

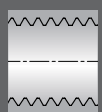
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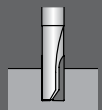
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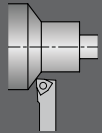
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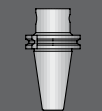
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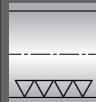
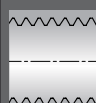
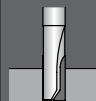
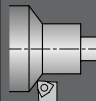
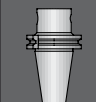


8



Informations	Page
Performance calculation	930 – 931
Dimensional variation	932
Types of wear on indexable inserts	933
Usage and safety notes	934 – 935
Clamping screws	936 – 939
KOMET ABS	940 – 943
KOMET KomLoc HSK	944 – 947
Coolant transfer	948
KOMET Company concept	949
International material classification	950 – 951
Numerical index	952 – 975

**1**

**2**

**3**

**4**

**5**

**6**

**7**

**8**


# KOMET

## Performance calculation

Example: Material 42CrMo4, bore 40 mm diameter  
 $a_p$  = cutting width in mm = 5 mm  
 $f$  = feed in mm/rev = 0,15 mm/rev  
 $k_c$  = special cutting force in N/mm<sup>2</sup> = 2450 N/mm<sup>2</sup>

$D$  = diameter in mm = 40 mm  
 $v_c$  = cutting speed in m/min = 180 m/min  
 $n$  = spindle speed in min<sup>-1</sup> = 1433 min<sup>-1</sup>  
 $\eta$  = machine output 0,7-0,85 (0,8) = 0,8

### Solid drilling

The machine power in kW

$$P_a = \frac{v_c \times f \times D \times k_c}{1000 \times 60 \times 4 \times \eta}$$

The feed  $F_f$  required is approx.:

$$F_f \approx 0,7 \times \frac{D}{2} \times f \times k_c$$

$$P_a = \frac{180 \times 0,15 \times 40 \times 2450}{1000 \times 60 \times 4 \times 0,8} = 13,8 \text{ kW}$$

$$F_f \approx 0,7 \times \frac{40}{2} \times 0,15 \times 2450 = 5145 \text{ N}$$

### Roughing / Fine boring

The machine power in kW

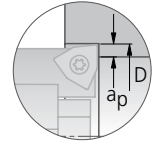
$$P_a = \frac{a_p \times f \times k_c \times n (D - a_p)}{2000 \times 9550 \times \eta}$$

The feed  $F_f$  required is approx.:

$$F_f \approx 0,7 \times a_p \times f \times k_c$$

$$P_a = \frac{5 \times 0,15 \times 2450 \times 1433 (40 - 5)}{2000 \times 9550 \times 0,8} = 6 \text{ kW}$$

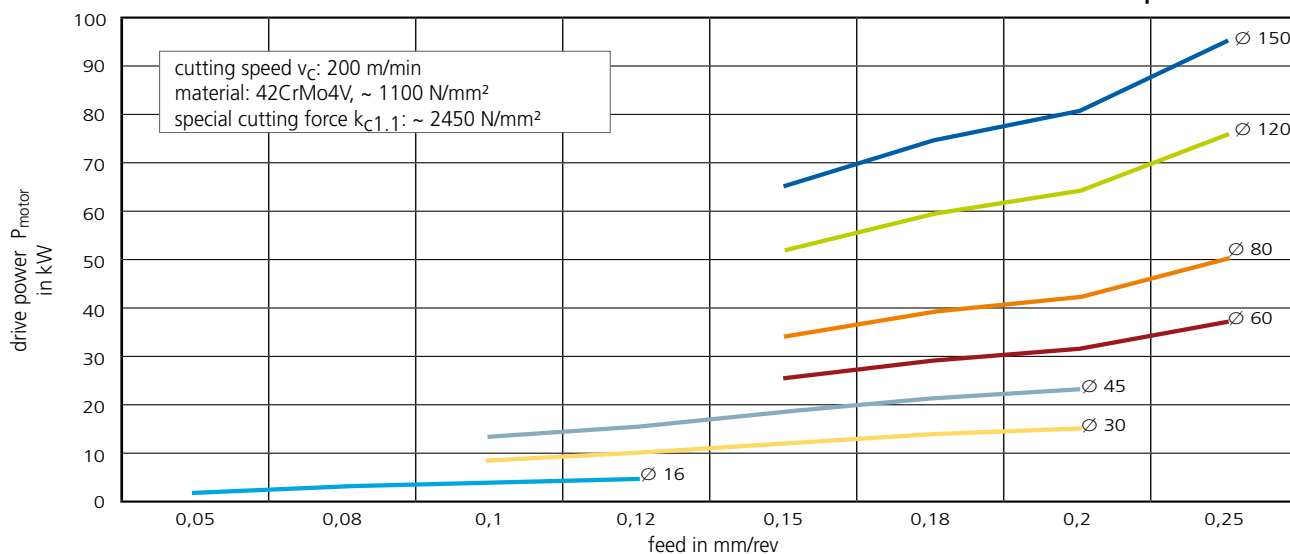
$$F_f \approx 0,7 \times 5 \times 0,15 \times 2450 = 1286,25 \text{ N}$$



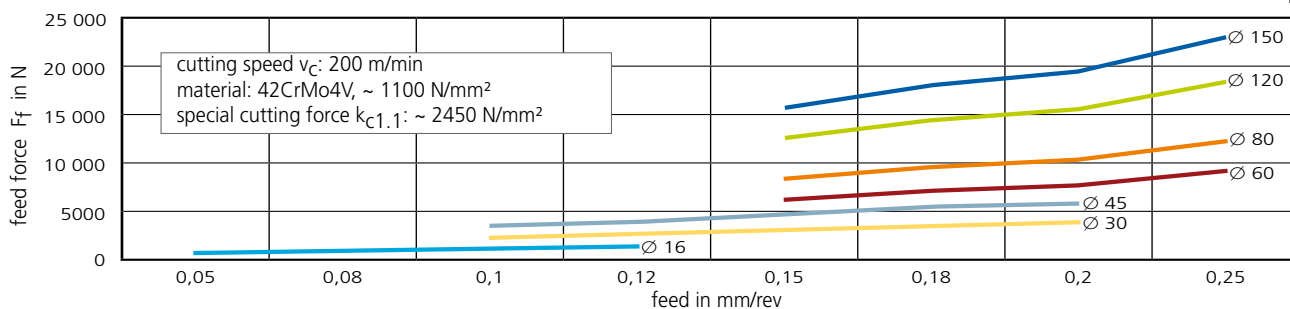
The  $k_c$  values depend on the feed rate. The table therefore shows the upper limits for these. This means the performance figure calculated may be slightly higher (~ 10 – 20%) than the actual performance required. This is necessary because of the variation in the effective level and provides a safeguard against bad results.

Material group	Strength Rm (N/mm <sup>2</sup> )	Hardness HB	Material	Material example, material code/DIN	Special cutting force $k_c$ (N/mm <sup>2</sup> )
P	≤500		non-alloy steels	1.0037 (S235JR)   1.0715 (11SMn30)   1.0044 (S2575JR)	1740
	500-900		non-alloy / low alloy steels	1.0050 (E295)   1.0535 (C55)   1.7131 (16MnCr5)	2060
	<500		lead alloys	1.0718 (11SMnPb30)	1250
	>900		non alloy / low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4)   1.1221 (C60E)	2450
	>900		high alloy steels	1.2341 (6CrMo15-5)   1.2601 (X165CrMoV12)	1820
			HSS		1860
S		250	special alloys: Inconel, Hastelloy, Nimonic, stc.	2.4668 (NiCr19Fe19Nb5Mo3)   2.4631 (Nimonic 80A)	2090
	400		titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	1370
M	≤600		stainless steels	1.4306 (X2CrNi19-11)   1.4401 (X5CrNiMo17-12-2)	2400
	<900		stainless steels	1.4511 (X3CrNb17)   1.4571 (X10CrNiMoTi17-12-2)	2530
	>900		stainless / fireproof steels	1.4713 (X10CrAlSi7)   1.4862 (X8NiCrSi38-18)	2580
		180	gray cast iron	0.6025 (EN-GJL-250)   0.6035 (EN-GJL-350)	1140
K		250	alloy gray cast iron	0.6660 (GGL-NiCr20 2)	1280
	≤600	130	spheroidal graphite cast iron, ferritic	0.7040 (EN-GJS-400-15)	1080
		230	spheroidal graphite cast iron, ferritic/perlitic	0.7050 (EN-GJS-500-7)   0.7055 (GGG-55)   0.8055 (GTW-55)	1135
	>600	250	spheroidal graphite cast iron, perlitic malleable iron	0.7060 (EN-GJS-600-3)   0.8165 (GTS-65)	1050
		200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	1180
		300	vermicular cast iron	EN-GJV Ti < 0,2   EN-GJV Ti > 0,2	1050
		90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	2.0375 (CuZn36Pb3)   2.1182.01 (G-CuPb15Sn)	780
		100	copper alloy, brass, bronze: average cut	2.0550 (CuZn40Al2)   2.0060 (E-Cu57)	780
N		60	wrought aluminium alloys	3.3315 (AlMg1)   3.0517 (AlMnCu)	650
		75	cast alum. alloy: Si-content <10%, magnesium alloy	3.3561 (G-ALMg5)   3.2373.61 (G-ALSi9Mg wa)	780
		100	cast alum.alloy: Si-content >10%	3.2381.01 (G-ALSi10Mg)	830
		1400	hardened steels < 45 HRC		2880
H		1800	hardened steels > 45 HRC		3300

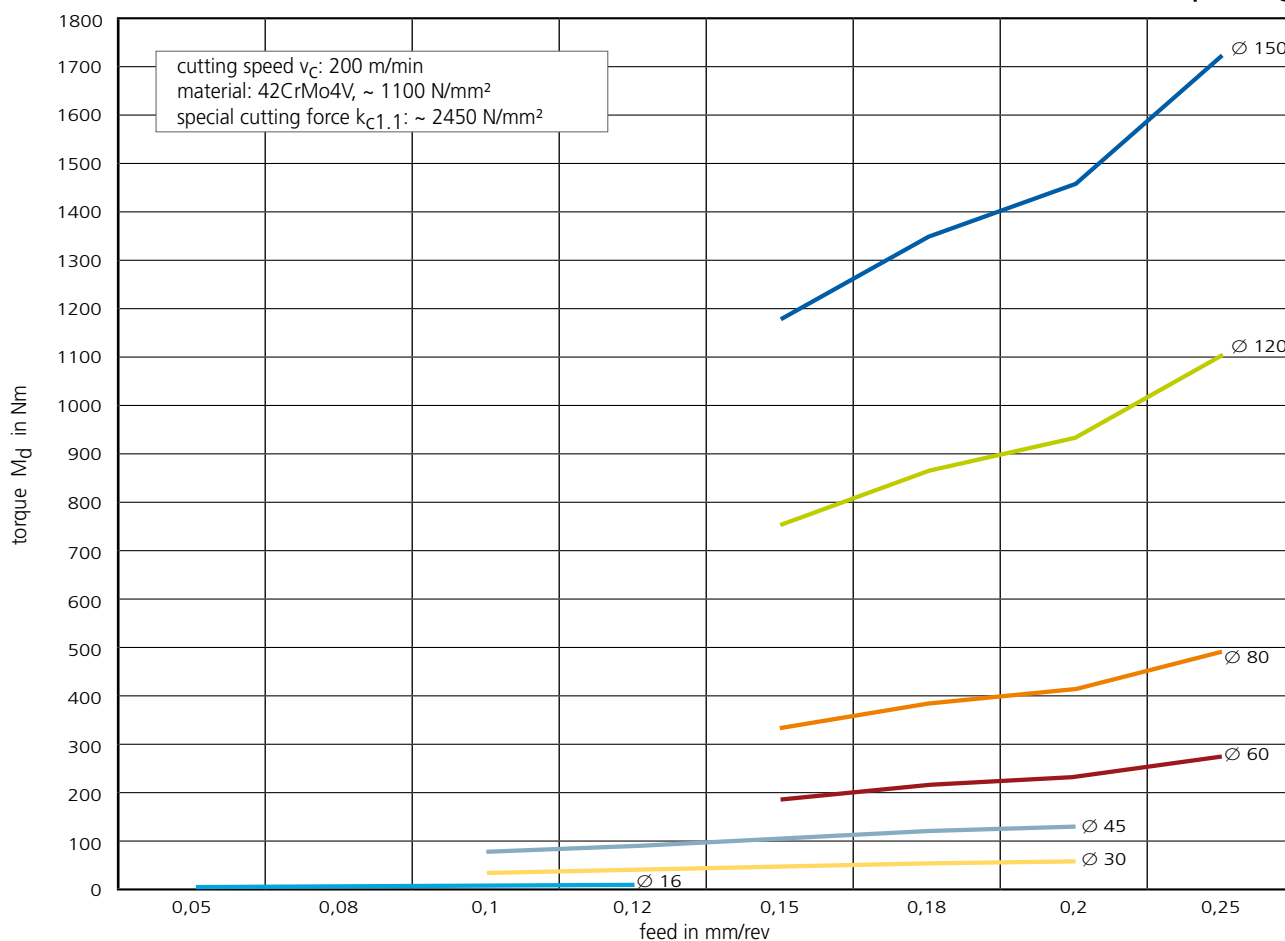
### Drive power kW



### Feed force $F_f$



### Torque $M_d$

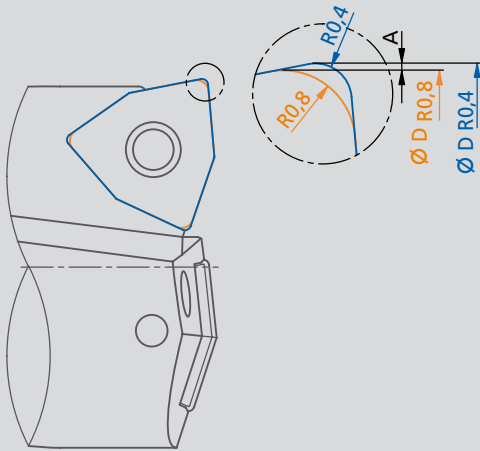


# KOMET

## Dimensional variation

1

### KUB Trigon, KUB drill



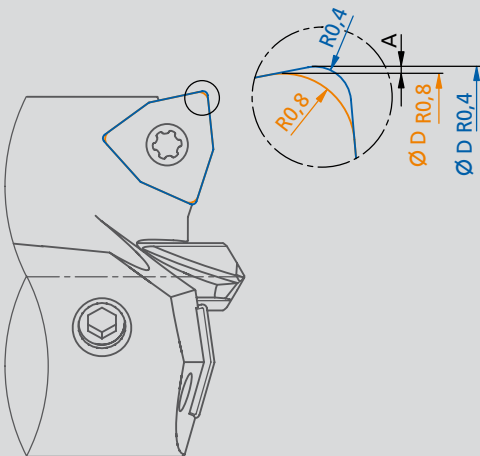
Ø D	A
25,0 – 27,9	0,08
28,0 – 28,9	0,09
29,0 – 29,9	0,10
30,0 – 31,9	0,08
32,0 – 33,9	0,09
34,0 – 36,9	0,10
37,0 – 38,9	0,08
39,0 – 41,9	0,09
42,0 – 44,9	0,10

$$D_{R0,8} = D_{R0,4} - 2 \times A$$

4

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### KUB Centron



Ø D	A
33,0 – 37,9	0,08
38,0 – 54,9	0,09
55,0 – 64,9	0,10

$$D_{R0,8} = D_{R0,4} - 2 \times A$$

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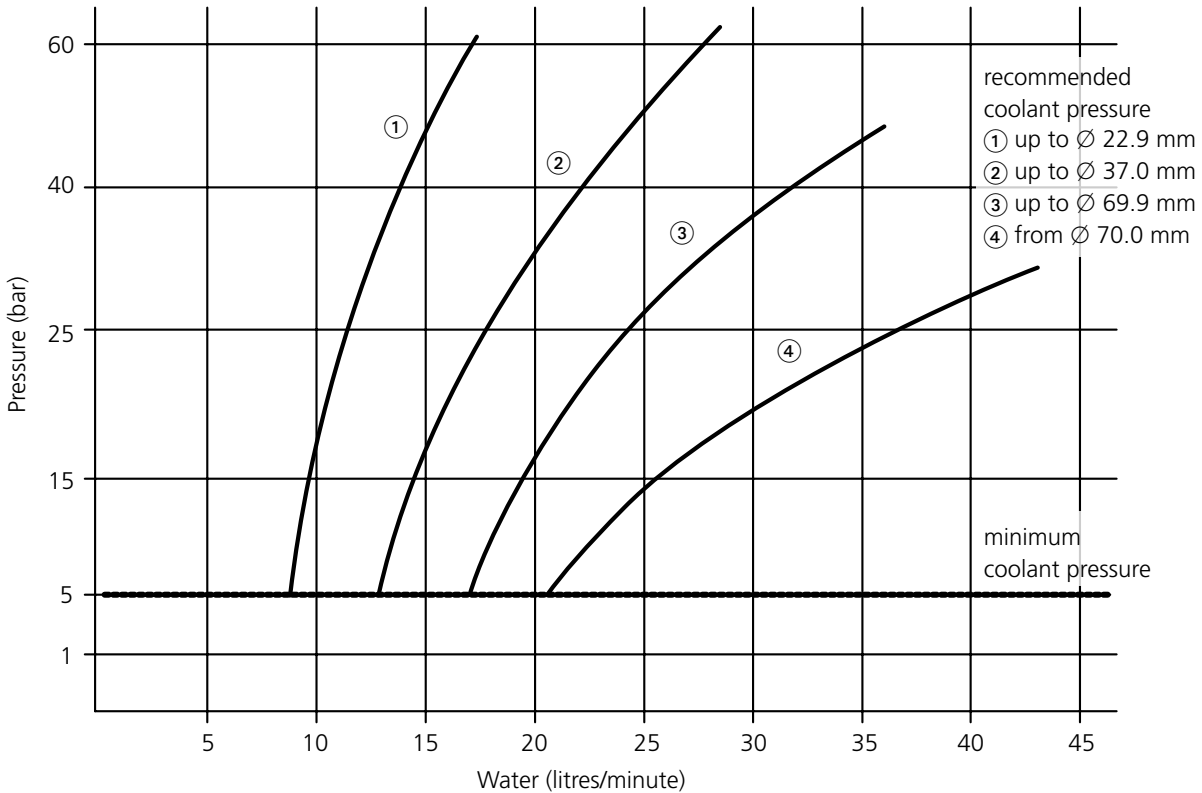
8

1.		<p><b>Wear on clearance face</b> normal type of wear expected</p>	<p><b>remedy:</b></p> <ul style="list-style-type: none"> <li>• use hardened/wear-resistant cutting materials</li> <li>• reduce cutting parameters</li> </ul>	1
2.		<p><b>Pitting</b> <b>caused by:</b></p> <ul style="list-style-type: none"> <li>• coating/substrate not sufficiently wear-resistant</li> <li>• chip geometry too negative</li> </ul>	<p><b>rectified by:</b></p> <ul style="list-style-type: none"> <li>• substrate or coatings with better wear resistance</li> <li>• positive chip geometries</li> </ul>	2
3.		<p><b>Microscopic fracturing</b> <b>caused by:</b></p> <ul style="list-style-type: none"> <li>• coating/substrate too brittle</li> <li>• vibrations on part or tool</li> <li>• interrupted cut</li> <li>• build-up on cutting edges</li> </ul>	<p><b>correcting by:</b></p> <ul style="list-style-type: none"> <li>• tougher coating</li> <li>• avoidance of vibrations</li> <li>• avoidance of build-up on cutting edges</li> </ul>	3
4.		<p><b>Stress fracture</b> <b>caused by:</b></p> <ul style="list-style-type: none"> <li>• wrong/excessively high cutting parameters</li> <li>• no allowance for tool restrictions</li> <li>• interrupted cut</li> </ul>	<p><b>rectified by:</b></p> <ul style="list-style-type: none"> <li>• checking of cutting data</li> <li>• checking of tool restrictions</li> </ul>	4
5.		<p><b>Thermal wear</b> <b>caused by:</b></p> <ul style="list-style-type: none"> <li>• cutting speed too high</li> <li>• excessive heat</li> </ul>	<p><b>rectified by:</b></p> <ul style="list-style-type: none"> <li>• reduction of cutting speed</li> <li>• wear-resistant, more thermally stable coatings or substrate</li> </ul>	5
6.		<p><b>Fracture of centre insert</b> <b>caused by:</b></p> <ul style="list-style-type: none"> <li>• basic substrate/coatings too brittle</li> <li>• central position of internal insert too high (insert protrudes over centre)</li> </ul>	<p><b>rectified by:</b></p> <ul style="list-style-type: none"> <li>• tougher coatings and substrate</li> <li>• check lower central position of internal insert</li> <li>• use centre plate with stronger chamfering</li> <li>• use internal and external insert with same geometry</li> </ul>	6



1

Coolant flow / coolant pressure:



5

- **Important note!** On exit of the drill a disc as shown is ejected. With rotating components this can cause accidents. Please arrange suitable guarding.



- The technical notes provided in the application details depend on the environmental and application conditions (such as machine, environmental temperature, lubrication/coolant used and desired machining results): these are based on proper application conditions, use and compliance with the spindle speed limits given for the tools.

7

- To prevent damage to machine and tool, we recommend that the drive power be calculated in advance (see performance calculation). The drive power which is actually available will be found in the machine manufacturer's spindle speed/performance diagram.

- Safety equipment should be provided to protect personnel from flying chips. Please see our safety note (enclosed with packing).

8

- To ensure the best possible tool life, the insert should be changed promptly.

Acceptable width of flank wear marks on inserts:

W29 10... to W29 18...	VB max = 0.20 mm
W29 24... to W29 34...	VB max = 0.25 mm
W29 42... to W29 58...	VB max = 0.30 mm

The application details given depend on the environmental and application conditions (e.g. machine, ambient temperature, lubricant/coolant used and machining result required): they are based on the correct application conditions, correct use and compliance with the spindle speed limits given for the tools.

All measurement specifications stated in the catalogue apply to the metric unit system, unless they are expressly identified using another unit of measurement.

### Hazard warning:

If using tungsten carbide-based hard metal products together with cobalt as a binder metal, please read our safety data sheets, which are available for you to download from our website.

(<http://www.kometgroup.com/navigation-top/download/service/datenblaetter.html>)

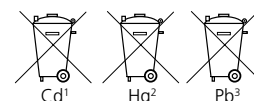
### Balancing note:

Tool holders or adaptors are only balanced as supplied, i.e. no allowance has been made for items which can alter this, such as boring tools, milling cutters, inserts, etc. When used at high speeds, we recommend precision balancing be carried out when the tool is fitted ready for use.

In accordance with German battery legislation, we are required to state the following:

Do not dispose of old batteries along with household waste. You can return used batteries free of charge to our shipping depot. As a consumer, you are legally obliged to return old batteries.

Batteries containing hazardous substances are marked with a crossed-out wheelie bin and the chemical symbol (Cd, Hg or Pb) that determines its classification as a hazardous-substance-containing heavy metal:

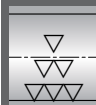


¹ „Cd“ stands for cadmium

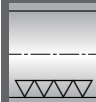
² „Hg“ stands for mercury

³ „Pb“ stands for lead

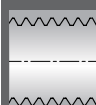
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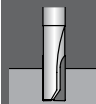
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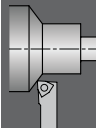
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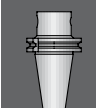
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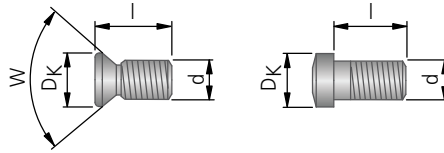
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# KOMET

## Clamping screw



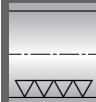
Order No.	Article	Packing unit piece	Thread d	Length l	Screw head taper angle		Screw turning slot			Tightening torque Nm
					DK	W	TorxPlus	WAF	Torx	
N00 55050	M3x7,8 /75°	10	3	7,8	4,5	75°		1,5		2,25
N00 55060	M3,5x9,4/60°	10	3,5	9,4	4,6	60°		1,5		2,8
N00 55070	M3,5x11,4/60°	10	3,5	11,4	4,6	60°		1,5		2,8
N00 55100	M4,5x12,4	10	4,5	12,4	5,9			2,5		4,5
N00 55110	M4,5x14,5	10	4,5	14,5	5,9			2,5		4,5
N00 55120	M4,5x16,4	10	4,5	16,4	5,9			2,5		4,5
N00 55130	M4,5x18,7	10	4,5	18,7	5,9			2,5		4,5
N00 55140	M4,5x22,5	10	4,5	22,5	5,9			2,5		4,5
N00 55180	M5,5x29,2	10	5,5	29,2	7,1			3		6,5
N00 55551	M2,5x2,8-8IP	10	2,5	2,8	3,45		8IP			1,28
N00 55561	M2,5x4-8IP	10	2,5	4	3,45		8IP			1,28
N00 55571	M2,5x6-8IP	10	2,5	6	3,45		8IP			1,28
N00 55581	M2,5x4,5-8IP	10	2,5	4,5	3,45		8IP			1,28
N00 55701	M3,5x5-8IP	10	3,5	5	5,15		8IP			2,25
N00 55711	M3,5x7,4-8IP	10	3,5	7,4	5,15		8IP			2,25
N00 55801	M4,5x6-10IP	10	4,5	6	6,05		10IP			4,3
N00 55811	M4,5x7-10IP	10	4,5	7	6,05		10IP			4,3
N00 55821	M4,5x9-10IP	10	4,5	9	6,05		10IP			4,3
N00 55851	M5x13,5-15IP	10	5	13,5	7,25		15IP			6,25
N00 55891	M5,5x8,5-20IP	10	5,5	8,5	7,25		20IP			6,25
N00 55901	M5,5x13,5-20IP	10	5,5	13,5	7,25		20IP			6,25
N00 56011	S/M1,8x2,9-5IP	10	1,8	2,95	2,4	75°	5IP			0,38
N00 56021	S/M2x3,8-6IP	10	2	3,8	2,7	75°	6IP			0,62
N00 56031	S/M2x4,9-6IP	10	2	4,9	2,7	75°	6IP			0,62
N00 56041	S/M2x4,3-6IP	10	2	4,3	2,7	75°	6IP			0,62
N00 56051	S/M1,8x3,8-5IP	10	1,8	3,85	2,4	75°	5IP			0,38
N00 56101	S/M2,6x5,2-8IP	10	2,6	5,2	3,4	75°	8IP			1,28
N00 56111	S/M2,6x6,2-8IP	10	2,6	6,2	3,4	75°	8IP			1,28
N00 56121	S/M2,6x4,7-8IP	10	2,6	4,7	3,4	75°	8IP			1,28
N00 56201	S/M3,5x6,2-10IP	10	3,5	6,2	4,65	75°	10IP			2,8
N00 56211	S/M3,5x7,3-10IP	10	3,5	7,3	4,65	75°	10IP			2,8
N00 56301	S/M4x8-10IP	10	4	8	5,15	75°	10IP			4,3
N00 56401	S/M5x9,4-20IP	10	5	9,4	6,65	75°	20IP			6,25
N00 56411	S/M5x13,4-20IP	10	5	13,4	6,65	75°	20IP			6,25
N00 56591	S2247-6IP	10	2,2	4,7	3,15	60°	6IP			1,01
N00 56651	S2560-8IP	10	2,5	6	3,5	55°	8IP			1,28
N00 56751	S3574-10IP	10	3,5	7,4	5,5	55°	10IP			2,8
N00 56771	S35102-10IP	10	3,5	10,25	5,5	55°	10IP			2,8
N00 56811	S40101-20IP	10	4	10,1	7,2	60°	20IP			4,3
N00 56851	S45111-20IP	10	4,5	11,1	6,9	55°	20IP			6,25
N00 56861	S4514-20IP	10	4,5	14	6,9	55°	20IP			4,3
N00 57191	S2043-6IP	10	2	4,3	2,7	55°	6IP			0,62
N00 57201	S2536-7IP	10	2,5	3,6	3,5	55°	7IP			0,9
N00 57211	S2542-8IP	10	2,5	4,2	3,5	55°	8IP			1,28
N00 57221	S2553-7IP	10	2,5	5,3	3,5	55°	7IP			0,9
N00 57241	S3070-8IP	10	3	7	4,3	55°	8IP			2,25

Order No.	Article	Packing unit  piece	Thread  d	Length  l	Screw head taper angle		Screw turning slot		Tightening torque  Nm
					D <sub>K</sub>	W	 TorxPlus	 TORX	
N00 57251	S3076-8IP	10	3	7,6	4,3	55°	8IP		2,25
N00 57261	S3575-15IP	10	3,5	7,5	5,5	55°	15IP		2,8
N00 57271	S3585-15IP	10	3,5	8,5	5,5	55°	15IP		2,8
N00 57281	S3598-15IP	10	3,5	9,8	5,5	55°	15IP		2,8
N00 57301	S45100-20IP	10	4,5	10	6,4	55°	20IP		6,25
N00 57321	S2556-8IP	10	2,5	5,6	3,8	50°	8IP		1,28
N00 57341	S3066-9IP	10	3	6,6	4,4	60°	9IP		2,5
N00 57411	S40101-15IP	10	4	10,1	5,5	60°	15IP		4,3
N00 57421	S/M4,5x7,8-15IP	10	4,5	7,8	6,7	60°	15IP		6,25
N00 57431	S3066-8IP	10	3	6,6	5	55°	8IP		2,25
N00 57440	S4089-15IP	10	4	8,9	5,5	55°	15IP		4,3
N00 57450	S50115-20IP	10	5	11,5	7,4	55°	20IP		6,25
N00 57460	S55140-20IP	10	5,5	14	8,2	55°	20IP		6,25
N00 57470	S60160-20IP	10	6	16	8,8	55°	20IP		6,25
N00 57480	S2564-8IP	10	2,5	6,4	3,5	55°	8IP		1,28
N00 57490	S3074-8IP	10	3	7,4	4,3	55°	8IP		2,25
N00 57500	S45105-20IP	10	4,5	10,5	6,4	55°	20IP		6,25
N00 57511	S/M2,5x7,2-8IP	10	2,5	7,2	3,4	75°	8IP		1,28
N00 57521	S/M3,5x7,3-10IP	10	3,5	7,3	5,1	75°	10IP		2,8
N00 57531	S/M4,5x9-15IP	10	4,5	9	6,0	75°	15IP		6,25
N00 57541	S/M5,5x11-20IP	10	5,5	11	7,2	75°	20IP		6,25
N00 57553	S/M2,2x5,5-6IP	10	2,2	5,5	3,1	75°	6IP		1,01
N00 57571	S/M2,5x6,3-8IP	10	2,5	6,3	3,4	75°	8IP		1,28
N00 57611	S/M3,5x6,6-10IP	10	3,5	6,6	5,1	75°	10IP		2,8
N00 57630	S/M3x5,8-8IP	10	3	5,8	3,8	75°	8IP		2,25
N00 57640	S/M3,5x6,9-10IP	10	3,5	6,9	4,6	75°	10IP		2,8
N00 57650	S/M4x8,7-15IP	10	4	8,7	5,3	75°	15IP		4,3
N00 57660	S/M2,2x4,8-6IP	10	2,2	4,8	2,9	75°	6IP		1,01
N00 57670	S/M5x10,4-20IP	10	5	10,4	6,6	75°	20IP		6,25
N00 57710	S3090-9IP	10	3	9	4,4	60°	9IP		2,5
N00 57780	S/M2,5x8,8-8IP	10	2,5	8,8	3,4	75°	8IP		1,28
N00 57790	S/M3,5x7,3-10IP	10	3,5	7,3	5,1	75°	10IP		2,8
N00 57810	S40120-15IP	10	4	12	5,5	60°	15IP		4,3
N00 57820	S2550-T8-55°	10	2,5	5,0	3,45	55°		T8	1,2
N00 57830	S3073-T8-55°	10	3	7,3	4,1	55°		T8	2
N00 57840	S3075-10IP	10	3	7,5	4,2	55°	10IP		2
N00 57860	S3572-T15-55°	10	3,5	7,2	5,2	55°		T15	3,2
N00 57870	S3586-T15-55°	10	3,5	8,6	5,2	55°		T15	3,2
N00 57880	S45105-T20-55°	10	4,5	10,5	6,6	55°		T20	5
N00 57890	S40110-15IP	10	4	11,0	6,6	55°	15IP		4,3
N00 57900	S45130-20IP	10	4,5	13,0	5,3	55°	20IP		5
N00 57910	S4085-T15-55°	10	4	8,5	5,3	55°		T15	4,25
N00 57920	S40110-T15	10	4	11,0	5,3	55°		T15	4,25

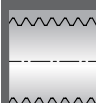
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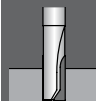
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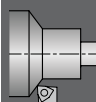
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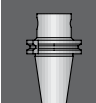
4



5



6



7



8



# KOMET

## Allocation of indexable insert to clamping screw



Insert	Clamping screw		Image
	Size	Order No. Article	
<b>W00</b> WOHX			
W00 04..	<b>N00 56011</b>	S/M1,8x2,9-5IP	
W00 10..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W00 17..	<b>N00 55581</b>	M2,5x4,5-8IP	
	<b>N00 55551*</b>	M2,5x2,8-8IP	
	<b>N00 55561*</b>	M2,5x4-8IP	
W00 24..	<b>N00 55571</b>	M2,5x6-8IP	
	<b>N00 55561*</b>	M2,5x4-8IP	
	<b>N00 55581*</b>	M2,5x4,5-8IP	
W00 34..	<b>N00 55701</b>	M3,5x5-8IP	
	<b>N00 55711</b>	M3,5x7,4-8IP	
W00 42..	<b>N00 55811</b>	M4,5x7-10IP	
	<b>N00 55801*</b>	M4,5x6-10IP	
W00 50..	<b>N00 55821*</b>	M4,5x9-10IP	
	<b>N00 55811</b>	M4,5x7-10IP	
W00 58..	<b>N00 55891</b>	M5,5x8,5-20IP	
	<b>N00 55901*</b>	M5,5x13,5-20IP	
<b>W01</b> WOHX			
W01 10..	<b>N00 56041</b>	S/M2x4,3-6IP	
W01 18..	<b>N00 57553</b>	S/M2,2x5,5-6IP	
W01 24..	<b>N00 57511</b>	S/M2,5x7,2-8IP	
W01 34..	<b>N00 57521</b>	S/M3,5x7,3-10IP	
W01 42..	<b>N00 57531</b>	S/M4,5x9-15IP	
W01 50..	<b>N00 57531</b>	S/M4,5x9-15IP	
W01 58..	<b>N00 57541</b>	S/M5,5x11-20IP	
<b>W04</b> WNHX			
W04 22..	<b>N00 55050</b>	M3x7,8 /75°-C1,5	
	<b>N00 55050</b>	M3x7,8 /75°-C1,5	
W04 34..	<b>N00 55060</b>	M3,5x9,4/60°-C1,5	
	<b>N00 55070</b>	M3,5x11,4/60°-C1,5	
W04 42..	<b>N00 55100</b>	M4,5x12,4-C2,5	
	<b>N00 55110</b>	M4,5x14,5-C2,5	
W04 50..	<b>N00 55130</b>	M4,5x18,7-C2,5	
	<b>N00 55120</b>	M4,5x16,4-C2,5	
W04 58..	<b>N00 55140</b>	M4,5x22,5-C2,5	
	<b>N00 55180</b>	M5,5x29,2-C3	
<b>W24</b>			
W24 12..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W24 20..	<b>N00 56651</b>	S2560-8IP	
<b>W27</b>			
W27 12..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W27 20..	<b>N00 56651</b>	S2560-8IP	
<b>W28</b> WOEX			
W28 10..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W28 17..	<b>N00 55581</b>	M2,5x4,5-8IP	
	<b>N00 55551*</b>	M2,5x2,8-8IP	
	<b>N00 55561*</b>	M2,5x4-8IP	

