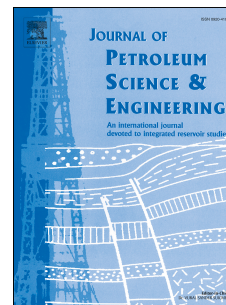


# Accepted Manuscript

Functionalization of fly ash for the substitution of bentonite in drilling fluid

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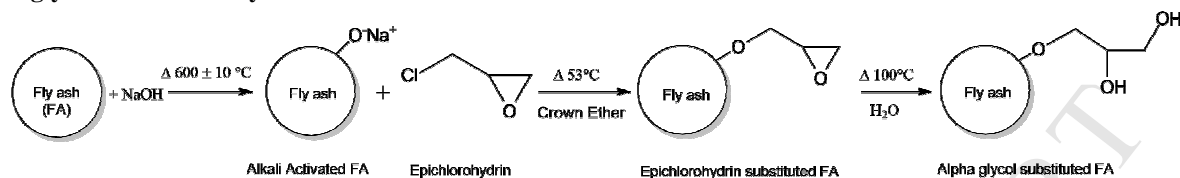
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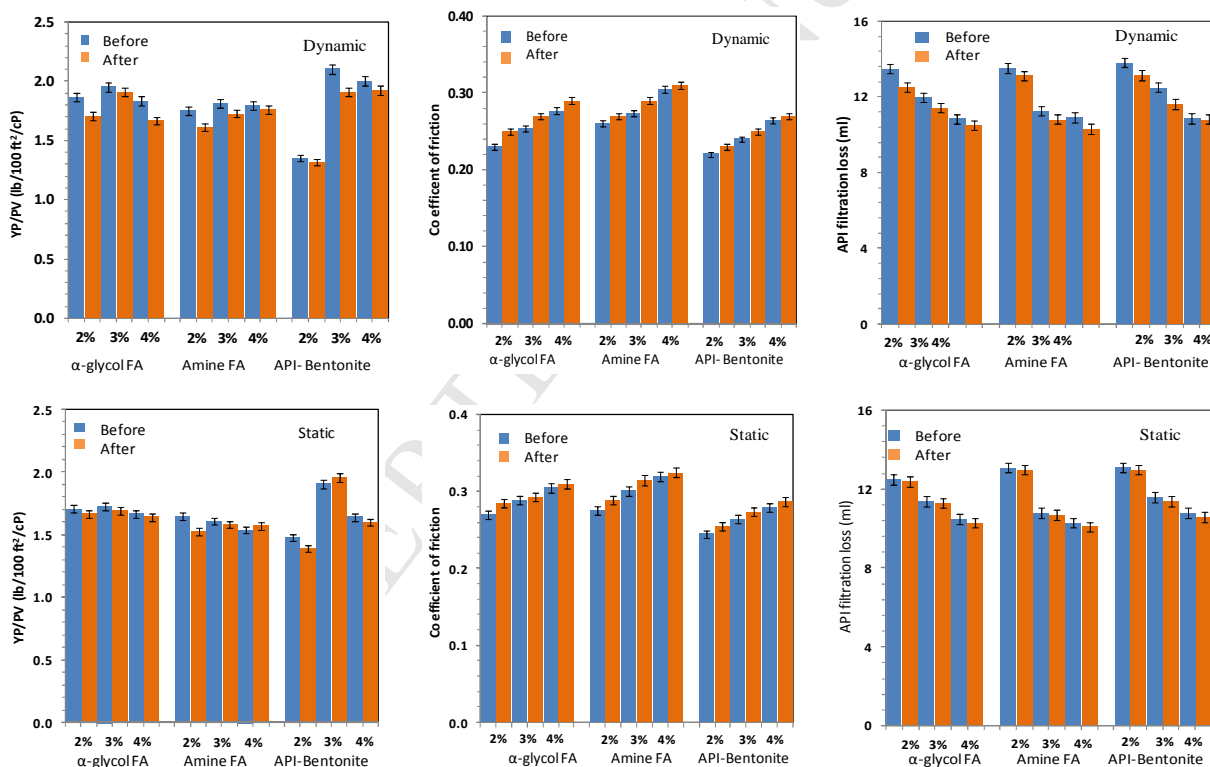
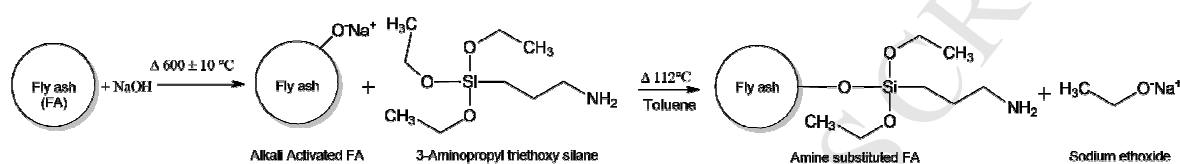
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## Graphical Abstract

 $\alpha$ -glycol-substituted fly ash:

## Amine-substituted fly ash:



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