EUROMAP 2	Injection moulding machines Mould fixing and connection dimensions

March, 1996
(172 pages)

This recommendation has been prepared by the Technical Commission of EUROMAP.

1 Scope

In this recommendation the EUROMAP overall sizes of the clamping unit of injection moulding machines are defined. For each of them mould fixing and connection dimensions are standardized to provide interchangeability.This recommendation is mainly intended to be used for injection moulding machines with horizontal and vertical clamping units containing four tiebars and for tiebarless machines. However, for clamping units with two or three tiebars and for turn/shuttle table machines the hole or T-slot patterns shall be applied accordingly.

2 Mould fixing and connection dimensions

2.1 Overall size S

The overall size S of the clamping unit of an injection moulding machine is given by the greater value e_1 [mm] and the smaller value e_2 [mm] of the clearance between the neighbouring tiebars (see figure 1); example S 315/280. The clear widths are taken from the decimal-geometric series of preferred numbers R20 and R40 according to ISO 3:1973 and ISO 497:1973. See table 1.

For easy reference EUROMAP overall sizes E as per EUROMAP 2/3 (1983) are indicated as well.

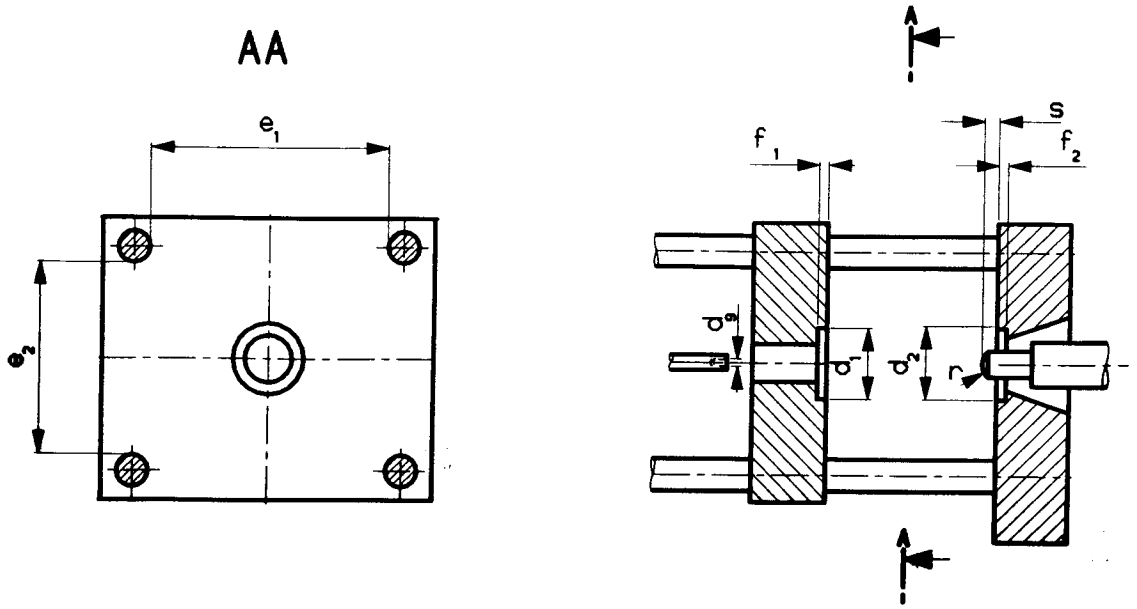

Figure 1: Clamping unit with tiebars

Explanation:

d_1	=	Diameter of mould location recess in the moveable platen
d_2	=	Diameter of mould location recess in the fixed platen
d_9	=	Ejector thread
e_1	=	Greater value of the clearance between neighbouring tiebars
e_2	=	Smaller value of the clearance distance between neighbouring tiebars
f_1	=	Depth of the mould location recess in the moveable platen
f_2	=	Depth of the mould location recess in the fixed platen
r	=	Nozzle radius
s	=	Maximum nozzle protrusion into the mould

In case of a tiebarless machine the dimensions e_1 and e_2 are defined as in figure 2.

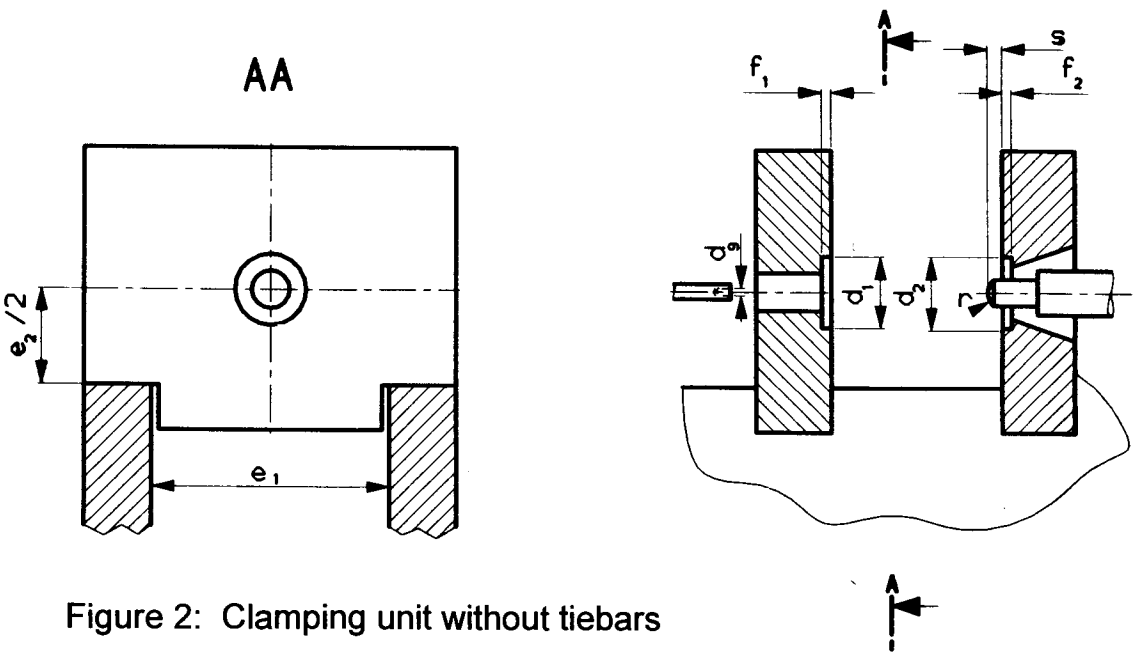

Figure 2: Clamping unit without tiebars

S e_1 [mm] / e_2 [mm]	E *)	S e_1 [mm] / e_2 [mm]	E *)	S e_1 [mm] / e_2 [mm]	E *)
S 200/200	E 1	S 630/560	-	S 2000/1600	-
S 224/200	-	S 710/560	-	S 1800/1800	E 20
S 250/200	-	S 630/630	E 11	S 2000/1800	-
S 224/224	E 2	S 710/630	-	S 2240/1800	-
S 250/224	-	S 800/630	-	S 2000/2000	E 21
S 280/224	-	S 710/710	E 12	S 2240/2000	-
S 250/250	E 3	S 800/710	-	S 2500/2000	-
S 280/250	-	S 900/710	-	S 2240/2240	E 22
S 315/250	-	S 800/800	E 13	S 2500/2240	-
S 280/280	E 4	S 900/800	-	S 2800/2240	-
S 315/280	-	S 1000/800	-	S 2360/2360	-
S 355/280	-	S 900/900	E 14	S 2650/2360	-
S 315/315	E 5	S 1000/900	-	S 3000/2360	-
S 355/315	-	S 1120/900	-	S 2500/2500	-
S 400/315	-	S 1000/1000	E 15	S 2800/2500	-
S 355/355	E 6	S 1120/1000	-	S 3150/2500	-
S 400/355	-	S 1250/1000	-	S 2650/2650	-
S 450/355	-	S 1120/1120	E 16	S 3000/2650	-
S 400/400	E 7	S 1250/1120	-	S 3350/2650	-
S 450/400	-	S 1400/1120	-	S 2800/2800	-
S 500/400	-	S 1250/1250	E 17	S 3150/2800	-
S 450/450	E 8	S 1400/1250	-	S 3550/2800	-
S 500/450	-	S 1600/1250	-	S 3000/3000	-
S 560/450	-	S 1400/1400	E 18	S 3350/3000	-
S 500/500	E 9	S 1600/1400	-	S 3350/3350	-
S 560/500	-	S 1800/1400	-	S 3550/3550	-
S 630/500	-	S 1600/1600	E 19		
S 560/560	E 10	S 1800/1600	-		

Table 1: EUROMAP overall size

*) according previous edition EUROMAP 2/3 (1983)

2.2 Fixing holes and T-slots

The area where no fixing holes and T-slots shall be made is defined with 0,7 e_1 x 0,7 e_2. For magnetic and power operated mould fixing systems fixing holes or T-slots are not required.

2.2.1 Fixing holes

In comparison with T-slots the use of fixing holes is preferred. They shall be in accordance with 2.4 and arranged according to 2.5.

2.2.2 T-slots

Instead of fixing holes, T-slots according to ISO 299 may be used.
They shall be in accordance with 2.4 and arranged according to 2.6.

2.3 Ejector holes

All ejector holes shown as ◔ are optional only.
However, if ejector holes are made, fixing holes in conflict shall be deleted.

2.4 Dimensions (mm)

Smaller value of the clearance between neighbouring tiebars	Mould location recess diameters	Minimum mould location recess depth	Mould mounting threads	Depth of mould mounting threads	T-slot width	Internal thread in the central ejector	Nozzle radius	Maximum installed nozzle protrusion depth	Ejector pins diameter hole
e_2	d_1^{H8} d_2^{H8}	$f_1;f_2$	d_8	t_h min	t_s^{H12}	d_9	r	s	d_{min}
200	80	10	M 12	24	14	M 12	15 or 20 or 25 or 35	10	25,4
224									
250	100								
280									
315	125					M 16		20	
355									
400			M 16	32	18				
450									
500	160		M 20	40	22	M 20			
560									
630									
710									
800	200					M 24		30	50,8
900									
1000	250	20	M 24	48	28	M 36			
1120									
1250									
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1600	315		M 30	60	36			50	
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1900			M 36	72	42				
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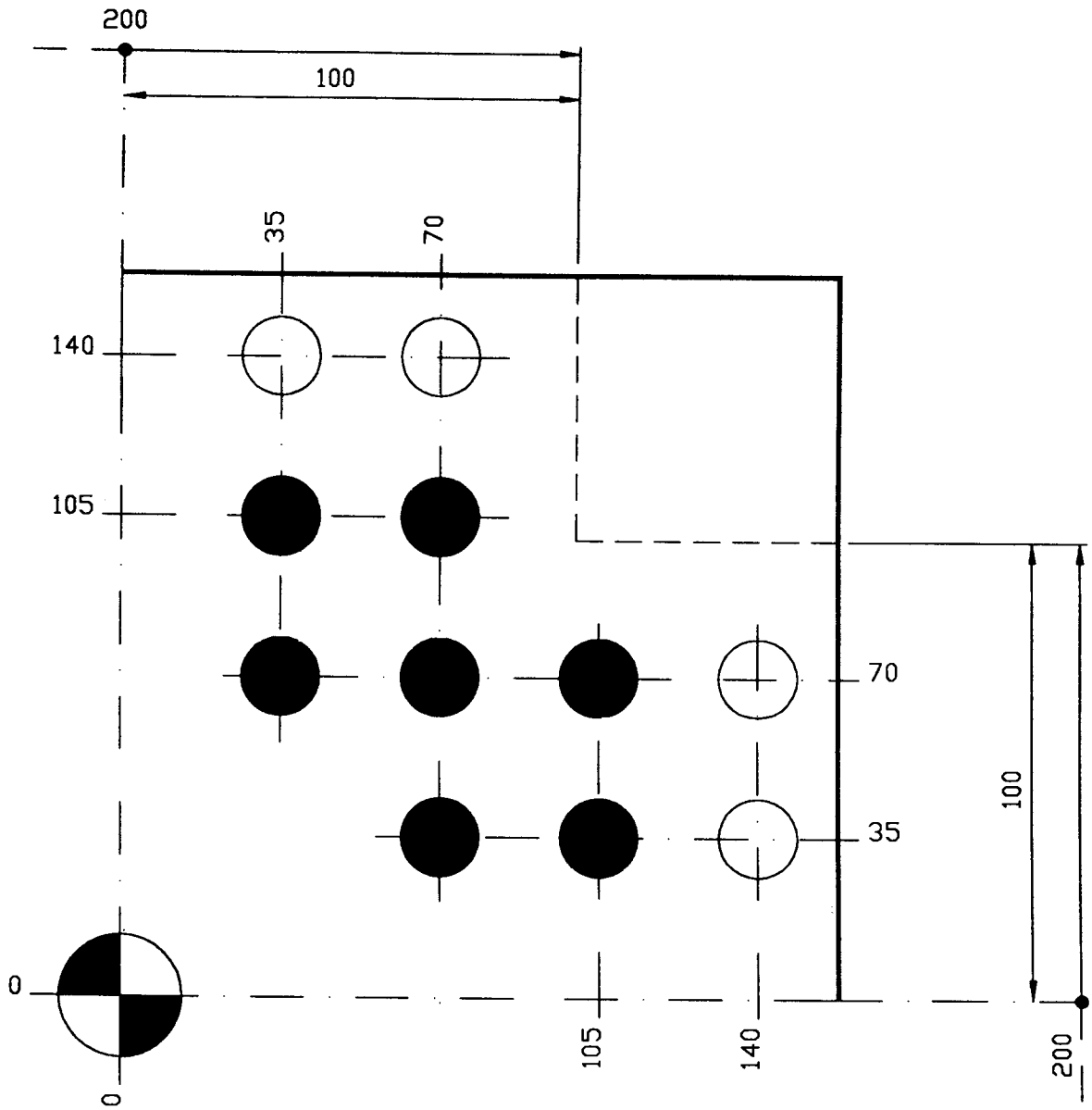
3150									
3350									
3550									

2.5 Hole patterns

Fixing holes indicated with a blackened circle ● shall be made.
Fixing holes indicated with an open circle ○ shall be made only, if the distance from the center line to the outer dimension of the platens ≥ 1,75 d_8

S 200/200



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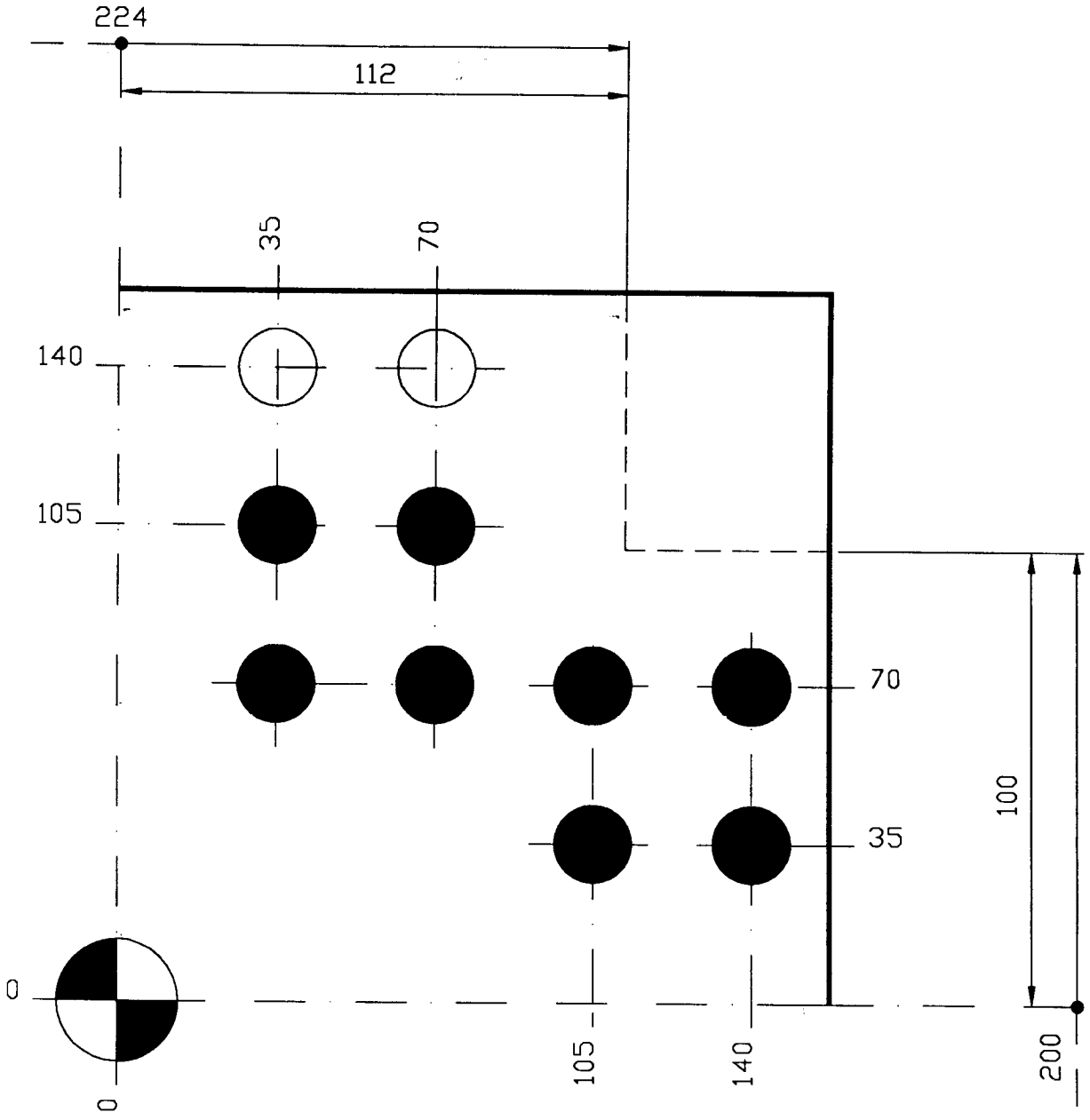