Insert	Clamping screw		Image
	Size	Order No. Article	
W28 24..	<b>N00 55571</b>	M2,5x6-8IP	
	<b>N00 55561*</b>	M2,5x4-8IP	
W28 34..	<b>N00 55581*</b>	M2,5x4,5-8IP	
	<b>N00 55701</b>	M3,5x5-8IP	
W28 42..	<b>N00 55711</b>	M3,5x7,4-8IP	
	<b>N00 55811</b>	M4,5x7-10IP	
W28 50..	<b>N00 55801*</b>	M4,5x6-10IP	
	<b>N00 55821*</b>	M4,5x9-10IP	
W28 58..	<b>N00 55811</b>	M4,5x7-10IP	
	<b>N00 55821*</b>	M4,5x9-10IP	
W28 72..	<b>N00 55891</b>	M5,5x8,5-20IP	
	<b>N00 55901*</b>	M5,5x13,5-20IP	
<b>W29</b> WOEX			
W29 04..	<b>N00 56051</b>	S/M1,8x3,8-5IP	
W29 10..	<b>N00 56041</b>	S/M2x4,3-6IP	
W29 18..	<b>N00 57553</b>	S/M2,2x5,5-6IP	
W29 24..	<b>N00 57511</b>	S/M2,5x7,2-8IP	
W29 34..	<b>N00 57521</b>	S/M3,5x7,3-10IP	
	<b>N00 57790**</b>	S/M3,5x7,3-10IP	
W29 42..	<b>N00 57531</b>	S/M4,5x9-15IP	
W29 50..	<b>N00 57531</b>	S/M4,5x9-15IP	
W29 58..	<b>N00 57541</b>	S/M5,5x11-20IP	
<b>W30</b> TOHX   TOGX			
W30 04..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W30 14..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56101*</b>	S/M2,6x5,2-8IP	
W30 26..	<b>N00 56121*</b>	S/M2,6x4,7-8IP	
	<b>N00 56201</b>	S/M3,5x6,2-10IP	
W30 44..	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
	<b>N00 56401</b>	S/M5x9,4-20IP	
	<b>N00 56411*</b>	S/M5x13,4-20IP	
<b>W32</b> TPHX			
W32 03..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W32 13..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56101*</b>	S/M2,6x5,2-8IP	
W32 18..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56121*</b>	S/M2,6x4,7-8IP	
W32 23..	<b>N00 56201</b>	S/M3,5x6,2-10IP	
	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
W32 32..	<b>N00 56301</b>	S/M4x8-10IP	
W32 44..	<b>N00 56401</b>	S/M5x9,4-20IP	
	<b>N00 56411*</b>	S/M5x13,4-20IP	
<b>W34</b> TOHT			
W34 18..	<b>N00 56651</b>	S2560-8IP	
W34 32..	<b>N00 56751</b>	S3574-10IP	
	<b>N00 56771</b>	S35102-10IP	

Insert	Clamping screw		Image
	Size	Order No. Article	
<b>W37</b> TPHB			
W37 18..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56101*</b>	S/M2,6x5,2-8IP	
W37 23..	<b>N00 56121*</b>	S/M2,6x4,7-8IP	
	<b>N00 56201</b>	S/M3,5x6,2-10IP	
W37 32..	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
	<b>N00 56301</b>	S/M4x8-10IP	
<b>W57</b> TOHX   TOGX			
W57 04..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W57 14..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56101*</b>	S/M2,6x5,2-8IP	
W57 26..	<b>N00 56121*</b>	S/M2,6x4,7-8IP	
	<b>N00 56201</b>	S/M3,5x6,2-10IP	
W57 26..	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
<b>W58</b> TPHX			
W58 03..	<b>N00 56031</b>	S/M2x4,9-6IP	
	<b>N00 56021*</b>	S/M2x3,8-6IP	
W58 13..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56101*</b>	S/M2,6x5,2-8IP	
W58 18..	<b>N00 56111</b>	S/M2,6x6,2-8IP	
	<b>N00 56121*</b>	S/M2,6x4,7-8IP	
W58 23..	<b>N00 56201</b>	S/M3,5x6,2-10IP	
	<b>N00 56211*</b>	S/M3,5x7,3-10IP	
W58 32..	<b>N00 56301</b>	S/M4x8-10IP	
<b>W59</b> TOHT			
W59 18..	<b>N00 56651</b>	S2560-8IP	
W59 32..	<b>N00 56751</b>	S3574-10IP	
	<b>N00 56771</b>	S35102-10IP	
<b>W60</b> DOHT			
W60 18..	<b>N00 56651</b>	S2560-8IP	
W60 32..	<b>N00 56751</b>	S3574-10IP	
	<b>N00 56771</b>	S35102-10IP	
<b>W78</b> VOHT   VOGW			
W78 18..	<b>N00 56651</b>	S2560-8IP	
W78 32..	<b>N00 56751</b>	S3574-10IP	
	<b>N00 56771</b>	S35102-10IP	
<b>W79</b> DOHT			
W79 18..	<b>N00 56651</b>	S2560-8IP	
W79 32..	<b>N00 56751</b>	S3574-10IP	
	<b>N00 56771</b>	S35102-10IP	
<b>W80</b> SOGX			
W80 10..	<b>N00 56051</b>	S/M1,8x3,8-5IP	
W80 12..	<b>N00 56041</b>	S/M2x4,3-6IP	
W80 18..	<b>N00 57553</b>	S/M2,2x5,5-6IP	
W80 20..	<b>N00 57553</b>	S/M2,2x5,5-6IP	
W80 24..	<b>N00 57571</b>	S/M2,5x6,3-8IP	
W80 28..	<b>N00 57251</b>	S3076-8IP	
W80 32..	<b>N00 57261</b>	S3575-15IP	
W80 38..	<b>N00 57261</b>	S3575-15IP	
W80 42..	<b>N00 57301</b>	S45100-20IP	
W80 46..	<b>N00 57301</b>	S45100-20IP	

## Allocation of indexable insert to clamping screw

Insert	Clamping screw	
	Size	Article
<b>W82</b> SOHX		
W82 32..	N00 57261	S3575-15IP
<b>W83</b> SOEX		
W83 13..	N00 56041	S/M2x4,3-6IP
W83 18..	N00 57553	S/M2,2x5,5-6IP
W83 23..	N00 57571	S/M2,5x6,3-8IP
	N00 57780**	S/M2,5x8,8-8IP
W83 32..	N00 57261	S3575-15IP
W83 39..	N00 57271	S3585-15IP
W83 44..	N00 57301	S45100-20IP
<b>W83</b> SPGT/SPGW		
W83 18..	N00 57221	S2553-7IP
W83 32..	N00 57261	S3575-15IP
W83 44..	N00 56851	S45111-20IP
<b>W84</b>		
W84 18..	N00 56651	S2560-8IP
W84 32..	N00 56771	S35102-10IP
<b>W85</b> CPGT/CPGW		
W85 09..	N00 57191	S2043-6IP
W85 18..	N00 57221	S2553-7IP
W85 18.. .01   .02	N00 56651	S2560-8IP
W85 23..	N00 57341	S3066-9IP
W85 32..	N00 57261	S3575-15IP
W85 32.. .02   .03 .04   .05	N00 56751	S3574-10IP
W85 44..	N00 56851	S45111-20IP
<b>W86</b>		
W86 18..	N00 56651	S2560-8IP
W86 32..	16301 00537	
<b>W89</b> VCMT/VBMT		
W89 23..	51560 74551	
W89 32.. .05   .06	16301 00537	
W89 32.. .07   .08	N00 57271	S3585-15IP
<b>C79</b> VBG T   VBGW		
C79 03..	N00 56031	S/M2x4,9-6IP
C79 18..	N00 57221	S2553-7IP
C79 32..	N00 57271	S3585-15IP
<b>C83</b> SCMT   SCGW		
C83 32..	N00 57261	S3575-15IP
C83 44..	N00 56851	S45111-20IP
<b>C84</b> TCGT   TCGW		
C84 13..	N00 57660	S/M2,2x4,8-6IP
C84 18..	N00 56651	S2560-8IP
C84 32..	N00 56771	S35102-10IP
<b>C85</b> CCGT   CCGW		
C85 18..	N00 57221	S2553-7IP
C85 32..	N00 56751	S3574-10IP
C85 44..	N00 56851	S45111-20IP

Insert	Clamping screw	
	Size	Article
<b>C86</b> DCGT   DCGW		
C86 18..	N00 56651	S2560-8IP
C86 32..	N00 57261	S3575-15IP
<b>C87</b> RCGT   RCGW		
C87 34..	N00 57261	S3575-15IP
<b>C88</b> RCGT   RCGW		
C88 17..	N00 57221	S2553-7IP
C88 24..	N00 57341	S3066-9IP
C88 34..	N00 57261	S3575-15IP
C88 42..	N00 57261	S3575-15IP
<b>C89</b> VCGT   VCGW		
C89 03..	N00 56031	S/M2x4,9-6IP
C89 18..	N00 57221	S2553-7IP
C89 32..	N00 57271	S3585-15IP
<b>C95</b> CPGT   CPGW		
C95 09..	N00 57191	S2043-6IP
C95 18..	N00 57221	S2553-7IP
C95 23..	N00 57341	S3066-9IP
C95 32..	N00 57261	S3575-15IP
C95 44..	N00 56851	S45111-20IP
<b>C98</b> RDHX		
C98 10..	N00 56051	SM1,8x3,8-5IP
C98 20..	N00 57221	S2553-7IP
C98 34..	N00 57261	S3575-15IP
C98 42..	N00 57261	S3575-15IP
<b>H60   H62</b> XOHX		
XOHX0802	N00 57660	S/M2,2x4,8-6IP
XOHX1003	N00 57630	S/M3x5,8-8IP
XOHX12T3	N00 57640	S/M3,5x6,9-10IP
XOHX1504	N00 57650	S/M4x8,7-15IP
XOHX2205	N00 57670	S/M5x10,4-20IP
<b>H80</b> LNHX		
LNHX09T3	N00 57251	S3076-8IP
LNHX1205	N00 57411	S40101-15IP
<b>Q09</b> SPGW   SPMT   SEHW   SEHT		
Q09 13..	N00 57221	S2553-7IP
Q09 18..	N00 57221	S2553-7IP
Q09 44..	N00 57301	S45100-20IP
Q09 53..	N00 57301	S45100-20IP
<b>Q12</b> TCAA   TNA A   TCAX   TNAX   TPAX		
Q12 18..	N00 57201	S2536-7IP
	N00 57211	S2542-8IP
	N00 57221	S2553-7IP
Q12 32.. .05   .06	N00 57231	S3056-8IP
Q12 32.. .07	N00 57241	S3070-8IP
Q12 32.. .08   .09	N00 57271	S3585-15IP
Q12 32.. .15   .16 .17	N00 57281	S3598-15IP
Q12 32.. .18   .19 .20	N00 57251	S3076-8IP

Insert	Clamping screw	
	Size	Article
Q12 32.. .38   .41 .42   .43	N00 57281	S3598-15IP
Q12 32.. .52   .53	N00 57431	S3066-8IP
Q12 44..	N00 57301	S45100-20IP
<b>Q15</b> CPMT   CPMW		
Q15 18..	N00 57221	S2553-7IP
Q15 32..	N00 57261	S3575-15IP
<b>Q21</b>		
Q21 24..	N00 57251	S3076-8IP
Q21 32..	N00 57261	S3575-15IP
Q21 44..	N00 57301	S45100-20IP
<b>Q33</b>		
Q33 18..	N00 56651	S2560-8IP
Q33 23..	N00 57241	S3070-8IP
	N00 57251	S3076-8IP
<b>Q36</b> APKT		
Q36 18..	N00 57321	S2556-8IP
Q36 24..	N00 57341	S3066-9IP
Q36 38..	N00 57411	S40101-15IP
<b>Q40</b> HOKT   HPCT   HPKT		
Q40 53..	N00 57890	S40110-15IP
<b>Q43</b> SDHT   SDKT   SDMX		
Q43 28..	N00 57830	S3073-T8-55°
Q43 38.. Ø24,5	N00 57910	S4085-T15-55°
Q43 38.. Ø32,5-92,5	N00 57890	S40110-15IP
<b>Q47</b> EOMT		
Q47 34.. Ø31,7	N00 57910	S4085-T15-55°
Q47 34.. Ø39,7-99,7	N00 57890	S40110-15IP
<b>Q55</b> RPMX   RPHX   RDHW   RDHX		
Q55 34..	N00 57840	S3075-10IP
Q55 42.. Ø25-32	N00 57910	S4085-T15-55°
Q55 42.. Ø40-100	N00 57890	S40110-15IP
<b>Q56</b> XPLT   XDLT   XOLT		
Q56 20..	N00 57820	S2550-T8-55°
Q56 32..	N00 57860	S3572-T15-55°
Q56 46..	N00 57880	S45105-T20-55°
<b>Q63</b> SOKU		
Q63 46..	N00 57890	S40110-15IP
Q63 53..	N00 57900	S45130-20IP
<b>Q75</b> RNKU   ROHU		
Q75 42..	N00 57890	S40110-15IP
<b>Q80</b> LNGU		
Q80 09..	N00 57191	S2043-6IP
Q80 20..	N00 57251	S3076-8IP
Q80 32..	N00 57411	S40101-15IP

\* only be used for special tools

\*\* tensile strength 1600 N/mm<sup>2</sup>



# KOMET ABS

## Even more perfectly joined

One benefit of the new version of the KOMET ABS connection is substantially higher clamping forces. It is fully compatible with the existing system, and also matches the original's high precision demands. In tooling systems, the tool adapter is an important element between the tool and machine.

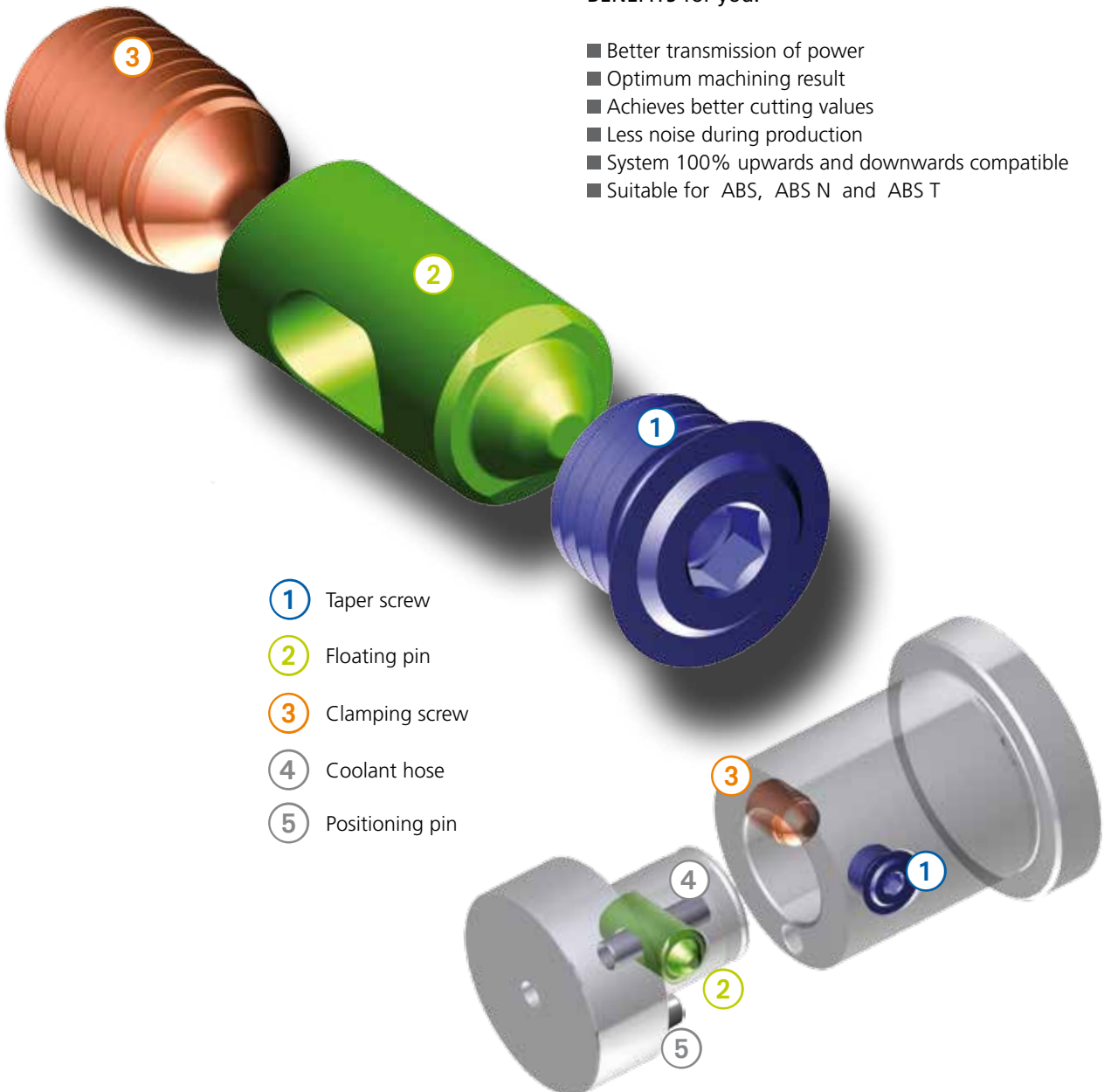
It must be able to transfer the machining forces safely. Moreover, tool adapters greatly influence the quality of the machining result. They also contribute to a cost efficient machining process. KOMET ABS connections form a modular coupling system for rotating and stationary tools. The interface system is designed according to the modular principle. In this way, users can quickly and cheaply make use of modular metal cutting tools, extensions or adaptors.

Since its launch by KOMET in 1981, the system has become established globally. It has fully developed components for each requirement.

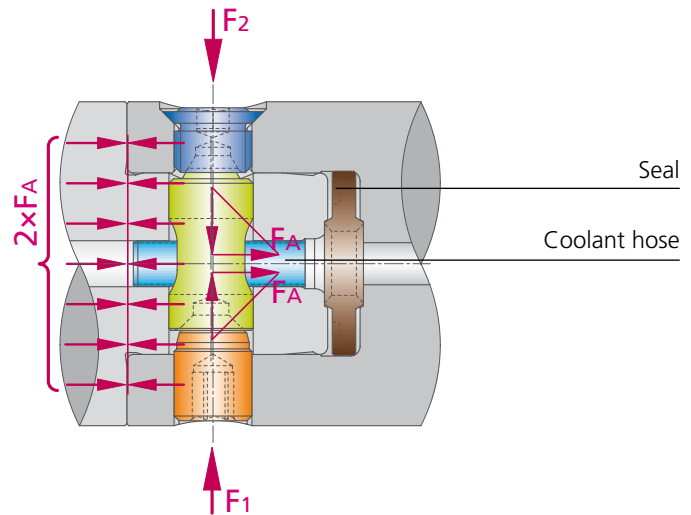
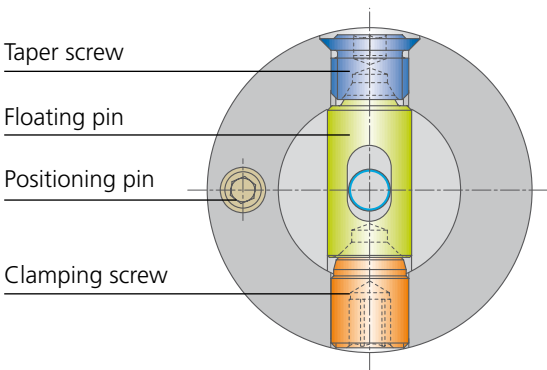
The new KOMET ABS is a technological leap forwards. The patented modifications have led to an increase of approx. 20 % in the clamping force. This means better transmission of power along with the corresponding effects on the machining result. During use, the new KOMET ABS connections are quieter, and can achieve better cutting values. On the other hand, it also means reduced tightening torque at a constant required clamping force. The service life of the assembly parts are therefore longer. With 100% system compatibility, existing and new components can be combined with each other.

### BENEFITS for you:

- Better transmission of power
- Optimum machining result
- Achieves better cutting values
- Less noise during production
- System 100% upwards and downwards compatible
- Suitable for ABS, ABS N and ABS T



- ① Taper screw
- ② Floating pin
- ③ Clamping screw
- ④ Coolant hose
- ⑤ Positioning pin



The ABS connection consists of a location (spindle) and a shank with spigot (tool). In addition to the cylindrical bore on the location, there are two cross threads with the clamping screw and the taper screw. On the shank section, in addition to the cylindrical pin with cross bore, there is a sliding pin and positioning pin.

By axially offsetting the clamping screw/taper screw and sliding pin, the tapered surfaces are brought into contact when the screws are tightened and produce double the expansion force through axial components  $2 \times F_A$ . If cutting forces or moments arise, there is sufficient play between the positioning pin and the positioning bore to allow for a specific, minimum torsion. Exact positioning is achieved with a suitable positioning pin. On tools where an accurately defined cutting position is required, positioning and torque transmission is by means of 2 key slots on the holder or 2 key blocks on the tool.

The exactly adjusted dimensions of the ABS System in conjunction with an extremely low amount of adjustment play produces minimum distortion from self-centering contact at four points. This in turn produces increased strength, a higher tool change repeatability and low vibration.

### Features / changes:

- The new ABS is generally compatible with all conventional ABS systems. You can see the variation possibilities illustrated above.
- Instead of a  $90^\circ$  tip, the floating pin now has a stepped shape at the flank towards the taper screw at which two contact parts are planned. Through the new shape, the basic body of the floating pin is longer and thus, a better guidance in the bore of the spigot is achieved.

The ABS coupling system is protected by patent application domestically and abroad.

Tools with the Original ABS connection system are manufactured and/or marketed exclusively by KOMET and companies specifically authorised by KOMET. All authorised (licensed) manufacturers are contractually bound to use manufacturing specifications supplied by KOMET.

Original ABS systems are identified with "ABS ... under licence to KOMET". All authorised ABS manufacturers guarantee a quality standard which complies with KOMET manufacturing specifications. Quality and safety is guaranteed subject to original ABS tools being correctly used. No guarantee can be given where tools are used with modular connections which are not identified as original ABS tools. This particularly applies for connections which are designed to be combined and used with original ABS tools.

Please ensure that tools are used with original ABS connections only.

- The taper screw was also improved by a new design with the features described above. This results in an increase of the clamping force and a higher accuracy of the ABS system.

Through the modifications mentioned, a better overall rigidity of the ABS system is achieved in addition. More efficient cutting tools can be used with the new ABS without any problems.



# KOMET ABS

## ABS N – The slotted ABS version

1

Taper screw

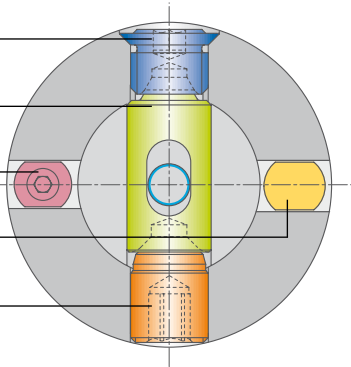
Sliding pin

2

Position key

Drive pin

Clamping screw



### Features:

For cutting operations which set high demands, the ABS system has been modified so that moment and cutting forces can be absorbed by high-precision slots. This of course ensures that the results from ABS and ABS N are consistently high.

### Compatibility:

- Standard ABS tools can be used in ABS N adaptors
- Because ABS tools can be easily converted, the tool can be held in standard adaptors.



High stability from ABS face connection with slots

3

4

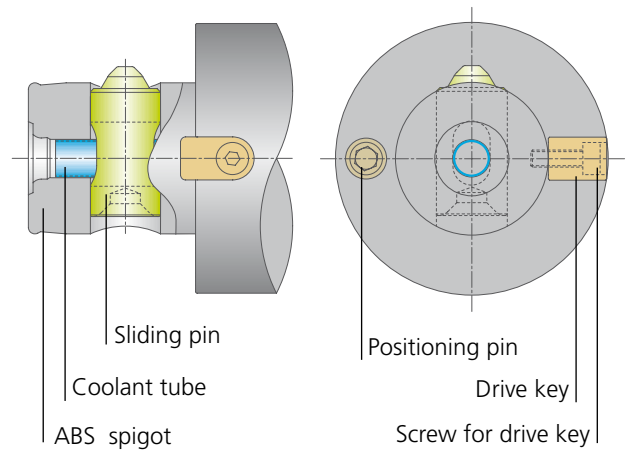
## ABS T – for increased torque requirements

### Features:

For cutting operations which set high demands, the ABS system has been modified so that moment and cutting forces can be absorbed by high-precision slots. This of course ensures that the results from ABS N and ABS T are consistently high.

### Compatibility:

- standard ABS T tools can be used in ABS N adaptors
- removal the drive key, ABS T tool can be held in standard adaptors ABS.



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HSK-A

ABS N

ABS T

ABS N

ABS T

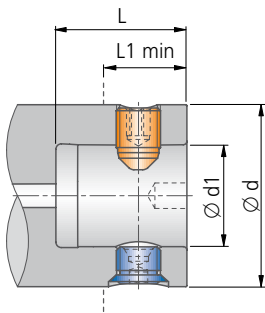
ISO

ABS N

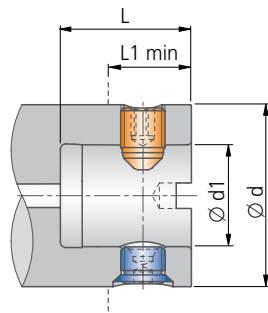
A colour code system is used for the ABS, ABS N and ABS T  $\varnothing d$  size so that selection of tools with a specific location size can be made quickly and accurately.

### Location hole

#### ABS



#### ABS N

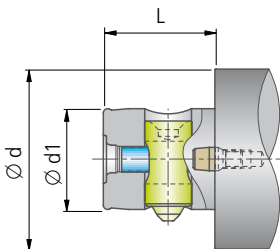


ABS / ABS N

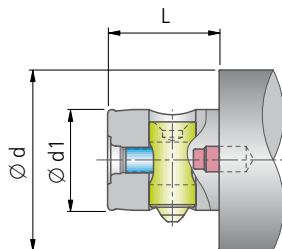
size	size	$\varnothing d$	$\varnothing d1$	L	L1 min.
ABS 25	ABS 25 N	25	13	24	13,0
ABS 32	ABS 32 N	32	16	27	16,0
ABS 40	ABS 40 N	40	20	31	18,5
ABS 50	ABS 50 N	50	28	36	22,0
ABS 63	ABS 63 N	63	34	43	28,0
ABS 80	ABS 80 N	80	46	48	34,0
ABS 100	ABS 100 N	100	56	60	40,5
ABS 125	ABS 125 N	125	70	76	51,0
ABS 160	ABS 160 N	160	90	96	65,0

### Location spigot

#### ABS



#### ABS N / ABS T



ABS / ABS N / ABS T

size	size	size	$\varnothing d$	$\varnothing d1$	L
ABS 25	ABS 25 N		25	13	20
ABS 32	ABS 32 N		32	16	23
ABS 40	ABS 40 N		40	20	26
ABS 50	ABS 50 N	ABS 50 T	50	28	31
ABS 63	ABS 63 N	ABS 63 T	63	34	38
ABS 80	ABS 80 N	ABS 80 T	80	46	43
ABS 100	ABS 100 N		100	56	55
ABS 125	ABS 125 N		125	70	70
ABS 160	ABS 160 N		160	90	90

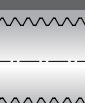
1



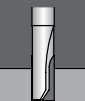
2



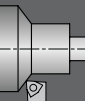
3



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# KOMET KomLoc HSK

## KomLoc clamping system

### Features of the system

- uncomplicated, low cost spindle contour
- small number of extremely sturdy components
- maximum clamping force
- specially suited to high speed machining (HSC)
- internal coolant supply
- practical ejector function

### Application area

There are numerous situations which require hollow taper shank tools to be clamped manual. The KOMET HSK clamping device is used universally on transfer lines, machining centres, turning machines, multi-head machines and setting devices.

- direct mounting on multi-spindle boring heads and short boring spindles
- spindle mounting and adaptor flanges
- adaptors as extensions or reducers

### Using the KomLoc clamping system

By using a hexagonal key, operating the KomLoc clamping system is quite simple. A low draw-in moment automatically

produces an excellent and stable clamping effect. In addition an axial movement or turning of the locking ring prevents dirt and chips from penetrating into the clamping mechanism.

### Ability for HSC (High Speed Cutting)

Because of the radially outward effect of the clamping action, the new KomLoc clamping system is almost predestined for use at high clamping speeds. The clamping cartridge is designed to be completely symmetric in rotation.

### Emulsion (water-miscible cooling lubricant)

Internal coolant supply is introduced by two coolant hoses which form a cage with the ejector and the distributor. This cage is supported on floating bearings and produces a seal for a coolant pressure of  $p > 2$  bar.

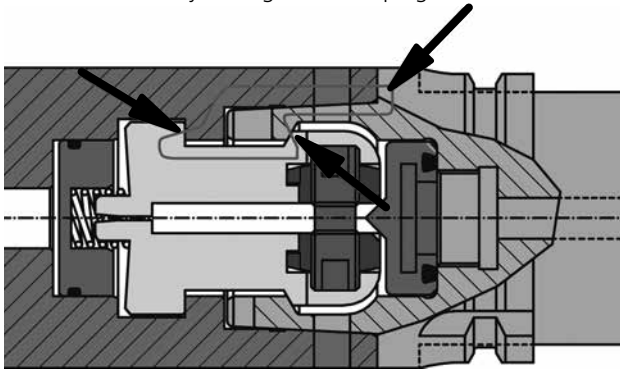
### Application details

By maintaining the correct draw-in moments and clamping forces the clamping device ensures an excellent transmission of the bending and torsion moments. The direction of these moments is not affected by the position of clamping cartridge.

## KomLoc HSK clamping system – System K

### Function

Force flows directly through the clamping claw



### Clamping mechanism

- The two clamping nuts are moved radially outwards by using a hexagonal key on the threaded spindle.
- The two clamping elements are applied to the clamping shoulder of the hollow taper shank.
- The high axial clamping force produces a positive connection.

### Release mechanism

Clamping is released by moving the two clamping elements inwards back to the block. This activates the ejector which releases the connection.

### Clamping force / Rigidity

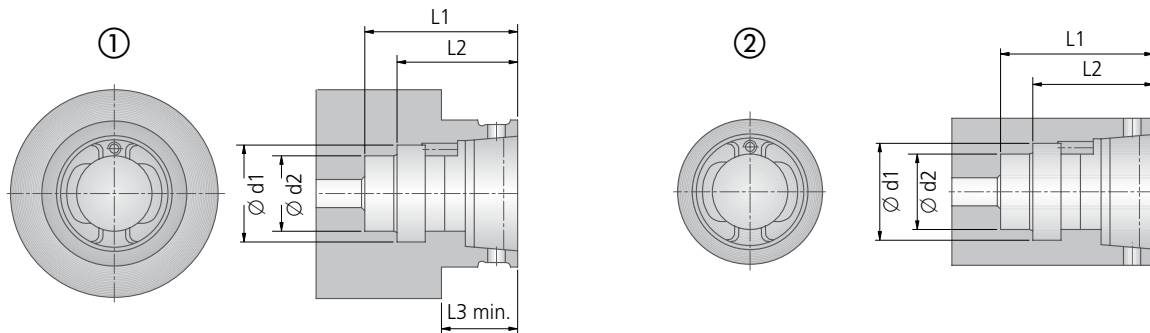
The high clamping forces (see table) produce excellent bending resistance.

Depending on the operation temperature and the lubrication on the clamping element, clamping forces may vary by  $\pm 15\%$ .

HSK size	WAF for operating	Torque setting (Nm)   Tension force (KN)				KOMET standard value			
		Nm	KN	Nm	KN	Nm	KN	Nm	KN
25	2	–	–	1	3,5	1,5	5,5	2	7
32	2,5	1,5	6,5	2	8	2,5	9	3,5	11
40	3	4	16	5	18	6	20	8	25
50	4	5	19	7,5	25	10	31	15	41
63	5	10	28	12,5	32	15	40	17,5	51
80	6	15	37	20	45	25	50	30	60
100	8	30	40	50	60	60	70	60	70



### Spindle contour



### Montage

The KomLoc clamping cartridge is extremely easy to fit. Insert the KomLoc cartridge, rotate 90° and secure with threaded pin. This can be effected from any side and requires no alignment.

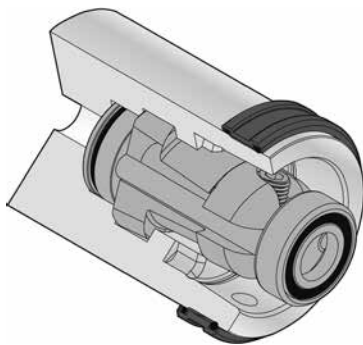
### Note

Sealing ring for use on short bore spindles to DIN 69002 in conjunction with centrifuge ring available on request.

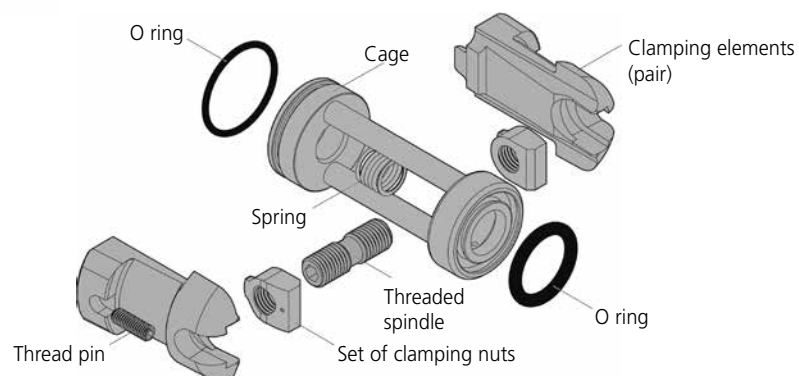
Detailed dimensional drawings can be supplied on request (free of charge).

