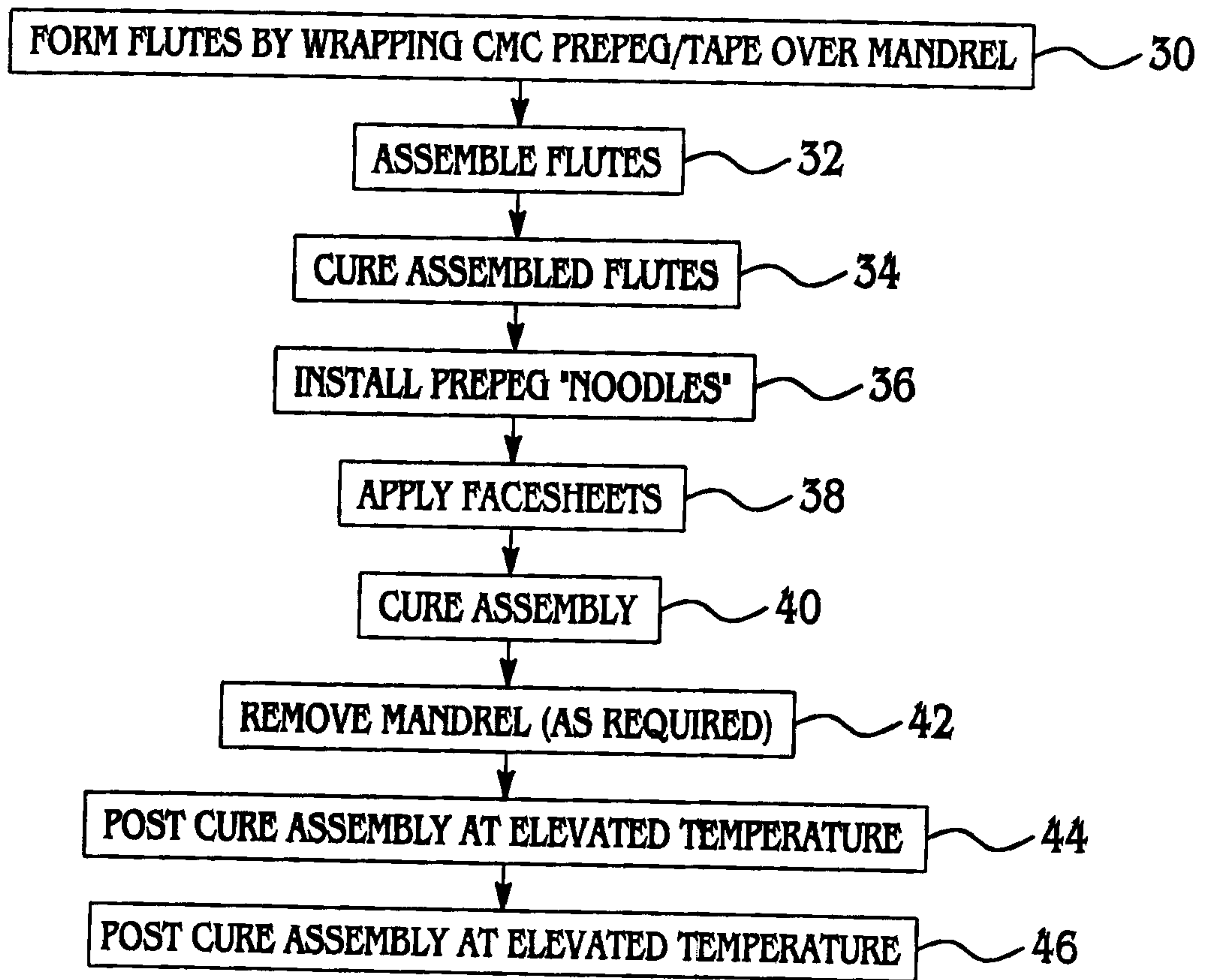