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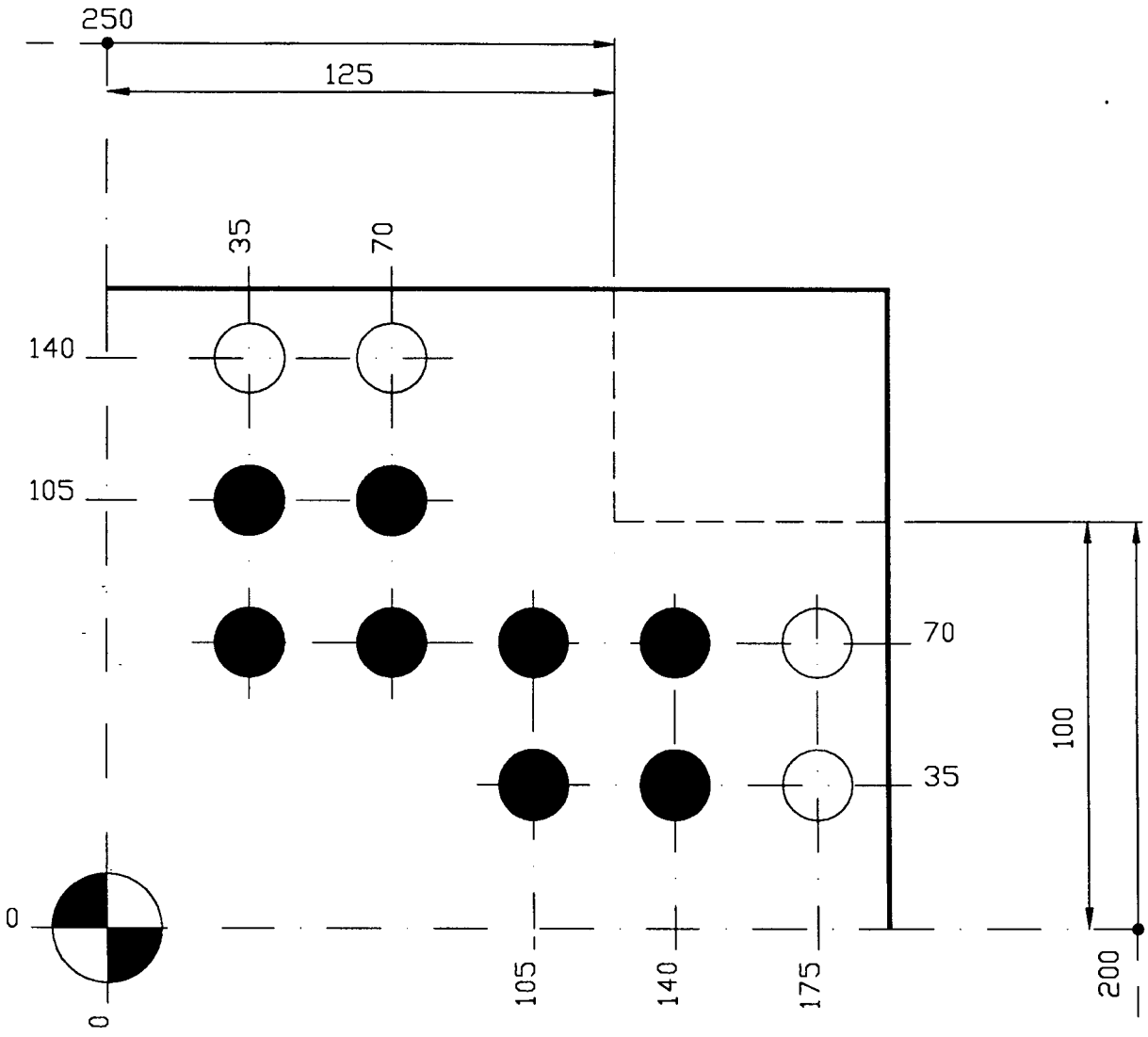

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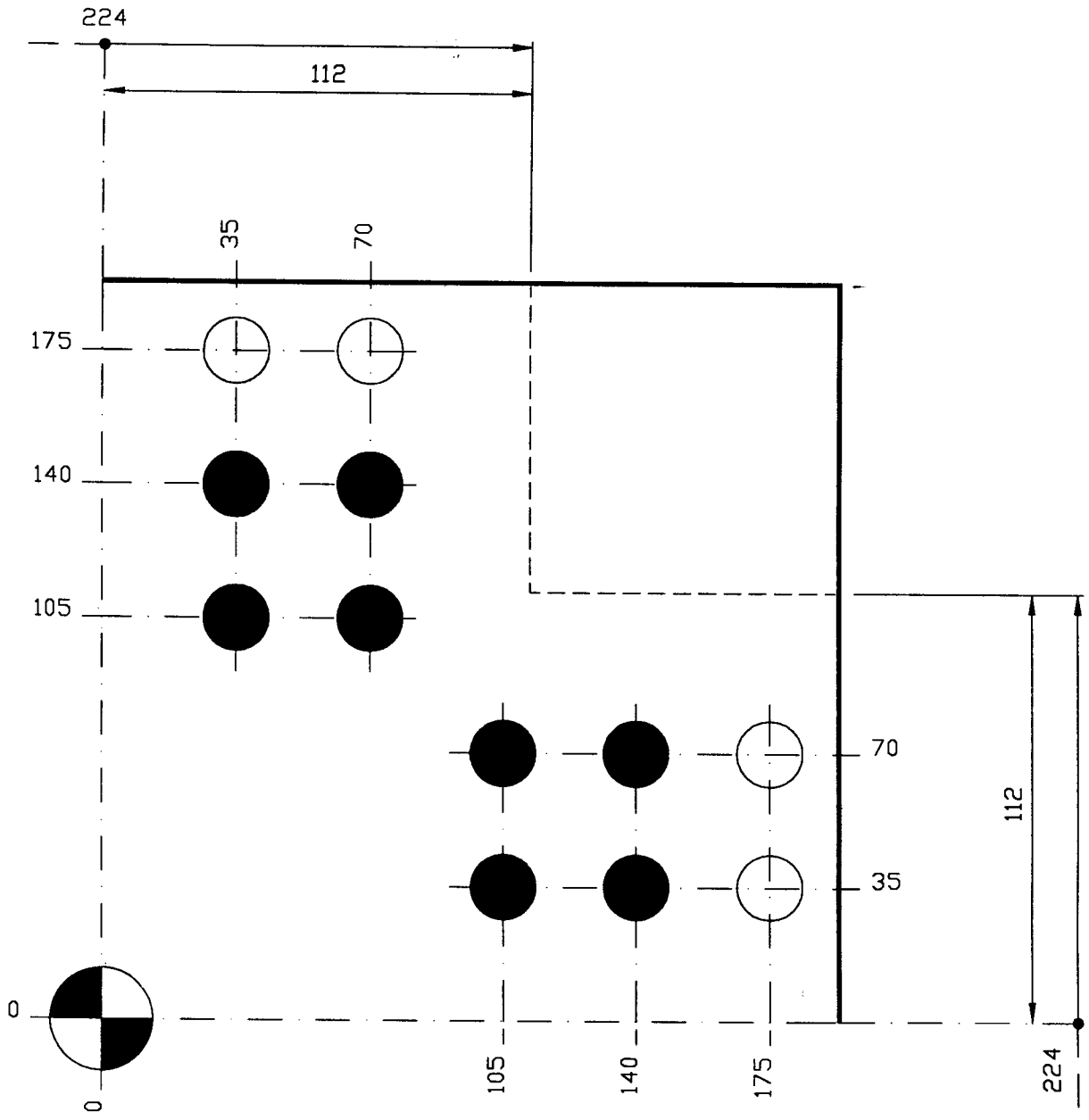

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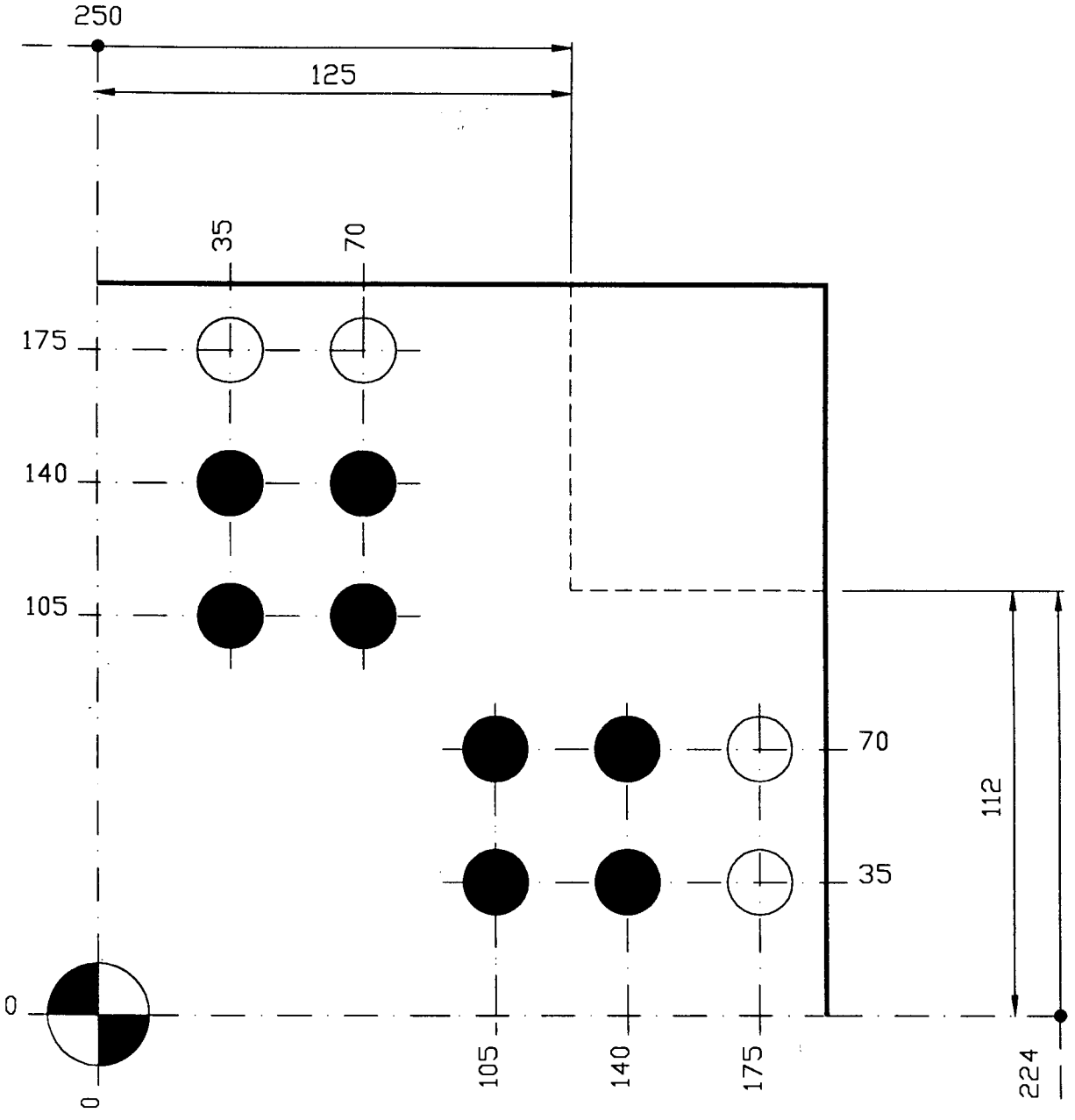

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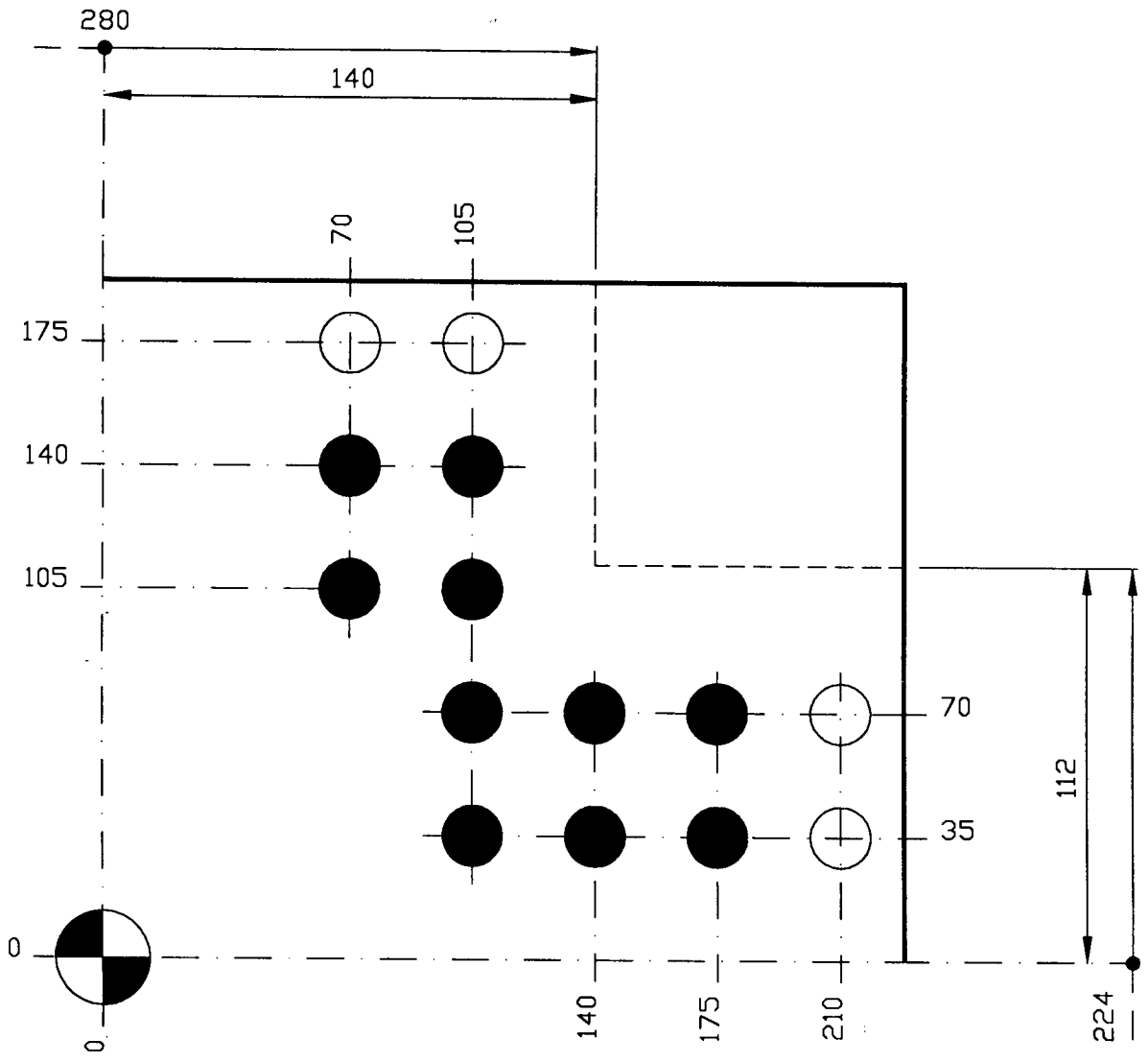

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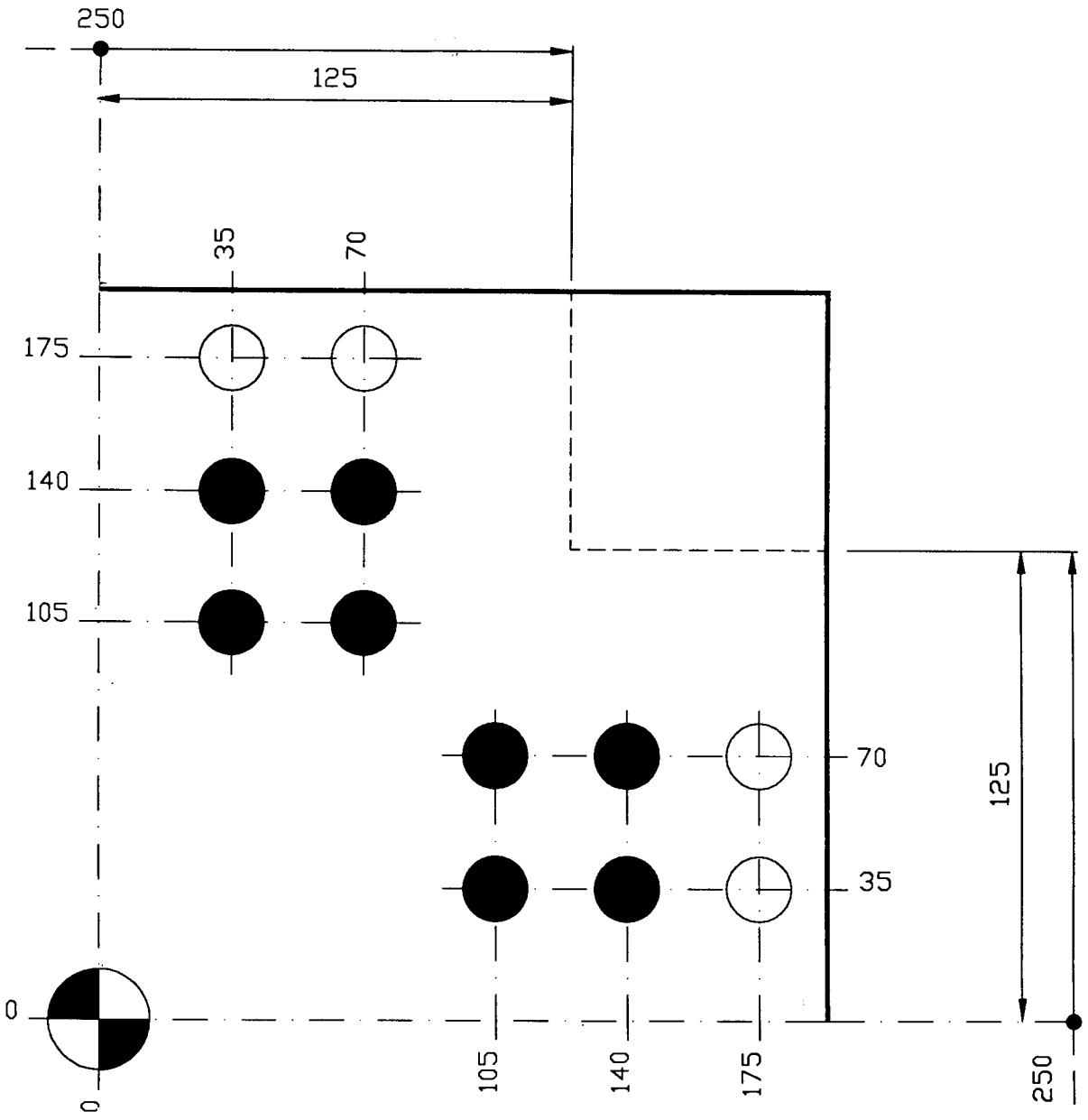