Fitting dimensions					①		②	
HSK size	L1	L2	Ø d1	Ø d2	Sealing ring, shifting		Sealing ring, turning	Ball pressure screw
					Order No.	L3 min.	Order No.	Order No.
32	34,3	27,3	21,1	17,0		16	L07 01730	
40	42,4	33,8	26,4	21,0	L07 01440	19	L07 01740	N10 30738
50	53,0	42,2	33,0	26,0	L07 01450	24	L07 01750	N10 30739
63	65,0	52,8	42,5	34,0	L07 01460	29	L07 01761	N10 30740
80	84,8	67,6	52,8	42,0		37	L07 01771	N10 30741
100	106,0	84,4	66,0	52,0	L07 01480	47		N10 30742

### Components



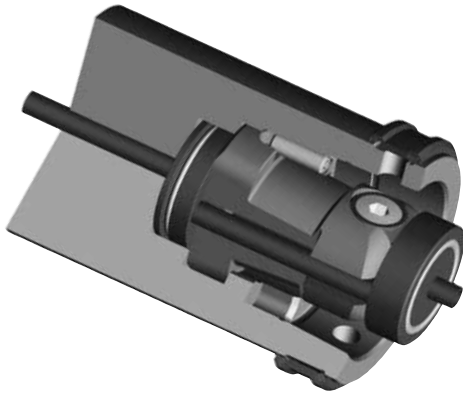
KomLoc Clamping cartridge	
Article	Order No.
System K IKZ-HSK25	L07 01020
System K IKZ-HSK32	L07 01030
System K IKZ-HSK40	L07 01040
System K IKZ-HSK50	L07 01050
System K IKZ-HSK63	L07 01060
System K IKZ-HSK80	L07 01070
System K IKZ-HSK100	L07 01080



# KOMET KomLoc HSK

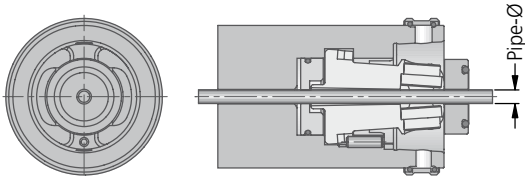
## KomLoc HSK clamping system – System K for MQL

1



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### Description / features

- KomLoc minimal lubrication clamping element with open central area
- through hose for supply of minimal lubrication
- high clamping force similar to KomLoc
- integral ejector
- compatible with existing KomLoc contour
- available in sizes HSK 40, 50, 63, 80 and 100
- operating key can be held on both sides

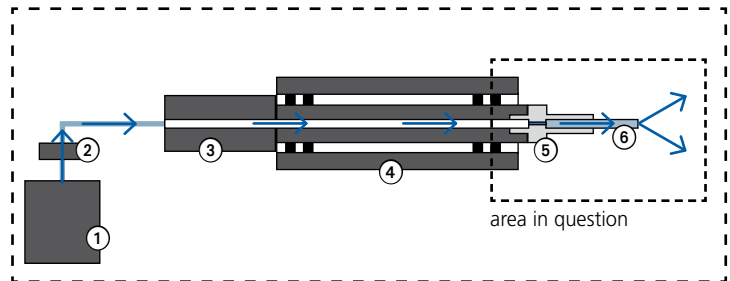
KomLoc System K

Article	Order No. with ejector	Pipe-Ø	Clamping force in kN
System K MQL-HSK40	L07 02040	3,9	20
System K MQL-HSK50	L07 02050	4,9	30
System K MQL-HSK63	L07 02060	6,9	40
System K MQL-HSK80	L07 02070	7,9	50
System K MQL-HSK100	L07 02080	9,9	70

### Overall system (MLC)

One important aspect for trouble-free functioning of the MLC system is the interplay of the individual elements in the overall minimal lubrication system. It is not generally sufficient for example for the tool just to be suitable for use with minimal lubrication. In fact all the elements need to be appropriately matched with one another.

machine tool

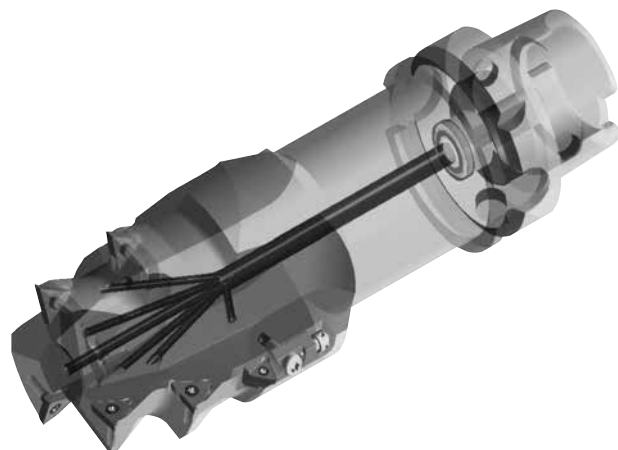


Components for an MLC machine tool

- ① MLC unit
- ② stop valve
- ③ rotating supply
- ④ operating spindle
- ⑤ toolholder
- ⑥ tool

### Tool design for minimal lubrication

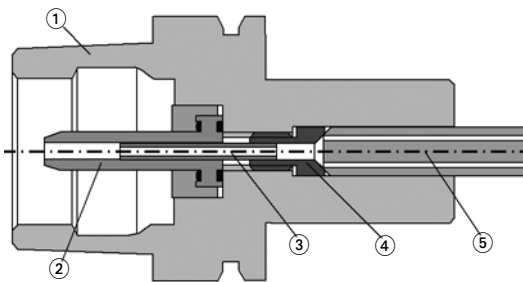
Our external engineers and our project team are at your disposal at any time for queries on concrete projects.



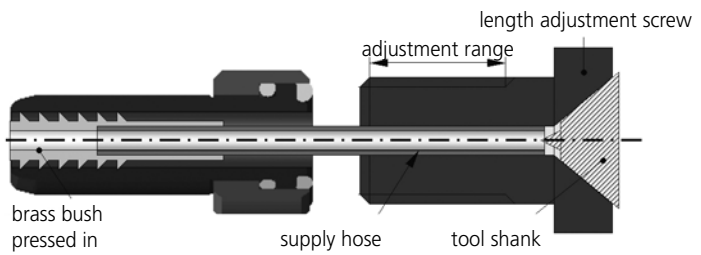
## KomLoc HSK clamping system – System K for MQL

### Automatic tool change

View of elements in question using an HSK connection as an example



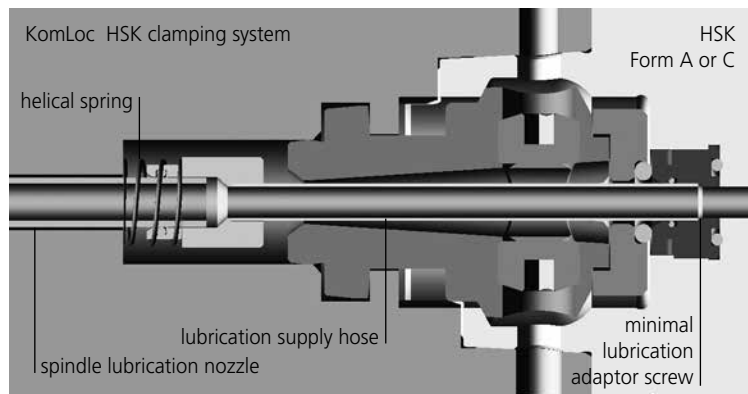
- ① toolholder
- ② coolant supply hose
- ③ minimal lubrication supply hose
- ④ length adjustment screw
- ⑤ tool



Accessories such as adjusting screws can be supplied for any chucks and supply hoses.

### Manual tool change

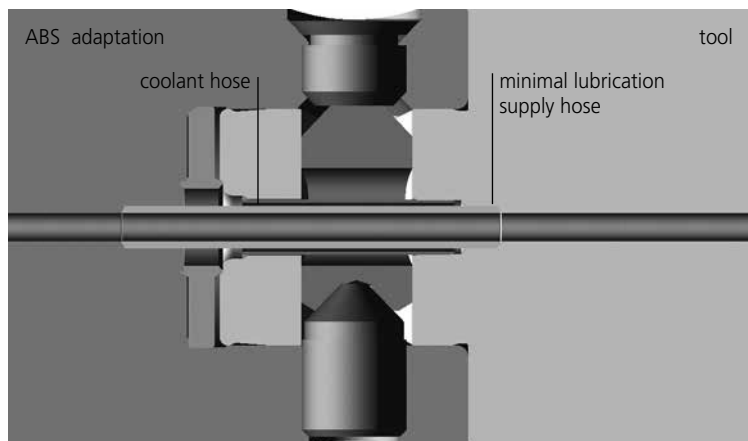
To successfully implement the manual clamping system, a solution for minimal lubrication supply on the machine was found for OEM projects. Here a system was applied which allowed the lubricant to be used in the best possible way. This solution involved connection by means of an HSK Form C adaptor with additional thread (as Form A) for the minimal lubricant adaptor screw to be fitted.



Layout for minimal lubrication with KomLoc HSK clamping system

### ABS modular connection

For ABS connections and ABS adaptors there are standard KOMET GROUP solutions. Please ask for information on the relevant projects. ABS connections usually involve connections with a tool or a form of adaptation with which an extension or a reduction is required.



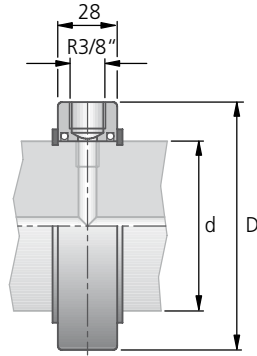
ABS supply solution for minimal lubrication



# KOMET

## Coolant supply ring for rotating adaptor

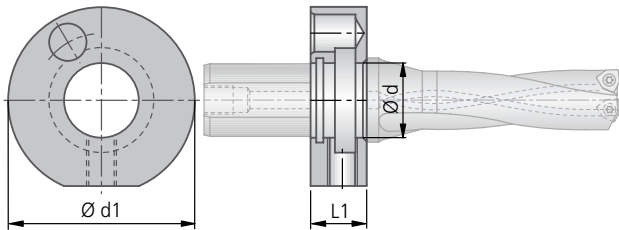
- For machines with manual tool change.
- Peripheral speed: 15 - 20 m/ sec.
- Coolant pressure up to approx. 10 bar.



Coolant supply ring KR D					
Order No. Article	d	D	kg	Sealing ring Order No.	Retaining ring DIN 471 Order No. Article
L01 00001 KR D 40	40	81	0,83	L01 00900	55231 04017 40x1,75
L01 00011 KR D 50	50	91	1,08	L01 00910	55231 05020 50x2
L01 00031 KR D 70	70	110	1,33	L01 00930	55231 07025 70x2,5
L01 00041 KR D 80	80	120	1,49	L01 00940	55231 08025 80x2,5
L01 00051 KR D 100	100	140	1,80	L01 00950	55231 10030 100x3

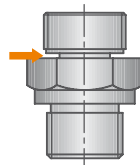
## Coolant supply ring for axial coolant supply

Coolant supply to DIN 69880



Coolant supply ring for NC adaptors				
Order No.	Ø d	Ø d1	L1	kg
L01 01100	30	68	15	0,34
L01 01000	40	83	15	0,46

## Coolant connection



Coolant connection	
Article	Order No.
KUB-3/8	L01 00800

### NOTE:

For safety reasons, only use a pipe connection with a definite shear point. Switch on coolant supply before starting operation. We recommend use of KOMET pipe connections to prevent any risk of accident from torn pipes should the coolant ring seize.

## A PLUS for our customers and the environment

### The company targets

KOMET pursues a consistent policy of investments and achieves long-term and profitable growth via continuous improvement of products and processes as well as via consistent qualification of employees. This increases the value of the company. KOMET consistently increases its innovation quota via research and development, offering the market new products every year. KOMET is a premium quality manufacturer and motivates employee qualification and customers. The training quota of vocational beginners is exemplary for the entire field of business.

### The products and services

KOMET products and services offer the customer incomparable added value. KOMET develops, manufactures and sells the comprehensive, modular portfolio on bore machining as full-range suppliers. KOMET offers the innovative technologies, thereby taking the high economic viability, best quality and most attractive designs into account. KOMET sees itself not purely as a tool manufacturer, but rather as suppliers of innovative solutions and ideas for the benefit of the customer.

### The customer

KOMET places value on long-term, binding customer relations, seeing itself as a partner of the customer in a balance of benefit supplies and benefit harvests.

KOMET records customers' demands and then produces the most effective ideas and tool solutions for their machining tasks. KOMET offers the customer information and collaboration via their worldwide presence in local Service Centres.

### The environment / surroundings

KOMET feels itself obliged to avoid any wastage, and therefore commits itself to responsible usage of raw materials and careful utilisation of remaining materials.

KOMET management is well aware of its responsibilities towards society, and creates the foundations for modern working environments and working conditions. The specifications on ergonomics and work safety are taken into account.


With these claims in mind, KOMET has introduced a modern, integrated management system, known as KMS (KOMET Management System), which is certified in accordance with ISO 9001:2015, ISO 14001:2015.

### Certification

<https://www.kometgroup.com/meta-navigation/downloads/zertifikate/>



# International material classification (to VDI 3323 standard)

Material	DIN 	AISI / SAAE 	BS EN 	AFNOR 	SS 	UNI 	UNE 	JIS 
1.0 1.0038	RS137-2	A570-36	4360 40C	E24-2NE	1311			
1.0 1.0116	St37-3	A573-81 65	4360 40B	E24-U	1312			
1.0 1.0144	St44-3	A573-81	4360 43C	E28-4	1412			
1.0 1.0201	St36	1006		Fd5	1160			
1.0 1.0345	H1	A515 65	1 501 161	A37CP	1330			
2.0 1.0401	C15	1015;1016;1017	080M15	CC12	1350	C15C16	F.111	
2.0 1.0402	C22	1020;1023	055M15;070M20 ... 2C	AF42C20;XC25;1C22	1450	C20; C21; C25	1C22F.112	S20C; S22C
2.0 1.0436	Ast45	A662C	1 501 224	A48FP	2103			
2.0 1.0443	G5-45	A27 65-35	A1	E23-45M				
2.0 1.0473	19Mn6	A537 1	1 501 224	A52CP	2101			
2.0 1.0501	C35	1035	060A35	CC35	1550	C35	F.113	
2.0 1.0503	C45	1043	080M46	AF65C45	1650	C45	F.5110	
2.0 1.0503	C45	1045	080M46	CC45	1650	C45	F.114	
2.0 1.0511	C40	1040	080M40	AF60C40		C40	F.114.A	
2.0 1.0535	C55	1055	070M55		1655	C55	F.115	
2.0 1.0551	G5-52	A27 70-36	A2	280-480M	1505			
2.0 1.0553	G5-60	A148 80-40	A3	320-560M	1606			
2.0 1.0577	Ast 52	A738	1 501 224	A52FP	2107			
2.0 1.0601	C60	1060	080A62 ... 43D	CC55		C60		
2.0 1.0841	St52-3	5120	150M19	20MC5	2172	Fe52	F.431	
2.0 1.1121	CK10	1010	045M10	XC10	1265	C10	F.1510-C10K	
2.0 1.1133	20Mn5	1022;1518	120M19	20M5	1132	G22Mn3;20Mn7	F.1515-20Mn6	SMnC420
2.0 1.1141	CK 15	1015, 1017	080M15	XC18	1370		F.1511	
2.0 1.1158	C25E;Ck25	1025	070M26	2C25;XC25	1450	C25	F.1120-C25k	S25C; S28C
2.0 1.1183	Cf35	1035	060A35	XC38T5	1572	C36		S35C
2.0 1.1191	Ck45	1042	080A47	XC45	1660	C45	F.1140	
2.0 1.1545	C105W1	W110	BW1A	Y105	1880	C36KU	F.5118	SK3
2.0 1.5415	15Mo3	ASTM A204Gr.A	1501-240	15D3	2912	16Mo3KW	16Mo3	STBA 12
2.0 1.5423	16Mo5	4520	1503-245-420			16Mo5	16Mo5	
2.0 1.5622	14Ni6	ASTM A350LF5		16N6		14Ni6	15Ni6	
2.1 1.0715	9SMn28	1213	230M07	S250	1912	CF9SMn28	11SMn28	SUM22
2.1 1.0718	9SMnPb28	12 L 13		S250Pb	1914	CF9SMnPb28	11SMnPb28	SUM22,3,4L
2.1 1.0722	10SPb20	11 L 08		10PbF2		CF10 SPb20	10SPb20	
2.1 1.0726	35S20	1140	212M36 ... 8M	35M F6	1957		F.210.G	
2.1 1.0727	45S20	1146		45M F4	1973			
2.1 1.0736	9SMn36	1215	240M07 ... 1b	S300		CF9SMn36	12SMn35	SUM25
2.1 1.0737	9SMnPb36	12 L 14		S300Pb	1926	CF9SMnPb36	12SMnP35	
3.0 1.0904	55Si7	9255	250A53 ... 45	55S7	2085	55Si8	56Si7	
3.0 1.0961	60SiCr8	9262		60SC6		60SiCr8	60SiCr8	
3.0 1.1157	40Mn4	1039	150M36 ... 15	35M5				
3.0 1.1167	36Mn5	1335	150M36	40M5	2120		36Mn5	SMn438(H)
3.0 1.1170	28Mn6	1330	150M28 ... 14A	20M5		C28Mn		SCMn1
3.0 1.1203	Ck55	1055	070M55	XC55		C50	F.1203-36MnG	S55C
3.0 1.1213	Cf53	1050	060A52	XC48T5	1674	C53		S50C
3.0 1.1221	Ck60	1064	060A62	XC65	1678	C60	F.1150	
3.0 1.1231	Ck67	1070	070A72	XC68	1770	C70	F.141	
3.0 1.1248	Ck75	1080	060A78	XC75	1774		F.5107	
3.0 1.1274	Ck101	1095	060A96	XC100	1870		F.5117	
3.0 1.2713	55NiCrMoV6	L6		55NCDV7			F.520.S	SKT4
3.0 1.2721	50NiCr13	L6		55NVCV6	2550		F.528.S	
3.0 1.3401	G-X120Mn12	ASTM A128 75	BW10	Z120M12	2183	GX120Mn12	AM-X120Mn12	SCMnH1
3.0 1.3505	100Cr6	52100	534A99 ... 31	100C6	2258	100Cr6	F.131	SUJ2
3.0 1.5662	X8Ni9	ASM A353	502-650	9 Ni		X10Ni9	F.2645	SL9N60(53)
3.0 1.5680	12Ni19	2515 (2517)	12Ni19	Z18N5		12Ni19	12Ni19	SL5N60
3.0 1.5710	36NiCr6	3135	640A35 ... 111A	35NC6				SNC236
3.0 1.5732	14NiCr10	3415		14NC11		16NiCr11	15NiCr11	SNC415(H)
3.0 1.5752	14NiCr14	3310	655M13 ... 36A	12NC15				SNC815(H)
3.0 1.6511	36CrNiMo4	9840	816M40 ... 110	40NCD3		36NiCrMo4(KB)	F.128	
3.0 1.6523	21NiCrMo2	8620, 8617	805M20 ... 362	20NCD2	2506	20NiCrMo2	20NiCrMo2	SNCM220(H)
3.0 1.6546	40NiCrMo22	8740, 8640, 8742	311-Type 7	40NCD2		40NiCrMo2(KB)	F.129	SNCM240
3.0 1.6582	35CrNiMo6	4340	817M40 ... 24	35NCD6	2541	35NiCrMo6(KB)	F.127	
3.0 1.6587	17CrNiMo6	4317	820A16	18NCD6			14NiCrMo13	
3.0 1.6657	14NiCrMo13-4	9310	832M13 ... 36C			15NiCrMo13	14NiCrMo131	
3.0 1.7015	15Cr3	5015	523M15	12C3				SCr415(H)
3.0 1.7033	34Cr4	5132	530A32 ... 18B	32C4		34Cr4(KB)	35Cr4	SCr430(H)
3.0 1.7035	41Cr4	5140	530M40 ... 18	42C4		41Cr4	42Cr4	SCr440(H)
3.0 1.7039	34MoCr54 G	L1	524A14		2092	105WCR 5		
3.0 1.7045	42Cr4	5140			2245		42Cr4	SCr440
3.0 1.7131	16MnCr5	5115	(527M20)	16MC5	2511	16MnCr5	16MnCr5	
3.0 1.7139	16MnCr5				2127			
3.0 1.7176	55Cr3	5155	527A60 ... 48	55C3				SUP9(A)
3.0 1.7218	25CrMo4	4130	1717CD5110	25CD4	2225	25CrMo4(KB)	55Cr3	SCM420/430
3.0 1.7220	34CrMo4	4135, 4137	34CrMo4	34CD4	2234	35CrMo4	34CrMo4	SCM435TK
3.0 1.7223	41CrMo4	4142				41CrMo4	42CrMo4	SNB 22-1
3.0 1.7225	42CrMo4	4140	708M40 ... 19A	42CD4	2244	42CrMo4	42CrMo4	SCM440(H)
3.0 1.7262	15CrMo5			12CD4	2216		12CrMo4	SCM415(H)
3.0 1.7335	13CrMo4 4	ASTM A182 F-12				14CrMo4 5	14CrMo45	
3.0 1.7337	16CrMo44	ASTM A387 12-2	1501 620	15CD 4.5	2216	12CrMo910		
3.0 1.7361	32CrMo12		722M24 ... 40B	30CD12	2240	32CrMo12	F.124.A	
3.0 1.7715	14MoV6 3		1503-660-440				13MoCrV6	
3.0 1.8159	50CrV4	6150				50CrV4	F.143	
3.0 1.8509	41CrAlMo7	ASTM A290	905M39 ... 41B	40CAD6, 12	2940	41CrAlMo7	41CrAlMo7	
3.0 1.8515	31 CeMo 12		722M24	30 CD 12	2240	30CrMo12	F.01712	
3.0 1.8523	39CrMoV13 9		897M39 ... 40C			36CrMoV12		
4.0 1.2067	100Cr6	L3		Y100C6			100Cr6	
4.0 1.2080	X210Cr12	D3	BD3	Z200C12		X210Cr13KU	X210Cr12	SKD1
4.0 1.2083	X42Cr13			X40Cr14	2314		F.5263	
4.0 1.2344	X40CrMoV5 1	H13	BH13	Z40CDV5	2242	X40CrMoV511KU	F.5318	SKD61

# International material classification (to VDI 3323 standard)

Material		DIN	AISI / SAAE	BS EN	AFNOR	SS	UNI	UNE	JIS
P	4.0 1.2363	X100CrMoV5 1	A2	BA2	Z100CDV5	2260	X100CrMoV51KU	F.5227	SKD12
	4.0 1.2379	X155CrVMo121	D2	BD2	Z160CDV12	2310	X155CrVMo12 1KU	F.520.A	SKD11
	4.0 1.2419	105WCr6			105WC13	2140	107WCr5	105WCr5	SKS31
	4.0 1.2436	X210 CrW 12	D4 (D6)	BD6	Z200CD12-01	2312	X215CrW12 1KU	F.5213	
	4.0 1.2542	45WCrV7	S1	BS1	45WCrV8	2710	45WCrV8KU	F.524	
	4.0 1.2581	X30WCrV9 3	H21	BH21	Z30WCV9		X30WCrV9 3KU	F.526	SKD5
	4.0 1.2601	X165CrMoV12				2310	X165CrMoV12KU	F.5211	
	4.1 1.3243	S6/5/2/5	M35	BM35	6-5-2-5	2723	H56 5 2 5	F.5613	SKH55
	4.1 1.3343	S6/5/2	M2	BM2	Z85WDCV	2722	H56 5 2	F.5604	SKH51
	4.1 1.3348	S2/9/2	M7		2 9 2	2782	H52 9 2		
S	5.0 -	CoCr22W14	AMS 5772		KC22				
	5.0 1.4362	X2CrNiN23 4	S32304		Z2CN23-04AZ	2327			
	5.0 1.4460	X8CrNiMo27-5	S32900			2324			
	5.0 1.4462	X2CrNiMoN2253	S31803		Z2CND22-05-03	2377			
	5.0 2.4375	NiCu30Al	4676	3072-76					
	5.0 2.4603	NiCr 30 FeMo	5390A		NC22FeD				
	5.0 2.4630	NiCr20Ti		HR5,203-4	NC20T				
	5.0 2.4631	NiCr20TiAk		Hr40,601	NC20TA				
	5.0 2.4856	NiCr22Mo9N	5666		NC22FeDNB				
	5.0 2.4973	NiCr19Co11	AMS 5399		NC19KDT				
	5.0 LW2.467	S-NiCr13A16	5391	3146-3	NC12AD				
	5.0 LW2.466	NiFe35Cr14	5660		ZSNCDT42				
	5.0 LW2.466	NiCr19Fe19	5383	HR8	NC19FeNb				
	5.0 LW2.466	NiCr19Fe19	AMS 5544		NC20K14				
	5.0 LW2.467	NiCo15Cr10	AMS 5397						
	5.0 LW2.496	CoCr20W15	5537C		KC20WN				
	5.1 -	TiAl4Mo4Sn4Si0.5							
	5.1 -	TiAl6V4ELI	AMS R56401	TA11					
	5.1 3.7114	TiAl5Sn2.5	AMS R54520	TA14/17	T-A5E				
	5.1 3.7164	TiAl6V4	AMS R56400	TA10-13/TA2	T-A6V				
M	6.0 1.4000	X7Cr13	403	403S17	Z6C13	2301	X6Cr13	F.3110	SUS403
	6.0 1.4006	X10Cr13	410	410S21 ... 56A	Z10C14	2302	X12Cr13	F.3401	SUS410
	6.0 1.4021	X20Cr13	420	420S37	Z20C13	2303	X20Cr13		
	6.0 1.4034	X46Cr13		420S45 ... 56D	Z40CM	2304	X40Cr14	F.3405	SUS420J2
	6.0 1.4057	X22CrNi17	431	431S29 ... 57	Z15CNi6.02	2321	X16CrNi16	F.3427	SUS431
	6.0 1.4104	X12CrMoS17	430F		Z10CF17	2383	X10CrS17	F.3117	SUS430F
	6.0 1.4112	X90 CrMoV 18	440B						
	6.0 1.4113	X6CrMo17	434	434S17	Z8CD17.01	2325	X8CrMo17		SUS434
	6.0 1.4305	X12CrNiS18 8	303	303S21 ... 58M	Z10CNF18.09	2346	X10CrNiS18.09	F.3508	SUS303
	6.0 1.4306	X2CrNiN18 9	304L	304S12	Z2CrNi18 10	2352	X2CrNi18 11	F.3503	SCS19
	6.0 1.4310	X12CrNi17 7	301		Z12CNi17.07	2331	X12CrNi17 07	F.3517	SUS301
	6.0 1.4311	X4CrNiN18 10	304LN	304S62	Z2CN18.10	2371			SUS304LN
	6.0 1.4313	X5CrNi13 4		425C11	Z4CND13.4M				SCS5
	6.0 1.4350	X5CrNi189	304	304S31 ... 58E	Z6CN18.09	2332/2333	X5CrNi18 10	F.3551	SUS304
	6.0 1.4401	X5CrNiMo18 10	316	316S16 ... 58J	Z2CND17.11	2347	X5CrNiMo17 12	F.3543	SUS316
	6.1 1.4429	X2CrNiMoN1813	316LN		Z2CND17.13	2375			SUS316LN
	6.1 1.4435	X2CrNiMo18 12	316L	316S13	Z2CND17.12	2353			X2CrNiMo17 12
	6.1 1.4438	X2CrNiMo18 16	317L	317S12	Z2CND19.15	2367			X2CrNiMo18 16
	6.1 1.4541	X10CrNiTi18 9	321	321S12 ... 58B	Z6CNT18.10	2337	X6CrNiTi18 11	F.3553	SUS321
	6.1 1.4542/1.4548	X5CrNiCuNb17-4-4	630		Z7CNU17-04				
	6.1 1.4550	X10CrNiNb	347	347S17 ... 58F	Z6CNNb18.10	2338	X6CrNiNb18 11	F.3552	SUS347
	6.1 1.4568/1.4504	X12CrNiAl177	17-7PH	316S111			Z8CNA17-07		X2CrNiMo1712
	6.1 1.4571	X10CrNiMoTi18	316Ti	320S17 ... 58J	Z6NDT17.12	2350	X6CrNiMoTi17 12	F.3535	
	6.1 1.4583	X10CrNiMoNb18	318		Z6CNDNb17 13B		X6CrNiMoNb	17 13	
	7.0 1.4718	X45CrSi9 3	HW 3	401S45 ... 52	Z45CS9		X45CrSi8	F.3220	SUH1
	7.0 1.4724	X10CrA113	405	403S17	Z10C13		X10CrA112	F.311	SUS405
	7.0 1.4742	X10CrA118	430	439S15 ... 60	Z10CAS18		X8Cr17	F.3113	SUS430
	7.0 1.4747	X80CrNiSi20	HNv6	443S65 ... 59	Z80CSN20.02		X80CrSiNi20	F.320B	SUH4
	7.0 1.4762	X10CrA124	446		Z10CAS24	2322	X16Cr26		SUH446
	7.0 1.4828	X15CrNiSi20 12	309	309S24	Z15CN520.12				SUH309
7.0 1.4845	X12CrNi25 21	310S	310S24	Z12CN25 20	2361	X6CrNi25 20	F.331	SUH310	
7.0 1.4864	X12NiCrSi	330		Z12NCS35.16				SUH330	
7.0 1.4865	G-X40NiCrSi		330C11			XG50NiCr		SCH15	
7.0 1.4871	X53CrMnNiN219	EV8	349S54	Z52CMN21.09		X53CrMnNiN		SUH35,SUH36	
K	8.0 0.6010	GG10	A48 20 B		Ft10D	01 10-00	G10	FG10	
	8.0 0.6015	GG15	A48 25 B	Grade 150	Ft15D	01 15-00	G14	FG15	
	8.0 0.6020	GG20	A48 30 B	Grade 220	Ft20D	01 20-00	G20	FG20	
	8.0 0.6025	GG25	A48 35 B	Grade 260	Ft25D	01 25-00	G25	FG25	
	8.0 0.6030	GG30	A48 45 B	Grade 300	Ft30D	01 30-00	G30	FG30	
	8.0 0.6035	GG35	A48 50 B	Grade 350	Ft35D	01 35-00	G35	FG35	
	8.0 0.6040	GG40	A48 60 B	Grade 400	Ft40D	01 40-00			
	9.0 0.7033	GGG35.3				07 17-1			
	9.0 0.7040	GGG40	60-40-18	SNG420/12	FGS400-12	07 17-0 2	G5400-12		FCD40
	9.0 0.7043	GGG40.3	0.7043	SNG370/17	FGS370-17	07 17-1 5	G5042/15		
	9.0 0.7050	GGG50	80-55-06	SNG500/7	FGS500-7	07 27-0 2	G5500/7		FCD50
	9.0 0.7060	GGG60		SNG600/3	FGS600-3	07 32-0 3	G5600/3		FCD60
	9.0 0.7070	GGG70	100-70-03	SNG700/2	FGS700-2	07 37-0 1	G5700/2		FCD70
	9.0 0.8135	GTS-35	32510	B340/12	MN35-10	08 15			
	9.0 0.8145	GTS-45	400 10	P440/7		08 52			
	9.0 0.8155	GTS-55	50005	P510/4	MP50-5	08 54			
9.0 0.8165	GTS-65	70003	P570/3	MP60-3	08 58				
N	14.0 3.2162	GD-AlSi8Cu3	A380.1	LM24		4250			
	14.0 3.2381	G-AlSi10Mg	A360.2	LM9		4253			
	14.0 3.2581	G-AlSi12	A413.2	LM6		4261			
	14.0 3.2583	G-AlSi12(Cu)	A413.1	LM20		4260			
14.0 3.2982	GD-AlSi12	A413.0			4247				



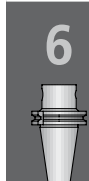
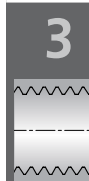


# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
099.00.090	490	37140026004000	697	38970001000020	578	508.53.010	494	51391 20011	669
099.00.090	492	37140026005000	697	38970001000022	578	508.53.011	494	51391 20012	669
099.00.090	494	37140026006300	697	38970001000024	578	508.53.020	494	51391 20013	669
099.00.092	490	37140026010000	697	38970002000094	579	508.53.021	494	51391 20014	669
099.00.092	492	37140026012500	697	38970002000113	579	508.53.022	494	51391 20015	669
099.00.092	494	37140026016000	697			510.15.008	491	51391 20016	669
099.00.095	492	37150026004000	697	50111002000111	613	510.15.008	493	51391 30001	669
099.00.095	494	37150026005000	697	50111002000112	613	510.15.008	495	51391 30002	669
099.03.002	418	37150026006300	697	50111002000113	613	510.15.009	491	51391 30004	669
		37150026008000	697	50111025000002	613	510.15.009	493	51391 30005	669
15E.30.10010	475	37150026010000	697	50115002000111	613	510.15.009	495	51391 30006	669
15E.30.10020	475	37150026012500	697	50115002000112	613	510.15.010	491	51391 30007	669
15E.30.10030	475	37150026016000	697	50115002000113	613	510.15.010	493	51391 30008	669
15E.30.10040	475	37155099004000	697	50161002000111	613	510.15.010	495	51391 30009	669
15E.30.10050	475	37155099005000	697	50161002000113	613	510.15.011	491	51391 30010	669
15E.30.10070	475	37155099006300	697	50161002000115	613	510.15.011	493	51391 30011	669
15F.00.30001	522	37155099008000	697	50161010000017	613	510.15.011	495	51391 30012	669
18050 10030	219	37155099010000	697	50161025000003	613	510.45.007	491	51391 30013	669
18050 10040	218	37155099012500	697	50165002000111	613	510.45.007	493	51391 30014	669
18050 35050	183	37170026003200	699	50165002000113	613	510.45.007	495	51391 30015	669
18589 00012	377	37170026004000	699	50165002000115	613	510.45.008	491	51391 30016	669
18589 00017	377	37170026005000	699	50221002000111	613	510.45.008	493	514.76.008	491
18589 10010	376	37170026006300	699	50221002000113	613	510.45.008	495	514.76.009	491
18589 10010	377	37310001001000	701	50221002000115	613	510.55.007	491	514.76.010	491
18589 10010	394	37310001001200	701	50221025000004	613	510.55.007	493	514.76.011	491
18589 10010	395	37310001001600	701	50225002000111	613	510.55.007	495	514.81.008	491
18589 10014	376	37310001002000	701	50225002000113	613	510.55.008	491	514.81.009	491
18589 10014	394	37310001002500	701	50225002000115	613	510.55.008	493	514.81.010	491
18589 10017	395	37310001003200	701	50225002000117	613	510.55.008	495	514.81.011	491
		37340098001000	695	50225010000021	613	51050 06010	808	517.76.008	493
		37340098001200	695	50225025000004	613	51050 06010	809	517.76.009	493
		37340098001600	695	50271002000113	613	51050 06010	810	517.76.010	493
		37340099001000	695	50271002000115	613	51050 08010	808	517.76.011	493
		37340099001200	695	50271025000004	613	51050 08010	809	517.81.008	493
		37340099001600	695	50275002000113	613	51050 08010	810	517.81.009	493
		37340099002000	695	50275002000115	613	51050 10012	808	517.81.010	493
		37340099002500	695	50275010000021	613	51050 10012	809	517.81.011	493
		37341099001000	697	50275025000004	613	51050 10012	810	518.78.009	495
		37341099001200	697	50310016001050	611	51050 12016	808	518.78.010	495
		37341099001600	697	50310016001080	611	51050 12016	809	518.78.011	495
		37341099002000	697	50310020002060	611	51050 12016	810	518.78.013	495
		37341099002500	697	50310020002096	611	51050 14016	809	518.78.014	495
		37341099003200	697	50310025004136	611	51050 14016	810	518.82.009	495
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		38170099002000	699	50341001001525	610	51050 16016	810	518.82.011	495
		38170099002500	699	50341001251100	610	51050 16016	811	518.82.013	495
		38300057000600	705	50341001251400	610	51050 18220	809	518.82.014	495
		38300072001000	705	50341002001020	610	51050 18220	810	52805 20045	669
		38300090001600	705	50341002003040	610	51050 18220	811	52805 20060	669
		38304057000600	704	50341004005060	610	51050 20220	809	52805 20070	669
		38304063000800	704	50391045011600	610	51050 20220	810	52805 20080	669
		38304072001000	704	50391045022000	610	51050 20220	811	52805 20090	669
		38320001001000	701	50391045043400	610	51200 00316	815	52805 20100	669
		38320001001200	701	504.76.009	490	51200 00320	815	52805 20110	669
		38320001001600	701	504.76.010	490	51200 00325	815	52805 32060	669
		38320001002000	701	504.76.011	490	51200 00332	815	52805 32070	669
		38320001002500	701	504.76.012	490	51200 00340	815	52805 32080	669
		38320001003200	701	507150..	672	51200 00416	815	52805 32090	669
		38321001001000	701	507160..	672	51200 00420	815	52805 32100	669
		38321001001200	701	507350..	672	51200 00425	815	52805 32110	669
		38321001001600	701	507360..	672	51200 00432	815	52805 32120	669
		38321001002000	701	507.02.008	492	51200 00440	815	52805 32140	669
		38321001002500	701	507.02.009	492	513.76.008	491	52805 32160	669
		38321001003200	701	507.02.010	492	513.76.009	491	52806 20045	669
		38390000000600	695	507.02.011	492	513.76.010	491	52806 20060	669
		38390000000800	695	507.02.012	492	513.76.011	491	52806 20070	669
		38390000001000	695	507.02.043	492	513.81.008	491	52806 20080	669
		38390000001200	695	507.02.044	492	513.81.009	491	52806 20090	669
		38391000001600	695	50775026000600	673	513.81.010	491	52806 20100	669
		38391000002000	695	50775026000800	673	513.81.011	491	52806 20110	669
		38392057000600	695	50775026001000	673	51305 04020	820	52806 32060	669
		38392063000800	695	50775026001200	673	51305 06025	820	52806 32070	669
		38392072001000	695	50775026001400	673	51305 07025	820	52806 32080	669
		38392083001200	695	50775026001600	673	51305 08028	820	52806 32090	669
		383930040002000	695	50776026000600	673	51305 10032	820	52806 32100	669
		38393090001600	695	50776026000800	673	51391 20001	669	52806 32110	669
		38802005001150	626	50776026001000	673	51391 20002	669	52806 32120	669
		38802007001150	626	50776026001200	673	51391 20004	669	52806 32140	669
		38896003001100	627	50776026001400	673	51391 20005	669	52806 32160	669
		38896003001150	627	50776026001600	673	51391 20006	669	52807 01016	815
		38896005001100	627	50795131002000	668	51391 20007	669	52807 01020	815
		38896005001150	627	50795135002000	668	51391 20008	669	52807 01025	815
		38896007001100	627	50795135003200	668	51391 20009	669	52807 01032	815
		38896007001150	627	508.53.009	494	51391 20010	669	52807 01040	815