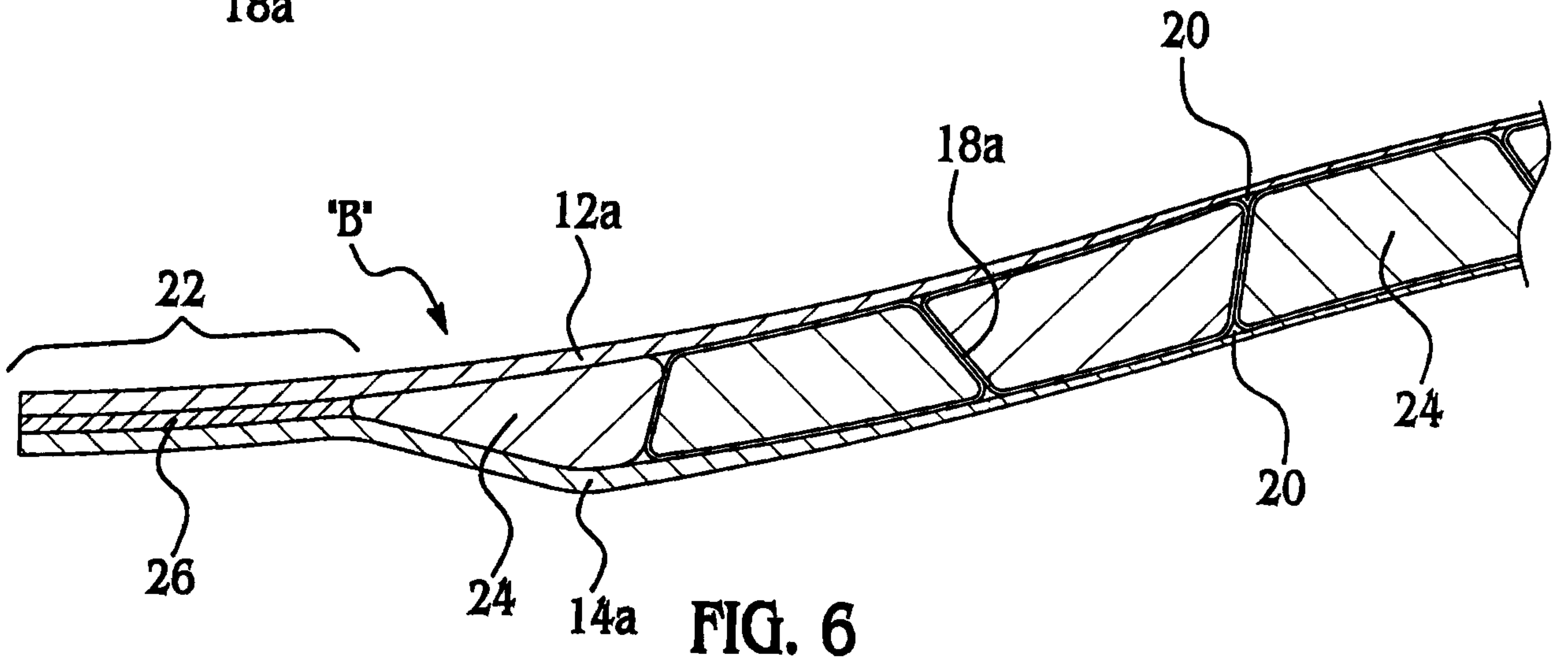
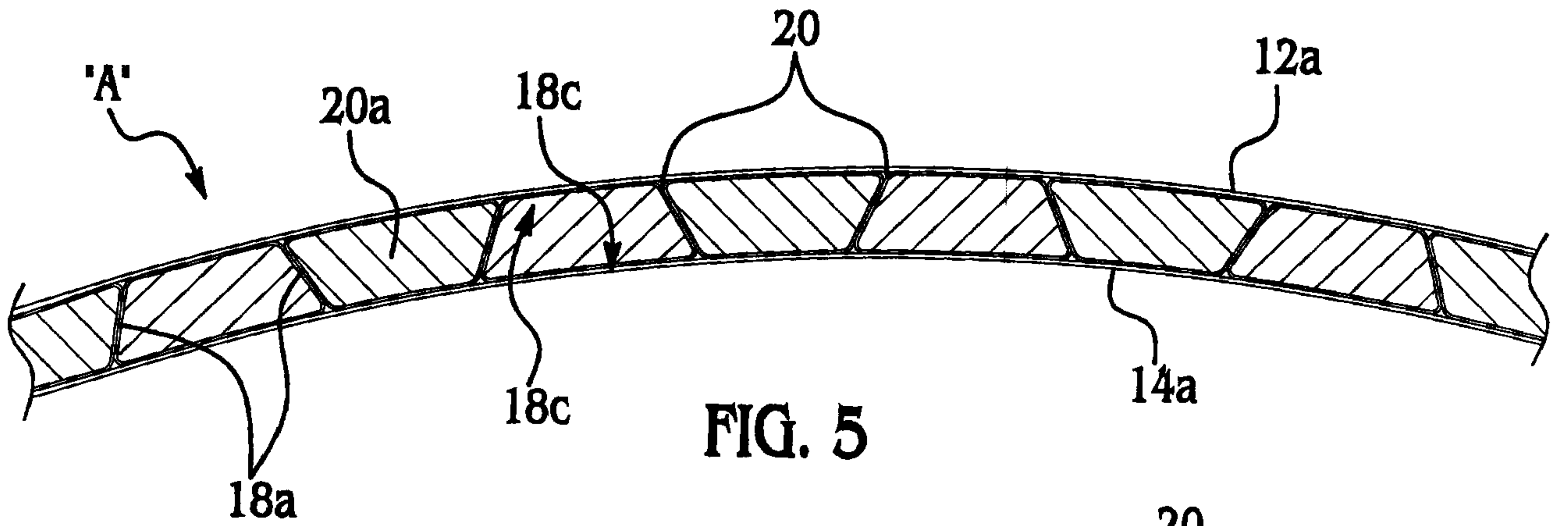