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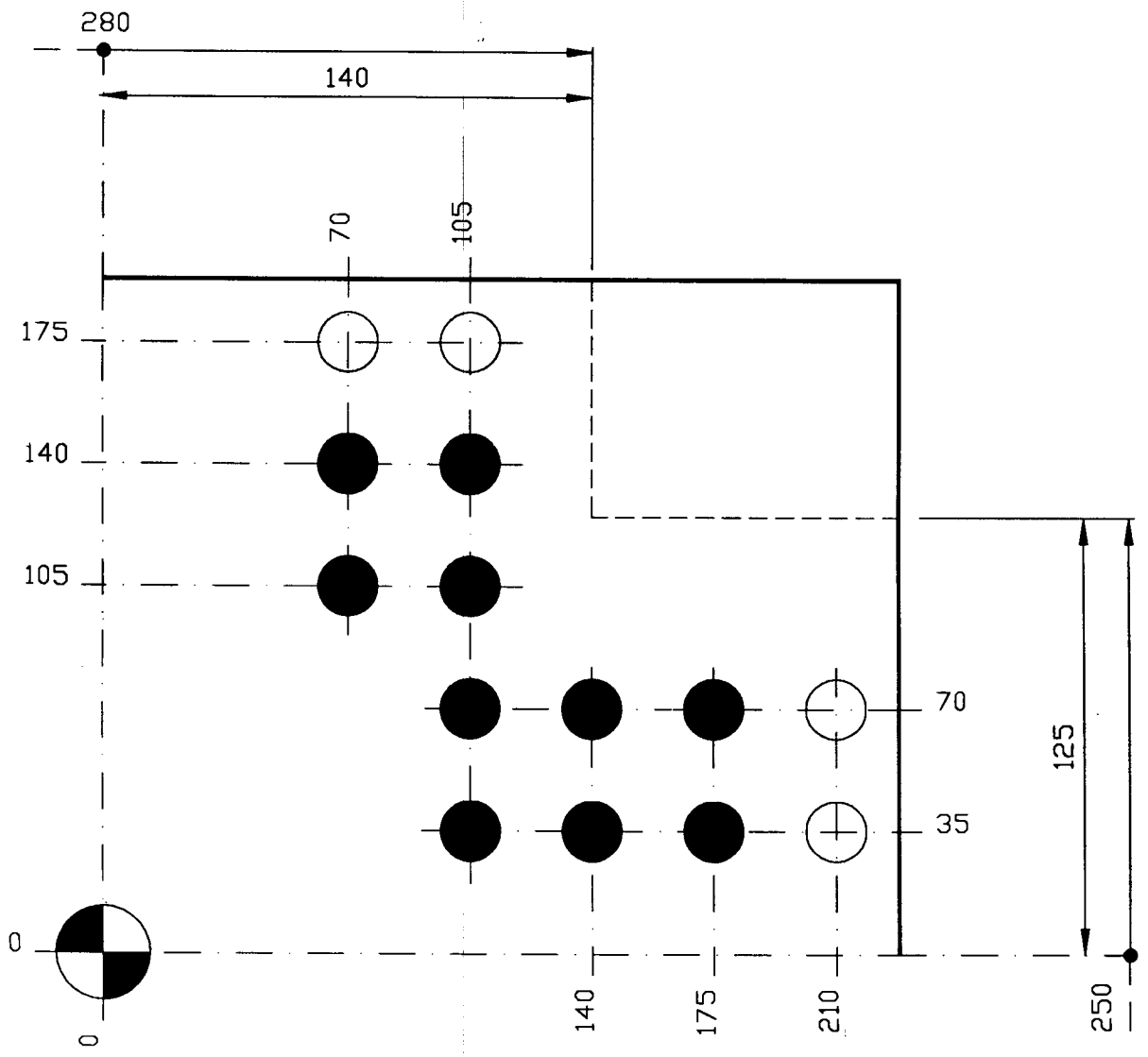

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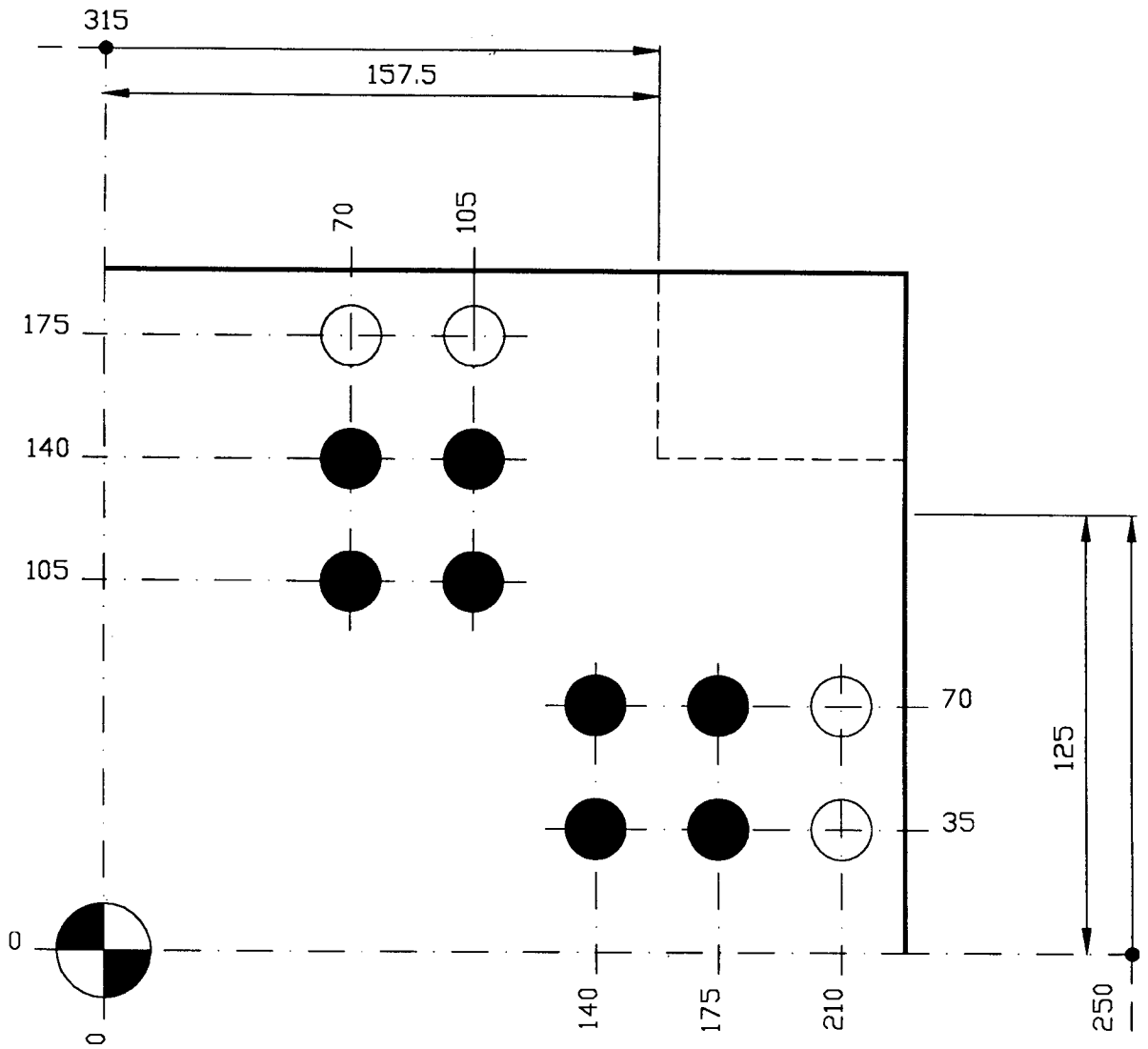

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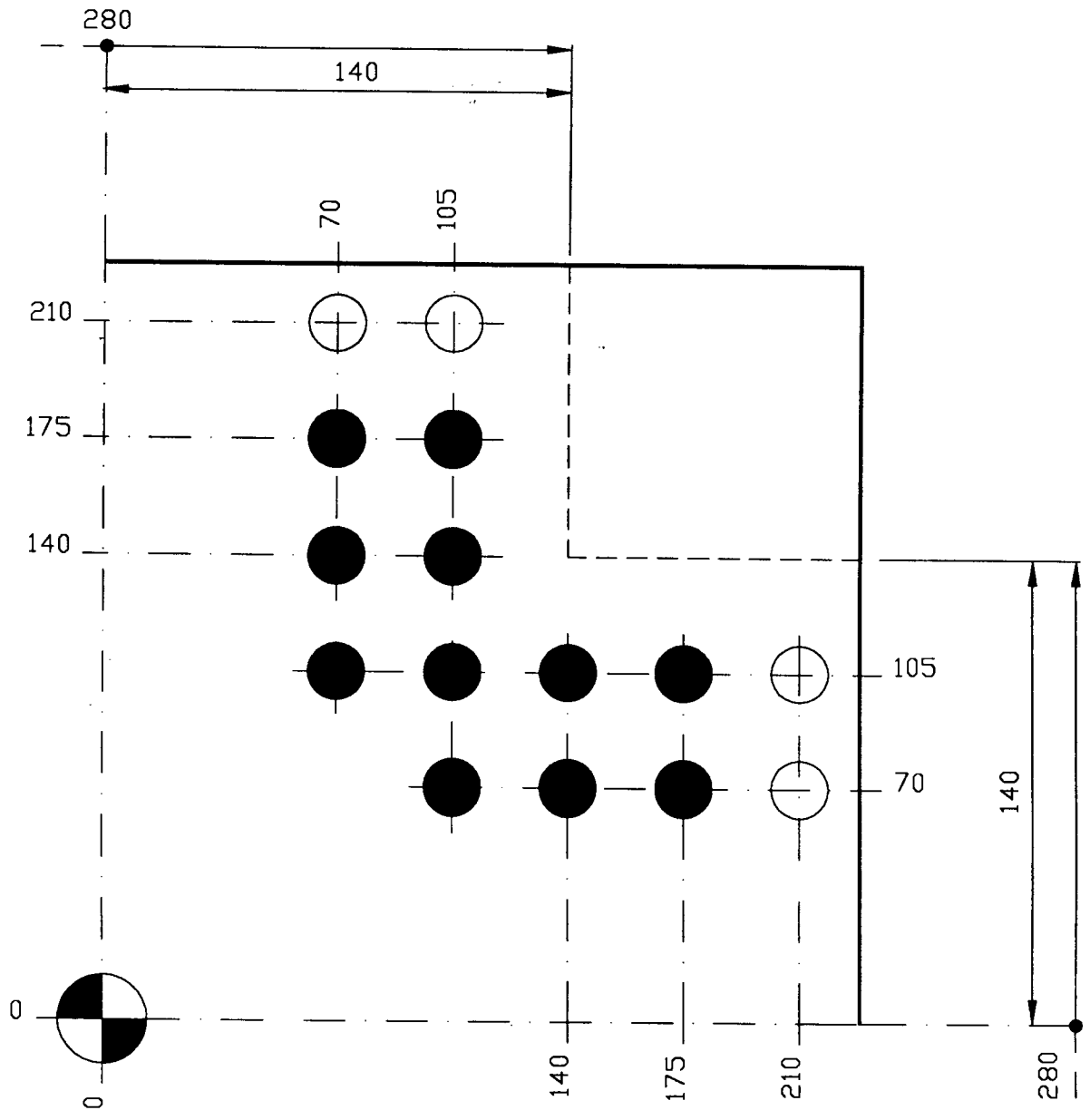

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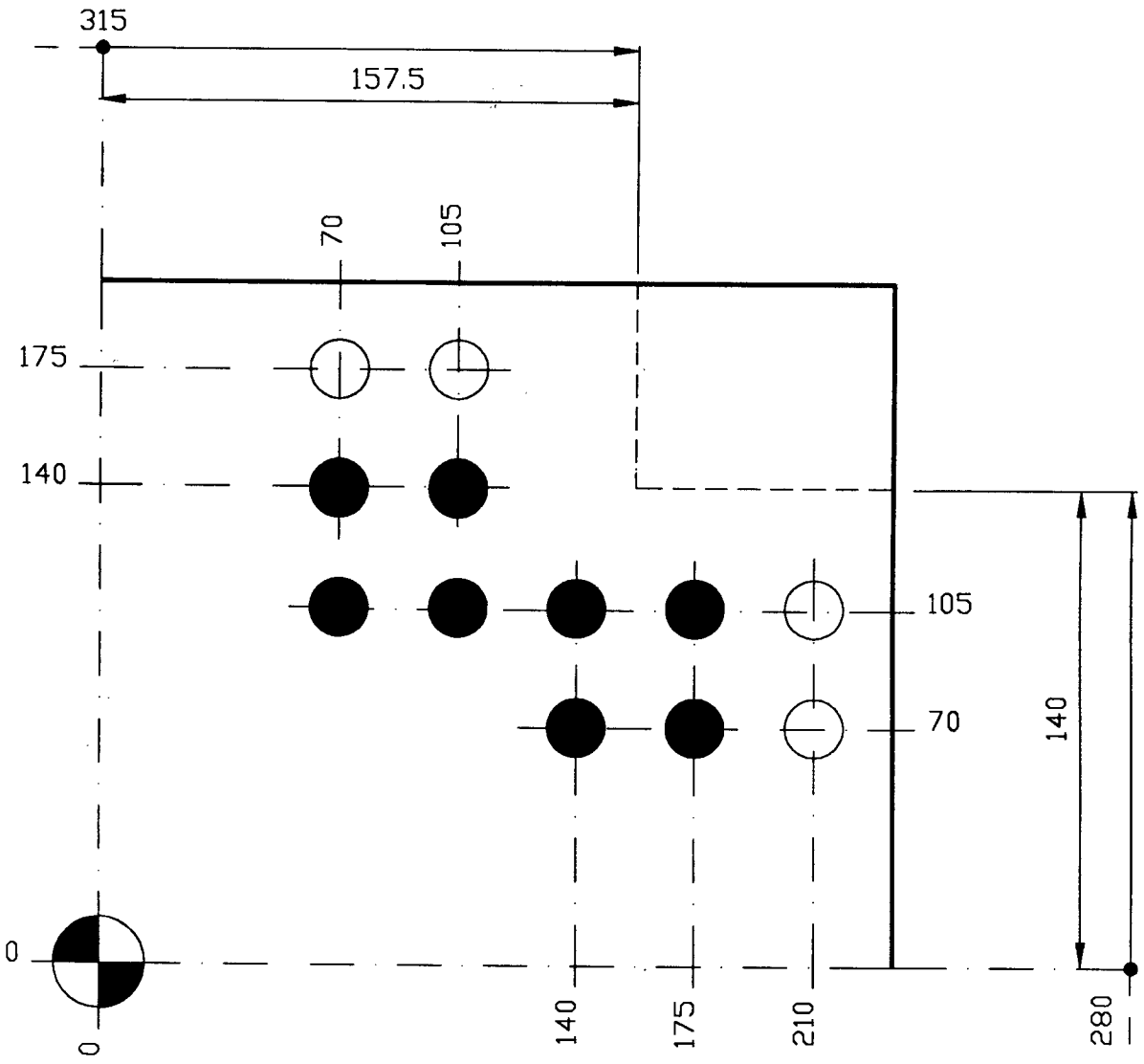

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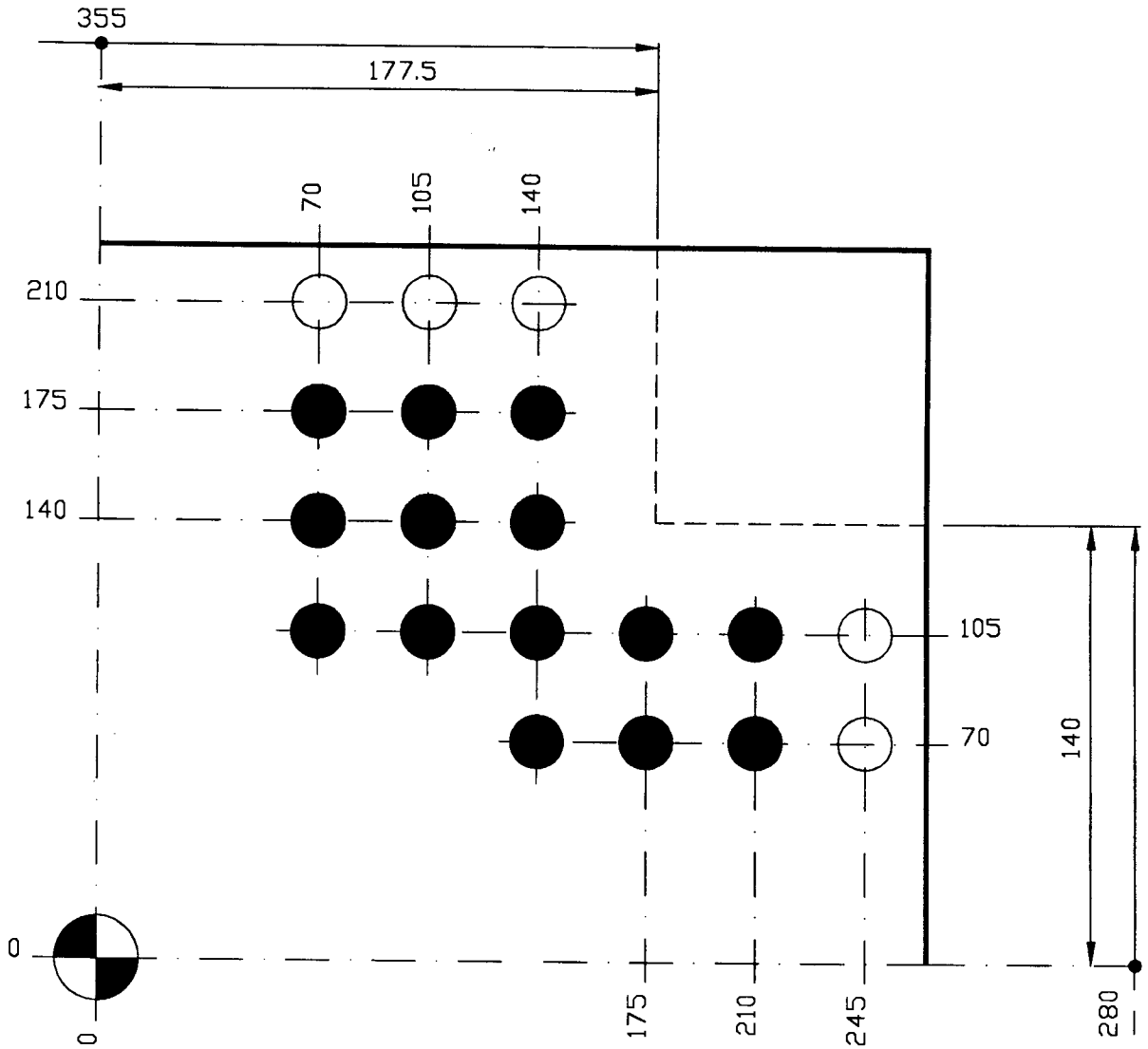