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
52807.03016	815	52M.57.1599	407	52P.57.11H7	404	55011.04020	196	55023.00206	389
52807.03020	815	52M.57.1600	407	52P.57.1200	407	55011.05012	153	55023.00206	390
52807.03025	815	52M.57.1601	407	52P.57.1201	407	55011.05012	158	55024.06012	706
52807.03032	815	52M.57.1602	407	52P.57.1202	407	55011.05012	159	55051.02005	347
52807.03040	815	52M.57.1603	407	52P.57.1203	407	55011.05012	178	55051.02505	178
52G.55	403	52M.57.16H7	404	52P.57.12H7	404	55011.05016	178	55051.03006	102
52H.55	403	52N.17	403	52P.57.1597	407	55011.05016	218	55051.03006	347
52J.65	403	52N.17.04H7	405	52P.57.1598	407	55011.05016	219	55051.03008	166
52K.65	403	52N.17.05H7	405	52P.57.1599	407	55011.05016	221	55051.03010	196
52M.57	403	52N.17.06H7	405	52P.57.1600	407	55011.05016	222	55051.04008	153
52M.57.0397	406	52N.17.07H7	405	52P.57.1601	407	55011.05016	223	55051.04008	166
52M.57.0398	406	52N.17.08H7	405	52P.57.1602	407	55011.05016	225	55051.04008	178
52M.57.0399	406	52N.17.09H7	405	52P.57.1603	407	55011.05016	227	55051.04008	258
52M.57.0400	406	52N.17.10H7	405	52P.57.16H7	404	55011.05020	778	55051.04010	102
52M.57.0401	406	52N.17.11H7	405	52Q.17	403	55011.05025	178	55051.04010	148
52M.57.0402	406	52N.17.12H7	405	52Q.17.04H7	405	55011.05025	196	55051.04010	153
52M.57.0403	406	52N.17.16H7	405	52Q.17.05H7	405	55011.05030	232	55051.04010	178
52M.57.0497	406	52P.57	403	52Q.17.06H7	405	55011.06016	819	55051.04010	196
52M.57.0498	406	52P.57.0397	406	52Q.17.07H7	405	55011.06025	196	55051.04012	102
52M.57.0499	406	52P.57.0398	406	52Q.17.08H7	405	55011.06030	178	55051.04016	196
52M.57.04H7	404	52P.57.0399	406	52Q.17.09H7	405	55011.08030	196	55051.04504	254
52M.57.0500	406	52P.57.0400	406	52Q.17.10H7	405	55011.08030	509	55051.04504	256
52M.57.0501	406	52P.57.0401	406	52Q.17.11H7	405	55011.08035	178	55051.05005	246
52M.57.0502	406	52P.57.0402	406	52Q.17.12H7	405	55011.08045	178	55051.05008	150
52M.57.0503	406	52P.57.0403	406	52Q.17.16H7	405	55011.10035	196	55051.05010	150
52M.57.0597	406	52P.57.0497	406	540.36.000	428	55011.12025	819	55051.05016	158
52M.57.0598	406	52P.57.0498	406	540.36.001	428	55011.12040	819	55051.05020	183
52M.57.0599	406	52P.57.0499	406	540.36.002	428	55011.12045	196	55051.05025	196
52M.57.05H7	404	52P.57.04H7	404	540.36.003	428	55011.16050	819	55051.06006	250
52M.57.0600	406	52P.57.0500	406	540.36.004	428	55011.16055	196	55051.06008	152
52M.57.0601	406	52P.57.0501	406	540.36.005	428	55012.04006	352	55051.06008	158
52M.57.0602	406	52P.57.0502	406	540.36.006	428	55012.04006	354	55051.06008	246
52M.57.0603	406	52P.57.0503	406	540.36.007	428	55012.04006	355	55051.06008	256
52M.57.0697	406	52P.57.0597	406	540.66.000	428	55012.04008	166	55051.06012	178
52M.57.0698	406	52P.57.0598	406	540.66.001	428	55012.04010	166	55051.06020	158
52M.57.0699	406	52P.57.0599	406	540.66.002	428	55012.06012	166	55051.06020	178
52M.57.06H7	404	52P.57.05H7	404	540.66.003	428	55021.03008	320	55051.08006	509
52M.57.0700	406	52P.57.0600	406	540.66.004	428	55021.03008	321	55051.08008	218
52M.57.0701	406	52P.57.0601	406	540.66.005	428	55021.03008	322	55051.08008	233
52M.57.0702	406	52P.57.0602	406	540.66.006	428	55021.03008	324	55051.08008	250
52M.57.0703	406	52P.57.0603	406	540.66.007	428	55021.03008	325	55051.08008	509
52M.57.0797	406	52P.57.0697	406	545.00.001	506	55021.03008	326	55051.08010	152
52M.57.0798	406	52P.57.0698	406	545.00.002	506	55021.03008	327	55051.08010	233
52M.57.0799	406	52P.57.0699	406	545.00.003	506	55021.03008	329	55051.08010	246
52M.57.07H7	404	52P.57.06H7	404	545.07.002	506	55021.03008	330	55051.08010	250
52M.57.0800	406	52P.57.0700	406	545.07.003	506	55021.03008	331	55051.08020	178
52M.57.0801	406	52P.57.0701	406	545.07.004	506	55021.03008	337	55051.08025	152
52M.57.0802	406	52P.57.0702	406	545.07.005	506	55021.03008	338	55051.08035	196
52M.57.0803	406	52P.57.0703	406	545.07.006	506	55021.03008	339	55051.08050	196
52M.57.0897	407	52P.57.0797	406	545.07.009	506	55021.03008	340	55051.08120	218
52M.57.0898	407	52P.57.0798	406	545.07.010	506	55021.03008	341	55051.08120	219
52M.57.0899	407	52P.57.0799	406	545.07.011	506	55021.03008	388	55051.10012	246
52M.57.08H7	404	52P.57.07H7	404	545.10.001	507	55021.03008	389	55051.10080	196
52M.57.0900	407	52P.57.0800	406	545.10.003	507	55021.03008	394	55051.12012	250
52M.57.0901	407	52P.57.0801	406	545.10.004	507	55021.03008	395	55051.12016	246
52M.57.0902	407	52P.57.0802	406	545.10.011	507	55021.04010	376	55051.16016	250
52M.57.0903	407	52P.57.0803	406	545.25.001	509	55021.04010	377	55051.20020	246
52M.57.0997	407	52P.57.0897	407	545.25.002	509	55021.05012	376	55051.20020	250
52M.57.0998	407	52P.57.0898	407	545.25.010	509	55021.05012	377	55051.20025	246
52M.57.0999	407	52P.57.0899	407	545.27.001	509	55021.05012	394	55051.20030	250
52M.57.09H7	404	52P.57.08H7	404	545.27.002	509	55021.05012	395	55052.06008	509
52M.57.1000	407	52P.57.0900	407	545.40.001	510	55023.00206	320	55052.06010	509
52M.57.1001	407	52P.57.0901	407	545.40.002	510	55023.00206	321	55052.12016	158
52M.57.1002	407	52P.57.0902	407	545.40.003	510	55023.00206	322	55052.12020	158
52M.57.1003	407	52P.57.0903	407	545.40.004	510	55023.00206	323	55053.06012	829
52M.57.1097	407	52P.57.0997	407	545.40.006	510	55023.00206	324	55053.08020	829
52M.57.1098	407	52P.57.0998	407	545.40.007	510	55023.00206	325	55053.10020	829
52M.57.1099	407	52P.57.0999	407	545.62.004	510	55023.00206	326	55053.12025	829
52M.57.10H7	404	52P.57.09H7	404	545.62.014	510	55023.00206	327	55053.16030	829
52M.57.1100	407	52P.57.1000	407	545.62.015	510	55023.00206	328	55054.02504	388
52M.57.1101	407	52P.57.1001	407	545.62.016	510	55023.00206	329	55054.02504	389
52M.57.1102	407	52P.57.1002	407	545.62.017	510	55023.00206	330	55054.03004	333
52M.57.1103	407	52P.57.1003	407	545.62.018	510	55023.00206	331	55054.03005	321
52M.57.1197	407	52P.57.1097	407	545.77.001	507	55023.00206	332	55054.03005	331
52M.57.1198	407	52P.57.1098	407	545.77.003	507	55023.00206	333	55054.03005	332
52M.57.1199	407	52P.57.1099	407	545.77.004	507	55023.00206	334	55054.03005	333
52M.57.11H7	404	52P.57.10H7	404	545.77.011	507	55023.00206	335	55054.03005	334
52M.57.1200	407	52P.57.1100	407	548.10.00030	513	55023.00206	336	55054.03005	335
52M.57.1201	407	52P.57.1101	407	548.10.00040	513	55023.00206	337	55054.03005	336
52M.57.1202	407	52P.57.1102	407	548.90.00030	513	55023.00206	338	55054.03005	337
52M.57.1203	407	52P.57.1103	407	548.91.00030	513	55023.00206	339	55054.03005	338
52M.57.12H7	404	52P.57.1197	407	55011.03010	819	55023.00206	340	55054.03005	339
52M.57.1597	407	52P.57.1198	407	55011.03016	178	55023.00206	341	55054.03005	340
52M.57.1598	407	52P.57.1199	407	55011.04020	178	55023.00206	388	55054.03005	341



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
55054 03006	388	56H.71	415	56R.71.14H7D	421	58N.58.24H7	438	640.65.22H7N	446
55054 03006	389	56H.93	415	56R.71.14H7N	421	58N.58.25H7	438	640.65.24H7N	446
55054 04008	320	56J.17	415	56R.71.15H7D	421	58N.58.26H7	438	640.65.25H7N	446
55054 04008	321	56J.21	415	56R.71.15H7N	421	58N.58.28H7	438	640.65.28H7N	446
55054 04008	322	56J.37	415	56R.71.16H7D	421	58N.58.30H7	438	640.65.30H7N	446
55054 04008	323	56J.65	415	56R.71.16H7N	421	58N.62	435	640.65.40H7N	446
55054 04008	324	56J.65.06H7N	420	56R.71.18H7D	421	58N.65	435	640.93.15H7D	446
55054 04008	325	56J.65.08H7N	420	56R.71.18H7N	421	58N.82	435	640.93.15H7N	446
55054 04008	326	56J.65.10H7N	420	56R.71.20H7D	421	58N.85	435	640.93.16H7D	446
55054 04008	327	56J.65.12H7N	420	56R.71.20H7N	421	58N.92	435	640.93.16H7N	446
55054 04008	328	56J.65.14H7N	420	56R.93	417	58N.92.12H7	439	640.93.18H7D	446
55054 04008	329	56J.65.15H7N	420	56R.93.06H7D	421	58N.92.14H7	439	640.93.18H7N	446
55054 04008	331	56J.65.16H7N	420	56R.93.06H7N	421	58N.92.15H7	439	640.93.20H7D	446
55054 04008	336	56J.65.18H7N	420	56R.93.08H7D	421	58N.92.16H7	439	640.93.20H7N	446
55054 04008	337	56J.65.20H7N	420	56R.93.08H7N	421	58N.92.18H7	439	640.93.22H7D	446
55054 04008	338	56J.67	415	56R.93.10H7D	421	58N.92.20H7	439	640.93.22H7N	446
55054 04008	339	56J.71	415	56R.93.10H7N	421	58N.92.22H7	439	640.93.24H7D	446
55054 04008	341	56J.71.06H7D	420	56R.93.12H7D	421	58N.92.24H7	439	640.93.24H7N	446
55054 04008	342	56J.71.06H7N	420	56R.93.12H7N	421	58N.92.25H7	439	640.93.25H7D	446
55054 04008	388	56J.71.08H7D	420	56R.93.14H7D	421	58N.92.26H7	439	640.93.25H7N	446
55054 04008	389	56J.71.08H7N	420	56R.93.14H7N	421	58N.92.28H7	439	640.93.28H7D	446
55054 04008	390	56J.71.10H7D	420	56R.93.15H7D	421	58N.92.30H7	439	640.93.28H7N	446
55054 05012	320	56J.71.10H7N	420	56R.93.15H7N	421	58N.93	435	640.93.30H7D	446
55054 05012	321	56J.71.12H7D	420	56R.93.16H7D	421	58T.17	437	640.93.30H7N	446
55054 05012	322	56J.71.12H7N	420	56R.93.16H7N	421	58T.21	437	640.93.40H7D	446
55054 05012	324	56J.71.14H7D	420	56R.93.18H7D	421	58T.57	437	640.93.40H7N	446
55054 05012	325	56J.71.14H7N	420	56R.93.18H7N	421	58T.65	437		
55054 05012	326	56J.71.15H7D	420	56R.93.20H7D	421	58T.85	437	70W.37.01040A	522
55054 05012	327	56J.71.15H7N	420	56R.93.20H7N	421	58T.93	437	70W.37.01045A	522
55054 05012	329	56J.71.16H7D	420	56X.21	418	58U.17	437	70W.37.01050A	522
55054 05012	330	56J.71.16H7N	420	57B.40.00010	515	58U.21	437	70W.37.01055A	522
55054 05012	331	56J.71.18H7D	420	57B.40.00020	515	58U.57	437	70W.37.01060A	522
55054 05012	337	56J.71.18H7N	420	57B.49.00010	514	58U.58	437	70W.37.01065A	522
55054 05012	338	56J.71.20H7D	420	57B.49.00020	514	58U.62	437	70W.37.01070A	522
55054 05012	339	56J.71.20H7N	420	57B.49.00030	514	58U.65	437	70W.37.01075A	522
55054 05012	340	56J.93	415	57B.49.00040	514	58U.82	437	70W.37.01080A	522
55054 05012	341	56J.93.06H7D	420	57B.50.00010	515	58U.85	437	70W.37.01090A	522
55054 05012	388	56J.93.06H7N	420	57B.50.00020	515	58U.92	437	70W.37.01100A	522
55054 05012	389	56J.93.08H7D	420	58310016001050	611	58U.93	437	70W.37.01110A	522
55054 05014	321	56J.93.08H7N	420	58310016001080	611			70W.37.01120A	522
55054 05014	331	56J.93.10H7D	420	58310020002060	611	61000 00388	669	70W.37.01130A	522
55054 05014	341	56J.93.10H7N	420	58310020002096	611	640.20	445	70W.93.02040A	522
55062 00008	819	56J.93.12H7D	420	58310025004136	611	640.21	445	70W.93.02045A	522
55062 00008	820	56J.93.12H7N	420	58M.17	435	640.26	445	70W.93.02050A	522
55062 00010	819	56J.93.14H7D	420	58M.21	435	640.27	445	70W.93.02055A	522
55062 00010	820	56J.93.14H7N	420	58M.57	435	640.36	445	70W.93.02060A	522
55062 00012	819	56J.93.15H7D	420	58M.57.12H7	438	640.37	445	70W.93.02065A	522
55062 00012	820	56J.93.15H7N	420	58M.57.14H7	438	640.62	445	70W.93.02070A	522
55062 00016	819	56J.93.16H7D	420	58M.57.15H7	438	640.65	445	70W.93.02075A	522
55062 00016	820	56J.93.16H7N	420	58M.57.16H7	438	640.66	445	70W.93.02080A	522
55062 00020	819	56J.93.18H7D	420	58M.57.18H7	438	640.67	445	70W.93.02090A	522
55062 00020	820	56J.93.18H7N	420	58M.57.20H7	438	640.70	445	70W.93.02100A	522
55231 04017	948	56J.93.20H7D	420	58M.57.22H7	438	640.71	445	70W.93.02110A	522
55231 05020	948	56J.93.20H7N	420	58M.57.24H7	438	640.92	445	70W.93.02120A	522
55231 07025	948	56Q.17	417	58M.57.25H7	438	640.93	445	70W.93.02130A	522
55231 08025	948	56Q.21	417	58M.57.26H7	438	640.01.001	447	71G.65	501
55231 10030	948	56Q.37	417	58M.57.28H7	438	640.01.002	447	71G.65.0700D	498
55232 01010	451	56Q.65	417	58M.57.30H7	438	640.01.003	447	71G.65.0700N	498
55232 01210	451	56Q.67	417	58M.65	435	640.01.005	447	71G.65.0750D	498
55232 01610	451	56Q.71	417	58M.85	435	640.01.006	447	71G.65.0750N	498
55232 02210	451	56Q.93	417	58M.93	435	640.03.001	451	71G.93	501
55237 00016	820	56R.17	417	58M.93.12H7	439	640.03.002	451	71G.93.0700D	498
55237 00022	820	56R.21	417	58M.93.14H7	439	640.03.003	451	71G.93.0700N	498
55237 00027	820	56R.37	417	58M.93.15H7	439	640.03.004	451	71G.93.0750D	498
55237 00032	820	56R.65	417	58M.93.16H7	439	640.03.005	451	71G.93.0750N	498
55237 00040	820	56R.65.06H7N	421	58M.93.18H7	439	640.04.001	451	71H.65	501
55311 01505	345	56R.65.08H7N	421	58M.93.20H7	439	640.04.002	451	71H.65.0800D	498
55311 02006	345	56R.65.10H7N	421	58M.93.22H7	439	640.04.003	451	71H.65.0800N	498
55311 02008	345	56R.65.12H7N	421	58M.93.24H7	439	640.04.005	451	71H.65.0850D	498
55311 03010	356	56R.65.14H7N	421	58M.93.25H7	439	640.04.006	451	71H.65.0850N	498
55311 04010	357	56R.65.15H7N	421	58M.93.26H7	439	640.81.001	447	71H.65.0900D	498
55311 05012	357	56R.65.16H7N	421	58M.93.28H7	439	640.81.002	447	71H.65.0900N	498
56341 00001	819	56R.65.18H7N	421	58M.93.30H7	439	640.81.003	447	71H.65.0950D	498
56341 00003	819	56R.65.20H7N	421	58N.17	435	640.81.005	447	71H.65.0950N	498
56771 10053	221	56R.67	417	58N.21	435	640.81.006	447	71H.65.1000D	498
56771 10053	222	56R.71	417	58N.57	435	640.84.001	451	71H.65.1000N	498
56771 10053	223	56R.71.06H7D	421	58N.58	435	640.84.002	451	71H.93	501
56771 10053	225	56R.71.06H7N	421	58N.58.12H7	438	640.84.003	451	71H.93.0800D	498
56771 10054	345	56R.71.08H7D	421	58N.58.14H7	438	640.84.005	451	71H.93.0800N	498
56H.17	415	56R.71.08H7N	421	58N.58.15H7	438	640.84.006	451	71H.93.0850D	498
56H.21	415	56R.71.10H7D	421	58N.58.16H7	438	640.65.15H7N	446	71H.93.0850N	498
56H.37	415	56R.71.10H7N	421	58N.58.18H7	438	640.65.16H7N	446	71H.93.0900D	498
56H.65	415	56R.71.12H7D	421	58N.58.20H7	438	640.65.18H7N	446	71H.93.0900N	498
56H.67	415	56R.71.12H7N	421	58N.58.22H7	438	640.65.20H7N	446	71H.93.0950D	498

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
71H.93.0950N	498	75J.71.26H7N	463	78M.57.22H7	456	80292001000020	572	80416001000020	638
71H.93.1000D	498	75J.71.28H7D	463	78M.57.24H7	456	80292001000022	572	80416001000022	638
71H.93.1000N	498	75J.71.28H7N	463	78M.57.25H7	456	80292001000024	572	80418001000018	640
72A.30.07000	499	75J.71.30H7D	463	78M.57.26H7	456	80292001000025	572	80418001000020	640
72A.30.07500	499	75J.71.30H7N	463	78M.57.28H7	456	80292001000026	572	80418001000022	640
72A.30.08000	499	75J.71.32H7D	463	78M.57.30H7	456	80292001000028	572	80420001000013	637
72A.30.08500	499	75J.71.32H7N	463	78M.65	455	80292002000070	573	80420001000015	637
72A.30.09000	499	75J.71.35H7D	463	78M.85	455	80292002000094	573	80420001000017	637
72A.30.09500	499	75J.71.35H7N	463	78M.93	455	80292002000113	573	80420001000018	637
72A.30.10000	499	75J.71.40H7D	463	78M.93.18H7	457	80292002000131	573	80420001000020	637
72A.60.07000	499	75J.71.40H7N	463	78M.93.20H7	457	80292002000147	573	80420001000022	637
72A.60.07500	499	75J.71.42H7D	463	78M.93.22H7	457	80292025000001	574	80420002000029	641
72A.60.08000	499	75J.71.42H7N	463	78M.93.24H7	457	80292025000002	574	80420002000048	641
72A.60.08500	499	75J.71.50H7D	463	78M.93.25H7	457	80296001000015	570	80420002000070	641
72A.60.09000	499	75J.71.50H7N	463	78M.93.26H7	457	80296001000017	570	80421001000024	637
72A.60.09500	499	75J.71.54H7D	463	78M.93.28H7	457	80296001000018	570	80421002000094	641
72A.60.10000	499	75J.71.54H7N	463	78M.93.30H7	457	80296001000020	570	80421002000113	641
75A.30.13060	473	75J.85	461	78N.17	455	80296001000022	570	80421002000131	641
75A.30.13070	473	75J.93	461	78N.21	455	80296001000024	570	80421002000147	641
75A.30.15060	473	75J.93.18H7D	462	78N.57	455	80296001000025	570	80444001000013	638
75A.30.15070	473	75J.93.18H7N	462	78N.58	455	80296001000026	570	80444001000015	638
75A.40.13010	473	75J.93.20H7D	462	78N.58.18H7	456	80296001000028	570	80444001000017	638
75A.40.13020	473	75J.93.20H7N	462	78N.58.20H7	456	80296002000037	571	80444001000018	638
75A.40.13030	473	75J.93.22H7D	462	78N.58.22H7	456	80296002000048	571	80444001000020	638
75A.40.13040	473	75J.93.22H7N	462	78N.58.24H7	456	80296002000070	571	80444001000022	638
75A.40.13050	473	75J.93.24H7D	462	78N.58.25H7	456	80296002000094	571	80444002000029	642
75A.40.13060	473	75J.93.24H7N	462	78N.58.26H7	456	80296002000111	571	80444002000048	642
75A.40.13070	473	75J.93.25H7D	462	78N.58.28H7	456	80296002000113	571	80444002000070	642
75A.40.15010	473	75J.93.25H7N	462	78N.58.30H7	456	80296002000131	571	80445001000024	638
75A.40.15020	473	75J.93.26H7D	462	78N.62	455	80296002000147	571	80445002000094	642
75A.40.15030	473	75J.93.26H7N	462	78N.65	455	80297001000015	570	80445002000113	642
75A.40.15040	473	75J.93.28H7D	462	78N.82	455	80297001000017	570	80445002000131	642
75A.40.15050	473	75J.93.28H7N	462	78N.85	455	80297001000018	570	80445002000147	642
75A.40.15060	473	75J.93.30H7D	462	78N.92	455	80297001000020	570	80456001000015	636
75A.40.15070	473	75J.93.30H7N	462	78N.92.18H7	457	80297001000022	570	80456001000017	636
75A.41.13010	473	75J.93.32H7D	462	78N.92.20H7	457	80297001000024	570	80456001000018	636
75A.41.13020	473	75J.93.32H7N	462	78N.92.22H7	457	80297001000025	570	80456001000020	636
75A.41.13030	473	75J.93.35H7D	462	78N.92.24H7	457	80297001000026	570	80456001000022	636
75A.41.13040	473	75J.93.35H7N	462	78N.92.25H7	457	80297001000028	570	80457001000024	636
75A.41.13050	473	75J.93.40H7D	462	78N.92.26H7	457	80297002000037	571	80472001000018	648
75A.41.15010	473	75J.93.40H7N	462	78N.92.28H7	457	80297002000048	571	80472001000020	648
75A.41.15020	473	75J.93.42H7D	462	78N.92.30H7	457	80297002000070	571	80472001000022	648
75A.41.15030	473	75J.93.42H7N	462	78N.93	455	80297002000094	571	80474001000015	648
75A.41.15040	473	75J.93.50H7D	462	80126001000015	639	80297002000111	571	80474001000017	648
75A.41.15050	473	75J.93.50H7N	462	80126001000017	639	80297002000113	571	80474001000018	648
75A.60.13050	473	75J.93.54H7D	462	80126001000018	639	80297002000131	571	80474001000020	648
75A.60.13060	473	75J.93.54H7N	462	80126001000020	639	80297002000147	571	80474001000022	648
75A.60.13070	473	76H.17	469	80126001000022	639	80334001000018	597	80475001000024	648
75H.17	461	76H.21	469	80126001000024	639	80334001000020	597	80476001000015	649
75H.21	461	76H.37	469	80127001000025	639	80334001000022	597	80476001000017	649
75H.37	461	76H.65	469	80127001000026	639	80334001000024	597	80476001000018	649
75H.65	461	76H.67	469	80128001000015	639	80335001000018	597	80476001000020	649
75H.67	461	76H.71	469	80128001000017	639	80335001000020	597	80476001000022	649
75H.71	461	76H.85	469	80128001000018	639	80335001000022	597	80477001000024	649
75H.85	461	76H.93	469	80128001000018	639	80335001000024	597	80494001000015	650
75H.93	461	76J.17	469	80128001000020	639	80341001000018	597	80494001000017	650
75J.17	461	76J.21	469	80128001000022	639	80341001000020	597	80494001000018	650
75J.21	461	76J.37	469	80129001000024	639	80341001000022	597	80494001000020	650
75J.37	461	76J.65	469	80129001000025	639	80341001000024	597	80494001000022	650
75J.65	461	76J.67	469	80129001000026	639	80345001000018	597	80495001000024	650
75J.65.18H7N	463	76J.71	469	80270001000015	563	80345001000020	597	80574001000015	648
75J.65.20H7N	463	76J.85	469	80270001000017	563	80345001000022	597	80574001000017	648
75J.65.22H7N	463	76J.93	469	80270001000018	563	80345001000024	597	80574001000018	648
75J.65.24H7N	463	77H.17	467	80270001000020	563	80356001000018	598	80574001000020	648
75J.65.25H7N	463	77H.21	467	80270001000022	563	80356001000020	598	80574001000022	648
75J.65.28H7N	463	77H.37	467	80273001000015	572	80356001000022	598	80575001000024	648
75J.65.30H7N	463	77H.65	467	80273001000017	572	80356001000024	598	80576001000015	649
75J.65.32H7N	463	77H.67	467	80273001000018	572	80361001000018	598	80576001000017	649
75J.65.35H7N	463	77H.71	467	80273001000020	572	80361001000020	598	80576001000018	649
75J.65.40H7N	463	77H.85	467	80273001000022	572	80361001000022	598	80576001000020	649
75J.65.50H7N	463	77H.93	467	80273001000024	572	80361001000024	598	80576001000022	649
75J.67	461	77J.17	467	80273001000025	572	80369001000018	599	80577001000024	649
75J.71	461	77J.21	467	80273001000026	572	80369001000020	599	80584001000013	651
75J.71.18H7D	463	77J.37	467	80273001000028	572	80369001000022	599	80584001000015	651
75J.71.18H7N	463	77J.65	467	80273002000070	573	80369001000024	599	80584001000017	651
75J.71.20H7D	463	77J.67	467	80273002000094	573	80373001000018	599	80584001000018	651
75J.71.20H7N	463	77J.71	467	80273002000113	573	80373001000020	599	80584001000020	651
75J.71.22H7D	463	77J.85	467	80273002000131	573	80373001000022	599	80585002000070	653
75J.71.22H7N	463	77J.93	467	80273002000147	573	80373001000024	599	80585002000094	653
75J.71.24H7D	463	78M.17	455	80273025000001	574	80380001000018	599	80586001000013	652
75J.71.24H7N	463	78M.21	455	80273025000002	574	80380001000020	599	80586001000015	652
75J.71.25H7D	463	78M.57	455	80292001000015	572	80380001000022	599	80586001000017	652
75J.71.25H7N	463	78M.57.18H7	456	80292001000017	572	80380001000024	599	80586001000018	652
75J.71.26H7D	463	78M.57.20H7	456	80292001000018	572	80416001000018	638	80586001000020	652



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
80587002000070	654	80703001000018	552	80842002001100	615	80935001000026	589	80970002000037	565
80587002000094	654	80703001000022	552	80842002001150	615	80935002000070	593	80970002000048	565
80594001000015	650	80703001010018	552	80842002004001100	615	80935002000094	593	80970002000070	565
80594001000017	650	80703001010022	552	80842004001150	615	80935002000111	593	80970002000094	565
80594001000018	650	80703001020018	552	80842005001100	615	80935002000113	593	80970002000111	565
80594001000020	650	80703001020022	552	80842005001150	615	80935051000018	592	80970002000113	565
80594001000022	650	80703001030018	552	80842005001200	615	80935051000020	592	80970002000131	565
80595001000024	650	80703001030022	552	80842006001100	615	80935051000022	592	80970002000147	565
80635001000018	600	80703001040018	552	80842006001150	615	80935051000024	592	80970002000011	566
80635001000020	600	80703001040022	552	80842006001200	615	80941001000015	589	80970010000012	566
80635001000022	600	80703001050018	552	80842006001300	615	80941001000017	589	80970010000013	566
80635001000024	600	80703001050022	552	80842006002014	618	80941001000018	589	80970010000015	566
80635002000070	601	80703001060018	552	80842007001100	615	80941001000020	589	80970010000011	567
80635002000094	601	80703001060022	552	80842007001150	615	80941001000022	589	80970010000012	567
80635002000111	601	80703001070022	552	80842007001200	615	80941001000024	589	80970010000013	567
80635002000113	601	80703002000094	553	80842007001300	615	80941001000025	589	80970010000014	567
80641001000018	600	80703002010094	553	80842007002011	618	80941001000026	589	80970010000015	567
80641001000020	600	80703002020094	553	80842007002014	618	80941002000048	593	80970016000001	568
80641001000022	600	80703002030094	553	80842008001100	615	80941002000070	593	80970016000002	568
80641001000024	600	80703002040094	553	80842008001150	615	80941002000094	593	80970016000003	568
80641002000048	601	80703002050094	553	80842008001200	615	80941002000111	593	80970016000004	568
80641002000070	601	80703002060094	553	80842008001300	615	80941002000113	593	80970017000002	568
80641002000094	601	80703002070094	553	80842008002011	618	80941002000131	593	80970017000003	568
80641002000111	601	80703002080094	553	80842008002014	618	80941002000147	593	80970017000004	568
80641002000113	601	80703002090094	553	80843004001100	616	80941010000011	594	80970025000001	569
80641002000131	601	80703002091094	553	80843004001150	616	80941010000012	594	80970025000002	569
80641010000011	602	80752001000018	605	80843006001100	616	80941010000013	594	80970025000003	569
80641010000012	602	80752001000020	605	80843006001150	616	80941010000015	594	80973001000015	562
80641010000013	602	80752001000022	605	80843008001150	616	80941011000011	595	80973001000017	562
80641010000015	602	80752001000024	605	80843008001200	616	80941011000012	595	80973001000018	562
80641011000011	603	80758001000018	605	80872016000005	619	80941011000013	595	80973001000020	562
80641011000012	603	80758001000020	605	80872016000007	619	80941011000015	595	80973001000022	562
80641011000013	603	80758001000022	605	80872017000005	619	80941025000001	596	80973001000024	562
80641011000015	603	80758001000024	605	80872017000007	619	80941025000002	596	80973001000025	562
80641025000001	604	80802002001100	615	80875016000005	619	80941051000018	592	80973001000026	562
80641025000002	604	80802002001150	615	80875016000007	619	80941051000020	592	80973001000028	562
80670001000018	580	80802004001100	615	80875017000005	619	80941051000022	592	80973002000070	564
80670001000020	580	80802004001150	615	80875017000007	619	80941051000024	592	80973002000094	564
80670001000022	580	80802005001012	617	80882006001100	623	80943001000018	591	80973002000113	564
80670001000024	580	80802005001020	617	80882006001150	623	80943001000020	591	80973002000131	564
80670002000070	581	80802005001024	617	80882006001200	623	80943001000022	591	80973002000147	564
80670002000094	581	80802005001100	615	80882006002014	624	80943001000024	591	80973010000011	566
80670002000113	581	80802005001150	615	80882008001100	623	80945001000015	588	80973010000012	566
80670002000131	581	80802005001200	615	80882008001150	623	80945001000017	588	80973010000013	566
80670002000147	581	80802006001012	617	80882008001200	623	80945001000018	588	80973010000015	566
80690001000018	580	80802006001020	617	80882008001300	623	80945001000020	588	80973011000011	567
80690001000020	580	80802006001024	617	80882008002011	624	80945001000022	588	80973011000012	567
80690001000022	580	80802006001100	615	80882008002014	624	80945001000024	588	80973011000013	567
80690001000024	580	80802006001150	615	80885006001100	623	80945002000070	593	80973011000014	567
80692001000018	580	80802006001200	615	80885006001150	623	80945002000094	593	80973011000015	567
80692001000020	580	80802006001300	615	80885006001200	623	80945002000113	593	80973016000002	568
80692001000022	580	80802006002014	618	80885006002014	624	80945010000011	594	80973016000003	568
80692001000024	580	80802007001008	617	80885008001100	623	80945010000012	594	80973016000004	568
80692002000070	581	80802007001012	617	80885008001150	623	80945010000013	594	80973017000002	568
80692002000094	581	80802007001020	617	80885008001200	623	80945010000015	594	80973017000003	568
80692002000113	581	80802007001024	617	80885008001300	623	80945011000011	595	80973017000004	568
80692002000131	581	80802007001100	615	80885008002011	624	80945011000012	595	80973025000001	569
80692002000147	581	80802007001150	615	80885008002014	624	80945011000013	595	80973025000002	569
80700001000018	552	80802007001200	615	80896006001100	622	80945011000015	595	80977001000013	576
80700001000022	552	80802007001300	615	80896006001150	622	80949001000018	591	80977001000015	576
80700001010018	552	80802007002011	618	80896006001200	622	80949001000020	591	80977001000017	576
80700001010022	552	80802007002014	618	80896008001100	622	80949001000022	591	80977001000018	576
80700001020018	552	80802008001008	617	80896008001150	622	80949001000024	591	80977001000020	576
80700001020022	552	80802008001012	617	80896008001200	622	80956001000018	590	80977001000022	576
80700001030018	552	80802008001020	617	80901001000013	589	80956001000020	590	80977001000024	576
80700001030022	552	80802008001100	615	80904001000015	590	80956001000022	590	80977002000113	577
80700001040018	552	80802008001150	615	80904001000017	590	80956001000024	590	80977002000131	577
80700001040022	552	80802008001200	615	80904001000018	590	80961001000017	590	80977002000147	577
80700001050018	552	80802008001300	615	80904001000020	590	80961001000018	590	80980001000015	545
80700001050022	552	80802008002011	618	80904001000022	590	80961001000020	590	80980001000017	545
80700001060018	552	80802008002014	618	80906001000013	589	80961001000022	590	80980001000018	545
80700001060022	552	80803004001100	616	80934001000015	588	80961001000024	590	80980001000020	545
80700001070022	552	80803004001150	616	80934001000017	588	80961001000026	590	80980001000022	545
80700002000094	553	80803006001100	616	80934001000018	588	80970001000008	563	80980001000024	545
80700002010094	553	80803006001150	616	80934001000020	588	80970001000013	563	80980001000025	545
80700002020094	553	80803008001150	616	80934001000022	588	80970001000015	563	80980002000094	546
80700002030094	553	80803008001200	616	80934001000024	588	80970001000017	563	80980002000113	546
80700002040094	553	80806006001100	621	80935001000015	589	80970001000018	563	80980001000009	547
80700002050094	553	80806006001150	621	80935001000017	589	80970001000020	563	80980010000010	547
80700002060094	553	80806008001150	621	80935001000018	589	80970001000022	563	80980010000011	547
80700002070094	553	80806008001200	621	80935001000020	589	80970001000024	563	80980010000012	547
80700002080094	553	80806008001300	621	80935001000022	589	80970001000025	563	80980010000013	547
80700002090094	553	80819006001150	620	80935001000024	589	80970001000026	563	80980010000014	547
80700002091094	553	80819008001150	620	80935001000025	589	80970001000028	563	80980010000015	547