FIG. 2





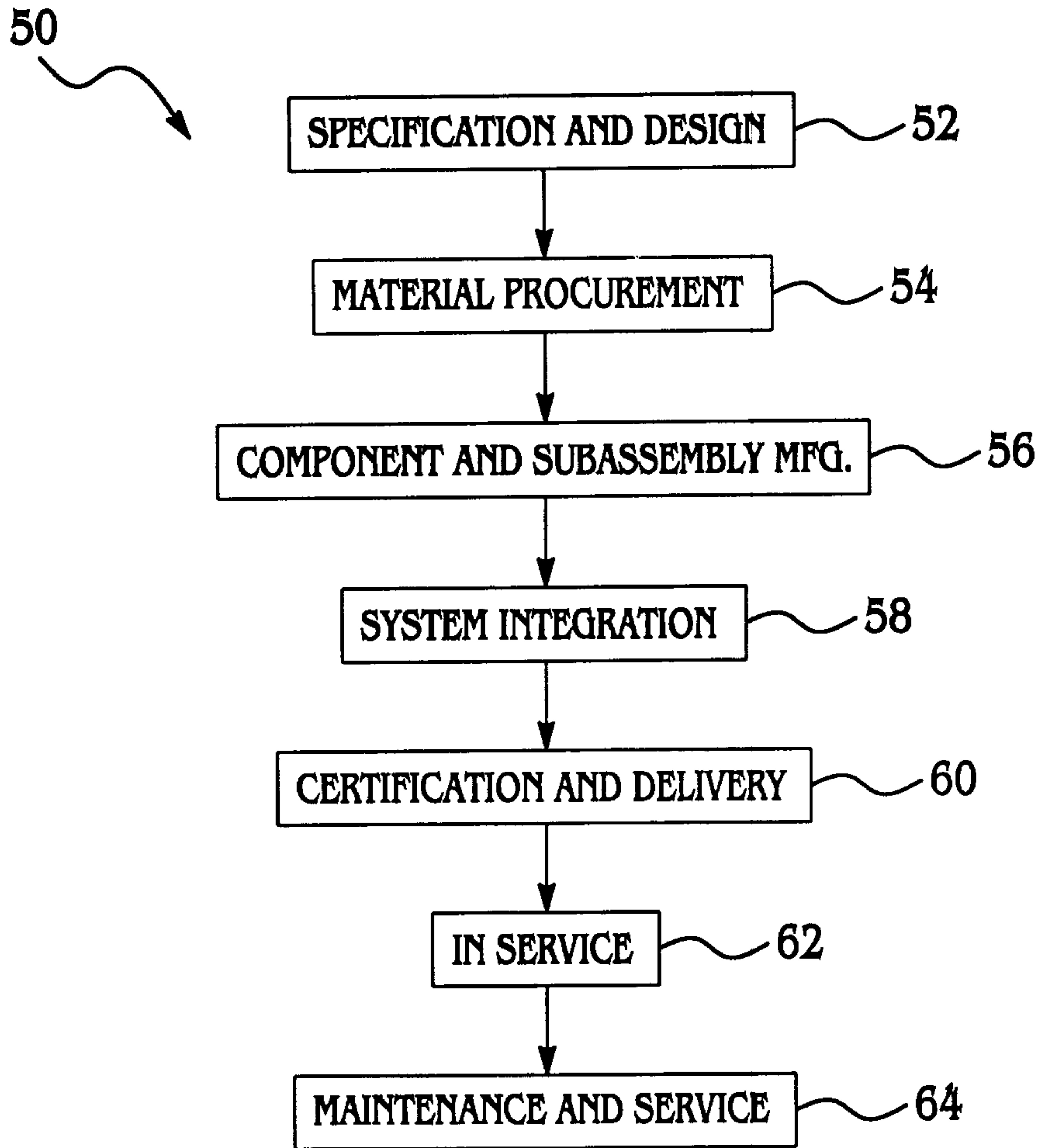