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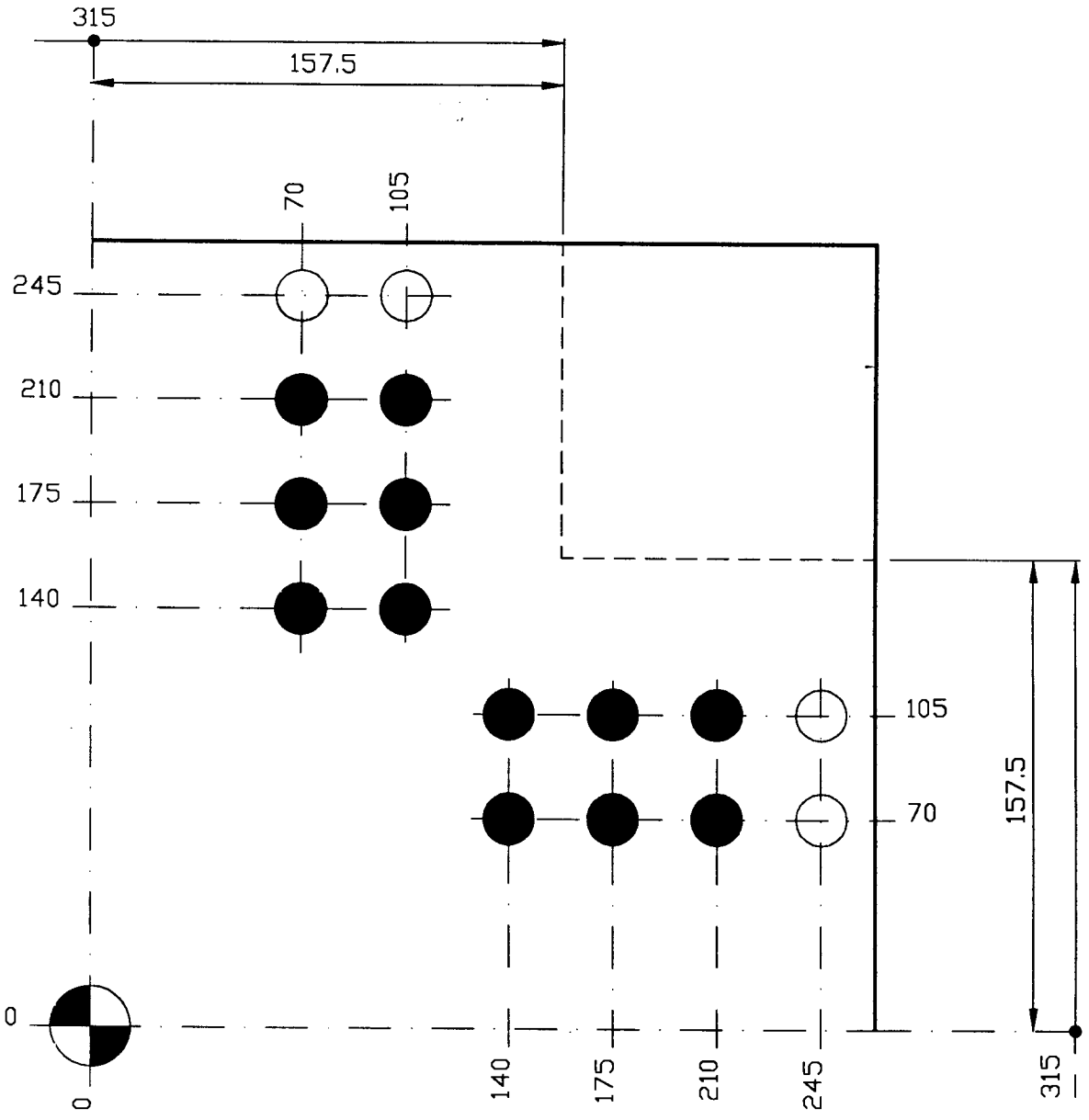
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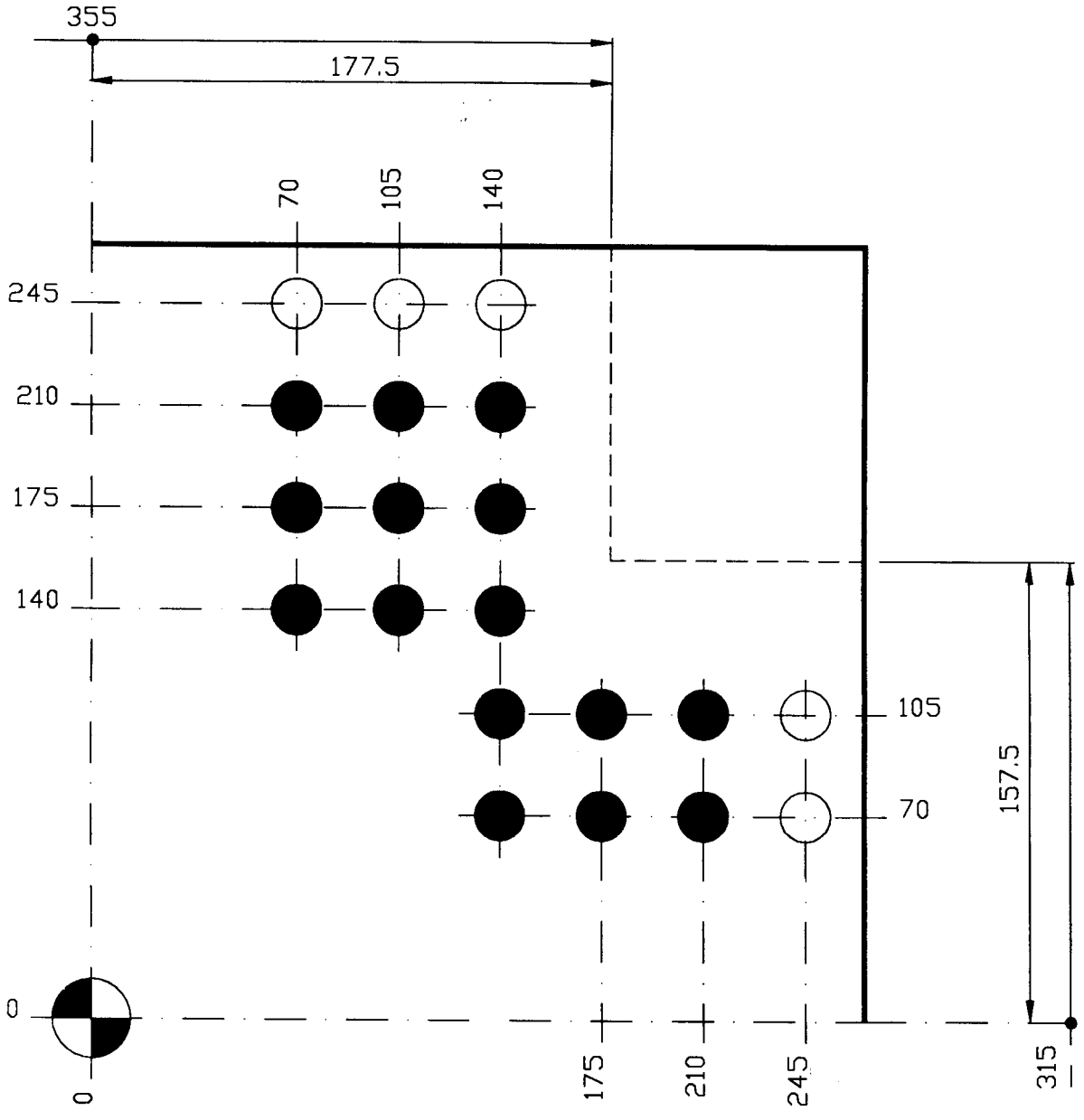
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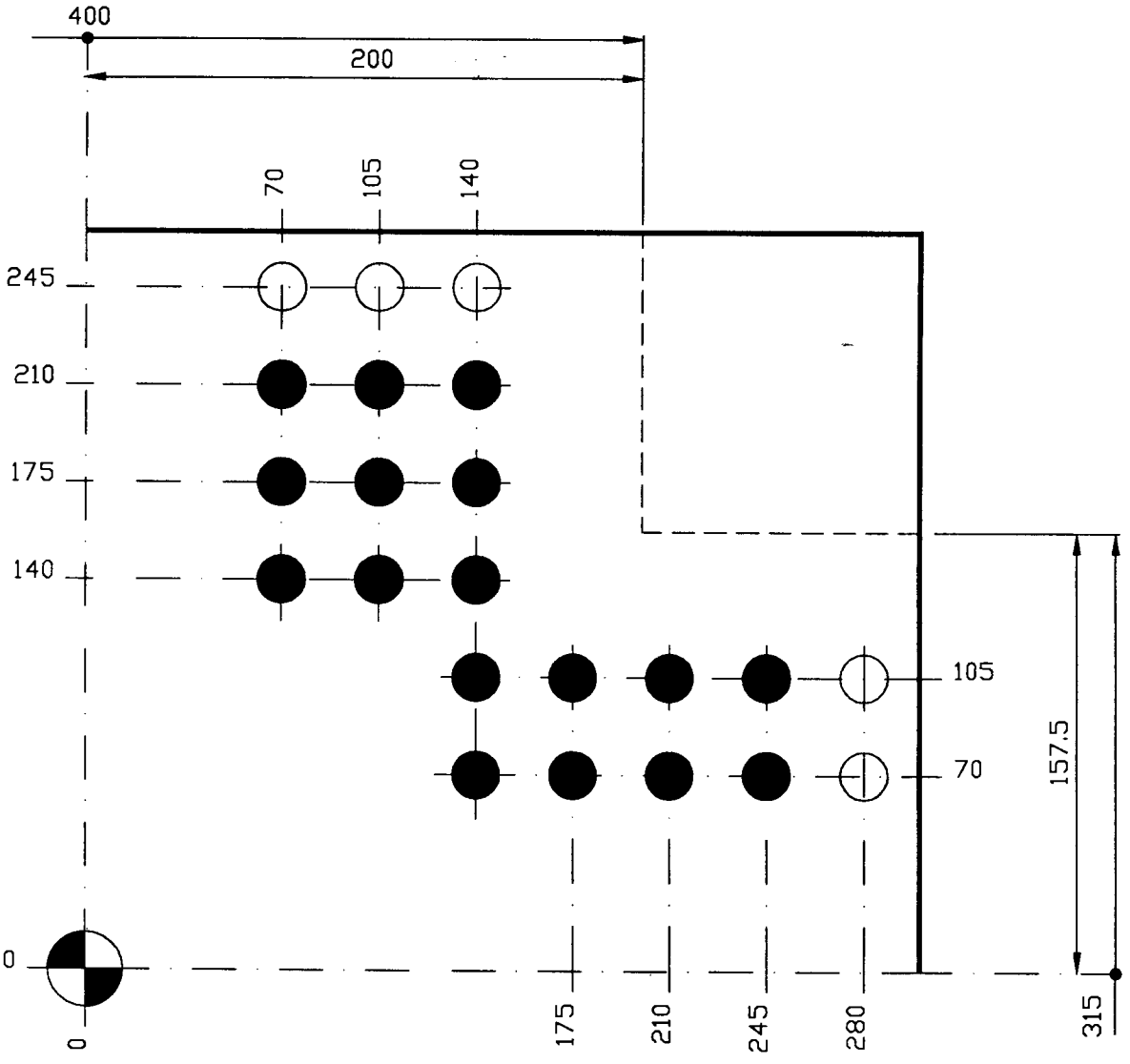
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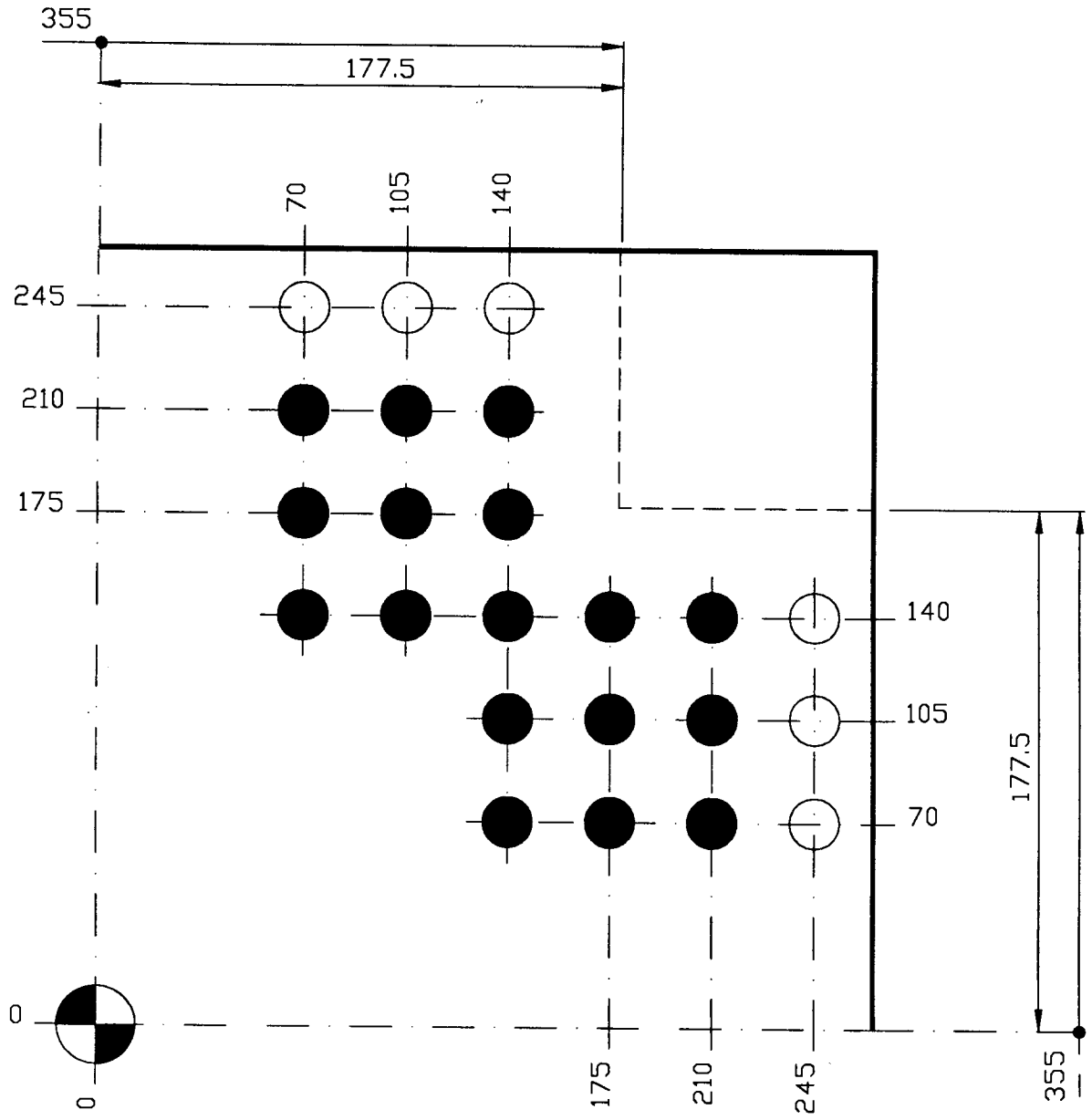
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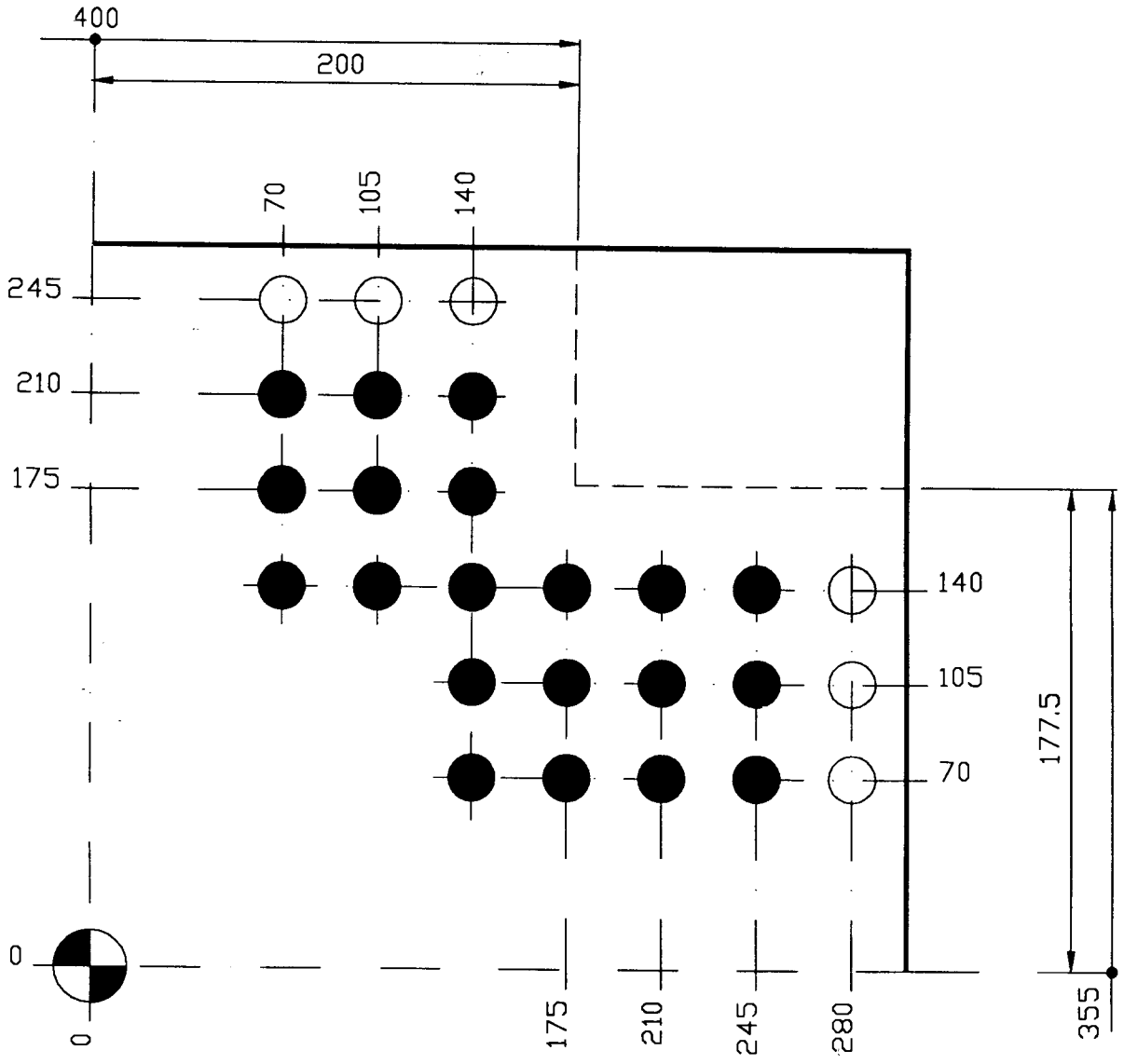
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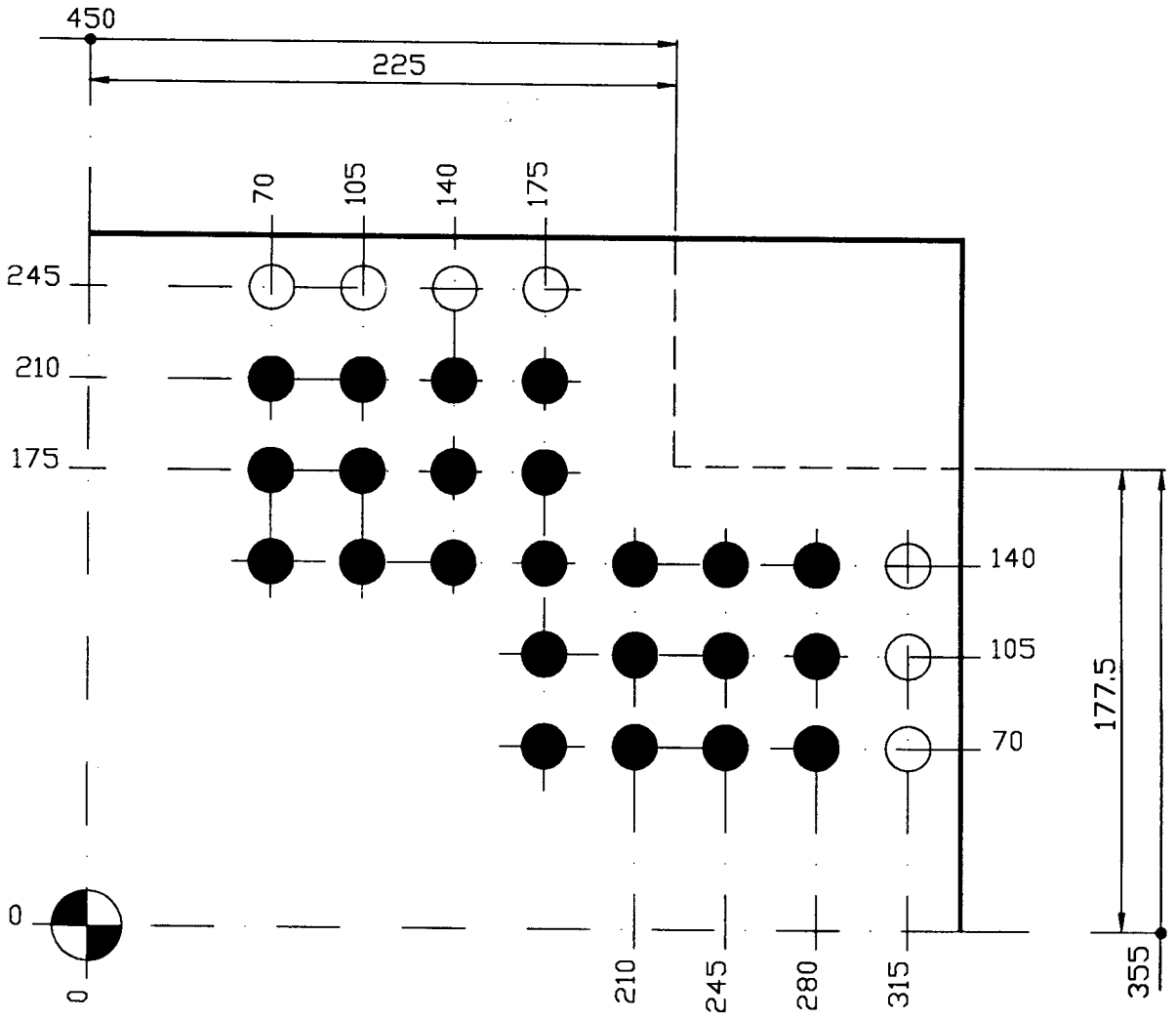
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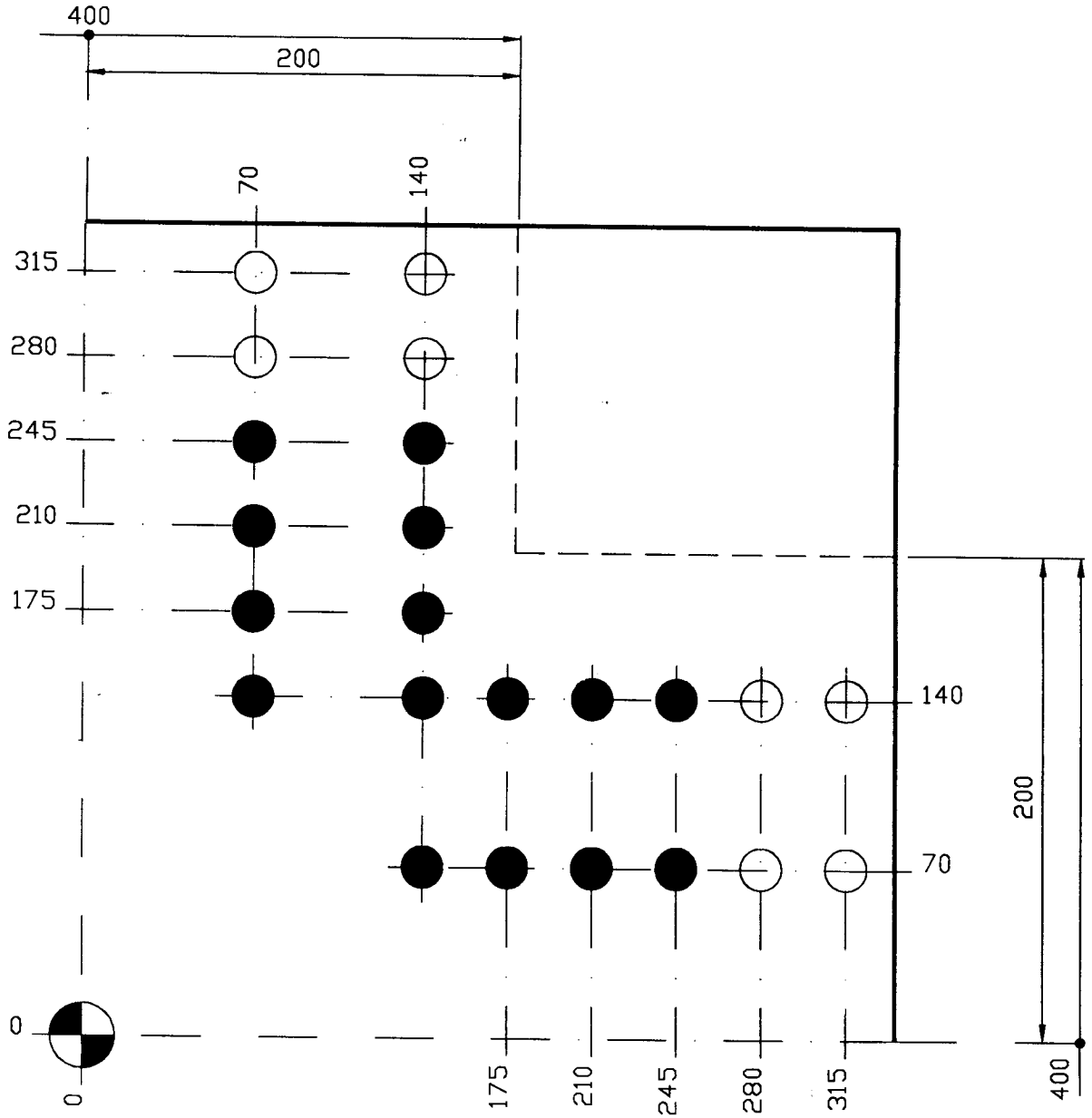
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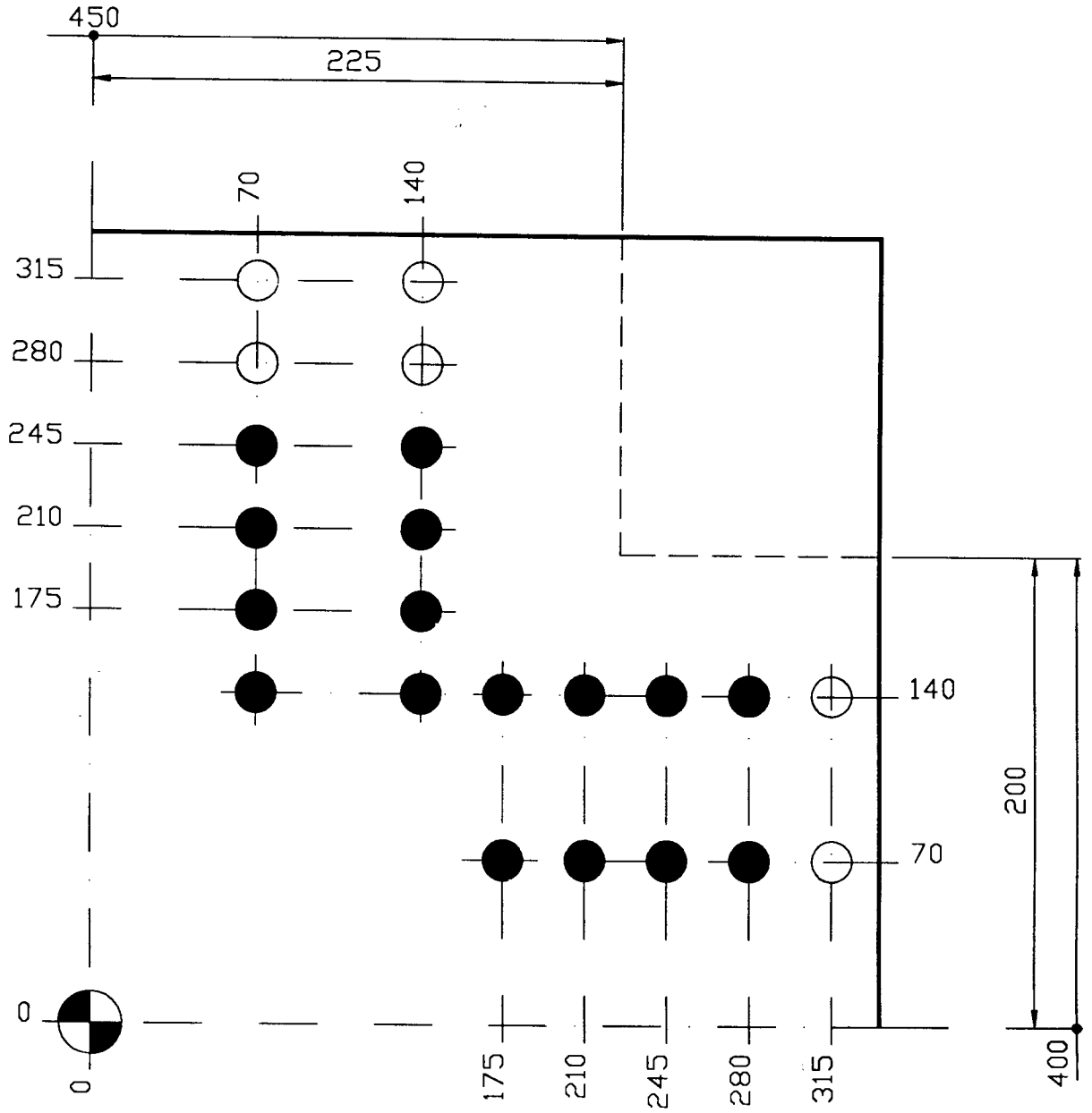
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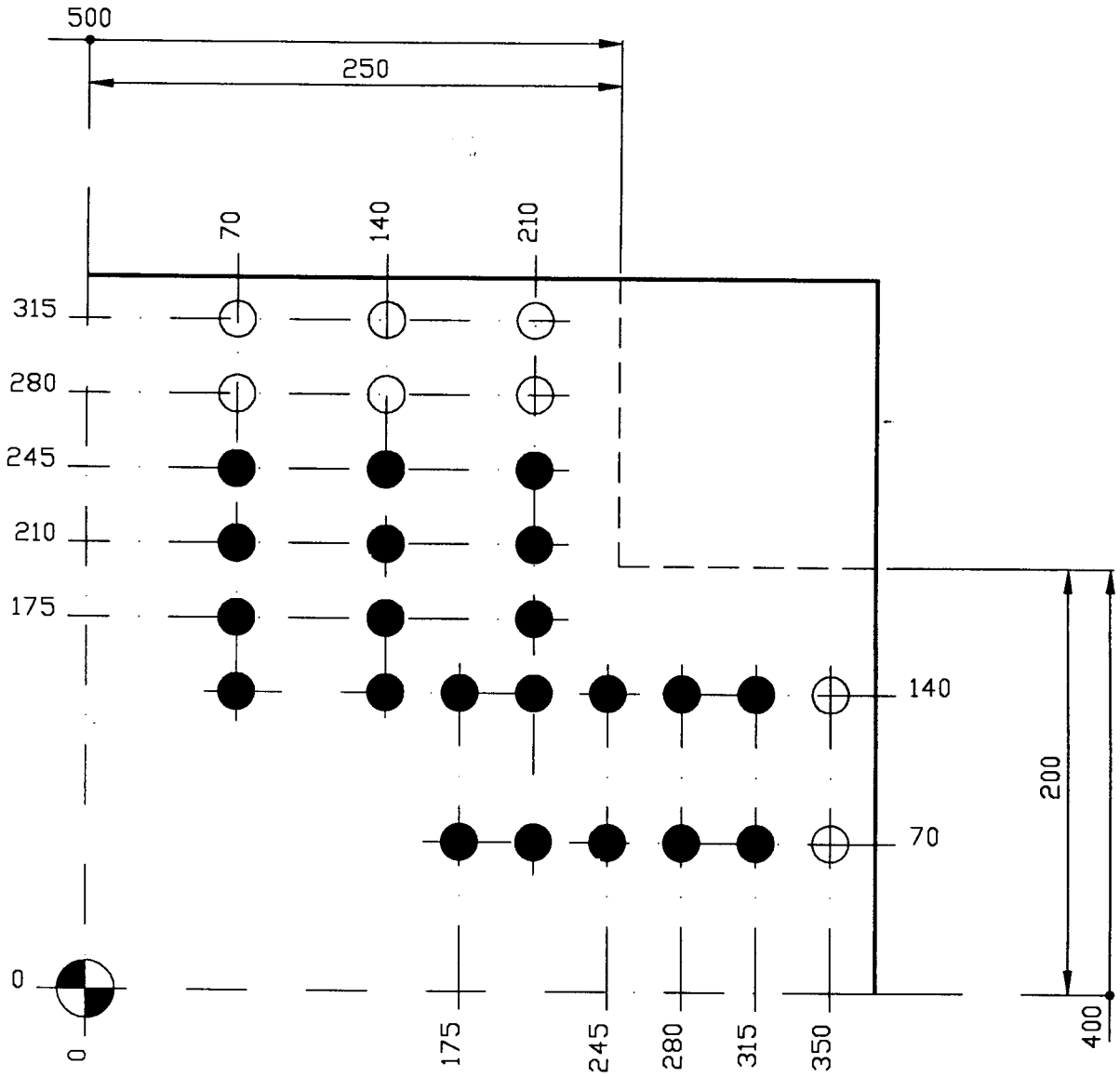
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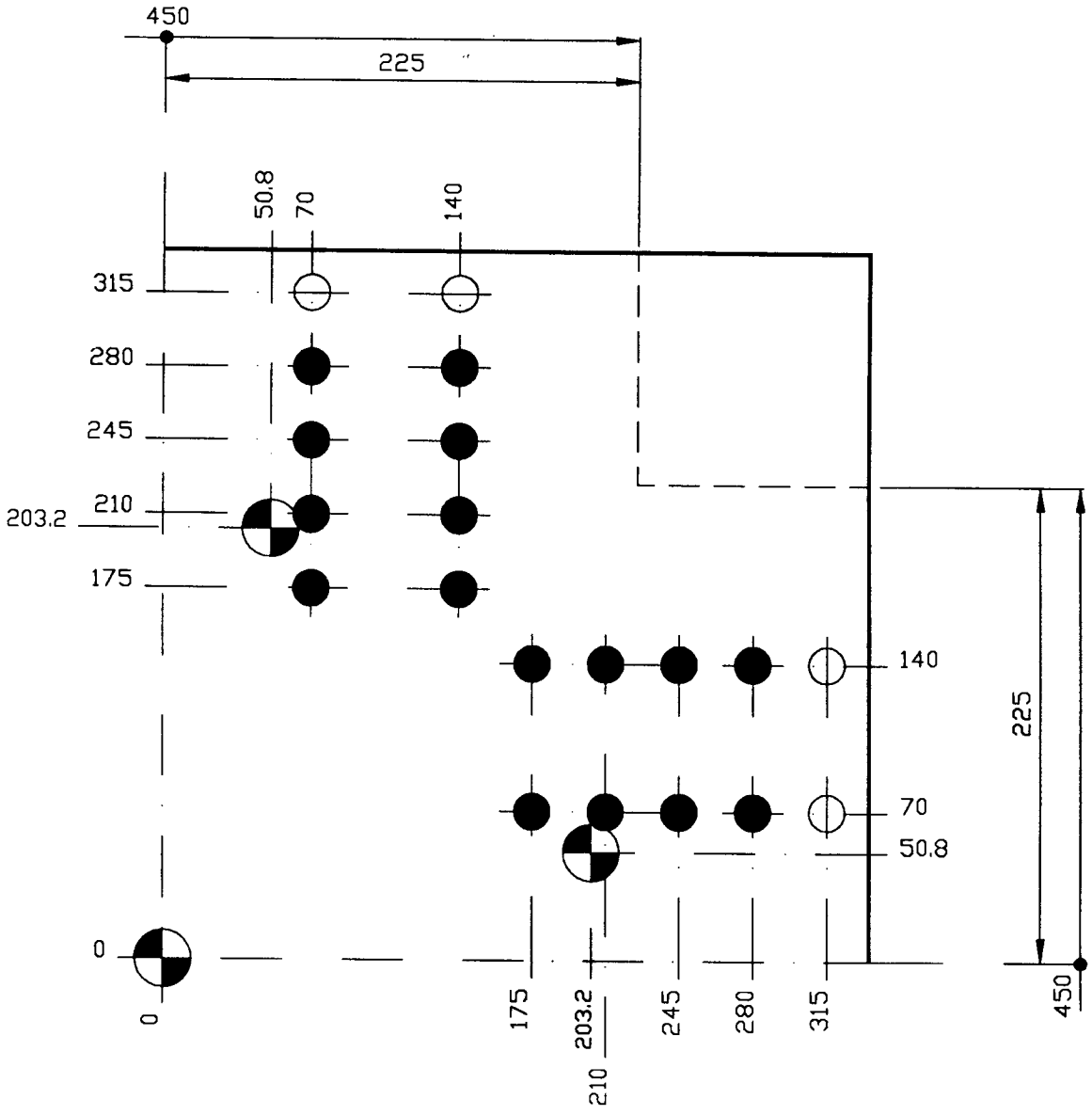
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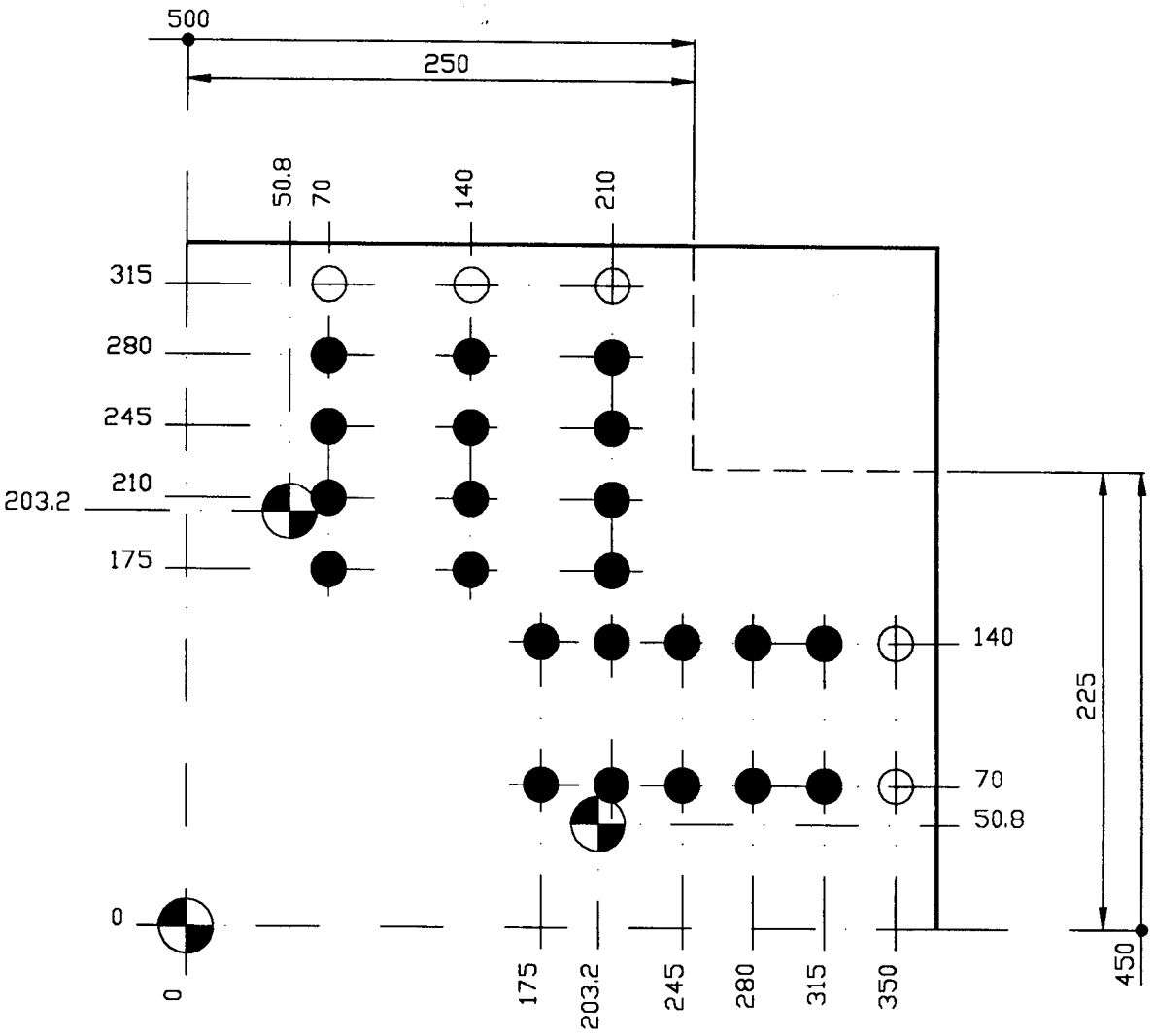
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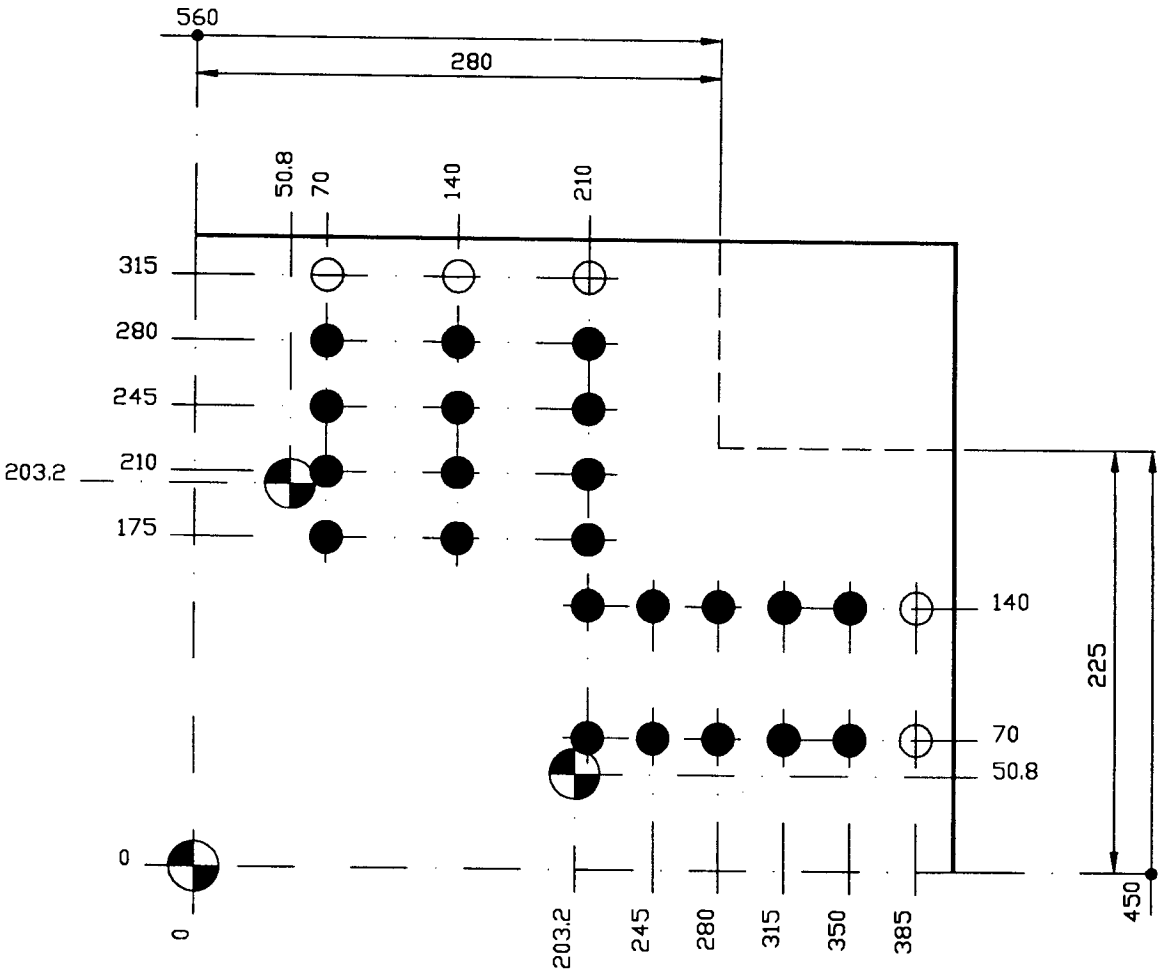