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
80980010000016	547	80990001000020	563	88296002000131	571	88670001000020	580	88802004001150	615
80980010000017	547	80990001000022	563	88296002000147	571	88670001000022	580	88802005001012	617
80980011000009	548	80990001000024	563	88297001000015	570	88670001000024	580	88802005001020	617
80980011000010	548	80992001000015	563	88297001000017	570	88670002000070	581	88802005001024	617
80980011000011	548	80992001000017	563	88297001000018	570	88670002000094	581	88802005001100	615
80980011000012	548	80992001000018	563	88297001000020	570	88670002000113	581	88802005001150	615
80980011000013	548	80992001000020	563	88297001000022	570	88670002000131	581	88802005001200	615
80980011000014	548	80992001000022	563	88297001000024	570	88670002000147	581	88802006001012	617
80980011000015	548	80992001000024	563	88297001000025	570	88690001000018	580	88802006001020	617
80980011000016	548	80992001000025	563	88297001000026	570	88690001000020	580	88802006001024	617
80980011000017	548	80992001000026	563	88297001000028	570	88690001000022	580	88802006001100	615
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80981001000015	562	80992002000147	565	88297002000113	571	88692002000070	581	88802007001012	617
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80981001000020	562	80992010000013	566	88297001000018	597	88692002000131	581	88802007001100	615
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80981001000025	562	80992011000012	567	88334001000024	597	88700001000022	552	88802007001300	615
80981001000026	562	80992011000013	567	88335001000018	597	88700001010018	552	88802007002011	618
80981001000028	562	80992011000014	567	88335001000020	597	88700001010022	552	88802007002014	618
80981002000070	564	80992011000015	567	88335001000022	597	88700001020018	552	88802008001008	617
80981002000094	564	80992025000001	569	88335001000024	597	88700001020022	552	88802008001012	617
80981002000111	564	80992025000002	569	88341001000018	597	88700001030018	552	88802008001020	617
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80981002000131	564	80995001000020	563	88341001000022	597	88700001040018	552	88802008001150	615
80981002000147	564	80995001000022	563	88341001000024	597	88700001040022	552	88802008001200	615
80981010000011	566	80995001000024	563	88345001000018	597	88700001050018	552	88802008001300	615
80981010000012	566	88270001000015	563	88345001000020	597	88700001050022	552	88802008002011	618
80981010000013	566	88270001000017	563	88345001000022	597	88700001060018	552	88802008002014	618
80981010000015	566	88270001000018	563	88345001000024	597	88700001060022	552	88803004001100	616
80981011000011	567	88270001000020	563	88356001000018	598	88700001070022	552	88803004001150	616
80981011000012	567	88270001000022	563	88356001000020	598	88700002000094	553	88803006001100	616
80981011000013	567	88273001000015	572	88356001000022	598	88700002010094	553	88803006001150	616
80981011000014	567	88273001000017	572	88356001000024	598	88700002020094	553	88803008001150	616
80981011000015	567	88273001000018	572	88361001000018	598	88700002030094	553	88803008001200	616
80981025000001	569	88273001000020	572	88361001000020	598	88700002040094	553	88806006001100	621
80981025000002	569	88273001000022	572	88361001000022	598	88700002050094	553	88806006001150	621
80981025000003	569	88273001000024	572	88361001000024	598	88700002060094	553	88806008001150	621
80983001000015	545	88273001000025	572	88369001000018	599	88700002070094	553	88806008001200	621
80983001000017	545	88273001000026	572	88369001000020	599	88700002080094	553	88806008001300	621
80983001000018	545	88273001000028	572	88369001000022	599	88700002090094	553	88819008001150	620
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80983001000024	545	88273002000113	573	88373001000020	599	88703001000022	552	88842002001150	615
80983001000025	545	88273002000131	573	88373001000022	599	88703001010018	552	88842004001100	615
80983002000094	546	88273002000147	573	88373001000024	599	88703001010022	552	88842004001150	615
80983002000113	546	88273025000001	574	88380001000018	599	88703001020018	552	88842005001100	615
80983010000009	547	88273025000002	574	88380001000020	599	88703001020022	552	88842005001150	615
80983010000010	547	88292001000015	572	88380001000022	599	88703001030018	552	88842005001200	615
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80983010000012	547	88292001000018	572	88635001000018	600	88703001040018	552	88842006001150	615
80983010000013	547	88292001000020	572	88635001000020	600	88703001040022	552	88842006001200	615
80983010000014	547	88292001000022	572	88635001000022	600	88703001050018	552	88842006001300	615
80983010000015	547	88292001000024	572	88635001000024	600	88703001050022	552	88842006002014	618
80983010000016	547	88292001000025	572	88635002000070	601	88703001060018	552	88842007001100	615
80983010000017	547	88292001000026	572	88635002000094	601	88703001060022	552	88842007001150	615
80983011000009	548	88292001000028	572	88635002000111	601	88703001070022	552	88842007001200	615
80983011000010	548	88292002000070	573	88635002000113	601	88703002000094	553	88842007001300	615
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80983011000013	548	88292002000131	573	88641001000022	600	88703002030094	553	88842008001100	615
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80983011000015	548	88292025000001	574	88641002000048	601	88703002050094	553	88842008001200	615
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80983011000017	548	88296001000015	570	88641002000094	601	88703002070094	553	88842008002011	618
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80983025000002	549	88296001000018	570	88641002000113	601	88703002090094	553	88843004001100	616
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80987001000017	554	88296001000024	570	88641010000012	602	88752001000020	605	88843006001150	616
80987001000018	554	88296001000025	570	88641010000013	602	88752001000022	605	88843008001100	616
80987001000020	554	88296001000026	570	88641010000015	602	88752001000024	605	88843008001200	616
80987001000022	554	88296001000028	570	88641011000011	603	88758001000018	605	88872016000005	619
80987001000024	554	88296002000037	571	88641011000012	603	88758001000020	605	88872016000007	619
80987002000113	555	88296002000048	571	88641011000013	603	88758001000022	605	88872017000005	619
80987002000131	555	88296002000070	571	88641011000015	603	88758001000024	605	88872017000007	619
80987002000147	555	88296002000094	571	88641025000001	604	88802002001100	615	88875016000005	619
80990001000017	563	88296002000111	571	88641025000002	604	88802002001150	615	88875016000007	619
80990001000018	563	88296002000113	571	88670001000018	580	88802004001100	615	88875017000005	619



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
88875017000007	619	88941051000024	592	88973002000094	564	88981010000011	566	88995001000024	563
88882006001100	623	88943001000018	591	88973002000113	564	88981010000012	566	90174001000018	655
88882006001150	623	88943001000020	591	88973002000131	564	88981010000013	566	90174001000020	655
88882006001200	623	88943001000022	591	88973002000147	564	88981010000015	566	90174001000022	655
88882006002014	624	88943001000024	591	88973010000011	566	88981011000011	567	90175001000024	655
88882008001100	623	88945001000015	588	88973010000012	566	88981011000012	567	90175002000094	658
88882008001150	623	88945001000017	588	88973010000013	566	88981011000013	567	90175002000113	658
88882008001200	623	88945001000018	588	88973010000015	566	88981011000014	567	90176001000018	656
88882008001300	623	88945001000020	588	88973011000011	567	88981025000001	569	90176001000020	656
88882008002011	624	88945001000022	588	88973011000012	567	88981025000002	569	90176001000022	656
88882008002014	624	88945001000024	588	88973011000013	567	88981025000003	569	90177001000024	656
88885006001100	623	88945002000070	593	88973011000014	567	88983001000015	545	90374001000018	655
88885006001150	623	88945002000094	593	88973011000015	567	88983001000017	545	90374001000020	655
88885006001200	623	88945002000113	593	88973016000002	568	88983001000018	545	90374001000022	655
88885006002014	624	88945010000011	594	88973016000003	568	88983001000020	545	90375001000024	655
88885008001100	623	88945010000012	594	88973017000002	568	88983001000022	545	90456001000018	634
88885008001150	623	88945010000013	594	88973017000003	568	88983001000024	545	90456001000020	634
88885008001200	623	88945010000015	594	88973017000004	568	88983001000025	545	90456001000022	634
88885008001300	623	88945011000011	595	88973017000005	568	88983002000094	546	90457001000024	634
88885008002011	624	88945011000012	595	88973025000001	569	88983002000113	546	90496001000018	657
88885008002014	624	88945011000013	595	88973025000002	569	88983010000009	547	90496001000020	657
88896006001100	622	88945011000015	595	88977001000001	575	88983010000010	547	90496001000022	657
88896006001150	622	88949001000018	591	88977001000004	575	88983010000011	547	90497001000024	657
88896006001200	622	88949001000020	591	88977001000005	575	88983010000012	547	90520001000018	635
88896008001100	622	88949001000022	591	88977001000008	575	88983010000013	547	90520001000020	635
88896008001150	622	88949001000024	591	88977001000009	575	88983010000014	547	90520001000022	635
88896008001200	622	88956001000018	590	88977001000011	575	88983010000015	547	90521001000024	635
88901001000013	589	88956001000020	590	88977001000013	576	88983010000016	547	90521001000025	635
88904001000015	590	88956001000022	590	88977001000015	576	88983010000017	547	90521001000026	635
88904001000017	590	88956001000024	590	88977001000017	576	88983011000009	548	90521001000028	635
88904001000018	590	88961001000017	590	88977001000018	576	88983011000010	548	90774001000022	659
88904001000020	590	88961001000018	590	88977001000020	576	88983011000011	548	90775001000024	659
88906001000013	589	88961001000020	590	88977001000022	576	88983011000012	548	90775001000026	659
88934001000015	588	88961001000022	590	88977001000024	576	88983011000013	548	90775001000028	659
88934001000017	588	88961001000024	590	88977002000113	577	88983011000014	548	90775002000094	661
88934001000018	588	88961001000026	590	88977002000131	577	88983011000015	548	90775002000113	661
88934001000020	588	88970001000008	563	88977002000147	577	88983011000016	548	90775002000147	661
88934001000022	588	88970001000013	563	88980001000015	545	88983011000017	548	90776001000022	660
88934001000024	588	88970001000015	563	88980001000017	545	88983011000018	548	90776001000024	660
88934001000025	589	88970001000017	563	88980001000018	545	88983025000001	549	90777001000026	660
88935001000015	589	88970001000018	563	88980001000020	545	88983025000002	549	90777001000028	660
88935001000017	589	88970001000022	563	88980001000022	545	88983025000003	549	90777002000094	662
88935001000018	589	88970001000024	563	88980001000024	545	88987001000015	554	90777002000113	662
88935001000020	589	88970001000024	563	88980001000025	545	88987001000017	554	90777002000147	662
88935001000022	589	88970001000025	563	88980002000094	546	88987001000018	554		
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88935001000025	589	88970001000028	563	88980002000131	546	88987001000022	554	A01 01140	822
88935001000026	589	88970002000037	565	88980001000010	547	88987001000024	554	A01 01150	822
88935002000070	593	88970002000048	565	88980001000011	547	88987002000113	555	A01 01160	822
88935002000094	593	88970002000070	565	88980010000012	547	88987002000131	555	A01 01250	822
88935002000111	593	88970002000094	565	88980010000013	547	88987002000147	555	A01 01260	822
88935002000113	593	88970002000111	565	88980010000014	547	88990001000017	563	A01 01270	822
88935051000018	592	88970002000113	565	88980010000015	547	88990001000018	563	A01 01450	822
88935051000020	592	88970002000131	565	88980010000016	547	88990001000020	563	A01 01460	822
88935051000022	592	88970002000147	565	88980010000017	547	88990001000022	563	A01 01470	822
88935051000024	592	88970010000011	566	88980011000009	548	88990001000024	563	A01 01490	822
88941001000015	589	88970010000012	566	88980011000010	548	88990001000015	563	A01 10151	828
88941001000017	589	88970010000013	566	88980011000011	548	88992001000017	563	A01 10251	828
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88941001000022	589	88970011000012	567	88980011000014	548	88992001000022	563	A01 10351	828
88941001000024	589	88970011000013	567	88980011000015	548	88992001000024	563	A01 10361	828
88941001000025	589	88970011000014	567	88980011000016	548	88992001000025	563	A01 10371	828
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88941002000048	593	88970016000001	568	88980025000001	549	88992001000028	563	A01 10461	828
88941002000070	593	88970016000002	568	88980025000002	549	88992002000070	565	A01 10471	828
88941002000094	593	88970016000003	568	88980025000003	549	88992002000094	565	A01 11152	826
88941002000111	593	88970016000004	568	88981001000008	562	88992002000113	565	A01 11252	826
88941002000113	593	88970017000002	568	88981001000013	562	88992002000131	565	A01 11262	826
88941002000131	593	88970017000003	568	88981001000015	562	88992002000147	565	A01 11271	826
88941002000147	593	88970017000004	568	88981001000017	562	88992010000011	566	A01 11352	826
88941010000011	594	88970025000001	569	88981001000018	562	88992010000012	566	A01 11362	826
88941010000012	594	88970025000002	569	88981001000020	562	88992010000013	566	A01 11372	826
88941010000013	594	88970025000003	569	88981001000022	562	88992010000015	566	A01 11452	826
88941010000015	594	88973001000015	562	88981001000024	562	88992011000011	567	A01 11462	826
88941011000011	595	88973001000017	562	88981001000025	562	88992011000012	567	A01 11472	826
88941011000012	595	88973001000018	562	88981001000026	562	88992011000013	567	A01 14251	827
88941011000013	595	88973001000020	562	88981001000028	562	88992011000014	567	A01 14261	827
88941011000015	595	88973001000022	562	88981002000070	564	88992011000015	567	A01 14351	827
889410250000001	596	88973001000024	562	88981002000094	564	88992025000001	569	A01 14361	827
889410250000002	596	88973001000025	562	88981002000111	564	88992025000002	569	A01 14370	827
88941051000018	592	88973001000026	562	88981002000113	564	88995001000018	563	A01 15450	824
88941051000020	592	88973001000028	562	88981002000131	564	88995001000020	563		
88941051000022	592	88973002000070	564	88981002000147	564	88995001000022	563		

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
A01 15460	824	A20 01080	804	A30 40801	809	A34 35070	814	A54 00150	793
A01 15550	824	A20 01160	804	A30 41001	809	A34 35080	814	A54 00160	793
A01 15560	824	A20 01170	804	A30 41201	809	A36 33050	829	A54 00330	793
A01 15570	824	A20 01180	804	A30 41601	809	A36 34050	829	A54 00340	793
A01 15650	824	A20 01220	807	A30 42002	809	A36 35050	829	A54 00350	793
A01 15660	824	A20 01230	807	A30 42502	809	A36 36050	829	A54 00360	793
A01 15670	824	A20 01240	806	A30 51001	809	A36 37050	829	A54 00370	793
A01 15750	824	A20 01250	806	A30 51201	809	A40 04022	820	A54 00380	793
A01 15760	824	A20 01260	806	A30 51601	809	A40 04032	820	A54 10850	794
A01 15770	824	A20 01270	806	A30 52001	809	A40 05021	820	A54 10860	794
A01 15780	824	A20 01320	807	A30 52501	809	A40 05031	820	A54 10870	794
A06 00120	772	A20 01330	807	A30 62501	809	A40 05041	820	A54 10880	794
A06 00130	772	A20 01420	807	A30 63201	809	A40 06031	820	A55 00120	787
A06 10140	772	A20 01430	807	A32 26050	825	A40 06041	820	A55 00130	787
A06 20121	772	A20 05450	799	A32 26061	825	A40 06051	820	A55 00140	787
A06 20131	772	A20 05460	799	A32 26071	825	A40 06061	820	A55 00150	787
A06 20141	772	A20 05470	799	A32 32060	816	A40 16062	819	A55 00160	787
A06 20151	772	A20 05480	799	A32 32070	816	A40 17062	819	A55 00330	787
A06 30050	773	A20 05640	799	A32 32080	816	A40 17072	819	A55 00340	787
A06 30070	773	A20 05652	799	A32 36050	825	A40 24023	819	A55 00350	787
A06 30120	772	A20 05661	799	A32 36061	825	A40 24034	819	A55 00360	787
A06 30130	772	A20 05671	799	A32 36071	825	A40 24043	819	A55 00370	787
A06 30140	772	A20 05680	799	A32 36091	825	A40 24053	819	A55 00380	787
A06 30150	772	A20 05751	799	A32 40010	810	A40 25032	819	A55 02150	792
A06 30160	772	A20 05760	799	A32 40020	810	A40 25042	819	A55 02160	792
A06 30170	772	A20 05770	799	A32 40030	810	A40 25052	819	A55 02350	792
A06 30220	772	A20 05840	799	A32 40040	810	A40 25062	819	A55 02360	792
A06 30251	775	A20 05851	799	A32 40050	810	A40 26042	819	A55 10650	789
A06 30261	775	A20 05861	799	A32 40060	810	A40 26052	819	A55 10850	789
A06 30270	775	A20 05871	799	A32 40070	810	A40 26062	819	A55 10860	789
A06 36730	774	A20 05880	799	A32 40080	810	A40 27052	819	A55 10870	789
A06 40150	772	A20 05910	799	A32 40090	810	A40 27062	819	A55 50350	788
A06 50050	773	A20 05920	799	A32 40260	811	A50 00120	781	A55 50360	788
A06 50060	773	A20 05930	799	A32 40270	811	A50 00130	781	A55 50370	788
A06 50070	773	A20 05950	799	A32 42101	816	A50 00140	781	A55 55150	788
A06 50120	772	A20 05960	799	A32 42110	816	A50 00150	781	A55 55160	788
A06 50130	772	A20 05970	799	A32 42120	816	A50 00160	781	A55 55350	788
A06 50140	772	A20 10120	796	A32 42130	816	A50 00320	781	A55 55360	788
A06 50150	772	A20 10220	796	A32 42140	816	A50 00330	781	A55 55370	788
A06 50160	772	A20 10230	796	A32 42150	816	A50 00340	781	A55 55380	788
A06 50170	772	A20 10320	796	A32 42160	816	A50 00350	781	A55 56150	791
A06 50180	772	A20 10330	796	A32 42170	816	A50 00360	781	A55 56160	791
A06 50251	775	A20 10340	796	A32 46040	825	A50 00370	781	A55 56350	791
A06 50261	775	A20 10420	796	A32 46050	825	A50 00380	781	A55 56360	791
A06 50270	775	A20 10430	796	A32 46061	825	A50 00390	781	A55 57121	790
A06 53650	317	A20 10440	796	A32 46071	825	A50 00650	783	A55 57131	790
A06 56730	774	A20 10450	796	A32 46081	825	A50 00850	783	A55 57141	790
A06 56740	774	A20 10530	796	A32 46091	825	A50 00860	783	A55 57151	790
A08 61031	776	A20 10540	796	A32 46101	825	A50 00870	783	A55 57161	790
A08 61060	778	A20 10550	796	A32 46111	825	A50 00880	783	A55 57331	790
A08 71031	776	A20 10560	796	A32 50040	810	A50 01351	785	A55 57341	790
A08 91060	778	A20 10650	796	A32 50050	810	A50 01361	785	A55 57351	790
A20 00020	798	A20 10660	796	A32 50060	810	A50 01451	785	A55 57361	790
A20 00030	798	A20 10670	796	A32 50070	810	A50 01461	785	A55 57371	790
A20 00040	798	A20 10770	796	A32 50080	810	A50 01470	785	A55 57381	790
A20 00050	798	A20 10780	796	A32 50100	810	A50 55120	780	A69 04050	823
A20 00060	798	A20 11560	805	A32 50110	810	A50 55130	780	A69 04200	317
A20 00070	798	A20 11670	805	A32 50280	811	A50 55140	780	A69 04210	317
A20 00080	798	A20 20340	797	A32 52180	816	A50 55150	780	A69 04220	317
A20 00090	798	A20 20450	797	A32 52190	816	A50 55160	780	A69 05050	823
A20 00150	798	A20 20550	797	A32 52200	816	A50 55250	780	A69 05210	317
A20 00160	798	A20 20560	797	A32 56111	825	A50 55260	780	A69 05220	317
A20 00170	798	A20 20650	797	A32 56121	825	A50 55320	780	A69 05230	317
A20 00220	798	A20 20670	797	A32 56131	825	A50 55330	780	A69 05230	823
A20 00230	798	A20 21450	797	A32 60060	810	A50 55340	780	A69 06060	823
A20 00240	798	A20 21560	797	A32 60070	810	A50 55350	780	A69 06220	317
A20 00250	798	A20 60530	803	A32 60080	810	A50 55360	780	A69 06230	317
A20 00260	798	A20 60540	803	A33 11120	815	A50 55370	780	A69 06240	317
A20 00270	798	A20 60550	803	A33 12130	815	A50 55380	780	A69 08050	823
A20 00280	798	A20 60560	803	A33 13141	815	A50 56150	784	A69 08060	823
A20 00290	798	A20 60570	803	A33 14151	815	A50 56160	784	A69 08070	823
A20 00530	798	A30 10601	808	A33 15161	815	A50 56350	784	A69 08230	317
A20 00540	798	A30 10801	808	A33 16171	815	A50 56360	784	A69 08250	317
A20 00550	798	A30 11001	808	A34 05030	812	A50 57151	786		
A20 00560	798	A30 20601	808	A34 14020	813	A50 57161	786	B00 00010	722
A20 00570	798	A30 20801	808	A34 14030	813	A50 57351	786	B00 00020	722
A20 00580	798	A30 21001	808	A34 14040	813	A50 57361	786	B00 00030	722
A20 00620	800	A30 21201	808	A34 15050	813	A50 57371	786	B00 00050	722
A20 00630	800	A30 30601	809	A34 24030	821	A50 57381	786	B00 00070	722
A20 00651	802	A30 30801	809	A34 24040	821	A50 76350	782	B00 00410	722
A20 00661	802	A30 31001	809	A34 32060	814	A50 76360	782	B00 00420	722
A20 00670	802	A30 31201	809	A34 33060	814	A50 76370	782	B00 00430	722
A20 01060	804	A30 31601	809	A34 34060	814	A50 76380	782	B00 00450	722
A20 01070	804	A30 40601	809	A34 34070	814	A54 00140	793	B00 00600	723





# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
B00 00610	723	B00 30290	234	D00 75030	740	D03 50140	716	D20 10131	371
B00 00620	723	B00 30290	714	D00 75040	740	D03 50150	716	D20 10630	372
B00 00630	723	B00 30300	714	D00 75050	740	D03 50160	716	D20 10650	372
B00 00640	723	B00 30311	714	D00 75060	740	D03 55120	716	D20 10691	372
B00 00650	723	B00 30321	714	D00 75070	740	D03 55130	716	D20 10711	372
B00 00680	234	B00 30331	714	D00 75120	739	D03 55140	716	D20 10731	372
B00 00690	234	B00 30411	715	D00 75130	739	D03 55150	716	D20 10810	373
B00 05010	722	B00 30421	715	D00 75140	739	D03 55160	716	D20 10830	373
B00 05020	722	B00 30431	715	D00 75150	739	D10 00030	745	D20 10850	373
B00 05030	722	B00 35300	714	D00 75160	739	D10 00040	745	D20 10891	373
B00 05050	722	B00 35311	714	D00 75410	741	D10 00050	745	D20 15010	371
B00 05060	722	B00 35321	714	D00 75420	741	D10 05010	744	D20 15030	371
B00 05070	722	B00 35331	714	D00 75430	741	D10 05020	744	D20 15050	371
B00 05410	722	B00 35400	715	D00 75440	741	D10 05030	745	D20 15091	371
B00 05420	722	B00 35411	715	D00 75450	741	D10 05040	745	D20 15111	371
B00 05430	722	B00 35421	715	D00 75460	741	D10 05050	745	D20 15131	371
B00 05440	722	B00 35431	715	D01 20042	742	D10 15010	743	D20 15671	372
B00 05450	722	B00 37010	238	D01 20052	742	D10 15110	743	D20 15810	373
B00 05460	722	B00 37010	726	D01 20062	742	D10 15240	743	D20 15830	373
B00 05470	722	B00 37020	238	D01 25012	742	D20 00000	363	D20 15891	373
B00 05600	723	B00 37020	726	D01 25022	742	D20 00020	363	D20 20040	374
B00 05610	723	B05 20100	218	D01 25032	742	D20 00040	363	D20 20060	374
B00 05620	723	B05 20100	219	D01 25042	742	D20 00060	363	D20 20081	374
B00 05630	723	B05 20100	220	D01 25052	742	D20 00091	363	D20 20101	374
B00 05640	723	B05 20120	218	D01 25062	742	D20 00100	364	D20 20220	375
B00 05650	723	B05 20120	220	D02 10023	720	D20 00120	364	D20 20240	375
B00 05670	723	B05 20140	219	D02 10033	720	D20 00140	364	D20 20260	375
B00 10610	727	B05 20140	220	D02 10043	720	D20 00160	364	D20 20281	375
B00 10620	727	B05 20160	218	D02 10053	720	D20 00171	364	D20 20301	375
B00 10630	727	B05 20160	220	D02 10063	720	D20 00191	364	D20 20321	375
B00 10640	727	B05 20180	219	D02 10122	718	D20 00200	365	D20 40000	349
B00 15510	238	B05 20180	220	D02 10133	718	D20 00220	365	D20 40010	349
B00 15510	726	B05 20220	218	D02 10143	718	D20 00240	365	D20 40100	350
B00 15530	238	B05 20220	219	D02 10153	718	D20 00271	365	D20 40210	351
B00 15530	726	B05 20220	220	D02 10163	718	D20 00400	366	D20 40310	352
B00 15610	238	B05 20260	219	D02 10173	718	D20 00420	366	D20 40320	352
B00 15610	726	B05 20260	220	D02 10571	719	D20 00440	366	D20 40410	353
B00 15620	238	B10 01011	316	D02 10581	719	D20 00460	366	D20 45310	352
B00 15620	726	B10 02011	316	D02 10591	719	D20 00471	366	D20 50090	363
B00 15630	238	B10 03011	316	D02 10601	719	D20 00500	367	D20 50120	364
B00 15630	726	B10 04011	316	D02 10671	721	D20 00520	367	D20 50190	364
B00 15640	238	B10 05011	316	D02 10681	721	D20 00600	368	D20 50420	366
B00 15640	726	B10 06011	316	D02 10691	721	D20 00620	368	D20 50490	366
B00 15650	238	B10 07011	316	D02 10701	721	D20 00640	368	D20 50590	367
B00 15650	726	B30 01010	246	D02 15023	720	D20 00660	368	D20 50620	368
B00 15661	238	B30 01220	246	D02 15033	720	D20 00691	368	D20 50690	368
B00 15661	726	B30 02010	246	D02 15043	720	D20 00791	369	D20 50720	369
B00 15671	238	B30 02200	246	D02 15053	720	D20 05000	363	D20 50790	369
B00 15671	726	B30 03010	246	D02 15063	720	D20 05020	363	D20 55090	363
B00 15681	238	B30 04010	246	D02 15073	720	D20 05060	363	D20 55120	364
B00 15681	726	B30 05010	246	D02 15122	718	D20 05071	363	D20 55490	366
B00 15691	238	B30 06010	246	D02 15133	718	D20 05091	363	D20 80360	354
B00 15691	726	B30 07010	246	D02 15143	718	D20 05100	364	D20 80460	355
B00 15710	238	B30 11010	250	D02 15153	718	D20 05120	364	D40 00160	331
B00 15710	726	B30 11020	250	D02 15163	718	D20 05200	365	D40 00170	331
B00 15720	726	B30 12010	250	D02 15173	718	D20 05220	365	D40 00180	331
B00 15730	726	B30 12020	250	D02 15571	719	D20 05240	365	D40 00460	333
B00 15741	726	B30 13010	250	D02 15671	721	D20 05271	365	D40 00470	333
B00 15751	238	B30 13020	250	D02 15681	721	D20 05291	365	D40 00670	334
B00 15751	726	B30 14010	250	D02 20001	725	D20 05400	366	D40 00860	335
B00 25510	240	B30 14020	250	D02 20011	725	D20 05420	366	D40 00870	335
B00 25530	240	B30 15010	250	D02 20021	725	D20 05440	366	D40 00970	336
B00 25540	240	B30 15020	250	D02 20031	725	D20 05471	366	D40 01020	337
B00 25610	240	B30 16010	250	D02 20111	724	D20 05491	366	D40 01040	337
B00 25620	240	B30 16020	250	D02 20121	724	D20 05500	367	D40 01110	338
B00 25630	240	B30 17010	250	D02 20131	724	D20 05520	367	D40 01120	338
B00 25640	240	B30 17020	250	D02 20141	724	D20 05540	367	D40 01140	338
B00 25650	240	B30 17030	250	D02 25001	725	D20 05560	367	D40 01210	339
B00 25661	240			D02 25011	725	D20 05571	367	D40 01220	339
B00 25671	240	D00 70020	740	D02 25021	725	D20 05600	368	D40 01240	339
B00 25681	240	D00 70030	740	D02 25031	725	D20 05620	368	D40 02010	388
B00 25691	240	D00 70040	740	D02 25041	725	D20 05640	368	D40 02020	388
B00 25700	240	D00 70050	740	D02 25111	724	D20 05691	368	D40 02030	388
B00 25710	240	D00 70060	740	D02 25121	724	D20 05700	369	D40 02040	388
B00 25810	240	D00 70070	740	D02 25131	724	D20 05720	369	D40 05160	331
B00 25820	240	D00 70130	739	D02 25141	724	D20 05740	369	D40 05170	331
B00 25830	240	D00 70140	739	D03 15011	728	D20 05760	369	D40 05180	331
B00 25840	240	D00 70150	739	D03 15021	728	D20 05791	369	D40 05190	331
B00 25850	240	D00 70160	739	D03 15031	728	D20 05800	369	D40 05260	332
B00 25861	240	D00 70440	741	D03 15041	728	D20 10030	371	D40 05270	332
B00 25871	240	D00 70450	741	D03 15051	728	D20 10050	371	D40 05460	333
B00 25911	240	D00 70460	741	D03 50030	717	D20 10071	371	D40 05470	333
B00 30280	234	D00 75010	740	D03 50120	716	D20 10091	371	D40 05660	334
B00 30280	714	D00 75020	740	D03 50130	716	D20 10111	371	D40 05670	334