FIG. 8

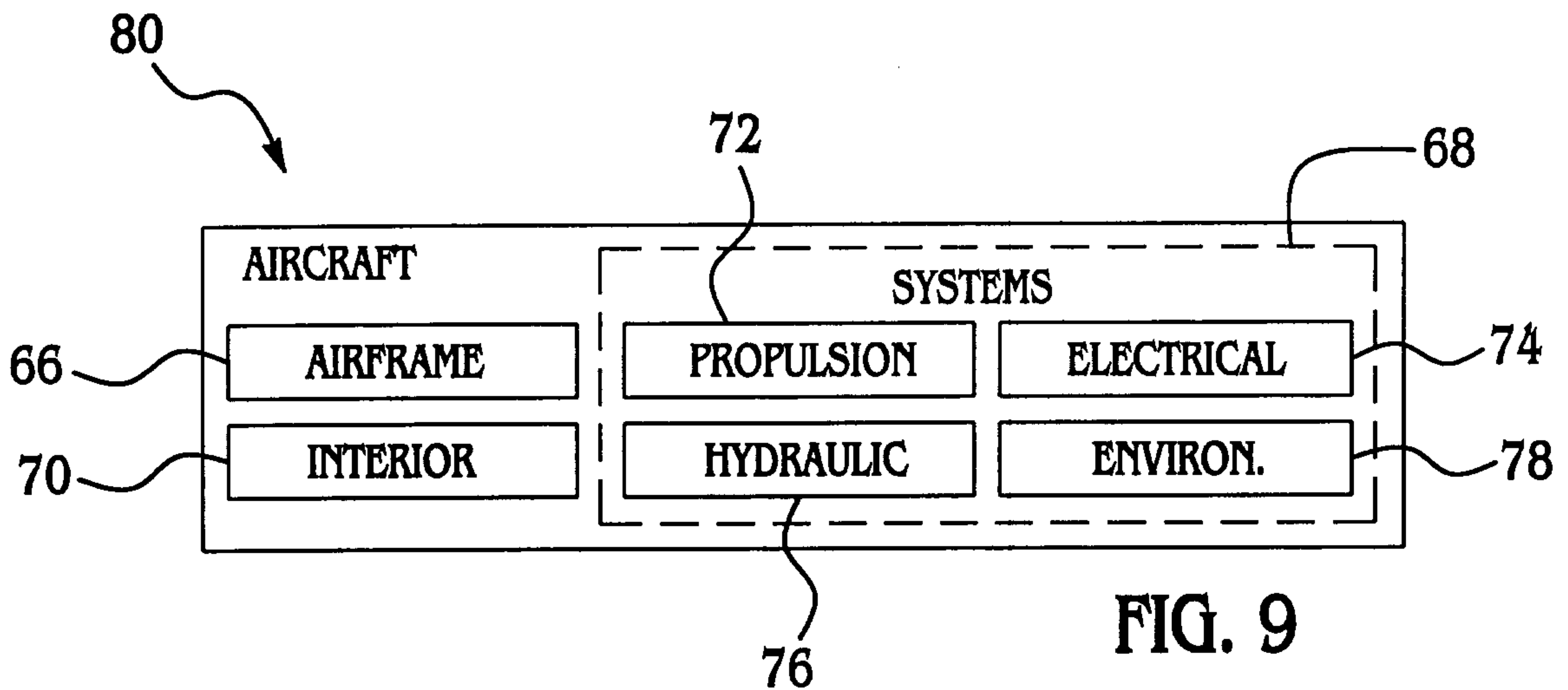


FIG. 9