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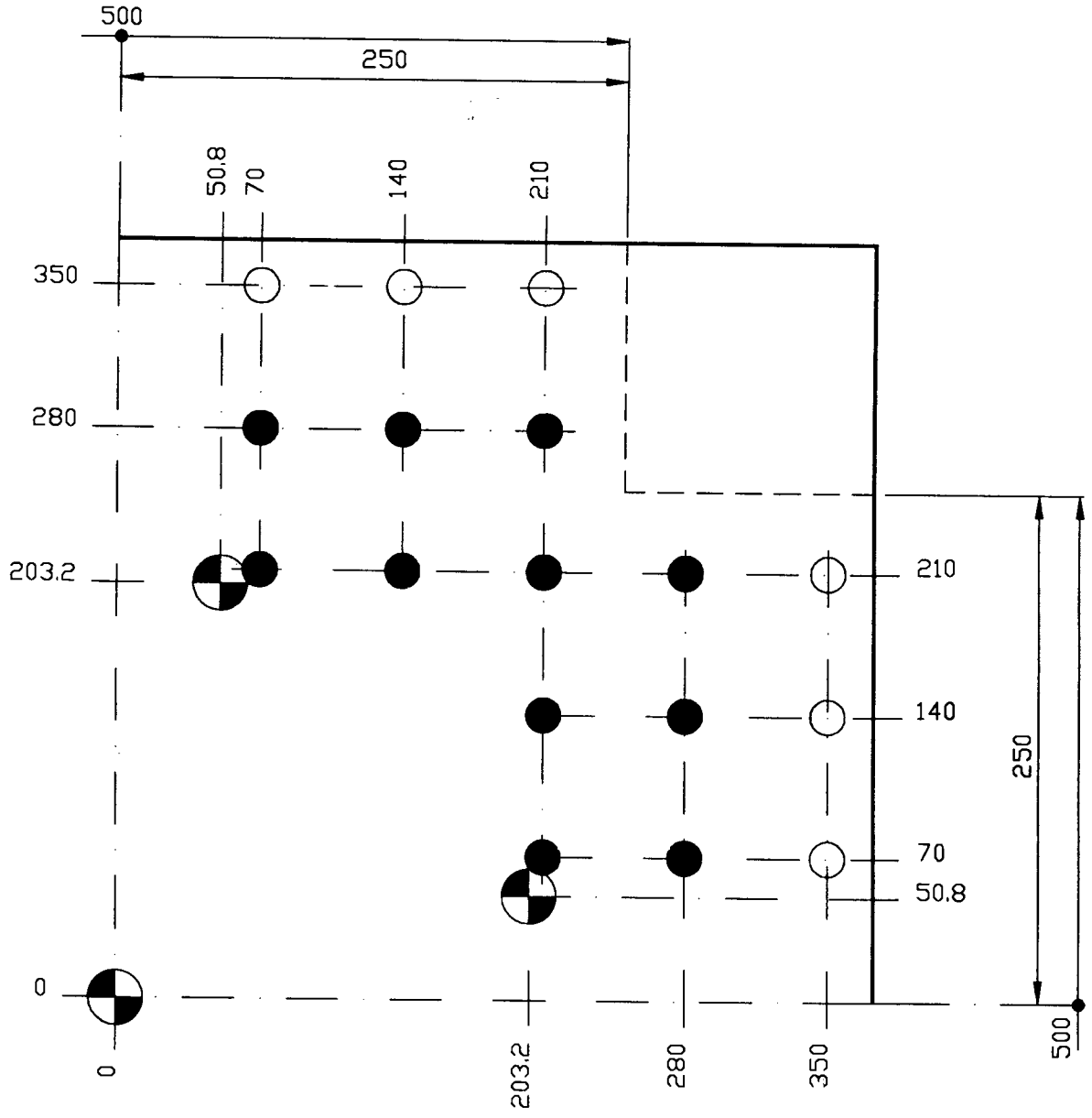
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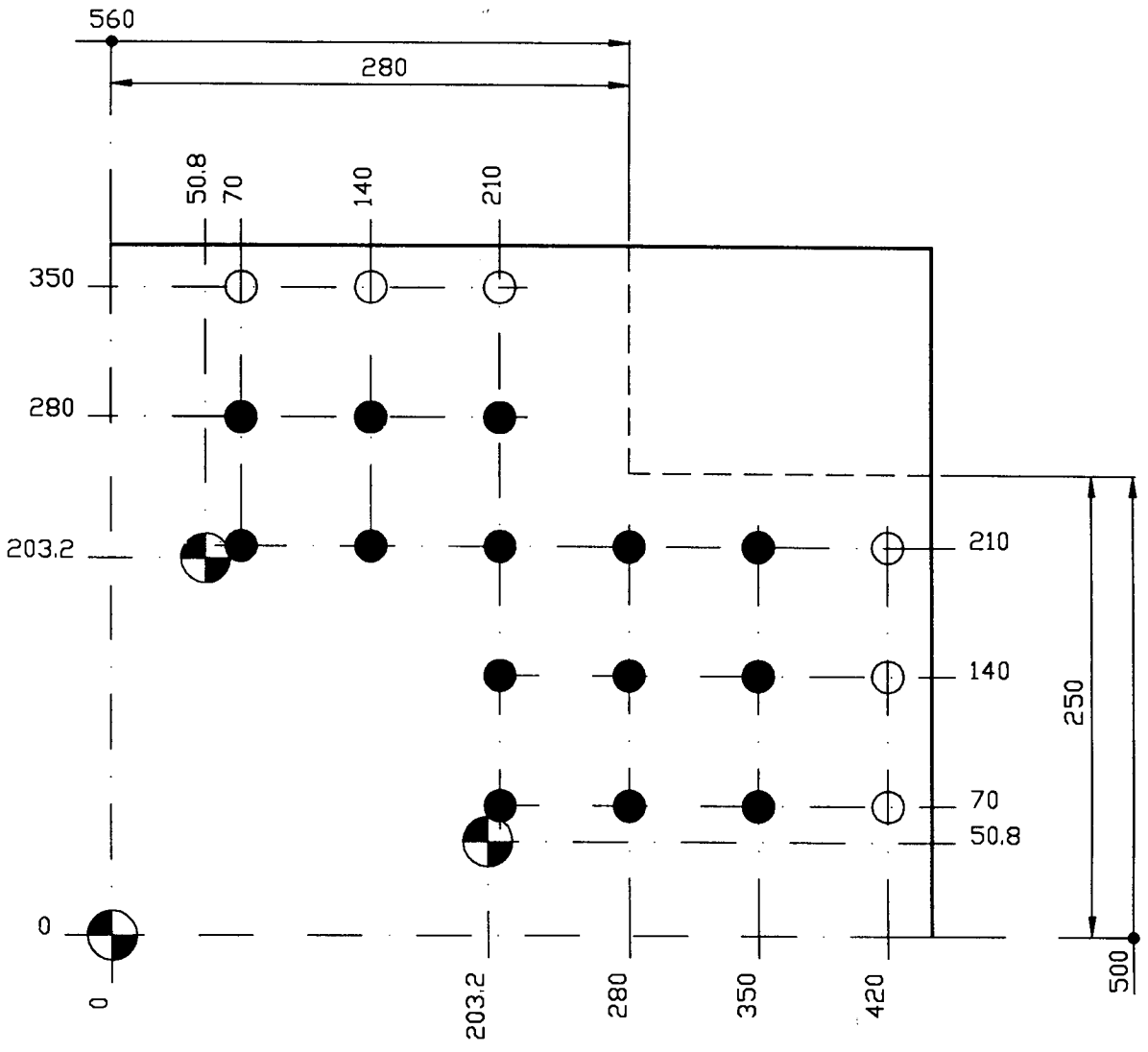
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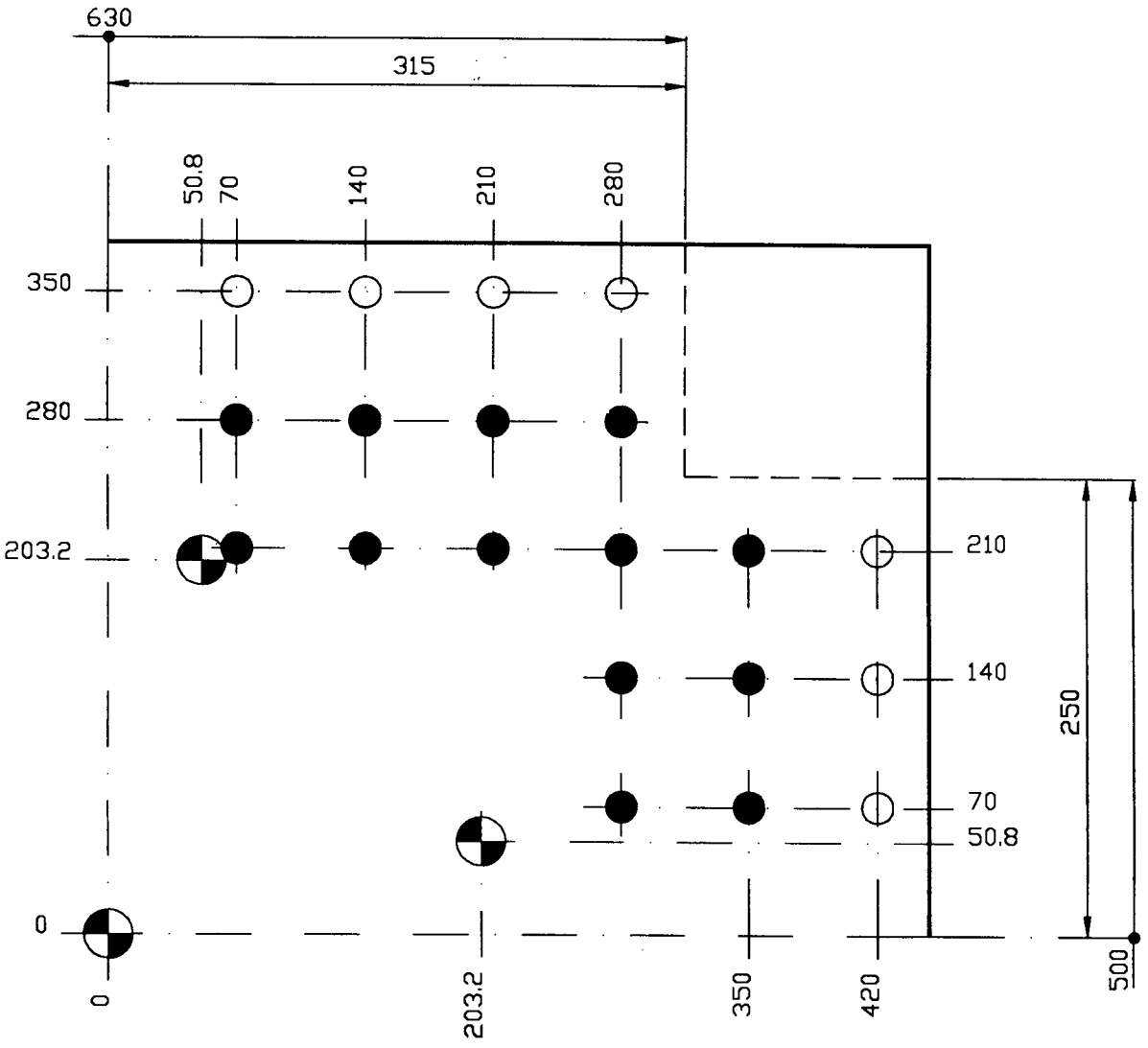
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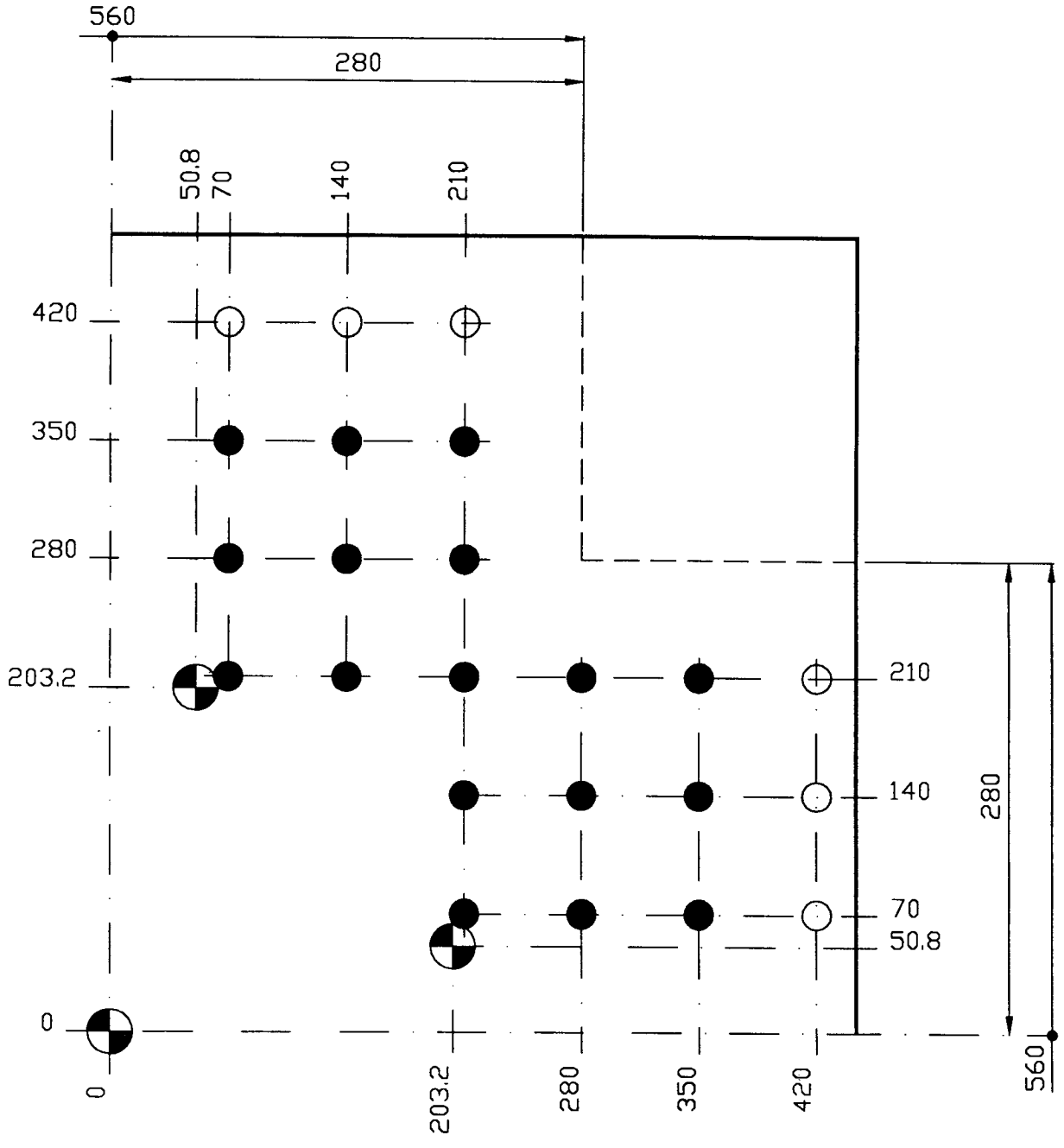
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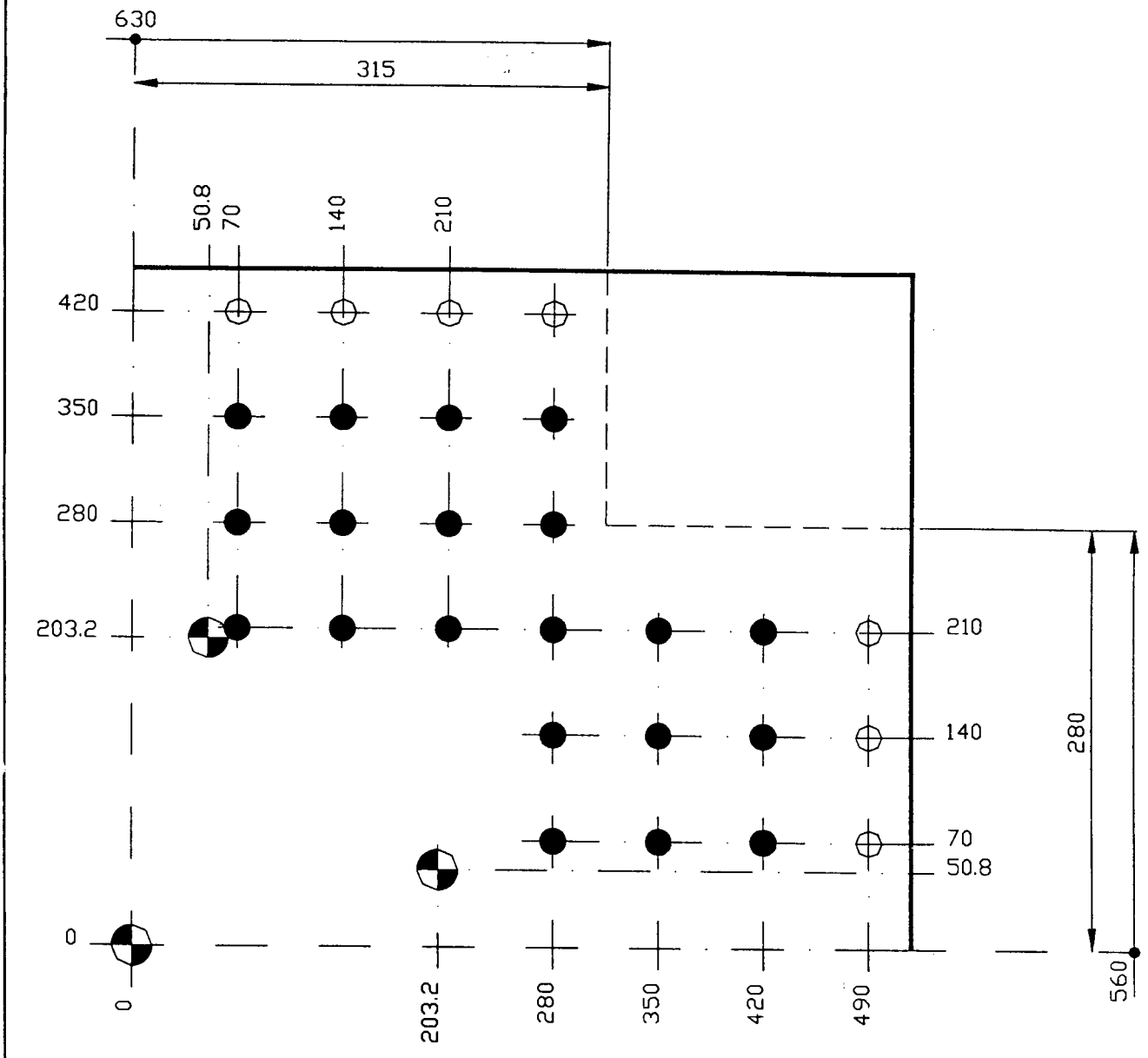
S 630/560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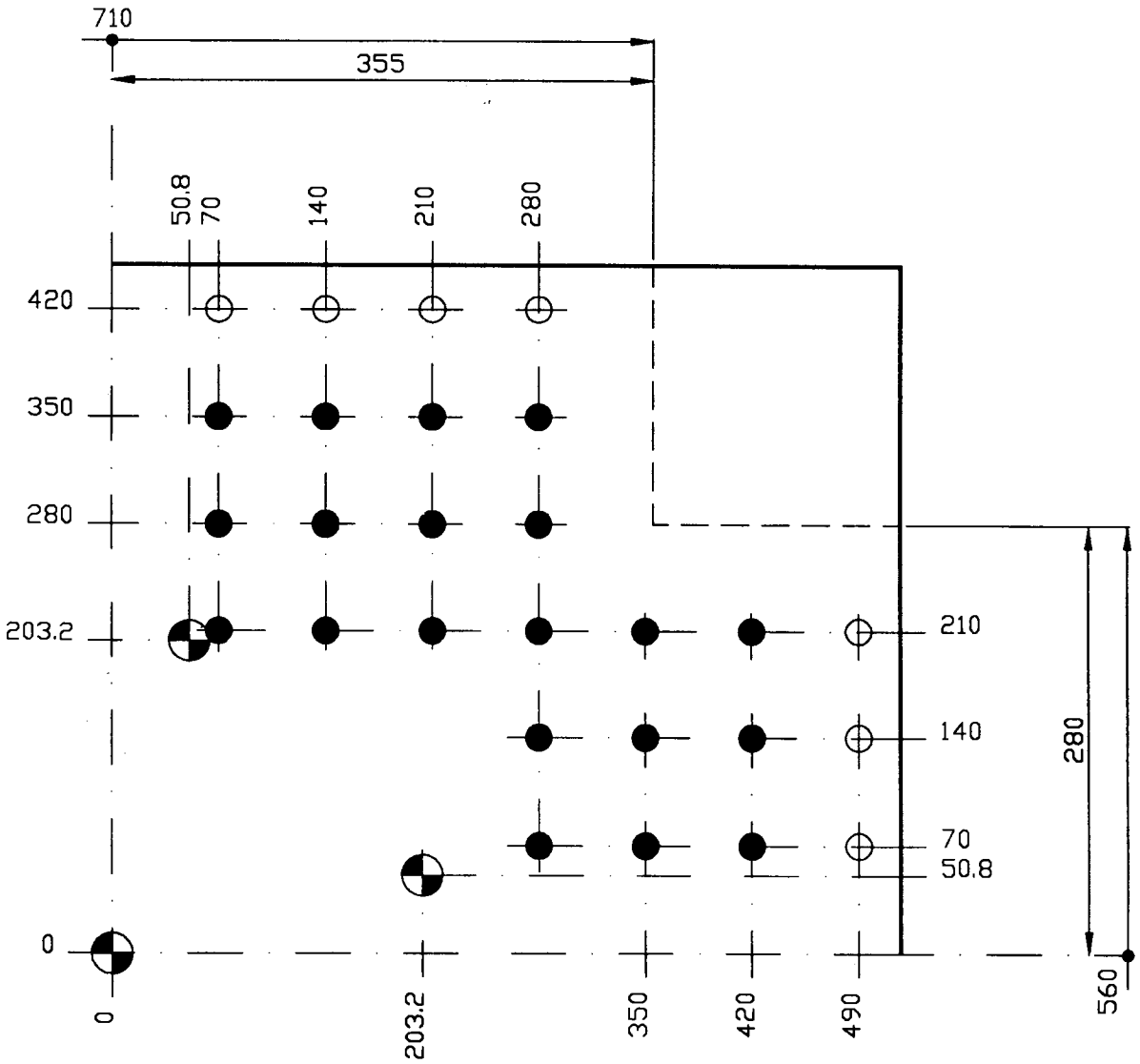
S 710/560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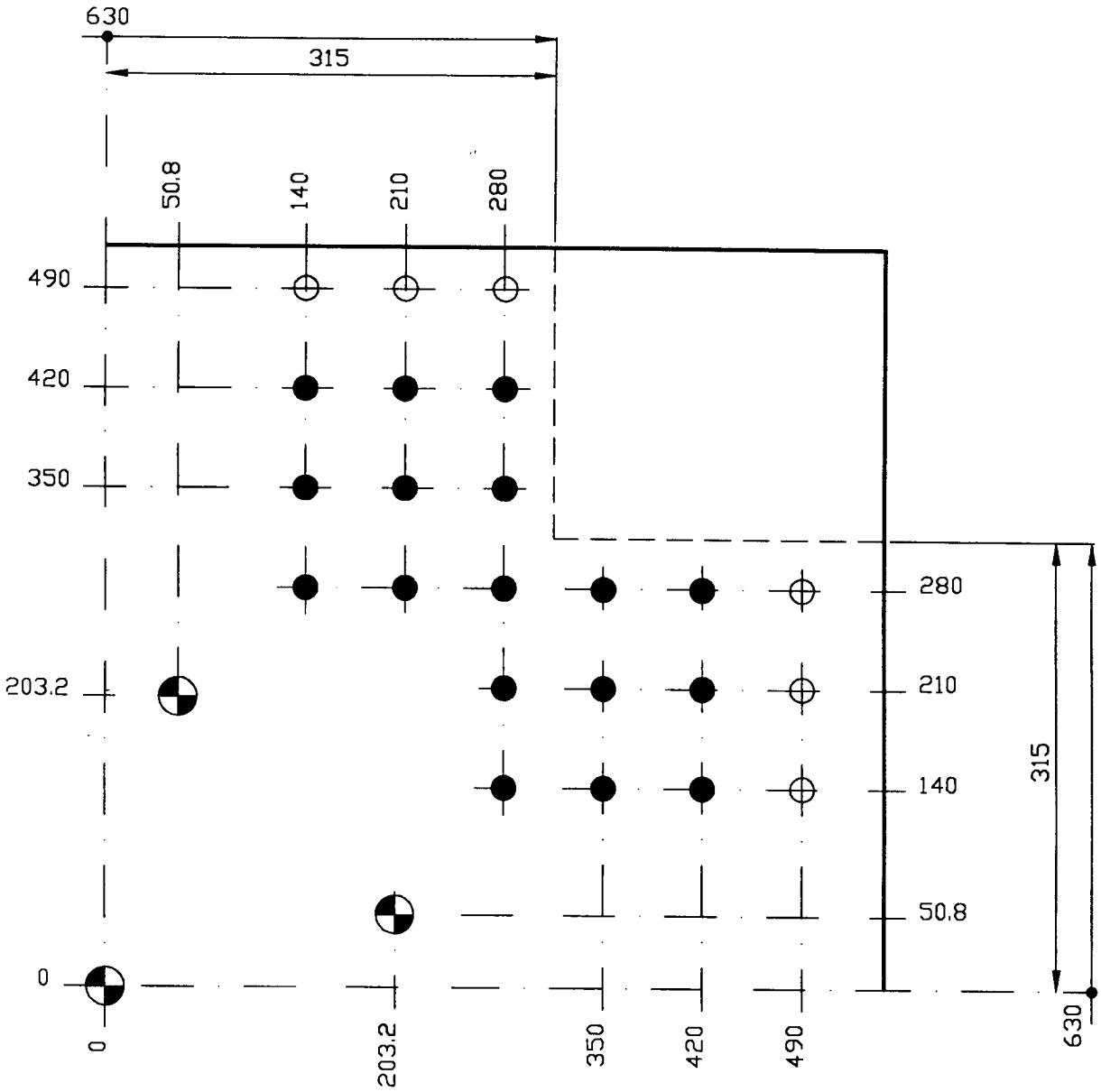
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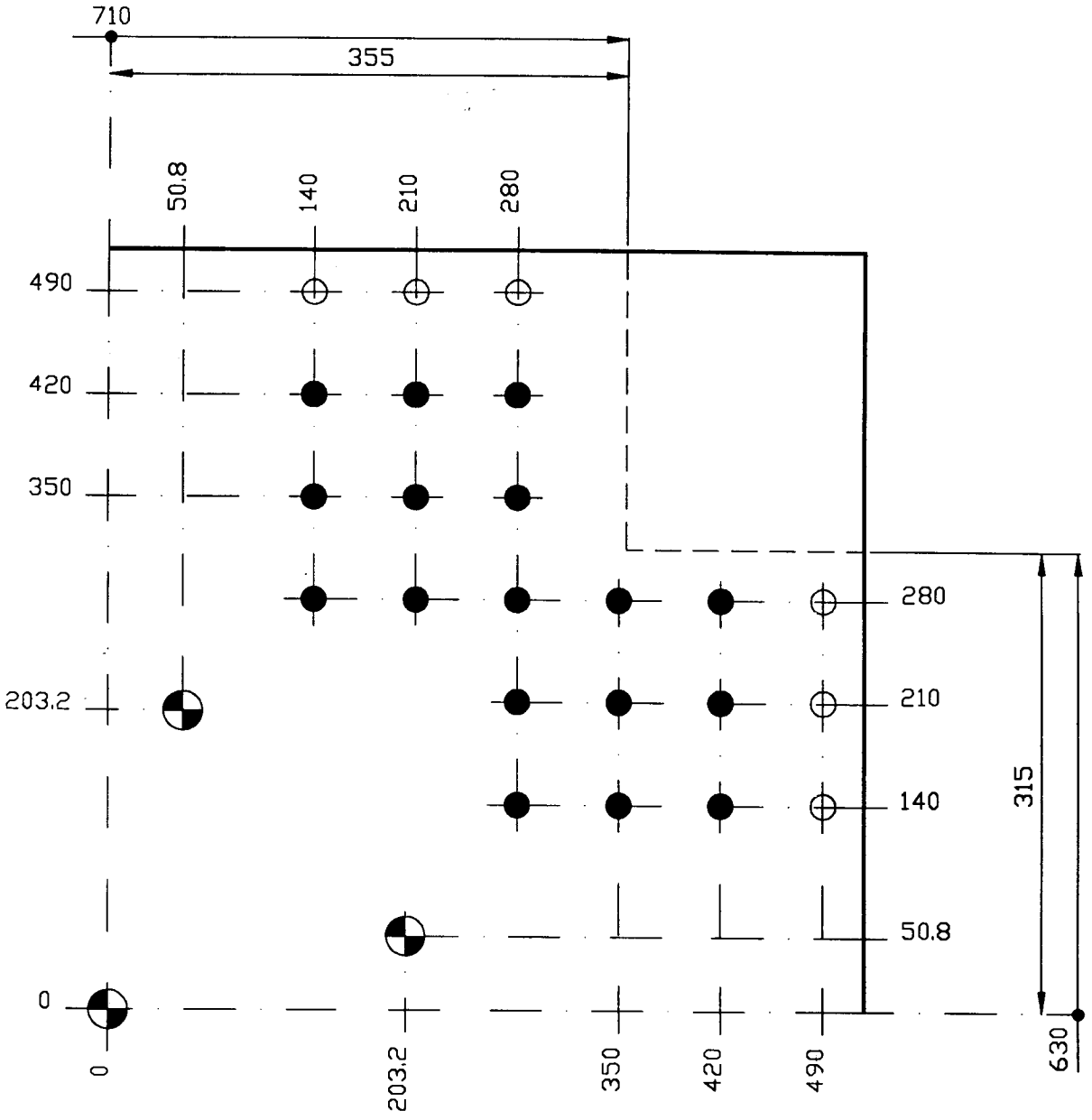
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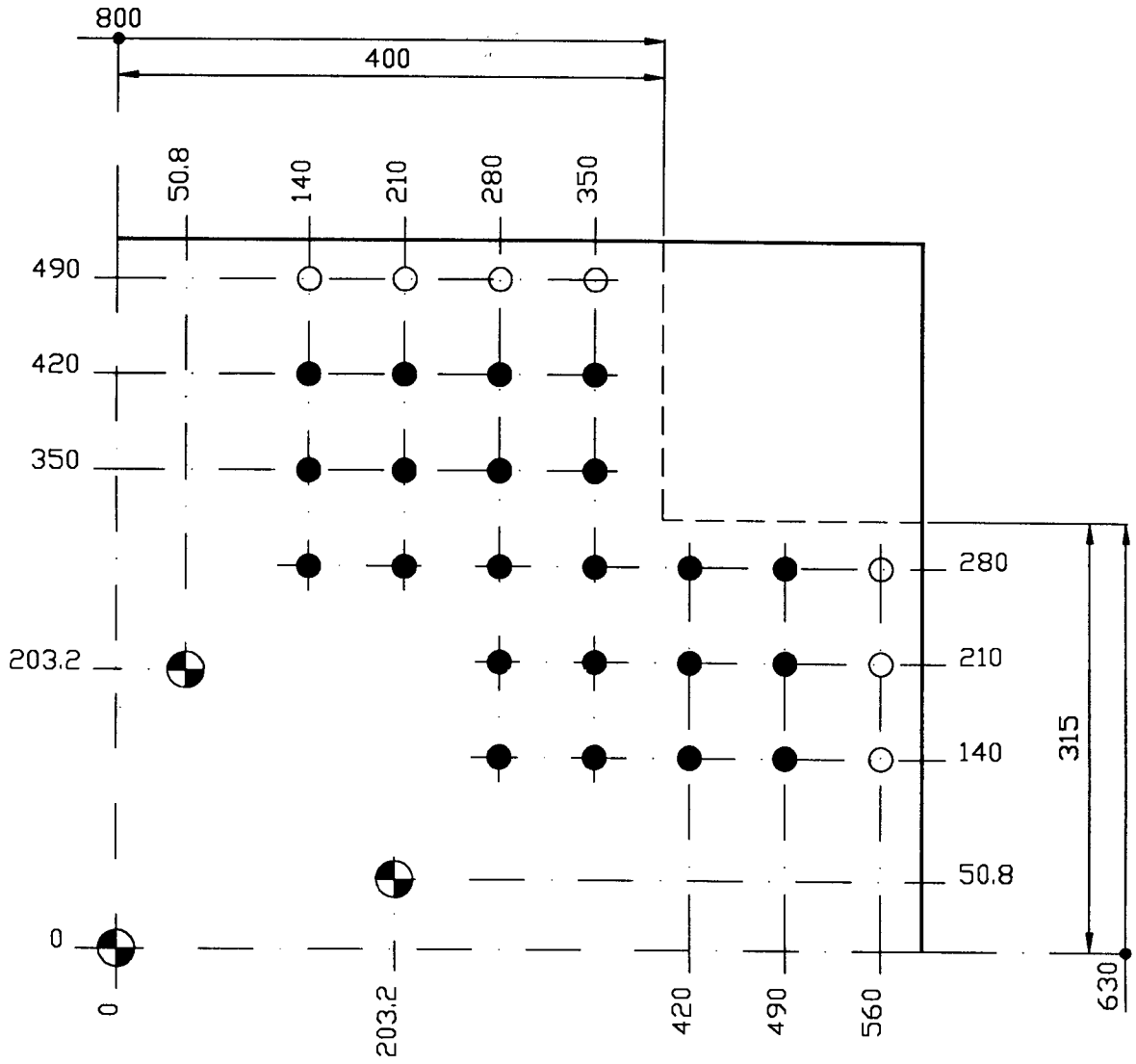
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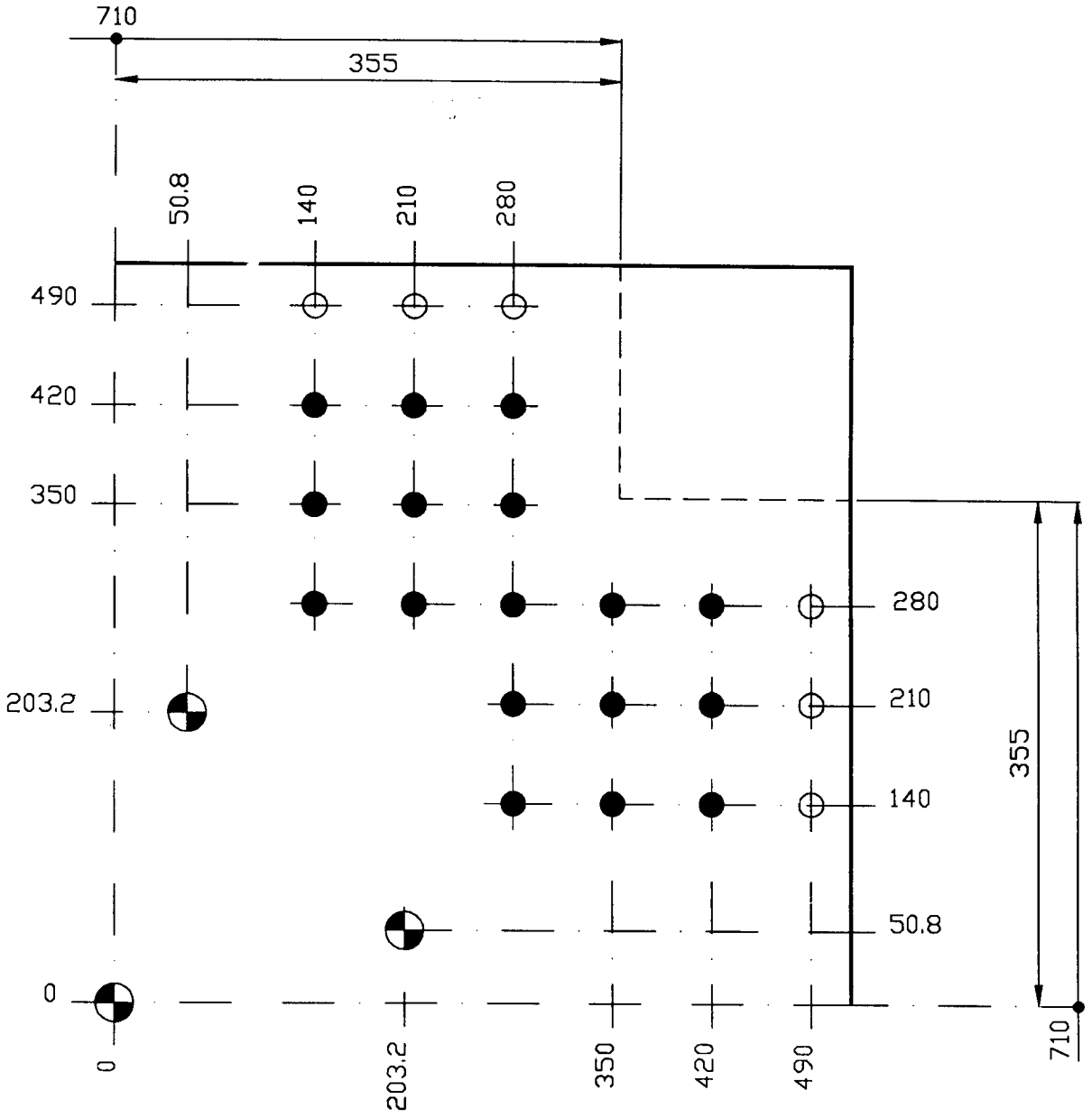
S 710/710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280
210
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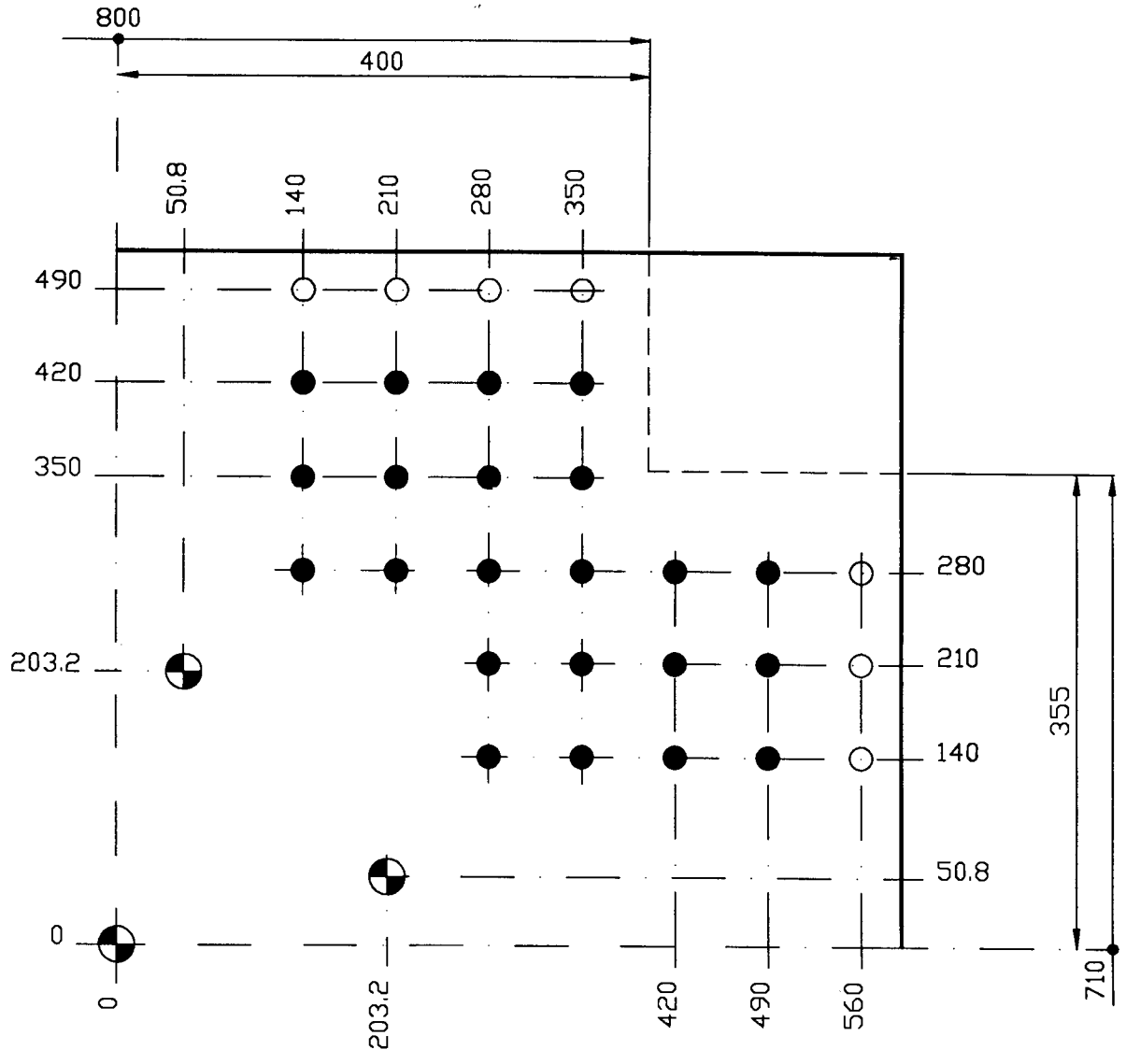
355
710