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
D40 05860	335	D40 65190	343	D54 60330	181	G03 70031	181	H01 15030	748
D40 05870	335	D50 00800	387	D54 60340	181	G03 70041	181	H01 15110	747
D40 05970	336	D50 00810	387	D54 60360	181	G03 70061	181	H01 15110	748
D40 05980	336	D50 50290	153	D54 60370	183	G03 70071	181	H01 15120	748
D40 06010	337	D50 50300	159	D54 60460	181	G03 70081	181	H01 15130	747
D40 06020	337	D50 50310	159	D54 60470	181	G03 70091	181	H05 25110	729
D40 06040	337	D50 55090	153	D54 60470	183	G03 70141	180	H05 25120	729
D40 06110	338	D50 55100	103	D54 60510	181	G03 70150	180	H05 25210	735
D40 06140	338	D50 55100	159	D54 60520	181	G03 70160	180	H05 25220	735
D40 06210	339	D50 55100	162	D54 60560	181	G03 70170	180	H05 25230	735
D40 06220	339	D50 55110	103	D54 60570	181	G03 70180	180	H05 35010	735
D40 06240	339	D50 55110	107	D54 60570	183	G03 70190	180	H05 35020	735
D40 06430	390	D50 55110	159	D54 60610	181	G03 70200	180	H05 35030	735
D40 06500	340	D50 55110	162	D54 60620	181	G03 70210	180	H05 35040	735
D40 06520	340	D50 55120	103	D54 60760	181	G03 70220	180	H05 35050	735
D40 06551	340	D50 55120	107	D54 60770	181	G03 70230	180	H05 35060	735
D40 06600	341	D50 55120	162			G03 70240	180	H05 65010	729
D40 06610	341	D50 55130	103	F10 00051	204	G03 70250	180	H05 65020	729
D40 06630	341	D50 55130	107	F10 00061	204	G03 70260	180	H10 15010.91	746
D40 06640	341	D50 55300	162	F10 00071	204	G03 70330	180	H10 15020.02	746
D40 06700	330	D50 55310	107	F10 00081	204	G03 80021	180	H10 15020.91	746
D40 06710	330	D50 55310	162	F10 00091	204	G03 80030	180	H10 15110.02	747
D40 06801	330	D50 55320	107	F10 00101	204	G03 80040	180	H10 15110.91	747
D40 06811	330	D50 55320	162	F10 00350	204	G03 80050	180	H10 15130.02	747
D40 06821	330	D50 55330	107	F10 00370	204	G03 80060	180	H10 15130.91	747
D40 06901	330	D52 01100	356	F10 00380	204	G03 80070	180	H10 15210.91	748
D40 06911	330	D52 01110	356	F10 00390	204	G03 80080	180	H10 15220.91	748
D40 06921	330	D52 06110	356	F10 00400	204	G03 80090	180	H10 15230.91	748
D40 07000	388	D52 50090	357	F10 10021	202	G03 80100	180	H10 15240.91	748
D40 07010	388	D52 50100	357	F10 10031	202	G03 80110	180	H10 15250.91	748
D40 07020	388	D52 50110	357	F10 10040	202	G03 80120	180	H10 15260.91	748
D40 07030	388	D52 50120	357	F10 10050	202	G03 80310	180	H10 15270.91	748
D40 07130	331	D52 50130	357	F10 10060	202	G04 00500	196	H10 15280.91	748
D40 07140	331	D52 55090	357	F10 11070	202	G04 01000	196	H10 15290.91	748
D40 07200	389	D52 55100	357	F10 11080	202	G04 01010	196	H10 15300.91	748
D40 07210	389	D52 55130	357	F10 11090	202	G04 01500	196	H15 21100.93	730
D40 07220	389	D53 05110	166	F10 11100	202	G04 01510	196	H15 21110.02	237
D40 07230	389	D53 05120	166	F10 11110	202	G04 02000	196	H15 21110.02	730
D40 07240	389	D53 05310	166	F10 11120	202	G04 02010	196	H15 21110.21	237
D40 07250	389	D53 05320	166	F10 11130	202	G04 02020	196	H15 21110.21	730
D40 50011	320	D53 51430	347	F51 02350	706	G04 02500	196	H15 21110.93	730
D40 50020	320	D53 51440	347	F51 02360	706	G04 02510	196	H15 21120.02	237
D40 50120	321	D53 53200	153	F51 34110	706	G04 03000	196	H15 21120.02	730
D40 50140	321	D53 53220	153	F51 34120	706	G04 03010	196	H15 21120.21	237
D40 50820	328	D53 53230	153	F51 34130	706	G04 03500	196	H15 21120.21	730
D40 50920	329	D53 53240	153			G05 00100	198	H15 21120.93	730
D40 50940	329	D53 53350	159	G01 63532	183	G05 00100	264	H15 21130.21	237
D40 55020	320	D53 53360	158	G01 63542	183	G05 10100	198	H15 21130.21	730
D40 55040	320	D53 53360	159	G01 63552	183	G05 10100	264	H15 21130.93	730
D40 55111	321	D53 53370	158	G01 70552	180	G05 10110	198	H15 21140.21	237
D40 55120	321	D53 53370	159	G01 70562	180	G05 10110	264	H15 21140.21	730
D40 55140	321	D53 53380	158	G01 71022	180	G05 20100	198	H15 21140.93	730
D40 55150	321	D53 53380	159	G01 71072	180	G05 20100	264	H15 21150.02	730
D40 55160	321	D53 53390	158	G01 71132	180	G10 10111	242	H15 21150.93	730
D40 55170	321	D53 53390	159	G01 71522	180	G10 10111.15	234	H15 21160.02	730
D40 55190	343	D53 53400	158	G01 71622	180	G10 10111.15	242	H15 21160.21	730
D40 55211	322	D53 53400	159	G01 72022	180	G10 10121	242	H15 21160.93	730
D40 55220	322	D53 53410	158	G01 72122	180	G10 10121.15	242	H15 21200.93	731
D40 55240	322	D53 53410	159	G01 72522	180	G10 10131	242	H15 21210.02	731
D40 55311	323	D53 53420	158	G01 72622	180	G10 10131.15	234	H15 21210.93	731
D40 55320	323	D53 53420	159	G01 73032	180	G10 10131.15	242	H15 21220.93	731
D40 55411	324	D53 53430	158	G01 73042	180	G10 10141	242	H15 21230.21	731
D40 55420	324	D53 53430	159	G01 73122	180	G10 10141.15	242	H15 21230.93	731
D40 55440	324	D53 56201	102	G01 73562	180	G10 10151	242	H15 21240.21	731
D40 55460	324	D53 56211	102	G01 73572	180	G10 10151.15	242	H15 21240.93	731
D40 55511	325	D53 56221	102	G03 10281	183	G10 10161	242	H15 21250.93	731
D40 55520	325	D53 56231	102	G03 10291	183	G10 10161.15	242	H15 21260.02	731
D40 55540	325	D53 56410	347	G03 10301	183	G10 10611	242	H15 21260.21	731
D40 55611	326	D53 56430	347	G03 50510	197	G10 10621	242	H15 21260.93	731
D40 55620	326	D53 56440	347	G03 50520	197	G10 10631	242	H15 21310.93	732
D40 55640	326	D54 60030	181	G03 50530	197	G10 10641	242	H15 21320.93	732
D40 55720	327	D54 60040	181	G03 50540	197	G10 10651	242	H15 21330.02	732
D40 55740	327	D54 60050	181	G03 50550	197	G10 10661	242	H15 21330.93	732
D40 55811	328	D54 60060	181	G03 50560	197	G10 12060	234	H15 21340.21	732
D40 55820	328	D54 60070	181	G03 50570	197	G10 12070	234	H15 21340.93	732
D40 55911	329	D54 60070	183	G03 60510	197	G10 12080	234	H15 21350.93	732
D40 55920	329	D54 60070	198	G03 60520	197	G10 12621	234	H15 21360.02	732
D40 55940	329	D54 60070	264	G03 60530	197	G10 12711	234	H15 21360.93	732
D40 58000	342	D54 60130	181	G03 60540	197	G10 12731	234	H15 21410.93	733
D40 58400	342	D54 60140	181	G03 60550	197	G10 12841	234	H15 21420.02	733
D40 65011	345	D54 60150	181	G03 60560	197	G10 12861	234	H15 21420.21	733
D40 65081	345	D54 60160	181	G03 60570	197			H15 21420.93	733
D40 65131	345	D54 60170	181	G03 70011	181	H01 15010	746	H15 21430.02	733
D40 65180	343	D54 60170	183	G03 70021	181	H01 15020	746	H15 21430.93	733



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
H15 21440.93	733	H50 21680	754	H52 61200.2082	758	H60 17800.84	915	H60 28500.2715	917
H15 21450.93	733	H50 23240	754	H52 61250.2082	758	H60 18000.84	915	H60 28500.84	917
H15 21460.21	733	H50 23280	754	H52 61300.1082	758	H60 18000.8440	915	H60 28500.8440	917
H15 21460.93	733	H51 31100.0182	756	H52 61300.2082	758	H60 18100.8440	915	H60 28600.84	917
H15 21530.02	734	H51 31150.0182	756	H52 61350.1082	758	H60 18500.84	915	H60 29000.2715	917
H15 21530.93	734	H51 31200.0182	756	H52 6150.1082	758	H60 18500.8440	915	H60 29100.84	917
H15 21540.02	734	H51 32100.0182	756	H52 62150.1582	758	H60 19000.2715	915	H60 29300.8440	918
H15 21540.93	734	H51 32150.0182	756	H52 62150.2082	758	H60 19000.84	915	H60 29500.2715	918
H15 21550.93	734	H51 32200.0182	756	H52 62200.1082	758	H60 19000.8440	915	H60 29500.84	918
H15 21560.02	734	H51 41100.0182	756	H52 62200.1582	758	H60 19100.8440	915	H60 29500.8440	918
H15 21560.93	734	H51 41150.0182	756	H52 62200.2082	758	H60 19500.2715	915	H60 29700.2715	918
H15 22110.93	730	H51 41200.0182	756	H52 62250.1082	758	H60 19500.84	915	H60 29700.84	918
H15 22120.21	730	H51 41250.0182	756	H52 62250.2082	758	H60 19500.8440	915	H60 29700.8440	918
H15 22130.93	730	H51 42100.0182	756	H52 62300.1082	758	H60 19800.2715	915	H60 29800.84	918
H15 22140.93	730	H51 42150.0182	756	H52 62300.1582	758	H60 20000.2715	915	H60 30000.2715	918
H15 22150.02	730	H51 42200.0182	756	H52 62300.2082	758	H60 20000.8440	915	H60 30000.84	918
H15 23110.02	730	H51 42250.0182	756	H52 62350.1082	758	H60 20500.2715	915	H60 30000.8440	918
H15 23110.21	730	H51 51100.0282	756	H52 62350.1582	758	H60 20500.84	915	H60 30100.84	918
H15 23110.93	730	H51 51150.0282	756	H52 62350.2082	758	H60 20700.8440	915	H60 30500.2715	918
H15 23120.02	730	H51 51200.0282	756	H52 81150.1082	758	H60 20800.2715	915	H60 30500.84	918
H15 23120.21	730	H51 51250.0282	756	H52 81150.1582	758	H60 21000.2715	915	H60 30700.8440	918
H15 23120.93	730	H51 51300.0282	756	H52 81150.2082	758	H60 21000.84	915	H60 30800.2715	918
H15 23130.21	730	H51 52100.0282	756	H52 81200.1082	758	H60 21000.8440	915	H60 31000.2715	918
H15 23130.93	730	H51 52150.0282	756	H52 81200.1582	758	H60 21100.2715	915	H60 31000.8440	918
H15 23140.21	730	H51 52200.0282	756	H52 81200.2082	758	H60 21100.84	915	H60 31100.84	918
H15 23140.93	730	H51 52250.0282	756	H52 81250.1082	758	H60 21300.84	916	H60 31500.84	918
H15 23150.02	730	H51 52300.0282	756	H52 81250.1582	758	H60 21500.2715	916	H60 31800.2715	918
H15 23150.93	730	H51 61150.0282	756	H52 81250.2082	758	H60 21500.8440	916	H60 31800.84	918
H15 23160.21	730	H51 61200.0282	756	H52 81300.1082	758	H60 21700.2715	916	H60 32000.2715	918
H15 23160.93	730	H51 61250.0282	756	H52 81300.2082	758	H60 21800.2715	916	H60 32000.84	918
H15 23220.93	731	H51 61300.0282	756	H52 81400.1582	758	H60 21800.8440	916	H60 32000.8440	918
H15 23230.02	731	H51 61350.0282	756	H52 81400.2082	758	H60 22000.2715	916	H60 32100.8440	918
H15 23240.93	731	H51 62150.0282	756	H52 82150.1082	758	H60 22000.84	916	H60 32700.8440	918
H15 23250.02	731	H51 62200.0282	756	H52 82150.1582	758	H60 22000.8440	916	H60 32900.8440	918
H15 23250.93	731	H51 62250.0282	756	H52 82150.2082	758	H60 22100.84	916	H60 33000.2715	918
H15 23260.93	731	H51 62300.0282	756	H52 82200.1082	758	H60 22200.84	916	H60 33000.84	918
H15 23330.93	732	H51 62350.0282	756	H52 82200.1582	758	H60 22200.8440	916	H60 33000.8440	918
H15 23340.93	732	H51 81150.0282	756	H52 82200.2082	758	H60 22400.84	916	H60 33100.84	918
H15 23350.93	732	H51 81200.0282	756	H52 82250.1082	758	H60 22500.84	916	H60 33400.2715	919
H15 23360.93	732	H51 81250.0282	756	H52 82250.1582	758	H60 22600.84	916	H60 33700.84	919
H15 23450.93	733	H51 81300.0282	756	H52 82250.2082	758	H60 22700.8440	916	H60 34000.2715	919
H15 31010.91	735	H51 81350.0282	756	H52 82300.1082	758	H60 23000.2715	916	H60 34500.8440	919
H15 31020.91	735	H51 81400.0282	756	H52 82300.1582	758	H60 23000.84	916	H60 34900.84	919
H15 31030.91	735	H51 82150.0282	756	H52 82300.2082	758	H60 23000.8440	916	H60 35000.2715	919
H15 31040.91	736	H51 82200.0282	756	H52 82350.1082	758	H60 23500.84	916	H60 35000.84	919
H15 31050.91	736	H51 82250.0282	756	H52 82350.1582	758	H60 23500.8440	916	H60 35000.8440	919
H15 31110.91	735	H51 82300.0282	756	H52 82350.2082	758	H60 23800.2715	916	H60 35200.8440	919
H15 31120.91	735	H51 82350.0282	756	H52 82400.1082	758	H60 23800.84	916	H60 35300.2715	919
H15 31130.91	735	H51 82400.0282	756	H52 82400.1582	758	H60 24000.2715	916	H60 35300.8440	919
H15 31140.91	736	H52 31100.1082	758	H52 82400.2082	758	H60 24000.84	916	H60 35500.2715	919
H15 31150.91	736	H52 31150.1082	758	H54 51150.1082	764	H60 24000.8440	916	H60 35700.84	919
H15 31210.91	735	H52 32100.1082	758	H54 52150.1082	764	H60 24500.2715	916	H60 36000.84	919
H15 31220.91	735	H52 32150.1082	758	H54 62150.1282	764	H60 24500.84	916	H60 36000.8440	919
H15 31230.91	735	H52 41100.1082	758	H54 82150.1582	764	H60 24600.2715	916	H60 36100.84	919
H15 31240.91	736	H52 41150.1082	758	H54 82150.1782	764	H60 24800.84	916	H60 36500.84	919
H15 31250.91	736	H52 41200.1082	758	H55 31100.0182	760	H60 24900.2715	916	H60 36800.2715	919
H15 31310.91	735	H52 42100.1082	758	H55 32100.0182	760	H60 25000.2715	916	H60 37000.2715	919
H15 31320.91	735	H52 42150.1082	758	H55 32150.0182	760	H60 25000.84	916	H60 37000.84	919
H15 31330.91	735	H52 42200.1082	758	H55 41200.0182	760	H60 25000.8440	916	H60 37100.2715	919
H15 31340.91	736	H52 42250.1082	758	H55 42150.0182	760	H60 25100.84	916	H60 37500.2715	920
H15 31350.91	736	H52 51150.1082	758	H55 42200.0182	760	H60 25500.84	917	H60 37500.84	920
H15 31410.91	735	H52 51150.2082	758	H55 51150.0282	760	H60 25700.84	917	H60 37500.8440	920
H15 31430.91	735	H52 51200.1082	758	H55 51200.0282	760	H60 25700.8440	917	H60 38000.84	920
H15 31440.91	736	H52 51200.1582	758	H55 52150.0282	760	H60 25800.2715	917	H60 39000.2715	920
H15 31510.91	735	H52 51200.2082	758	H55 52250.0282	760	H60 25900.8440	917	H60 39200.2715	920
H15 31520.91	735	H52 51300.1082	758	H55 61300.0282	760	H60 26000.2715	917	H60 39300.8440	920
H15 31530.91	735	H52 52100.1082	758	H55 62200.0282	760	H60 26000.84	917	H60 39500.2715	920
H15 31540.91	736	H52 52100.1582	758	H55 62300.0282	760	H60 26000.8440	917	H60 39700.84	920
H15 31550.91	736	H52 52100.2082	758	H55 81200.0282	760	H60 26500.2715	917	H60 40000.2715	920
H15 32030.91	736	H52 52150.1082	758	H55 82400.0282	760	H60 26500.84	917	H60 40000.8440	920
H15 32040.91	736	H52 52150.2082	758	H56 31100.0140	762	H60 26500.8440	917	H60 42000.2715	921
H15 32120.91	736	H52 52200.1082	758	H56 32100.0140	762	H60 26700.84	917	H60 42000.8440	921
H15 32130.91	736	H52 52200.1582	758	H56 41121.0140	762	H60 27000.2715	917	H60 43000.2715	921
H15 32220.91	736	H52 52200.2082	758	H56 42121.0140	762	H60 27000.84	917	H60 43000.84	921
H15 32230.91	736	H52 52250.1082	758	H56 51151.0140	762	H60 27000.8440	917	H60 44000.2715	921
H15 32240.91	736	H52 52250.1582	758	H56 52151.0140	762	H60 27100.2715	917	H62 20100.7710	915
H15 32330.91	736	H52 52250.2082	758	H56 61201.0140	762	H60 27100.84	917	H62 21000.7710	915
H15 32540.91	736	H52 52300.1082	758	H56 62201.0140	762	H60 27500.8440	917	H62 25000.7710	916
H15 32550.91	736	H52 52300.2082	758	H56 81251.0140	762	H60 28000.2715	917	H62 31200.7710	918
H50 01240	754	H52 61150.1082	758	H56 82251.0140	762	H60 28000.84	917	H62 39200.7710	920
H50 01281	754	H52 61150.1582	758	H60 17500.2715	915	H60 28000.8440	917	H75 10000.018425	22
H50 01640	754	H52 61150.2082	758	H60 17500.84	915	H60 28100.84	917	H75 10000.018425	922
H50 01681	754	H52 61200.1082	758	H60 17500.8440	915	H60 28200.84	917	H75 10100.018425	22
H50 21640	754	H52 61200.1582	758	H60 17700.8440	915	H60 28300.2715	917	H75 10100.018425	922



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
H80 32000.012710	200	L01 13251	817	L02 30170	335	L02 30010	389	L02 30130	321
H80 32000.016110	200	L01 13261	817	L02 30170	336	L02 30020	320	L02 30130	322
H80 35000.012710	200	L01 13271	817	L02 30170	337	L02 30020	321	L02 30130	323
H80 35000.016110	200	L01 13281	817	L02 30170	338	L02 30020	322	L02 30130	324
H80 37500.012710	200	L01 13291	817	L02 30170	339	L02 30020	323	L02 30130	325
H80 37500.016110	200	L01 13301	817	L02 30170	340	L02 30020	324	L02 30130	326
H80 40000.012710	200	L01 13321	817	L02 30170	341	L02 30020	325	L02 30130	327
H80 40000.016110	200	L01 13331	817	L02 11000	745	L02 30020	326	L02 30130	328
H80 42000.012710	200	L01 13501	817	L02 11010	745	L02 30020	327	L02 30130	329
H80 42000.016110	200	L01 13511	817	L02 11040	744	L02 30020	328	L02 30130	330
H80 44000.012710	200	L01 13521	817	L02 11040	745	L02 30020	329	L02 30130	331
H80 44000.016110	200	L01 13531	817	L02 11110	743	L02 30020	330	L02 30130	336
H80 46000.012710	200	L01 13541	817	L02 20010	337	L02 30020	331	L02 30130	337
H80 46000.016110	200	L01 13551	817	L02 20010	340	L02 30020	332	L02 30130	338
H80 48000.012710	200	L01 13561	817	L02 20040	337	L02 30020	333	L02 30130	339
H80 48000.016110	200	L01 13571	817	L02 20110	338	L02 30020	334	L02 30130	341
H80 50000.012710	200	L01 13581	817	L02 20120	338	L02 30020	335	L02 30130	343
H80 50000.016110	200	L01 14201	511	L02 20140	338	L02 30020	336	L02 30130	388
H80 52000.012710	200	L01 14201	817	L02 20220	321	L02 30020	337	L02 30130	389
H80 52000.016110	200	L01 14211	511	L02 20220	330	L02 30020	338	L02 30130	390
H80 54000.012710	200	L01 14211	817	L02 20220	331	L02 30020	339	L02 30140	321
H80 54000.016110	200	L01 14221	511	L02 20220	341	L02 30020	340	L02 30140	322
H80 56000.012710	200	L01 14221	817	L02 20220	388	L02 30020	341	L02 30140	324
H80 56000.016110	200	L01 14231	511	L02 20220	390	L02 30020	342	L02 30140	325
H80 58000.012710	200	L01 14231	817	L02 20250	321	L02 30020	345	L02 30140	326
H80 58000.016110	200	L01 14241	511	L02 20250	331	L02 30020	388	L02 30140	327
H80 60000.012710	200	L01 14241	817	L02 20250	341	L02 30020	389	L02 30140	329
H80 60000.016110	200	L01 14251	511	L02 20310	321	L02 30020	390	L02 30140	330
H80 62000.012710	200	L01 14251	817	L02 20310	322	L02 30030	320	L02 30140	331
H80 62000.016110	200	L01 14261	511	L02 20310	324	L02 30030	321	L02 30140	337
H80 67000.012710	200	L01 14261	817	L02 20310	325	L02 30030	322	L02 30140	338
H80 67000.016110	200	L01 14271	511	L02 20310	326	L02 30030	324	L02 30140	339
H80 72000.012710	200	L01 14271	817	L02 20310	328	L02 30030	325	L02 30140	340
H80 72000.016110	200	L01 14281	511	L02 20310	329	L02 30030	326	L02 30140	341
H80 77000.012710	200	L01 14281	817	L02 20310	330	L02 30030	327	L02 30140	342
H80 77000.016110	200	L01 14291	511	L02 20310	331	L02 30030	329	L02 30140	343
H80 82000.012710	200	L01 14291	817	L02 20310	332	L02 30030	330	L02 30140	388
H80 82000.016110	200	L01 14301	511	L02 20310	333	L02 30030	331	L02 30140	389
H80 87000.012710	200	L01 14301	817	L02 20310	334	L02 30030	337	L02 30160	321
H80 87000.016110	200	L01 14311	511	L02 20310	335	L02 30030	338	L02 30160	331
H80 92000.012710	200	L01 14311	817	L02 20310	336	L02 30030	339	L02 30160	341
H80 92000.016110	200	L01 14321	511	L02 20310	341	L02 30030	340	L02 30160	389
H80 97000.012710	200	L01 14321	817	L02 20310	388	L02 30030	341	L02 30300	166
H80 97000.016110	200	L01 14331	511	L02 20310	389	L02 30030	388	L02 30851	343
		L01 14331	817	L02 20410	323	L02 30030	389	L02 30860	343
L01 00001	948	L01 14410	511	L02 20420	323	L02 30100	321	L02 30880	343
L01 00011	948	L01 14410	817	L02 20520	324	L02 30100	324	L02 30890	343
L01 00031	948	L01 14420	511	L02 20520	330	L02 30100	331	L02 30920	780
L01 00041	948	L01 14420	817	L02 20540	324	L02 30100	332	L02 30920	784
L01 00051	948	L01 14430	511	L02 20540	330	L02 30100	333	L02 30920	785
L01 00800	948	L01 14430	817	L02 20720	328	L02 30100	334	L02 30920	788
L01 00900	948	L01 14450	511	L02 20720	337	L02 30100	335	L02 30920	791
L01 00910	948	L01 14450	817	L02 20810	339	L02 30100	340	L02 30920	792
L01 00930	948	L01 14460	511	L02 20820	339	L02 30111	321	L02 30930	780
L01 00940	948	L01 14460	817	L02 20840	339	L02 30111	324	L02 30930	785
L01 00950	948	L01 14470	511	L02 20920	320	L02 30111	331	L02 30940	780
L01 01000	948	L01 14470	817	L02 20920	325	L02 30111	332	L02 30940	784
L01 01100	948	L01 14521	511	L02 20920	326	L02 30111	333	L02 30940	785
L01 02041	775	L01 14521	817	L02 20920	329	L02 30111	334	L02 30940	788
L01 02051	775	L01 14531	511	L02 20920	336	L02 30111	335	L02 30940	791
L01 02061	775	L01 14531	817	L02 21040	337	L02 30111	340	L02 30940	792
L01 03990	148	L01 14541	817	L02 21110	338	L02 30111	389	L02 31010	345
L01 04000	148	L01 14551	511	L02 21140	338	L02 30121	320	L02 31020	345
L01 04010	148	L01 14551	817	L02 21200	331	L02 30121	321	L05 01010	378
L01 04020	148	L01 14561	511	L02 21200	333	L02 30121	322	L05 01020	246
L01 04020	150	L01 14561	817	L02 21200	335	L02 30121	323	L05 01020	379
L01 04150	150	L01 14571	511	L02 21220	321	L02 30121	324	L05 01020	381
L01 04160	150	L01 14571	817	L02 21220	331	L02 30121	325	L05 01020	382
L01 04190	148	L01 14581	511	L02 21220	388	L02 30121	326	L05 01020	392
L01 04190	150	L01 14581	817	L02 21720	328	L02 30121	328	L05 01030	246
L01 04240	150	L02 30170	320	L02 21720	337	L02 30121	329	L05 01030	379
L01 04300	158	L02 30170	321	L02 21810	339	L02 30121	330	L05 01030	381
L01 04310	152	L02 30170	322	L02 21820	339	L02 30121	331	L05 01030	382
L01 04350	158	L02 30170	323	L02 21840	339	L02 30121	332	L05 01030	392
L01 04370	152	L02 30170	324	L02 21940	329	L02 30121	333	L05 01040	246
L01 04450	152	L02 30170	325	L02 30010	321	L02 30121	334	L05 01040	379
L01 04450	158	L02 30170	326	L02 30010	324	L02 30121	335	L05 01040	381
L01 10431	236	L02 30170	328	L02 30010	331	L02 30121	336	L05 01040	382
L01 10441	236	L02 30170	329	L02 30010	332	L02 30121	338	L05 01040	392
L01 13201	817	L02 30170	330	L02 30010	333	L02 30121	339	L05 01050	246
L01 13211	817	L02 30170	331	L02 30010	334	L02 30121	340	L05 01050	379
L01 13221	817	L02 30170	332	L02 30010	335	L02 30121	341	L05 01050	381
L01 13231	817	L02 30170	333	L02 30010	340	L02 30121	389	L05 01060	246
L01 13241	817	L02 30170	334	L02 30010	388	L02 30130	320	L05 01060	379

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
L05 01060	381	M03 11230	257	M05 21150	226	M30 02121	247	M30 54011	247
L05 01070	246	M03 11230	259	M05 21150	228	M30 02121	381	M30 54011	382
L05 01070	379	M03 11250	257	M05 80101	218	M30 02131	247	M30 54021	247
L05 01070	381	M03 11260	261	M05 80101	219	M30 02131	381	M30 54021	382
L05 01110	218	M03 11310	255	M05 80101	223	M30 02141	247	M30 54030	382
L05 01110	219	M03 11320	225	M05 80101	228	M30 02141	381	M30 54040	382
L05 01120	218	M03 11320	257	M05 80200	223	M30 02151	247	M31 00022	376
L05 01120	219	M03 11320	259	M05 80200	228	M30 02151	381	M31 00032	376
L05 01240	218	M03 11330	225	M05 80300	223	M30 02161	247	M31 00042	376
L05 01240	219	M03 11330	227	M05 80300	228	M30 02161	381	M31 00122	394
L05 02020	815	M03 11330	229	M05 80400	223	M30 02231	247	M31 00153	394
L05 02030	815	M03 11330	257	M05 80400	228	M30 02241	247	M31 00162	394
L05 02040	815	M03 11330	259	M05 80500	223	M30 02251	247	M31 01022	377
L05 02050	815	M03 11350	257	M05 80500	228	M30 02261	247	M31 01032	377
L05 02060	815	M03 12000	255	M05 80510	223	M30 02271	247	M31 01042	377
L05 02070	815	M03 12020	224	M05 80510	228	M30 02281	247	M31 01122	395
L05 10170	23	M03 12020	257	M05 80520	223	M30 02291	247	M31 01153	395
L05 10170	25	M03 12020	259	M05 80520	228	M30 02301	247	M31 01162	395
L05 10170	27	M03 12030	224	M05 80530	223	M30 02311	247		
L07 01020	945	M03 12030	226	M05 80530	228	M30 02321	247	N00 02062	218
L07 01030	945	M03 12030	228	M05 80540	223	M30 02331	247	N00 02062	219
L07 01040	945	M03 12030	257	M05 80540	228	M30 02341	247	N00 40010	386
L07 01050	776	M03 12030	259	M05 90100	218	M30 02351	247	N00 40020	386
L07 01050	778	M03 12120	224	M05 90100	219	M30 02361	247	N00 40030	386
L07 01050	945	M03 12120	257	M05 90100	221	M30 04011	247	N00 40040	386
L07 01060	776	M03 12120	259	M05 90100	224	M30 04011	382	N00 40050	386
L07 01060	945	M03 12130	224	M05 90200	233	M30 04111	247	N00 52000	103
L07 01070	945	M03 12130	226	M05 90210	233	M30 04121	247	N00 52000	153
L07 01080	778	M03 12130	228	M05 90220	233	M30 20011	250	N00 52000	159
L07 01080	945	M03 12130	257	M05 90230	233	M30 20011	383	N00 52000	162
L07 01440	945	M03 12130	259	M05 90240	233	M30 20021	250	N00 52000	356
L07 01450	776	M03 12160	261	M05 90300	232	M30 20021	383	N00 52000	357
L07 01450	945	M03 12210	255	M05 90501	218	M30 20031	250	N00 52010	103
L07 01460	776	M03 12220	225	M05 90501	219	M30 20031	383	N00 52010	107
L07 01460	945	M03 12220	257	M05 90501	222	M30 20041	250	N00 52010	159
L07 01480	945	M03 12220	259	M05 90501	223	M30 20041	383	N00 52010	162
L07 01730	945	M03 12230	225	M05 90501	227	M30 20051	198	N00 52010	357
L07 01740	945	M03 12230	227	M10 50010.15	244	M30 20051	250	N00 52020	103
L07 01750	945	M03 12230	229	M10 50011	244	M30 20051	264	N00 52020	107
L07 01761	778	M03 12230	257	M10 50021	244	M30 20051	383	N00 52020	357
L07 01761	945	M03 12230	259	M10 50021.15	244	M30 20061	250	N00 52500	349
L07 01771	945	M03 12260	261	M10 50030.15	244	M30 20061	383	N00 52500	350
L07 01790	778	M03 12300	255	M10 50031	244	M30 20071	250	N00 52510	349
L07 02040	946	M03 12320	225	M30 00011	378	M30 20071	383	N00 52510	350
L07 02050	946	M03 12320	257	M30 00031	247	M30 20201	393	N00 52510	351
L07 02060	946	M03 12320	259	M30 00031	379	M30 20211	393	N00 52510	352
L07 02070	946	M03 12330	225	M30 00031	382	M30 20221	393	N00 52510	353
L07 02080	946	M03 12330	227	M30 00041	379	M30 50021	379	N00 52520	352
		M03 12330	229	M30 00051	379	M30 50031	379	N00 52520	354
M01 00001	801	M03 12330	257	M30 00051	382	M30 50041	379	N00 52520	355
M01 00011	801	M03 12330	259	M30 00061	379	M30 50051	379	N00 55050	936
M01 00021	801	M03 12350	257	M30 00071	379	M30 50061	379	N00 55060	743
M03 00115	254	M03 12360	261	M30 00071	382	M30 50071	379	N00 55060	936
M03 00515	254	M03 20090	260	M30 00081	379	M30 50111.21	378	N00 55070	936
M03 01025	256	M03 20100	260	M30 00091	379	M30 51021	379	N00 55100	936
M03 01535	256	M03 20110	260	M30 00101	379	M30 51031	379	N00 55110	744
M03 02045	256	M03 20120	260	M30 00111	379	M30 51041	379	N00 55110	745
M03 02555	256	M03 20140	258	M30 00121	379	M30 51051	379	N00 55110	936
M03 10011	255	M03 20150	258	M30 00131	379	M30 51061	379	N00 55120	743
M03 10021	255	M03 20160	258	M30 00161	379	M30 51071	379	N00 55120	936
M03 10033	224	M03 20170	258	M30 02031	247	M30 51111.21	378	N00 55130	745
M03 10033	257	M03 20180	258	M30 02031	381	M30 52021	247	N00 55130	936
M03 10033	259	M03 20190	258	M30 02031	392	M30 52021	381	N00 55140	745
M03 10043	224	M04 30000	219	M30 02041	247	M30 52031	247	N00 55140	936
M03 10043	226	M04 30000	219	M30 02041	381	M30 52031	381	N00 55180	936
M03 10043	228	M04 30000.20	219	M30 02041	392	M30 52041	247	N00 55551	936
M03 10043	257	M04 30000.23	219	M30 02051	247	M30 52041	381	N00 55561	349
M03 10043	259	M04 30000.24	219	M30 02051	381	M30 52051	247	N00 55561	350
M03 10063	257	M04 30010	219	M30 02051	392	M30 52051	381	N00 55561	936
M03 10070	261	M04 30100	219	M30 02061	247	M30 52061	247	N00 55571	153
M03 11100	255	M04 30110	219	M30 02061	381	M30 52061	381	N00 55571	357
M03 11110	255	M05 00010	218	M30 02061	392	M30 52071	247	N00 55571	936
M03 11120	224	M05 01000	218	M30 02071	247	M30 52071	381	N00 55581	148
M03 11120	257	M05 20101	218	M30 02071	381	M30 52421	247	N00 55581	150
M03 11120	259	M05 20101	219	M30 02071	392	M30 52421	392	N00 55581	202
M03 11130	224	M05 20101	221	M30 02081	247	M30 52431	247	N00 55581	936
M03 11130	226	M05 20110	221	M30 02081	381	M30 52431	392	N00 55600	356
M03 11130	228	M05 20151	218	M30 02081	392	M30 52441	247	N00 55701	103
M03 11130	257	M05 20151	219	M30 02091	247	M30 52441	392	N00 55701	150
M03 11200	255	M05 20151	221	M30 02091	381	M30 53021	381	N00 55701	159
M03 11210	255	M05 20151	222	M30 02101	247	M30 53031	381	N00 55701	162
M03 11230	225	M05 20151	223	M30 02101	381	M30 53041	381	N00 55701	349
M03 11230	227	M05 21100	224	M30 02111	247	M30 53051	381	N00 55701	350
M03 11230	229	M05 21150	224	M30 02111	381	M30 53061	381	N00 55701	351



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
N00 55701	352	N00 56041	81	N00 56111	381	N00 57201	936	N00 57511	329
N00 55701	353	N00 56041	87	N00 56111	383	N00 57211	148	N00 57511	343
N00 55701	356	N00 56041	95	N00 56111	936	N00 57211	936	N00 57511	345
N00 55701	357	N00 56041	98	N00 56121	349	N00 57221	387	N00 57511	354
N00 55701	936	N00 56041	148	N00 56121	936	N00 57221	936	N00 57511	355
N00 55711	936	N00 56041	202	N00 56201	166	N00 57241	522	N00 57511	363
N00 55801	936	N00 56041	321	N00 56201	347	N00 57241	936	N00 57511	364
N00 55811	936	N00 56041	324	N00 56201	352	N00 57251	51	N00 57511	365
N00 55821	103	N00 56041	376	N00 56201	376	N00 57251	55	N00 57511	366
N00 55821	107	N00 56041	377	N00 56201	377	N00 57251	59	N00 57511	367
N00 55821	159	N00 56041	714	N00 56201	388	N00 57251	937	N00 57511	368
N00 55821	162	N00 56041	715	N00 56201	389	N00 57261	35	N00 57511	369
N00 55821	357	N00 56041	936	N00 56201	394	N00 57261	37	N00 57511	371
N00 55821	936	N00 56051	51	N00 56201	395	N00 57261	39	N00 57511	372
N00 55851	936	N00 56051	55	N00 56201	724	N00 57261	53	N00 57511	716
N00 55891	103	N00 56051	59	N00 56201	725	N00 57261	57	N00 57511	717
N00 55891	936	N00 56051	81	N00 56201	936	N00 57261	71	N00 57511	739
N00 55901	107	N00 56051	936	N00 56211	204	N00 57261	138	N00 57511	740
N00 55901	357	N00 56101	204	N00 56211	220	N00 57261	140	N00 57511	741
N00 55901	936	N00 56101	220	N00 56211	225	N00 57261	142	N00 57511	937
N00 56011	220	N00 56101	225	N00 56211	226	N00 57261	330	N00 57521	77
N00 56011	234	N00 56101	227	N00 56211	228	N00 57261	390	N00 57521	83
N00 56011	238	N00 56101	229	N00 56211	247	N00 57261	937	N00 57521	91
N00 56011	714	N00 56101	232	N00 56211	250	N00 57271	138	N00 57521	95
N00 56011	715	N00 56101	234	N00 56211	256	N00 57271	140	N00 57521	98
N00 56011	726	N00 56101	238	N00 56211	258	N00 57271	340	N00 57521	150
N00 56011	936	N00 56101	240	N00 56211	331	N00 57271	937	N00 57521	158
N00 56021	220	N00 56101	242	N00 56211	336	N00 57281	937	N00 57521	159
N00 56021	238	N00 56101	247	N00 56211	356	N00 57301	37	N00 57521	162
N00 56021	240	N00 56101	250	N00 56211	363	N00 57301	40	N00 57521	197
N00 56021	244	N00 56101	257	N00 56211	364	N00 57301	53	N00 57521	202
N00 56021	247	N00 56101	259	N00 56211	366	N00 57301	57	N00 57521	320
N00 56021	250	N00 56101	261	N00 56211	367	N00 57301	71	N00 57521	321
N00 56021	347	N00 56101	347	N00 56211	368	N00 57301	138	N00 57521	322
N00 56021	349	N00 56101	350	N00 56211	369	N00 57301	140	N00 57521	323
N00 56021	350	N00 56101	351	N00 56211	379	N00 57301	142	N00 57521	324
N00 56021	379	N00 56101	352	N00 56211	381	N00 57301	330	N00 57521	325
N00 56021	381	N00 56101	353	N00 56211	383	N00 57301	937	N00 57521	326
N00 56021	382	N00 56101	376	N00 56211	722	N00 57321	937	N00 57521	327
N00 56021	383	N00 56101	379	N00 56211	723	N00 57341	340	N00 57521	328
N00 56021	388	N00 56101	381	N00 56211	936	N00 57341	937	N00 57521	329
N00 56021	389	N00 56101	382	N00 56301	388	N00 57411	937	N00 57521	342
N00 56021	392	N00 56101	383	N00 56301	389	N00 57421	937	N00 57521	357
N00 56021	393	N00 56101	388	N00 56301	936	N00 57431	937	N00 57521	363
N00 56021	394	N00 56101	389	N00 56401	166	N00 57440	138	N00 57521	364
N00 56021	395	N00 56101	392	N00 56401	256	N00 57440	148	N00 57521	365
N00 56021	722	N00 56101	393	N00 56401	260	N00 57440	937	N00 57521	366
N00 56021	723	N00 56101	394	N00 56401	936	N00 57450	140	N00 57521	368
N00 56021	726	N00 56101	395	N00 56411	331	N00 57450	937	N00 57521	369
N00 56021	727	N00 56101	722	N00 56411	369	N00 57460	140	N00 57521	371
N00 56021	936	N00 56101	723	N00 56411	389	N00 57460	142	N00 57521	372
N00 56031	221	N00 56101	724	N00 56411	936	N00 57460	150	N00 57521	373
N00 56031	225	N00 56101	725	N00 56591	340	N00 57460	937	N00 57521	375
N00 56031	234	N00 56101	726	N00 56591	936	N00 57470	142	N00 57521	673
N00 56031	247	N00 56101	727	N00 56651	331	N00 57470	152	N00 57521	716
N00 56031	255	N00 56101	936	N00 56651	337	N00 57470	937	N00 57521	728
N00 56031	257	N00 56111	204	N00 56651	338	N00 57480	138	N00 57521	739
N00 56031	259	N00 56111	221	N00 56651	339	N00 57480	148	N00 57521	740
N00 56031	331	N00 56111	222	N00 56651	341	N00 57480	937	N00 57521	741
N00 56031	333	N00 56111	223	N00 56651	718	N00 57490	138	N00 57521	937
N00 56031	334	N00 56111	247	N00 56651	719	N00 57490	148	N00 57531	91
N00 56031	335	N00 56111	250	N00 56651	720	N00 57490	937	N00 57531	98
N00 56031	363	N00 56111	331	N00 56651	721	N00 57500	140	N00 57531	102
N00 56031	364	N00 56111	332	N00 56651	742	N00 57500	150	N00 57531	103
N00 56031	365	N00 56111	333	N00 56651	936	N00 57500	937	N00 57531	107
N00 56031	366	N00 56111	334	N00 56751	337	N00 57511	77	N00 57531	150
N00 56031	367	N00 56111	335	N00 56751	338	N00 57511	83	N00 57531	158
N00 56031	368	N00 56111	336	N00 56751	339	N00 57511	89	N00 57531	159
N00 56031	369	N00 56111	345	N00 56751	341	N00 57511	91	N00 57531	162
N00 56031	371	N00 56111	356	N00 56751	345	N00 57511	95	N00 57531	197
N00 56031	373	N00 56111	363	N00 56751	718	N00 57511	98	N00 57531	202
N00 56031	375	N00 56111	364	N00 56751	719	N00 57511	148	N00 57531	320
N00 56031	379	N00 56111	365	N00 56751	720	N00 57511	150	N00 57531	321
N00 56031	381	N00 56111	366	N00 56751	721	N00 57511	153	N00 57531	322
N00 56031	392	N00 56111	367	N00 56751	742	N00 57511	197	N00 57531	324
N00 56031	724	N00 56111	368	N00 56751	936	N00 57511	202	N00 57531	325
N00 56031	725	N00 56111	369	N00 56771	331	N00 57511	320	N00 57531	326
N00 56031	936	N00 56111	371	N00 56771	936	N00 57511	321	N00 57531	327
N00 56041	35	N00 56111	372	N00 56811	936	N00 57511	322	N00 57531	329
N00 56041	39	N00 56111	373	N00 56851	341	N00 57511	323	N00 57531	343
N00 56041	51	N00 56111	374	N00 56851	936	N00 57511	324	N00 57531	357
N00 56041	55	N00 56111	375	N00 56861	499	N00 57511	325	N00 57531	371
N00 56041	59	N00 56111	377	N00 56861	936	N00 57511	326	N00 57531	372
N00 56041	77	N00 56111	379	N00 57191	936	N00 57511	328	N00 57531	374

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
N00 57531	375	N00 70140	242	N10 12020	140	U10 71900	35	U11 53000	35
N00 57531	716	N00 70160	673	N10 12030	140	U10 71950	35	U11 53100	35
N00 57531	728	N00 70190	242	N10 12050	140	U10 72000	35	U11 53150	35
N00 57531	739	N00 70210	673	N10 12050	142	U10 72050	35	U11 53200	35
N00 57531	740	N00 70370	158	N10 12060	142	U10 72100	35	U11 53300	35
N00 57531	741	N00 70380	158	N10 12070	142	U10 72200	35	U11 53400	37
N00 57531	937	N00 70400	673	N10 20220	343	U10 72250	35	U11 53500	37
N00 57541	102	N00 70460	158	N10 30738	945	U10 72300	35	U11 53600	37
N00 57541	103	N00 70800	158	N10 30739	778	U10 72400	35	U11 53700	37
N00 57541	107	N00 70910	148	N10 30739	945	U10 72450	35	U11 53750	37
N00 57541	197	N00 70920	148	N10 30740	945	U10 72500	35	U11 53800	37
N00 57541	357	N00 70930	148	N10 30741	945	U10 72600	35	U11 53900	37
N00 57541	728	N00 70940	148	N10 30742	778	U10 72650	35	U11 53950	37
N00 57541	937	N00 70950	150	N10 30742	945	U10 72700	35	U11 54000	37
N00 57553	35	N00 70960	150	N12 20120	819	U10 72800	35	U11 54100	37
N00 57553	39	N00 70970	152	N12 20140	819	U10 72850	35	U11 54200	37
N00 57553	51	N00 71000	808	N12 20170	819	U10 72900	35	U11 54300	37
N00 57553	55	N00 71000	809			U10 72950	35	U11 54400	37
N00 57553	59	N00 71020	673	U10 01402	39	U10 73000	35	U11 61402	39
N00 57553	77	N00 71020	815	U10 01502	39	U10 73100	35	U11 61502	39
N00 57553	81	N00 71020	816	U10 01550	39	U10 73150	35	U11 61550	39
N00 57553	83	N00 71050	808	U10 01600	39	U10 73200	35	U11 61600	39
N00 57553	89	N00 71050	809	U10 01700	39	U10 73300	35	U11 61650	39
N00 57553	95	N00 71050	815	U10 11750	39	U10 73400	37	U11 61700	39
N00 57553	98	N00 71070	673	U10 11800	39	U10 73500	37	U11 71750	39
N00 57553	138	N00 71070	815	U10 11850	39	U10 73600	37	U11 71800	39
N00 57553	140	N00 71070	816	U10 11900	39	U10 73700	37	U11 71850	39
N00 57553	148	N00 71100	808	U10 11950	39	U10 73750	37	U11 71900	39
N00 57553	321	N00 71110	808	U10 12000	39	U10 73800	37	U11 71950	39
N00 57553	364	N00 71120	809	U10 12050	39	U10 73900	37	U11 72000	39
N00 57553	366	N00 71130	673	U10 12100	39	U10 73950	37	U11 72050	39
N00 57553	368	N00 71130	809	U10 12200	39	U10 74000	37	U11 72100	39
N00 57553	369	N00 71150	815	U10 12250	39	U10 74100	37	U11 72200	39
N00 57553	937	N00 71200	808	U10 12300	39	U10 74200	37	U11 72250	39
N00 57553	330	N00 71210	808	U10 22400	39	U10 74300	37	U11 72300	39
N00 57571	35	N00 71220	673	U10 22450	39	U10 74400	37	U11 82400	39
N00 57571	37	N00 71220	809	U10 22500	39	U10 84500	37	U11 82450	39
N00 57571	39	N00 71230	673	U10 22600	39	U10 84600	37	U11 82500	39
N00 57571	51	N00 71230	809	U10 22650	39	U10 84700	37	U11 82600	39
N00 57571	55	N00 71240	815	U10 22700	39	U10 84800	37	U11 82650	39
N00 57571	59	N00 71250	815	U10 22800	39	U10 84900	37	U11 82700	39
N00 57571	71	N00 71280	815	U10 22850	39	U10 85000	37	U11 82800	39
N00 57571	138	N00 71300	808	U10 22900	39	U10 85100	37	U11 82850	39
N00 57571	140	N00 71310	809	U10 22950	39	U10 85200	37	U11 82900	39
N00 57571	142	N00 71320	809	U10 23000	39	U10 85300	37	U11 82950	39
N00 57571	153	N00 71320	815	U10 23100	39	U10 85400	37	U11 83000	39
N00 57571	330	N00 71340	815	U10 23150	39	U10 95500	37	U11 83100	39
N00 57571	357	N00 71350	815	U10 23200	39	U10 95600	37	U11 83150	39
N00 57571	937	N00 71400	673	U10 23300	39	U10 95700	37	U11 83200	39
N00 57611	102	N00 71400	809	U10 23400	40	U10 95800	37	U11 83300	39
N00 57611	103	N00 71410	809	U10 23500	40	U10 95900	37	U11 83400	40
N00 57611	937	N00 71500	809	U10 23600	40	U10 96000	37	U11 83500	40
N00 57630	119	N00 71520	815	U10 23700	40	U10 96100	37	U11 83600	40
N00 57630	121	N00 71540	816	U10 23750	40	U10 96200	37	U11 83700	40
N00 57630	937	N00 71600	809	U10 23800	40	U10 96300	37	U11 83750	40
N00 57640	121	N00 71650	809	U10 23900	40	U10 96400	37	U11 83800	40
N00 57640	123	N00 71730	816	U10 23950	40	U10 96500	37	U11 83900	40
N00 57640	937	N00 71800	816	U10 24000	40	U11 51402	35	U11 83950	40
N00 57650	123	N00 71900	815	U10 24100	40	U11 51502	35	U11 84000	40
N00 57650	125	N00 71910	815	U10 24200	40	U11 51550	35	U11 84100	40
N00 57650	127	N00 71940	815	U10 24300	40	U11 51600	35	U11 84200	40
N00 57650	937	N00 71970	815	U10 24400	40	U11 51650	35	U11 84300	40
N00 57660	117	N00 71980	815	U10 33300	39	U11 51700	35	U11 84400	40
N00 57660	937	N00 72000	825	U10 33400	40	U11 51750	35	U11 93300	39
N00 57670	127	N00 72010	825	U10 33500	40	U11 51800	35	U11 93400	40
N00 57670	129	N00 72050	825	U10 33600	40	U11 51850	35	U11 93500	40
N00 57670	131	N00 72060	825	U10 33700	40	U11 51900	35	U11 93600	40
N00 57670	937	N00 72070	825	U10 33750	40	U11 51950	35	U11 93700	40
N00 57710	937	N00 72080	825	U10 33800	40	U11 52000	35	U11 93750	40
N00 57780	937	N10 11010	102	U10 33900	40	U11 52050	35	U11 93800	40
N00 57790	937	N10 11200	347	U10 33950	40	U11 52100	35	U11 93900	40
N00 57810	937	N10 11210	178	U10 34000	40	U11 52200	35	U11 93950	40
N00 57820	937	N10 11310	178	U10 34100	40	U11 52250	35	U11 94000	40
N00 57830	937	N10 11310	347	U10 34200	40	U11 52300	35	U11 94100	40
N00 57840	937	N10 11320	178	U10 34300	40	U11 52400	35	U11 94200	40
N00 57860	937	N10 11400	102	U10 34400	40	U11 52450	35	U11 94300	40
N00 57870	937	N10 11400	178	U10 71402	35	U11 52500	35	U11 94400	40
N00 57880	937	N10 11400	347	U10 71502	35	U11 52600	35	U12 34500	37
N00 57890	937	N10 11500	102	U10 71550	35	U11 52650	35	U12 34600	37
N00 57900	937	N10 11500	178	U10 71600	35	U11 52700	35	U12 34700	37
N00 57910	937	N10 11500	387	U10 71700	35	U11 52800	35	U12 34800	37
N00 57920	937	N10 11510	153	U10 71750	35	U11 52850	35	U12 34900	37
N00 70080	242	N10 11510	178	U10 71800	35	U11 52900	35	U12 35000	37
N00 70090	242	N10 12010	138	U10 71850	35	U11 52950	35	U12 35100	37





# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
U12 35200	37	U20 82550	121	U40 72600	58	U42 51900	50	U43 22850	54
U12 35300	37	U20 82600	121	U40 72650	58	U42 51950	50	U43 22900	54
U12 35400	37	U20 82650	121	U40 72700	58	U42 52000	50	U43 22950	54
U12 45500	37	U20 82700	121	U40 72750	58	U42 52050	50	U43 23000	54
U12 45600	37	U20 92750	121	U40 72800	58	U42 52100	50	U43 33050	56
U12 45700	37	U20 92800	123	U40 72850	58	U42 52150	50	U43 33100	56
U12 45800	37	U20 92850	123	U40 72900	58	U42 52200	50	U43 33150	56
U12 45900	37	U20 92900	123	U40 72950	58	U42 52250	50	U43 33200	56
U12 46000	37	U20 92950	123	U40 73000	58	U42 52300	50	U43 33250	56
U12 46100	37	U20 93000	123	U42 01400	54	U42 52350	50	U43 33300	56
U12 46200	37	U20 93050	123	U42 01450	54	U42 52400	50	U43 33350	56
U12 46300	37	U20 93100	123	U42 01500	54	U42 52450	50	U43 33400	56
U12 46400	37	U20 93150	125	U42 01550	54	U42 52500	50	U43 33450	56
U12 46500	37	U20 93200	125	U42 01600	54	U42 52550	50	U43 33500	56
U20 01750	117	U20 93250	125	U42 01650	54	U42 52600	50	U43 33550	56
U20 01800	117	U20 93300	125	U42 01700	54	U42 52650	50	U43 33600	56
U20 01850	117	U20 93350	125	U42 11750	54	U42 52700	50	U43 33650	56
U20 01900	117	U20 93400	125	U42 11800	54	U42 52750	50	U43 33700	56
U20 01950	117	U20 93450	125	U42 11850	54	U42 52800	50	U43 33750	56
U20 02000	117	U20 93500	127	U42 11900	54	U42 52850	50	U43 33800	56
U20 02050	117	U20 93550	127	U42 11950	54	U42 52900	50	U43 33850	56
U20 02100	119	U20 93600	127	U42 12000	54	U42 52950	50	U43 33900	56
U20 02150	119	U22 21750	133	U42 12050	54	U42 53000	50	U43 33950	56
U20 02200	119	U22 22100	133	U42 12100	54	U42 63050	52	U43 34000	56
U20 02250	119	U22 22500	133	U42 12150	54	U42 63100	52	U43 34050	56
U20 02300	119	U22 23000	133	U42 12200	54	U42 63150	52	U43 34100	56
U20 02350	119	U22 43650	133	U42 12250	54	U42 63200	52	U43 34150	56
U20 02400	119	U22 71750	133	U42 12300	54	U42 63250	52	U43 34200	56
U20 02450	121	U22 82100	133	U42 12350	54	U42 63300	52	U43 34250	56
U20 02500	121	U22 82500	133	U42 22400	54	U42 63350	52	U43 34300	56
U20 02550	121	U22 93000	133	U42 22450	54	U42 63400	52	U43 34350	56
U20 02600	121	U40 61400	58	U42 22500	54	U42 63450	52	U43 34400	56
U20 02650	121	U40 61450	58	U42 22550	54	U42 63500	52	U43 34450	56
U20 02700	121	U40 61500	58	U42 22600	54	U42 63550	52	U43 34500	56
U20 02750	121	U40 61550	58	U42 22650	54	U42 63600	52	U43 34550	56
U20 02800	123	U40 61600	58	U42 22700	54	U42 63650	52	U43 34600	56
U20 02850	123	U40 61650	58	U42 22750	54	U42 63700	52	U43 51400	50
U20 02900	123	U40 61700	58	U42 22800	54	U42 63750	52	U43 51450	50
U20 02950	123	U40 61750	58	U42 22850	54	U42 63800	52	U43 51500	50
U20 03000	123	U40 61800	58	U42 22900	54	U42 63850	52	U43 51550	50
U20 03050	123	U40 61850	58	U42 22950	54	U42 63900	52	U43 51600	50
U20 03100	123	U40 61900	58	U42 23000	54	U42 63950	52	U43 51650	50
U20 03150	125	U40 61950	58	U42 33050	56	U42 64000	52	U43 51700	50
U20 03200	125	U40 62000	58	U42 33100	56	U42 64050	52	U43 51750	50
U20 03250	125	U40 62050	58	U42 33150	56	U42 64100	52	U43 51800	50
U20 03300	125	U40 62100	58	U42 33200	56	U42 64150	52	U43 51850	50
U20 03350	125	U40 62150	58	U42 33250	56	U42 64200	52	U43 51900	50
U20 03400	125	U40 62200	58	U42 33300	56	U42 64250	52	U43 51950	50
U20 03450	125	U40 62250	58	U42 33350	56	U42 64300	52	U43 52000	50
U20 03500	127	U40 62300	58	U42 33400	56	U42 64350	52	U43 52050	50
U20 03550	127	U40 62350	58	U42 33450	56	U42 64400	52	U43 52100	50
U20 03600	127	U40 62400	58	U42 33500	56	U42 64450	52	U43 52150	50
U20 13650	127	U40 62450	58	U42 33550	56	U42 64500	52	U43 52200	50
U20 13700	127	U40 62500	58	U42 33600	56	U42 64550	52	U43 52250	50
U20 13750	127	U40 62550	58	U42 33650	56	U42 64600	52	U43 52300	50
U20 13800	127	U40 62600	58	U42 33700	56	U43 01400	54	U43 52350	50
U20 13850	129	U40 62650	58	U42 33750	56	U43 01450	54	U43 52400	50
U20 13900	129	U40 62700	58	U42 33800	56	U43 01500	54	U43 52450	50
U20 13950	129	U40 62750	58	U42 33850	56	U43 01550	54	U43 52500	50
U20 14000	129	U40 62800	58	U42 33900	56	U43 01600	54	U43 52550	50
U20 14050	129	U40 62850	58	U42 33950	56	U43 01650	54	U43 52600	50
U20 14100	129	U40 62900	58	U42 34000	56	U43 01700	54	U43 52650	50
U20 14150	129	U40 62950	58	U42 34050	56	U43 11750	54	U43 52700	50
U20 14200	131	U40 63000	58	U42 34100	56	U43 11800	54	U43 52750	50
U20 14250	131	U40 71600	58	U42 34150	56	U43 11850	54	U43 52800	50
U20 14300	131	U40 71650	58	U42 34200	56	U43 11900	54	U43 52850	50
U20 14350	131	U40 71700	58	U42 34250	56	U43 11950	54	U43 52900	50
U20 14400	131	U40 71750	58	U42 34300	56	U43 12000	54	U43 52950	50
U20 71750	117	U40 71800	58	U42 34350	56	U43 12050	54	U43 53000	50
U20 71800	117	U40 71850	58	U42 34400	56	U43 12100	54	U43 63050	52
U20 71850	117	U40 71900	58	U42 34450	56	U43 12150	54	U43 63100	52
U20 71900	117	U40 71950	58	U42 34500	56	U43 12200	54	U43 63150	52
U20 81950	117	U40 72000	58	U42 34550	56	U43 12250	54	U43 63200	52
U20 82000	117	U40 72050	58	U42 34600	56	U43 12300	54	U43 63250	52
U20 82050	117	U40 72100	58	U42 51400	50	U43 22350	54	U43 63300	52
U20 82100	119	U40 72150	58	U42 51450	50	U43 22400	54	U43 63350	52
U20 82150	119	U40 72200	58	U42 51500	50	U43 22450	54	U43 63400	52
U20 82200	119	U40 72250	58	U42 51550	50	U43 22500	54	U43 63450	52
U20 82250	119	U40 72300	58	U42 51600	50	U43 22550	54	U43 63500	52
U20 82300	119	U40 72350	58	U42 51650	50	U43 22600	54	U43 63550	52
U20 82350	119	U40 72400	58	U42 51700	50	U43 22650	54	U43 63600	52
U20 82400	119	U40 72450	58	U42 51750	50	U43 22700	54	U43 63650	52
U20 82450	121	U40 72500	58	U42 51800	50	U43 22750	54	U43 63700	52
U20 82500	121	U40 72550	58	U42 51850	50	U43 22800	54	U43 63750	52

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
U43 63800	52	U44 51500	51	U45 22450	55	U45 63400	53	V11 02500.135210	12
U43 63850	52	U44 51550	51	U45 22500	55	U45 63450	53	V11 02600.135210	12
U43 63900	52	U44 51600	51	U45 22550	55	U45 63500	53	V11 02700.135210	12
U43 63950	52	U44 51650	51	U45 22600	55	U45 63550	53	V11 02800.135210	12
U43 64000	52	U44 51700	51	U45 22650	55	U45 63600	53	V11 02900.135210	12
U43 64050	52	U44 51750	51	U45 22700	55	U45 63650	53	V11 03000.135210	12
U43 64100	52	U44 51800	51	U45 22750	55	U45 63700	53	V11 03100.135210	12
U43 64150	52	U44 51850	51	U45 22800	55	U45 63750	53	V11 03200.135210	12
U43 64200	52	U44 51900	51	U45 22850	55	U45 63800	53	V11 03300.135210	12
U43 64250	52	U44 51950	51	U45 22900	55	U45 63850	53	V11 03400.135210	12
U43 64300	52	U44 52000	51	U45 22950	55	U45 63900	53	V11 03500.135210	12
U43 64350	52	U44 52050	51	U45 23000	55	U45 63950	53	V11 03600.135210	12
U43 64400	52	U44 52100	51	U45 23050	57	U45 64000	53	V11 03700.135210	12
U43 64450	52	U44 52150	51	U45 23100	57	U45 64050	53	V11 03800.135210	12
U43 64500	52	U44 52200	51	U45 23150	57	U45 64100	53	V11 03900.135210	12
U43 64550	52	U44 52250	51	U45 23200	57	U45 64150	53	V11 04000.135210	12
U43 64600	52	U44 52300	51	U45 23250	57	U45 64200	53	V11 04100.135210	12
U44 01400	55	U44 52350	51	U45 23300	57	U45 64250	53	V11 04200.135210	12
U44 01450	55	U44 52400	51	U45 23350	57	U45 64300	53	V11 04300.135210	12
U44 01500	55	U44 52450	51	U45 23400	57	U45 64350	53	V11 04400.135210	12
U44 01550	55	U44 52500	51	U45 23450	57	U45 64400	53	V11 04500.135210	12
U44 01600	55	U44 52550	51	U45 23500	57	U45 64450	53	V11 04600.135210	12
U44 01650	55	U44 52600	51	U45 23550	57	U45 64500	53	V11 04700.135210	12
U44 01700	55	U44 52650	51	U45 23600	57	U45 64550	53	V11 04800.135210	12
U44 11750	55	U44 52700	51	U45 23650	57	U45 64600	53	V11 04830.135210	12
U44 11800	55	U44 52750	51	U45 23700	57	U49 02600	71	V11 04900.135210	12
U44 11850	55	U44 52800	51	U45 23750	57	U49 03300	71	V11 04930.135210	12
U44 11900	55	U44 52850	51	U45 23800	57	U49 03900	71	V11 05000.135210	12
U44 11950	55	U44 52900	51	U45 23850	57	U49 04500	71	V11 05100.135210	12
U44 12000	55	U44 52950	51	U45 23900	57	U53 21000	23	V11 05200.135210	12
U44 12050	55	U44 53000	51	U45 23950	57	U53 21050	23	V11 05300.135210	12
U44 12100	55	U44 63050	53	U45 24000	57	U53 21100	23	V11 05400.135210	12
U44 12150	55	U44 63100	53	U45 24050	57	U53 21150	23	V11 05500.135210	12
U44 12200	55	U44 63150	53	U45 24100	57	U53 31200	23	V11 05600.135210	12
U44 12250	55	U44 63200	53	U45 24150	57	U53 31250	23	V11 05700.135210	12
U44 12300	55	U44 63250	53	U45 24200	57	U53 31300	23	V11 05800.135210	12
U44 22350	55	U44 63300	53	U45 24250	57	U53 31400	25	V11 05900.135210	12
U44 22400	55	U44 63350	53	U45 24300	57	U53 31500	25	V11 06000.135210	12
U44 22450	55	U44 63400	53	U45 24350	57	U53 41600	25	V11 06000.135510	16
U44 22500	55	U44 63450	53	U45 24400	57	U53 41700	27	V11 06100.135210	12
U44 22550	55	U44 63500	53	U45 24450	57	U53 41800	27	V11 06100.135210	12
U44 22600	55	U44 63550	53	U45 24500	57	U53 41900	27	V11 06200.135210	12
U44 22650	55	U44 63600	53	U45 24550	57	U55 21000	23	V11 06300.135210	12
U44 22700	55	U44 63650	53	U45 24600	57	U55 21050	23	V11 06350.135210	12
U44 22750	55	U44 63700	53	U45 24650	57	U55 21100	23	V11 06400.135210	12
U44 22800	55	U44 63750	53	U45 24700	51	U55 21150	23	V11 06500.135210	12
U44 22850	55	U44 63800	53	U45 24750	51	U55 31200	23	V11 06600.135210	12
U44 22900	55	U44 63850	53	U45 24800	51	U55 31250	23	V11 06700.135210	12
U44 22950	55	U44 63900	53	U45 24850	51	U55 31300	23	V11 06800.135210	12
U44 23000	55	U44 63950	53	U45 24900	51	U55 31400	25	V11 06900.135210	12
U44 33050	57	U44 64000	53	U45 24950	51	U55 31500	25	V11 07000.135210	12
U44 33100	57	U44 64050	53	U45 25000	51	U55 41600	25	V11 07100.135210	12
U44 33150	57	U44 64100	53	U45 25050	51	U55 41700	27	V11 07200.135210	13
U44 33200	57	U44 64150	53	U45 25100	51	U55 41800	27	V11 07300.135210	13
U44 33250	57	U44 64200	53	U45 25150	51	U55 41900	27	V11 07400.135210	13
U44 33300	57	U44 64250	53	U45 25200	51	U57 21000	23	V11 07500.135210	13
U44 33350	57	U44 64300	53	U45 25250	51	U57 21050	23	V11 07600.135210	13
U44 33400	57	U44 64350	53	U45 25300	51	U57 21100	23	V11 07700.135210	13
U44 33450	57	U44 64400	53	U45 25350	51	U57 21150	23	V11 07800.135210	13
U44 33500	57	U44 64450	53	U45 25400	51	U57 31200	23	V11 07900.135210	13
U44 33550	57	U44 64500	53	U45 25450	51	U57 31250	23	V11 07930.135210	13
U44 33600	57	U44 64550	53	U45 25500	51	U57 31300	23	V11 08000.135210	13
U44 33650	57	U44 64600	53	U45 25550	51	U57 31400	25	V11 08000.135510	16
U44 33700	57	U45 01400	55	U45 25600	51	U57 31500	25	V11 08000.235510	16
U44 33750	57	U45 01450	55	U45 25650	51	U57 41600	25	V11 08100.135210	13
U44 33800	57	U45 01500	55	U45 25700	51	U57 41700	27	V11 08200.135210	13
U44 33850	57	U45 01550	55	U45 25750	51	U57 41800	27	V11 08300.135210	13
U44 33900	57	U45 01600	55	U45 25800	51	U57 41900	27	V11 08400.135210	13
U44 33950	57	U45 01650	55	U45 25850	51			V11 08500.135210	13
U44 34000	57	U45 01700	55	U45 25900	51	V03 06000.145510	17	V11 08600.135210	13
U44 34050	57	U45 11750	55	U45 25950	51	V03 08000.145510	17	V11 08700.135210	13
U44 34100	57	U45 11800	55	U45 26000	51	V03 10000.145510	17	V11 08800.135210	13
U44 34150	57	U45 11850	55	U45 26050	51	V11 00800.135210	12	V11 08900.135210	13
U44 34200	57	U45 11900	55	U45 26100	51	V11 01000.135210	12	V11 09000.135210	13
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U44 34500	57	U45 12200	55	U45 26400	53	V11 02000.135210	12	V11 09520.135210	13
U44 34550	57	U45 12250	55	U45 26450	53	V11 02100.135210	12	V11 09600.135210	13
U44 34600	57	U45 12300	55	U45 26500	53	V11 02200.135210	12	V11 09700.135210	13
U44 51400	51	U45 22350	55	U45 26550	53	V11 02300.135210	12	V11 09800.135210	13
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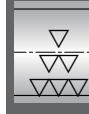
# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
V11 10000.135210	13	V14 75800	106	V21 10900.135210	15	V30 33501	76	V30 74301	76
V11 10000.135510	16	V14 75900	106	V21 11000.135210	15	V30 33601	76	V30 74401	76
V11 10000.235510	16	V14 76000	106	V21 11100.135210	15	V30 33701	76	V30 91403	77
V11 10100.135210	13	V14 76100	106	V21 11200.135210	15	V30 33751	76	V30 91503	77
V11 10200.135210	13	V14 76200	106	V21 11300.135210	15	V30 33801	76	V30 91551	77
V11 10300.135210	13	V14 76300	106	V21 11400.135210	15	V30 33901	76	V30 91601	77
V11 10400.135210	13	V14 76400	106	V21 11500.135210	15	V30 33951	76	V30 91701	77
V11 10500.135210	13	V14 76500	106	V21 11600.135210	15	V30 34001	76	V30 91751	77
V11 10600.135210	13	V14 76600	106	V21 11700.135210	15	V30 34101	76	V30 91801	77
V11 10700.135210	13	V14 76700	106	V21 11800.135210	15	V30 34201	76	V30 91851	77
V11 10800.135210	13	V14 76800	106	V21 11900.135210	15	V30 34301	76	V30 91901	77
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V11 11600.135210	13	V14 77600	106	V21 12700.135210	15	V30 62000	95	V30 92451	77
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V11 12700.135210	13	V21 05400.135210	14	V30 22100	95	V30 63100	95	V30 93151	77
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V13 34500	106	V21 05800.135210	14	V30 22500	95	V30 63500	95	V30 93501	77
V13 34600	106	V21 05900.135210	14	V30 22600	95	V30 63600	95	V30 93601	77
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V13 35400	106	V21 06900.135210	14	V30 23600	95	V30 71503	76	V30 94401	77
V13 35400	106	V21 07000.135210	14	V30 23700	95	V30 71551	76	V36 71402	87
V13 35400	106	V21 07100.135210	14	V30 23800	95	V30 71601	76	V36 71502	87
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V14 35600	106	V21 07900.135210	14	V30 31503	76	V30 72101	76	V36 72300	89
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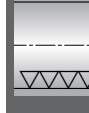
# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
V38 61700	98	V38 93000	91	V39 92300	89	V44 32502	82	V45 73152	82
V38 61800	98	V38 93100	91	V39 92400	89	V44 32602	82	V45 73202	82
V38 61900	98	V38 93150	91	V39 92450	89	V44 32652	82	V45 73302	82
V38 62000	98	V38 93200	91	V39 92500	89	V44 32702	82	V45 73402	82
V38 62100	98	V38 93300	91	V39 92600	89	V44 32802	82	V45 73502	82
V38 62200	98	V38 93400	91	V39 92650	89	V44 32852	82	V45 73602	82
V38 62300	98	V38 93500	91	V39 92700	89	V44 32902	82	V45 73702	82
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V38 64300	98	V39 63200	98	V39 94200	91	V44 32952	82	V45 93502	83
V38 64400	98	V39 63300	98	V39 94300	91	V44 32952	82	V45 93602	83
V38 71402	87	V39 63400	98	V39 94400	91	V44 32952	82	V46 22000	138
V38 71502	87	V39 63500	98	V43 31202	80	V44 32952	82	V46 22100	138
V38 71600	87	V39 63600	98	V43 31272	80	V44 32952	82	V46 22200	138
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V38 73200	91	V39 72100	89	V43 32252	80	V44 32952	82	V46 23500	138
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V38 74300	91	V39 73200	91	V43 71602	80	V44 32952	82	V46 24500	140
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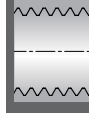
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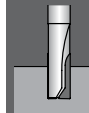
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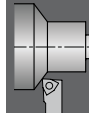
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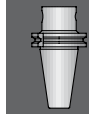
4