S 800/710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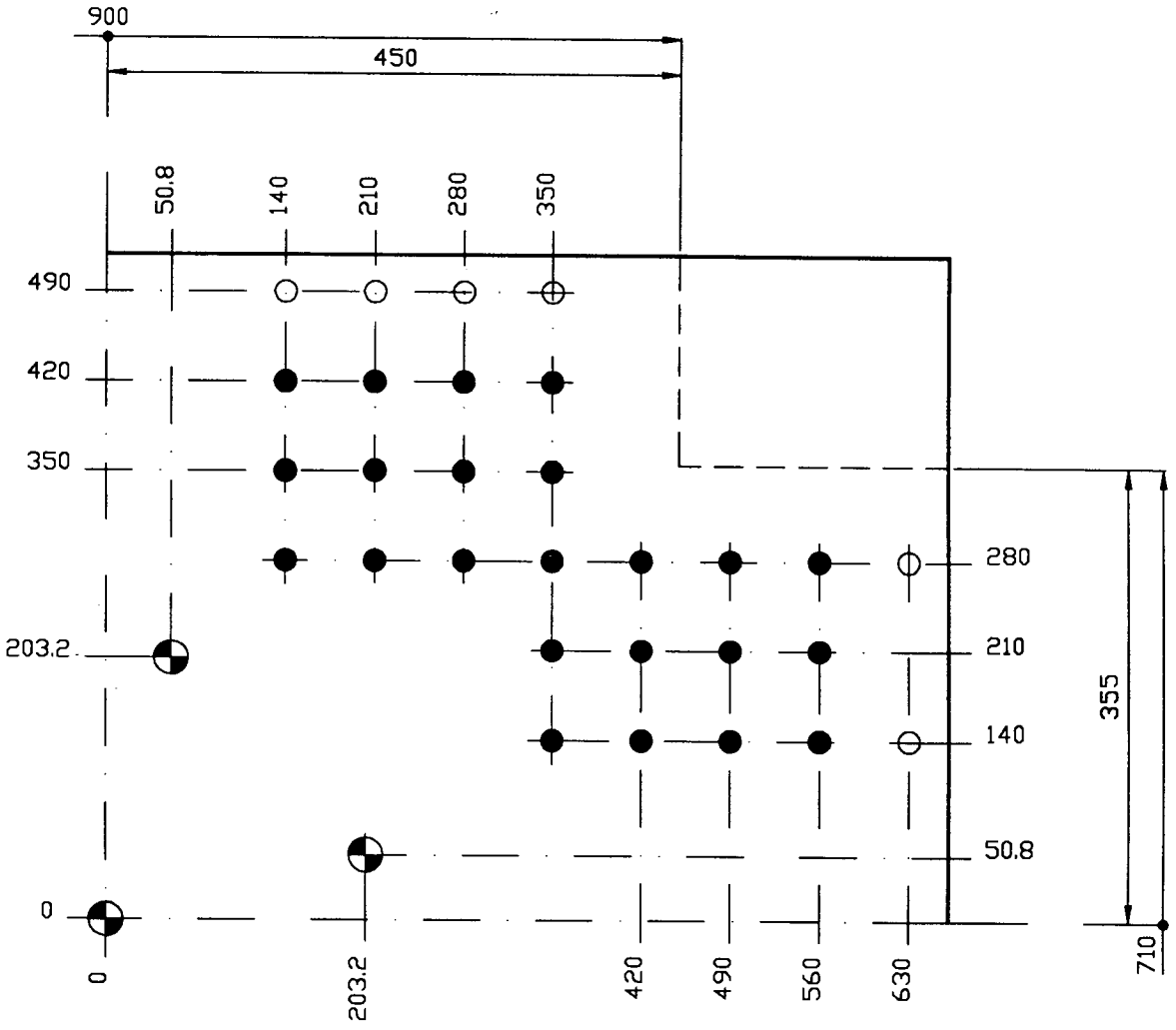
710

S 900/710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203.2
420
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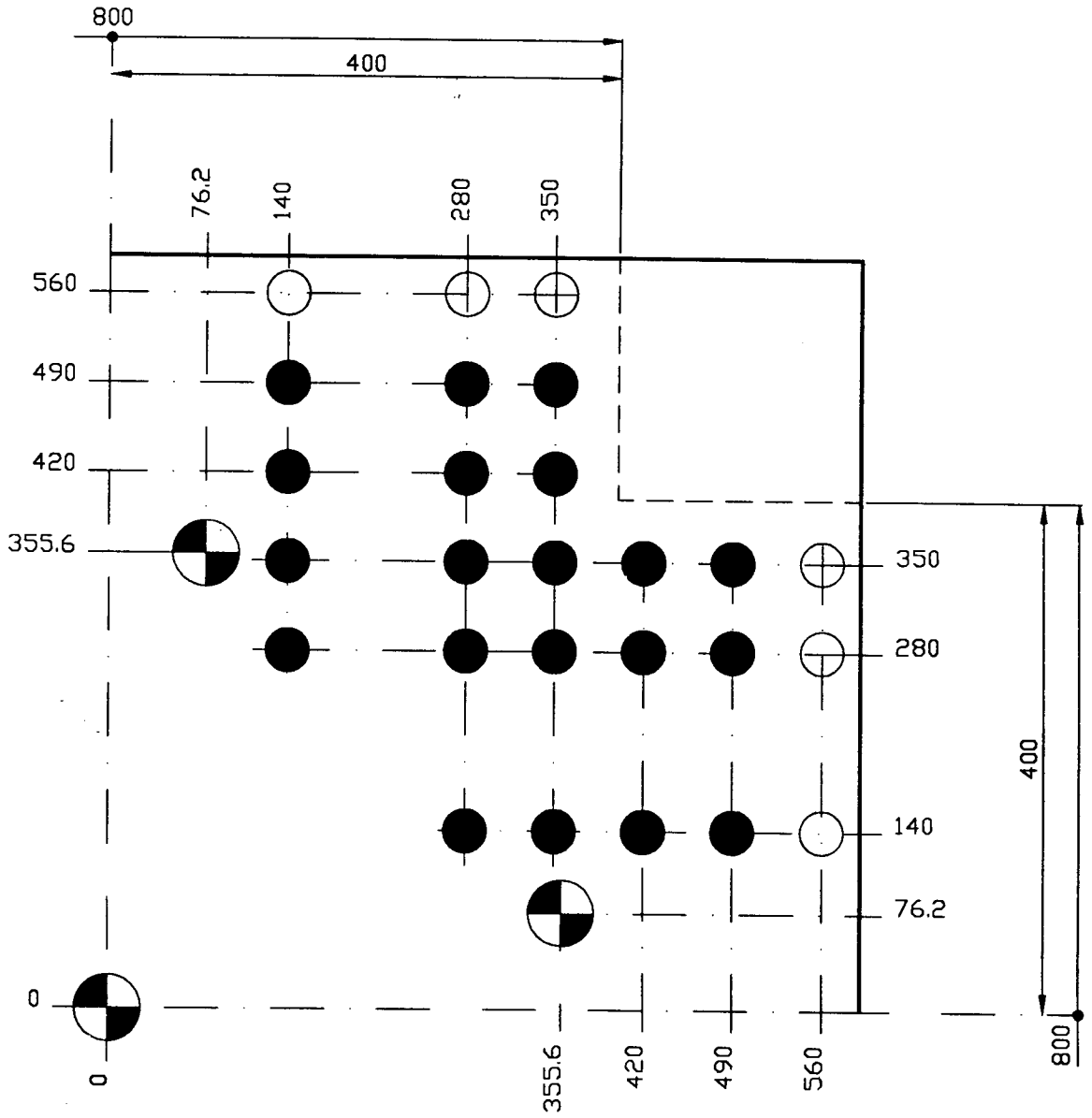
560
630
710