5



6



7



8



# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
V46 41101	158	V47 20551	150	V83 75400	102	V96 01150.8450	141	W01 42060.0203	843
V46 41151	158	V47 20651	142	V84 75500	102	V96 01150.8450	925	W01 42060.026425	843
V46 41201	158	V47 20651	152	V84 75600	102	V96 01160.8450	139	W01 42060.028425	843
V46 41251	158	V47 20721	152	V84 75700	102	V96 01160.8450	141	W01 42060.0421	843
V46 41301	158	V47 40201	138	V84 75800	102	V96 01160.8450	143	W01 42060.046115	843
V46 41351	158	V47 40201	148	V84 75900	102	V96 01160.8450	925	W01 42120.026425	843
V46 41401	158	V47 40261	138	V84 76000	102	W00 04120.0104	842	W01 42120.028425	843
V46 41451	158	V47 40261	148	V84 76100	102	W00 04120.0121	842	W01 42120.0403	843
V46 41501	158	V47 40331	138	V84 76200	102	W00 04120.012710	842	W01 42120.0421	843
V46 41551	158	V47 40331	148	V84 76300	102	W00 04120.016440	842	W01 42120.046425	843
V46 50201	148	V47 40401	140	V84 76400	102	W00 04120.018440	842	W01 42120.048425	843
V46 50211	148	V47 40401	150	V84 76500	102	W00 04120.022710	842	W01 42360.0203	844
V46 50221	148	V47 40461	140	V84 76600	102	W00 04120.028440	842	W01 42360.046115	844
V46 50231	148	V47 40461	150	V84 76700	102	W00 04420.0104	842	W01 42360.046425	844
V46 50241	148	V47 40551	140	V84 76800	102	W00 04420.012710	842	W01 42360.3403	849
V46 50251	148	V47 40551	142	V84 76900	102	W00 04420.016440	842	W01 42360.3421	849
V46 50260	148	V47 40551	150	V84 77000	102	W00 04420.018440	842	W01 42420.0203	844
V46 50270	148	V47 40651	142	V84 77100	102	W00 04420.022710	842	W01 42420.0221	844
V46 50280	148	V47 40651	152	V84 77200	102	W00 04420.028440	842	W01 42420.026425	844
V46 50290	148	V47 40721	152	V84 77300	102	W01 10060.048425	843	W01 42420.028425	844
V46 50300	148	V47 60201	138	V84 77400	102	W01 10120.0403	843	W01 42420.048425	844
V46 50310	148	V47 60201	148	V84 77500	102	W01 10120.0421	843	W01 42600.047615	845
V46 50320	148	V47 60261	138	V84 77600	102	W01 10120.048425	843	W01 42600.087615	845
V46 50330	148	V47 60261	148	V84 77700	102	W01 10360.048425	844	W01 42600.756115	848
V46 50340	148	V47 60331	138	V84 77800	102	W01 10420.048425	844	W01 42600.906115	847
V46 50350	148	V47 60331	148	V84 77900	102	W01 18120.0421	843	W01 50060.0403	843
V46 50360	148	V47 60401	140	V84 78000	102	W01 18120.046425	843	W01 50060.0421	843
V46 50370	148	V47 60401	150	V84 78100	102	W01 18120.048425	843	W01 50060.046425	843
V46 50380	148	V47 60461	140	V95 10012.0089	149	W01 18420.048425	844	W01 50060.048425	843
V46 50390	148	V47 60461	150	V95 10012.0089	925	W01 18600.0421	845	W01 50120.0421	843
V46 50400	150	V47 60551	140	V95 10012.0090	149	W01 18600.047615	845	W01 50120.048425	843
V46 50410	150	V47 60551	142	V95 10022.0089	925	W01 24060.0203	843	W01 50360.0403	844
V46 50420	150	V47 60551	150	V95 10022.0089	925	W01 24060.0221	843	W01 50420.0403	844
V46 50430	150	V47 60651	142	V95 10022.0090	149	W01 24060.026425	843	W01 50420.048425	844
V46 50440	150	V47 60651	152	V95 10032.0089	925	W01 24060.028425	843	W01 50600.756115	848
V46 50450	150	V47 60721	152	V95 10032.0089	925	W01 24060.046115	843	W01 50600.906115	847
V46 50460	150	V50 30830	162	V95 10032.0090	151	W01 24120.0203	843	W01 58060.068425	843
V46 50470	150	V50 30880	162	V95 10032.0090	925	W01 24120.026425	843	W01 58120.068425	843
V46 50480	150	V50 30930	162	V95 10032.0090	925	W01 24120.028425	843	W04 34180.0212	850
V46 50490	150	V50 30980	162	V95 10042.0089	151	W01 24120.0403	843	W04 34480.0212	851
V46 50500	150	V50 31030	162	V95 10042.0089	925	W01 24120.0421	843	W04 42180.0204	850
V46 50510	150	V50 31080	162	V95 10042.0090	925	W01 24120.046425	843	W04 42180.0212	850
V46 50520	150	V50 31130	162	V95 10050.0089	153	W01 24120.048425	843	W04 42180.0221	850
V46 50530	150	V50 31180	162	V95 10050.0090	925	W01 24120.048425	843	W04 42180.026425	850
V46 50540	150	V50 31230	162	V95 10050.0090	153	W01 24120.048425	843	W04 42480.0204	851
V46 50550	150	V50 31280	162	V95 10050.0090	925	W01 24360.046115	844	W04 42480.0212	851
V46 50560	150	V59 64500	98	V95 10063.0089	159	W01 24420.0203	844	W04 42480.0221	851
V46 50570	150	V59 64600	98	V95 10063.0089	925	W01 24420.0221	844	W04 42480.026425	851
V46 50580	150	V59 64700	98	V95 10063.0089	159	W01 24420.026425	844	W04 42480.0412	851
V46 50590	150	V59 64800	98	V95 10063.0090	925	W01 24420.028425	844	W04 50180.0404	850
V46 50600	150	V59 64900	98	V95 10063.0090	159	W01 24600.0421	845	W04 50180.0412	850
V46 50610	150	V59 65000	98	V95 10063.0090	925	W01 24600.047615	845	W04 50180.046425	850
V46 50620	150	V59 65100	98	V95 10213.0089	159	W01 24600.087615	845	W04 50480.0212	851
V46 50630	150	V59 65400	98	V95 10213.0089	925	W01 24600.756115	848	W04 50480.0412	851
V46 50640	150	V59 74500	91	V95 10213.0090	159	W01 24600.906115	847	W04 50480.0421	851
V46 50650	152	V59 74600	91	V95 10213.0090	925	W01 24940.0457	846	W04 50480.046425	851
V46 50660	152	V59 74700	91	V95 10310.8450	149	W01 34060.0203	843	W04 58480.0612	851
V46 50670	152	V59 74800	91	V95 10310.8450	925	W01 34060.0221	843	W29 04010.027935	853
V46 50680	152	V59 74900	91	V95 10320.8450	149	W01 34060.026425	843	W29 04010.028425	853
V46 50690	152	V59 75000	91	V95 10320.8450	925	W01 34060.0421	843	W29 10010.0404	853
V46 50700	152	V59 75100	91	V95 10330.8450	151	W01 34060.046115	843	W29 10010.0421	853
V46 50710	152	V59 75200	91	V95 10330.8450	925	W01 34060.048425	843	W29 10010.046115	853
V46 50720	152	V59 75300	91	V95 10340.8450	151	W01 34120.0203	843	W29 10010.0462	853
V46 50730	152	V59 75400	91	V95 10340.8450	925	W01 34120.028425	843	W29 10010.0472	853
V46 50740	152	V71 00200	166	V96 01100.8450	139	W01 34120.0403	843	W29 10010.047615	853
V46 50750	152	V71 00210	166	V96 01100.8450	141	W01 34120.0421	843	W29 10010.047935	853
V46 50760	152	V71 00250	166	V96 01100.8450	143	W01 34120.046425	843	W29 10010.048425	853
V46 50770	152	V71 00260	166	V96 01110.8450	925	W01 34120.048425	843	W29 10030.046425	855
V46 50780	152	V71 00330	166	V96 01110.8450	139	W01 34360.0203	844	W29 10030.048425	855
V46 50790	152	V82 73900	102	V96 01110.8450	141	W01 34360.026425	844	W29 10110.0421	856
V46 50800	152	V82 74000	102	V96 01110.8450	143	W01 34360.3403	849	W29 10110.0450	857
V46 50810	152	V82 74100	102	V96 01110.8450	925	W01 34360.3421	849	W29 10110.0477	856
V47 20201	138	V82 74200	102	V96 01120.8450	139	W01 34360.346440	849	W29 10110.047710	856
V47 20201	148	V82 74300	102	V96 01120.8450	141	W01 34360.3521	849	W29 10130.0404	858
V47 20261	138	V82 74400	102	V96 01120.8450	143	W01 34420.0203	844	W29 10130.047325	858
V47 20261	148	V83 74500	102	V96 01120.8450	925	W01 34420.026425	844	W29 10130.0479	858
V47 20331	138	V83 74600	102	V96 01130.8450	139	W01 34420.028425	844	W29 10130.048425	858
V47 20331	148	V83 74700	102	V96 01130.8450	141	W01 34600.0421	845	W29 10150.048430	859
V47 20401	140	V83 74800	102	V96 01130.8450	143	W01 34600.047615	845	W29 10160.0460	860
V47 20401	150	V83 74900	102	V96 01140.8450	925	W01 34600.087615	845	W29 10160.048430	860
V47 20461	140	V83 75000	102	V96 01140.8450	139	W01 34600.756115	848	W29 10200.042730	861
V47 20461	150	V83 75100	102	V96 01140.8450	141	W01 34600.906115	847	W29 10200.048430	861
V47 20551	140	V83 75200	102	V96 01150.8450	925	W01 34940.0457	846	W29 18010.0404	853
V47 20551	142	V83 75300	102		139			W29 18010.0421	853

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
W29 18010.046115	853	W29 34010.0462	853	W29 42130.048425	858	W30 04060.026425	862	W30 04420.0303	863
W29 18010.0462	853	W29 34010.046420	853	W29 42150.0460	859	W30 04060.026440	862	W30 04420.0321	863
W29 18010.0472	853	W29 34010.046425	853	W29 42150.0473	859	W30 04060.027615	862	W30 04420.0337	863
W29 18010.047615	853	W29 34010.046440	853	W29 42150.048430	859	W30 04060.028425	862	W30 04420.036425	863
W29 18010.047935	853	W29 34010.0472	853	W29 42160.0460	860	W30 04060.0303	862	W30 04420.036440	863
W29 18010.048425	853	W29 34010.047615	853	W29 42160.048430	860	W30 04060.0321	862	W30 04420.038425	863
W29 18030.046425	855	W29 34010.047935	853	W29 42200.042730	861	W30 04060.032710	862	W30 04420.0430	863
W29 18030.048425	855	W29 34010.048425	853	W29 42200.048430	861	W30 04060.036110	862	W30 04420.0438	863
W29 18110.0421	856	W29 34010.0821	853	W29 50000.0403	852	W30 04060.036425	862	W30 04420.046425	863
W29 18110.0450	857	W29 34010.086115	853	W29 50000.0421	852	W30 04060.036440	862	W30 04420.048425	863
W29 18110.0477	856	W29 34010.0862	853	W29 50000.046115	852	W30 04060.037615	862	W30 04500.0221	863
W29 18110.047710	856	W29 34010.086425	853	W29 50000.046425	852	W30 04060.038425	862	W30 04500.0321	863
W29 18130.0404	858	W29 34010.086440	853	W29 50000.046440	852	W30 04060.0403	862	W30 04600.0221	864
W29 18130.047325	858	W29 34010.0872	853	W29 50000.048425	852	W30 04060.0421	862	W30 04600.0303	864
W29 18130.0479	858	W29 34010.087615	853	W29 50000.086115	852	W30 04060.046425	862	W30 04600.0321	864
W29 18130.048425	858	W29 34010.087935	853	W29 50000.086440	852	W30 04060.046440	862	W30 04600.036425	864
W29 18150.0460	859	W29 34010.088425	853	W29 50010.0403	853	W30 04060.3021	862	W30 04600.037615	864
W29 18150.048430	859	W29 34020.046425	854	W29 50010.0404	853	W30 04060.306425	862	W30 04600.038425	864
W29 18160.0473	860	W29 34020.046440	854	W29 50010.0421	853	W30 04060.308425	862	W30 04660.0303	865
W29 18160.048430	860	W29 34020.086440	854	W29 50010.046115	853	W30 04060.316425	868	W30 04660.0321	865
W29 18200.042730	861	W29 34030.0403	855	W29 50010.0462	853	W30 04060.316440	868	W30 04660.036425	865
W29 18200.048430	861	W29 34030.046425	855	W29 50010.046420	853	W30 04060.317615	868	W30 04660.036440	865
W29 24000.0403	852	W29 34030.048425	855	W29 50010.046425	853	W30 04120.0203	862	W30 04660.038425	865
W29 24000.0421	852	W29 34030.086425	855	W29 50010.046440	853	W30 04120.0221	862	W30 04720.0303	865
W29 24000.046115	852	W29 34030.088425	855	W29 50010.0472	853	W30 04120.0230	862	W30 04720.0321	865
W29 24000.046425	852	W29 34110.0421	856	W29 50010.047615	853	W30 04120.0232	862	W30 04720.036425	865
W29 24000.046440	852	W29 34110.0450	857	W29 50010.047935	853	W30 04120.0237	862	W30 04820.0230	866
W29 24000.047615	852	W29 34110.0477	856	W29 50010.048425	853	W30 04120.0238	862	W30 04820.0232	866
W29 24000.048425	852	W29 34110.047710	856	W29 50010.0803	853	W30 04120.026425	862	W30 04820.0238	866
W29 24010.0403	853	W29 34130.047325	858	W29 50010.0804	853	W30 04120.026440	862	W30 04820.0332	866
W29 24010.0404	853	W29 34130.0479	858	W29 50010.0821	853	W30 04120.028425	862	W30 04820.0430	866
W29 24010.0421	853	W29 34130.048425	858	W29 50010.086115	853	W30 04120.0303	862	W30 04820.0438	866
W29 24010.046115	853	W29 34150.0460	859	W29 50010.0862	853	W30 04120.0321	862	W30 04820.3230	870
W29 24010.0462	853	W29 34150.048430	859	W29 50010.086420	853	W30 04120.0332	862	W30 04820.3238	870
W29 24010.046420	853	W29 34160.0460	860	W29 50010.086425	853	W30 04120.0337	862	W30 04830.0232	867
W29 24010.046425	853	W29 34160.0473	860	W29 50010.086440	853	W30 04120.036425	862	W30 04980.035510	874
W29 24010.046440	853	W29 34160.048430	860	W29 50010.087615	853	W30 04120.036440	862	W30 04990.0240	876
W29 24010.0472	853	W29 34200.042730	861	W29 50010.087935	853	W30 04120.038425	862	W30 04990.025510	875
W29 24010.047615	853	W29 34200.048430	861	W29 50010.088425	853	W30 04120.0403	862	W30 04990.0257	876
W29 24010.047935	853	W29 42000.0403	852	W29 50020.046440	854	W30 04120.0421	862	W30 04990.035510	875
W29 24010.048425	853	W29 42000.0421	852	W29 50020.086440	854	W30 04120.0430	862	W30 04990.0357	876
W29 24010.0803	853	W29 42000.046115	852	W29 50030.0403	855	W30 04120.0438	862	W30 04990.045510	875
W29 24010.0804	853	W29 42000.046425	852	W29 50030.046425	855	W30 04120.046425	862	W30 14060.0203	862
W29 24010.0821	853	W29 42000.046440	852	W29 50030.048425	855	W30 04120.046440	862	W30 14060.0221	862
W29 24010.086115	853	W29 42000.047615	852	W29 50030.086425	855	W30 04120.048425	862	W30 14060.022710	862
W29 24010.0862	853	W29 42000.048425	852	W29 50030.088425	855	W30 04120.0306425	862	W30 14060.026110	862
W29 24010.086420	853	W29 42010.0403	853	W29 50110.0421	856	W30 04120.308425	862	W30 14060.026425	862
W29 24010.086425	853	W29 42010.0404	853	W29 50110.0450	857	W30 04120.3121	868	W30 14060.026440	862
W29 24010.086440	853	W29 42010.0421	853	W29 50110.0477	856	W30 04120.3130	868	W30 14060.027615	862
W29 24010.087615	853	W29 42010.046115	853	W29 50110.047710	856	W30 04120.3138	868	W30 14060.028425	862
W29 24010.087935	853	W29 42010.0462	853	W29 50130.0404	858	W30 04120.316425	868	W30 14060.0403	862
W29 24010.088425	853	W29 42010.046420	853	W29 50130.047325	858	W30 04120.318425	868	W30 14060.0421	862
W29 24020.046425	854	W29 42010.046425	853	W29 50130.0479	858	W30 04120.3230	869	W30 14060.042710	862
W29 24020.046440	854	W29 42010.046440	853	W29 50130.048425	858	W30 04120.3232	869	W30 14060.046110	862
W29 24020.086440	854	W29 42010.0472	853	W29 50200.042730	861	W30 04120.3237	869	W30 14060.046425	862
W29 24030.046425	855	W29 42010.047615	853	W29 50200.048430	861	W30 04120.3238	869	W30 14060.046440	862
W29 24030.048425	855	W29 42010.047935	853	W29 58000.0821	852	W30 04120.326425	869	W30 14060.047615	862
W29 24030.086425	855	W29 42010.048425	853	W29 58000.086115	852	W30 04120.326440	869	W30 14060.048425	862
W29 24110.0421	856	W29 42010.0803	853	W29 58000.086425	852	W30 04120.328425	869	W30 14060.0821	862
W29 24110.0450	857	W29 42010.0804	853	W29 58000.086440	852	W30 04120.3977	871	W30 14060.082710	862
W29 24110.0477	856	W29 42010.0821	853	W29 58000.088425	852	W30 04200.0221	862	W30 14060.086110	862
W29 24110.047710	856	W29 42010.086115	853	W29 58010.0803	853	W30 04200.026425	862	W30 14060.086425	862
W29 24130.0404	858	W29 42010.0862	853	W29 58010.0804	853	W30 04200.028425	862	W30 14060.087615	862
W29 24130.047325	858	W29 42010.086420	853	W29 58010.0821	853	W30 04200.0321	862	W30 14060.088425	862
W29 24130.0479	858	W29 42010.086425	853	W29 58010.086115	853	W30 04200.036425	862	W30 14060.3021	862
W29 24130.048425	858	W29 42010.086440	853	W29 58010.0862	853	W30 04360.0203	863	W30 14060.306425	862
W29 24150.0460	859	W29 42010.0872	853	W29 58010.086420	853	W30 04360.0221	863	W30 14060.308425	862
W29 24150.0473	859	W29 42010.087615	853	W29 58010.086425	853	W30 04360.026425	863	W30 14060.3121	868
W29 24150.048430	859	W29 42010.087935	853	W29 58010.086440	853	W30 04360.028425	863	W30 14060.316425	868
W29 24160.0460	860	W29 42010.088425	853	W29 58010.0872	853	W30 04360.0303	863	W30 14060.316440	868
W29 24160.048430	860	W29 42020.046440	854	W29 58010.087615	853	W30 04360.0321	863	W30 14060.317615	868
W29 24200.042730	861	W29 42020.086440	854	W29 58010.087935	853	W30 04360.036425	863	W30 14120.0203	862
W29 24200.048430	861	W29 42030.0403	855	W29 58010.088425	853	W30 04360.036440	863	W30 14120.0221	862
W29 34000.0403	852	W29 42030.046425	855	W29 58020.086440	854	W30 04360.038425	863	W30 14120.0230	862
W29 34000.0421	852	W29 42030.048425	855	W29 58030.086425	855	W30 04360.046425	863	W30 14120.0232	862
W29 34000.046115	852	W29 42030.086425	855	W29 58030.088425	855	W30 04360.048425	863	W30 14120.0237	862
W29 34000.046425	852	W29 42030.088425	855	W29 58130.0804	858	W30 04420.0203	863	W30 14120.0238	862
W29 34000.046440	852	W29 42110.0421	856	W29 58130.087325	858	W30 04420.0221	863	W30 14120.026425	862
W29 34000.047615	852	W29 42110.0450	857	W29 58130.0879	858	W30 04420.0230	863	W30 14120.026440	862
W29 34000.048425	852	W29 42110.0477	856	W29 58130.088425	858	W30 04420.0232	863	W30 14120.028425	862
W29 34010.0403	853	W29 42110.047710	856	W30 04060.0203	862	W30 04420.0237	863	W30 14120.0403	862
W29 34010.0404	853	W29 42130.0404	858	W30 04060.0221	862	W30 04420.0238	863	W30 14120.0421	862
W29 34010.0421	853	W29 42130.047325	858	W30 04060.022710	862	W30 04420.026425	863	W30 14120.0430	862
W29 34010.046115	853	W29 42130.0479	858	W30 04060.026110	862	W30 04420.028425	86		

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
W30 14120.0437	862	W30 14660.338425	865	W30 26120.088425	862	W32 03600.0421	880	W57 14180.088430	889
W30 14120.0438	862	W30 14720.026425	865	W30 26120.306425	862	W32 03600.0450	881	W57 26120.0423	887
W30 14120.046425	862	W30 14720.0403	865	W30 26120.3130	868	W32 03980.045510	883	W57 26120.047710	887
W30 14120.046440	862	W30 14720.0421	865	W30 26120.316425	868	W32 03990.045510	884	W57 26140.023210	888
W30 14120.048425	862	W30 14720.046425	865	W30 26120.316440	868	W32 13150.0421	877	W57 26140.023230	888
W30 14120.0821	862	W30 14720.046440	865	W30 26120.318425	868	W32 13150.0450	878	W57 26140.028430	888
W30 14120.086425	862	W30 14720.048425	865	W30 26120.3230	869	W32 13150.047710	877	W57 26140.043210	888
W30 14120.088425	862	W30 14800.0421	865	W30 26120.3232	869	W32 13150.0821	877	W57 26140.043230	888
W30 14120.3021	862	W30 14820.0230	866	W30 26120.3237	869	W32 13150.0850	878	W57 26140.046320	888
W30 14120.306425	862	W30 14820.0232	866	W30 26120.3238	869	W32 13150.087710	877	W57 26140.048430	888
W30 14120.308425	862	W30 14820.0238	866	W30 26120.326425	869	W32 13450.0421	879	W57 26140.088430	888
W30 14120.3130	868	W30 14820.0430	866	W30 26120.326440	869	W32 13600.0421	880	W57 26180.0432	889
W30 14120.3138	868	W30 14820.0432	866	W30 26120.328425	869	W32 13600.0450	881	W57 26180.048430	889
W30 14120.316425	868	W30 14820.0438	866	W30 26120.3977	871	W32 13600.0821	880	W57 26180.088430	889
W30 14120.316440	868	W30 14820.3230	870	W30 26200.0221	862	W32 13600.0850	881	W58 03120.047710	890
W30 14120.318425	868	W30 14820.3232	870	W30 26200.0421	862	W32 13940.045510	882	W58 13120.047710	890
W30 14120.3230	869	W30 14820.3238	870	W30 26200.0521	862	W32 13980.025510	883	W58 18120.047710	890
W30 14120.3232	869	W30 14830.0232	867	W30 26360.0221	863	W32 13980.045510	883	W58 23120.047710	890
W30 14120.3237	869	W30 14940.045510	872	W30 26360.028425	863	W32 13990.045510	884	W58 32120.047710	890
W30 14120.3238	869	W30 14940.0457	873	W30 26360.046425	863	W32 18150.0421	877	W59 18050.0403	891
W30 14120.326115	869	W30 14980.045510	874	W30 26360.0503	863	W32 18150.047710	877	W59 18050.0421	891
W30 14120.326425	869	W30 14990.0240	876	W30 26360.0521	863	W32 18150.0821	877	W59 18050.046425	891
W30 14120.326440	869	W30 14990.025510	875	W30 26360.056425	863	W32 18150.0850	878	W59 18050.046440	891
W30 14120.328425	869	W30 14990.0257	876	W30 26360.056440	863	W32 18150.087710	877	W59 18050.047615	891
W30 14120.3977	871	W30 14990.0440	876	W30 26360.058425	863	W32 18450.0421	879	W59 18050.0479	891
W30 14200.0203	862	W30 14990.045510	875	W30 26420.0221	863	W32 18600.0421	880	W59 18050.048425	891
W30 14200.0221	862	W30 14990.0457	876	W30 26420.026425	863	W32 18600.0450	881	W59 32050.0803	891
W30 14200.026425	862	W30 14990.085510	875	W30 26420.0438	863	W32 18600.0821	880	W59 32050.0821	891
W30 14200.028425	862	W30 14990.0857	876	W30 26420.0503	863	W32 18600.0850	881	W59 32050.086425	891
W30 14200.0421	862	W30 26060.0203	862	W30 26420.0521	863	W32 18940.045510	882	W59 32050.086440	891
W30 14200.046425	862	W30 26060.0221	862	W30 26420.0537	863	W32 18940.085510	882	W59 32050.087615	891
W30 14360.0203	863	W30 26060.022710	862	W30 26420.056425	863	W32 18980.045510	883	W59 32050.0879	891
W30 14360.0221	863	W30 26060.026110	862	W30 26420.058425	863	W32 18990.045510	884	W59 32050.088425	891
W30 14360.026425	863	W30 26060.026425	862	W30 26500.058425	863	W32 23150.0421	877	W60 18060.0203	892
W30 14360.028425	863	W30 26060.027615	862	W30 26600.047615	864	W32 23150.0450	878	W60 18060.046425	892
W30 14360.0403	863	W30 26060.028425	862	W30 26600.0503	864	W32 23150.087710	877	W60 18120.0203	892
W30 14360.0421	863	W30 26060.0403	862	W30 26600.0521	864	W32 23600.0421	880	W60 18120.0221	892
W30 14360.046425	863	W30 26060.0421	862	W30 26600.057615	864	W32 23600.0450	881	W60 18120.022710	892
W30 14360.046440	863	W30 26060.042710	862	W30 26600.058425	864	W32 23600.0821	880	W60 18120.026425	892
W30 14360.047615	863	W30 26060.046110	862	W30 26600.0821	864	W32 23940.045510	882	W60 18120.0403	892
W30 14360.048425	863	W30 26060.046425	862	W30 26600.086425	864	W32 23980.045510	883	W60 18120.0421	892
W30 14360.088425	863	W30 26060.046440	862	W30 26600.087615	864	W32 23990.045510	884	W60 18120.042710	892
W30 14360.3003	863	W30 26060.047615	862	W30 26660.0503	865	W32 32150.0421	877	W60 18120.046425	892
W30 14420.0203	863	W30 26060.048425	862	W30 26660.0521	865	W32 32150.0450	878	W60 18200.0221	892
W30 14420.0221	863	W30 26060.0503	862	W30 26660.056425	865	W32 32600.0421	880	W60 18360.0203	893
W30 14420.0232	863	W30 26060.0521	862	W30 26660.056440	865	W32 32600.0450	881	W60 18360.026425	893
W30 14420.0237	863	W30 26060.052710	862	W30 26660.057615	865	W32 32600.0821	880	W60 18360.046425	893
W30 14420.0238	863	W30 26060.056110	862	W30 26660.058425	865	W32 32600.0850	881	W60 18420.0203	893
W30 14420.026425	863	W30 26060.056425	862	W30 26720.0503	865	W32 32940.045510	882	W60 18420.0221	893
W30 14420.028425	863	W30 26060.056440	862	W30 26720.0521	865	W32 32980.045510	883	W60 18420.026425	893
W30 14420.0403	863	W30 26060.057615	862	W30 26720.056425	865	W32 32990.045510	884	W60 18420.0403	893
W30 14420.0421	863	W30 26060.058425	862	W30 26820.0232	866	W32 44600.0421	880	W60 18420.0421	893
W30 14420.0430	863	W30 26060.082710	862	W30 26820.0238	866	W32 44600.0821	880	W60 18420.046425	893
W30 14420.0432	863	W30 26060.086110	862	W30 26820.0438	866	W32 44600.0850	881	W60 18500.0221	893
W30 14420.0437	863	W30 26060.086425	862	W30 26820.0532	866	W34 18660.0421	885	W60 18500.0421	893
W30 14420.0438	863	W30 26060.087615	862	W30 26820.3230	870	W34 18660.046425	885	W60 18600.0221	894
W30 14420.046425	863	W30 26060.088425	862	W30 26820.3238	870	W37 18600.0421	886	W60 18600.0421	894
W30 14420.046440	863	W30 26060.3121	868	W30 26940.055510	872	W37 18600.0821	886	W60 18990.0240	895
W30 14420.047615	863	W30 26060.316425	868	W30 26940.0557	873	W37 23600.0821	886	W60 18990.0440	895
W30 14420.048425	863	W30 26060.316440	868	W30 26980.055510	874	W57 04120.0223	887	W60 18990.0457	895
W30 14420.3021	863	W30 26060.317615	868	W30 26990.025510	875	W57 04120.027710	887	W60 32120.0203	892
W30 14500.0221	863	W30 26060.318425	868	W30 26990.0257	876	W57 04140.023210	888	W60 32120.0221	892
W30 14500.0421	863	W30 26120.0203	862	W30 26990.0440	876	W57 04140.023230	888	W60 32120.026425	892
W30 14500.046425	863	W30 26120.0221	862	W30 26990.045510	875	W57 04140.0260	888	W60 32120.0403	892
W30 14600.0221	864	W30 26120.0232	862	W30 26990.0457	876	W57 04140.028430	888	W60 32120.0421	892
W30 14600.0403	864	W30 26120.0237	862	W30 26990.055510	875	W57 04140.043210	888	W60 32120.042710	892
W30 14600.0421	864	W30 26120.0238	862	W30 26990.0557	876	W57 04140.043230	888	W60 32120.046425	892
W30 14600.0462	864	W30 26120.026425	862	W30 44060.088425	862	W57 04140.0460	888	W60 32120.082710	892
W30 14600.046425	864	W30 26120.026440	862	W30 44360.0803	863	W57 04140.048430	888	W60 32120.086425	892
W30 14600.047615	864	W30 26120.028425	862	W30 44360.088425	863	W57 04180.0432	889	W60 32360.086425	893
W30 14600.048425	864	W30 26120.0403	862	W30 44420.088425	863	W57 04180.048430	889	W60 32420.0203	893
W30 14600.087615	864	W30 26120.0421	862	W30 44600.0821	864	W57 14120.0423	887	W60 32420.0221	893
W30 14660.028425	865	W30 26120.0430	862	W30 44600.087615	864	W57 14120.047710	887	W60 32420.026425	893
W30 14660.0403	865	W30 26120.0438	862	W30 44660.0803	865	W57 14140.023210	888	W60 32420.0403	893
W30 14660.0404	865	W30 26120.046425	862	W30 44660.0821	865	W57 14140.023230	888	W60 32420.0421	893
W30 14660.0421	865	W30 26120.048425	862	W30 44660.086425	865	W57 14140.0260	888	W60 32420.046425	893
W30 14660.046425	865	W30 26120.0503	862	W30 44660.086440	865	W57 14140.028430	888	W60 32420.086425	893
W30 14660.046440	865	W30 26120.0521	862	W30 44660.087615	865	W57 14140.043210	888	W60 32600.0421	894
W30 14660.047615	865	W30 26120.0532	862	W30 44720.0821	865	W57 14140.043230	888	W60 32990.0240	895
W30 14660.048425	865	W30 26120.0537	862	W30 44720.086425	865	W57 14140.0460	888	W60 32990.0440	895
W30 14660.3303	865	W30 26120.056425	862	W32 03150.0421	877	W57 14140.048430	888	W60 32990.0457	895
W30 14660.3321	865	W30 26120.056440	862	W32 03150.0450	878	W57 14180.0432	889	W78 18070.0214	896
W30 14660.336425	865	W30 26120.058425	862	W32 03150.047710	877	W57 14180.048430	889	W78 18070.0266	896
W30 14660.336440	865	W30 26120.086425	862	W32 03450.0421	879	W57 14180.0832	889	W78 18070.0414	896

# Numerical index

Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page	Order No.	Page
W78 18070.0466	896	W80 32010.086115	899	W83 23000.0174	903	W85 32000.2421	909		
W78 18990.0457	897	W80 32010.086425	899	W83 23000.0274	905	W85 32000.2450	910		
W78 32070.0414	896	W80 32010.087710	899	W83 23010.086420	903	W85 32000.2477	909		
W78 32070.0466	896	W80 32010.087935	899	W83 23010.087615	903	W85 32000.2621	912		
W78 32070.0814	896	W80 32010.088425	899	W83 23010.087935	903	W85 32000.3140	913		
W78 32070.0866	896	W80 32030.088430	900	W83 23010.088425	903	W85 32000.3157	913		
W78 32990.0857	897	W80 32210.087710	901	W83 23030.086730	904	W85 32000.3421	911		
W79 18060.0203	898	W80 32210.087935	901	W83 23030.088430	904	W85 32000.3521	911		
W79 18060.0221	898	W80 32210.088430	901	W83 23130.086420	905	W85 44000.2950	910		
W79 18060.022710	898	W80 38010.086115	899	W83 23130.087935	905	W85 44000.2977	909		
W79 18060.026425	898	W80 38010.086425	899	W83 23130.088425	905	W85 44000.3077	909		
W79 18060.026440	898	W80 38010.087710	899	W83 23210.086130	906	W85 44000.3221	912		
W79 18060.0403	898	W80 38010.087935	899	W83 23210.087710	906	W85 44000.3321	912		
W79 18060.0421	898	W80 38010.088425	899	W83 23210.087935	906	W85 44000.3921	911		
W79 18060.042710	898	W80 38030.088430	900	W83 23210.088430	906	W89 32000.0576	914		
W79 18060.046425	898	W80 38210.087710	901	W83 23330.087935	907	W89 32000.0675	914		
W79 18060.046440	898	W80 38210.087935	901	W83 23330.088425	907	W89 32000.0676	914		
W79 18060.047615	898	W80 38210.088430	901	W83 32000.156115	903				
W79 18060.086425	898	W80 42010.086115	899	W83 32000.1574	903				
W79 18060.086440	898	W80 42010.086425	899	W83 32000.1774	905				
W79 32060.0221	898	W80 42010.087710	899	W83 32000.1821	908				
W79 32060.026425	898	W80 42010.087935	899	W83 32000.1921	908				
W79 32060.0403	898	W80 42010.088425	899	W83 32010.086420	903				
W79 32060.0421	898	W80 42030.088430	900	W83 32010.087615	903				
W79 32060.042710	898	W80 42210.087710	901	W83 32010.087935	903				
W79 32060.046425	898	W80 42210.087935	901	W83 32010.088425	903				
W79 32060.046440	898	W80 42210.088430	901	W83 32030.086730	904				
W79 32060.0821	898	W80 46010.086115	899	W83 32030.088430	904				
W79 32060.082710	898	W80 46010.086425	899	W83 32130.086420	905				
W79 32060.086425	898	W80 46010.087710	899	W83 32130.087935	905				
W79 32060.086440	898	W80 46010.087935	899	W83 32130.088425	905				
W80 10010.046115	899	W80 46010.088425	899	W83 32210.086130	906				
W80 10010.046425	899	W80 46030.088430	900	W83 32210.087710	906				
W80 10010.047710	899	W80 46210.087710	901	W83 32210.087935	906				
W80 10010.047935	899	W80 46210.087935	901	W83 32210.088430	906				
W80 10010.048425	899	W80 46210.088430	901	W83 32320.087935	907				
W80 10030.048430	900	W82 32210.048530	902	W83 32320.088425	907				
W80 10210.047710	901	W82 32210.082730	902	W83 39130.086420	905				
W80 10210.047935	901	W82 32210.088530	902	W83 39130.0874	905				
W80 10210.048430	901	W83 13000.016115	903	W83 39130.087935	905				
W80 12010.046115	899	W83 13000.0174	903	W83 39130.088425	905				
W80 12010.046425	899	W83 13010.046420	903	W83 39210.086130	906				
W80 12010.047710	899	W83 13010.047615	903	W83 39210.087710	906				
W80 12010.047935	899	W83 13010.047935	903	W83 39210.087935	906				
W80 12010.048425	899	W83 13010.048425	903	W83 39210.088430	906				
W80 12030.048430	900	W83 13030.046730	904	W83 44000.186115	903				
W80 12210.047710	901	W83 13030.048430	904	W83 44000.1874	903				
W80 12210.047935	901	W83 13130.047935	905	W83 44000.1974	905				
W80 12210.048430	901	W83 13130.048425	905	W83 44010.086420	903				
W80 18010.066115	899	W83 13210.046130	906	W83 44010.087615	903				
W80 18010.066425	899	W83 13210.047710	906	W83 44010.087935	903				
W80 18010.067710	899	W83 13210.047935	906	W83 44010.088425	903				
W80 18010.067935	899	W83 13210.048430	906	W83 44030.086730	904				
W80 18010.068425	899	W83 13320.047935	907	W83 44030.088430	904				
W80 18030.068430	900	W83 13320.048425	907	W83 44130.086420	905				
W80 18210.067710	901	W83 18000.096115	903	W83 44130.087935	905				
W80 18210.067935	901	W83 18000.0974	903	W83 44130.088425	905				
W80 18210.068430	901	W83 18000.1074	905	W83 44210.086130	906				
W80 20010.086115	899	W83 18000.1521	908	W83 44210.087710	906				
W80 20010.086425	899	W83 18000.1621	908	W83 44210.087935	906				
W80 20010.087710	899	W83 18010.066420	903	W83 44210.088430	906				
W80 20010.087935	899	W83 18010.067615	903	W83 44320.087935	907				
W80 20010.088425	899	W83 18010.067935	903	W83 44320.088425	907				
W80 20030.088430	900	W83 18010.068425	903	W85 09000.0121	909				
W80 20210.087710	901	W83 18030.066730	904	W85 09000.0321	909				
W80 20210.087935	901	W83 18030.068430	904	W85 09000.0377	909				
W80 20210.088430	901	W83 18130.066420	905	W85 09000.1221	909				
W80 24010.086115	899	W83 18130.067935	905	W85 09000.1321	911				
W80 24010.086425	899	W83 18130.068425	905	W85 09000.1421	911				
W80 24010.087710	899	W83 18130.086420	905	W85 18000.0621	909				
W80 24010.087935	899	W83 18130.0874	905	W85 18000.0821	909				
W80 24010.088425	899	W83 18130.087935	905	W85 18000.0877	909				
W80 24030.088430	900	W83 18130.088425	905	W85 18000.1721	912				
W80 24210.087710	901	W83 18210.066130	906	W85 18000.1821	912				
W80 24210.087935	901	W83 18210.067710	906	W85 18000.2657	913				
W80 24210.088430	901	W83 18210.067935	906	W85 18000.2721	911				
W80 28010.086115	899	W83 18210.068430	906	W85 18000.2821	911				
W80 28010.086425	899	W83 18210.086130	906	W85 23000.0121	909				
W80 28010.087710	899	W83 18210.087710	906	W85 23000.0221	909				
W80 28010.087935	899	W83 18210.087935	906	W85 23000.0321	911				
W80 28010.088425	899	W83 18210.088430	906	W85 23000.0421	911				
W80 28030.088430	900	W83 18330.067935	907	W85 32000.2321	909				
W80 28210.087710	901	W83 18330.068425	907	W85 32000.2350	910				
W80 28210.087935	901	W83 23000.016115	903	W85 32000.2377	909				