S 800/800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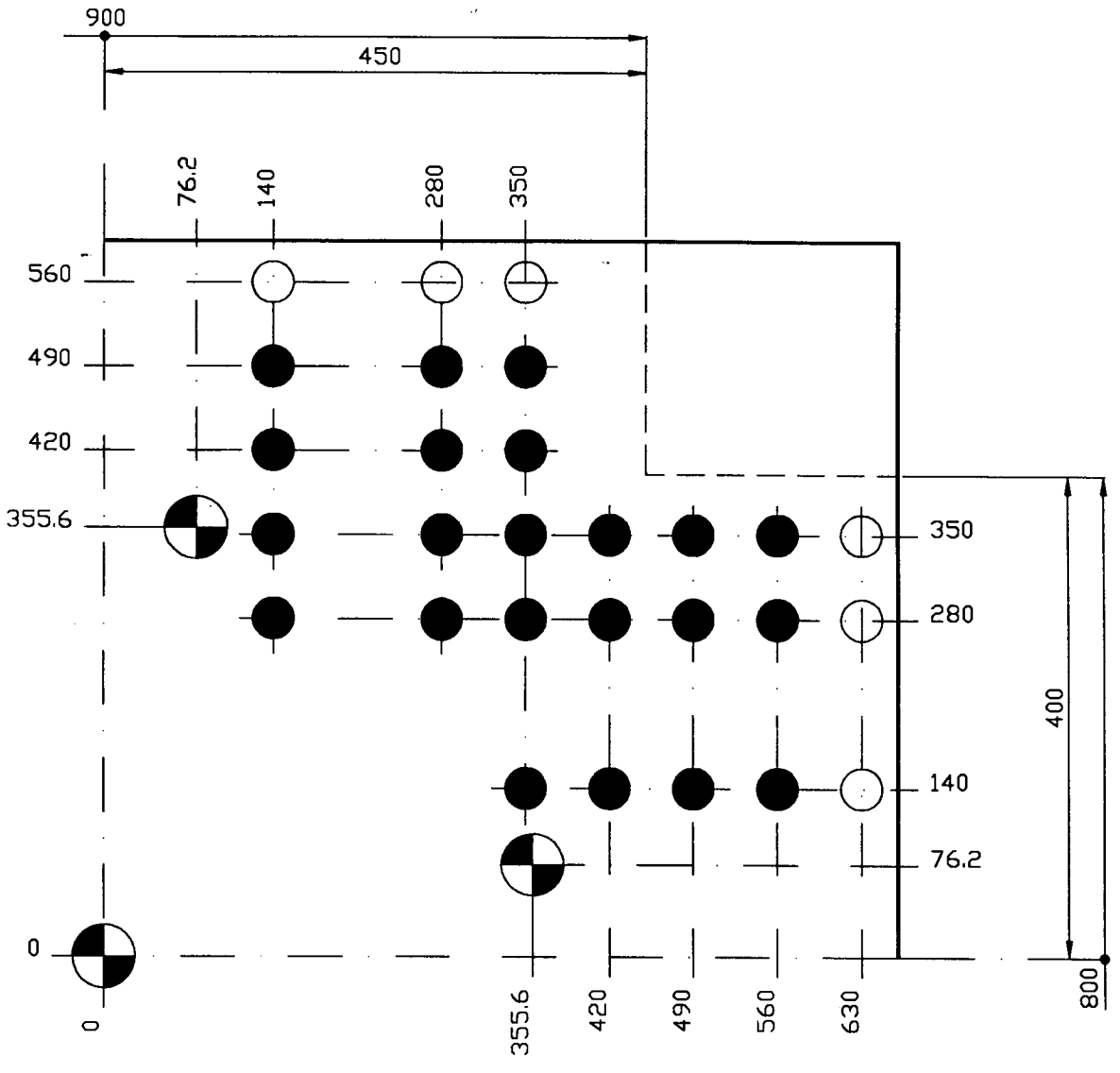
800

S 900/800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280
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76.2
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355.6
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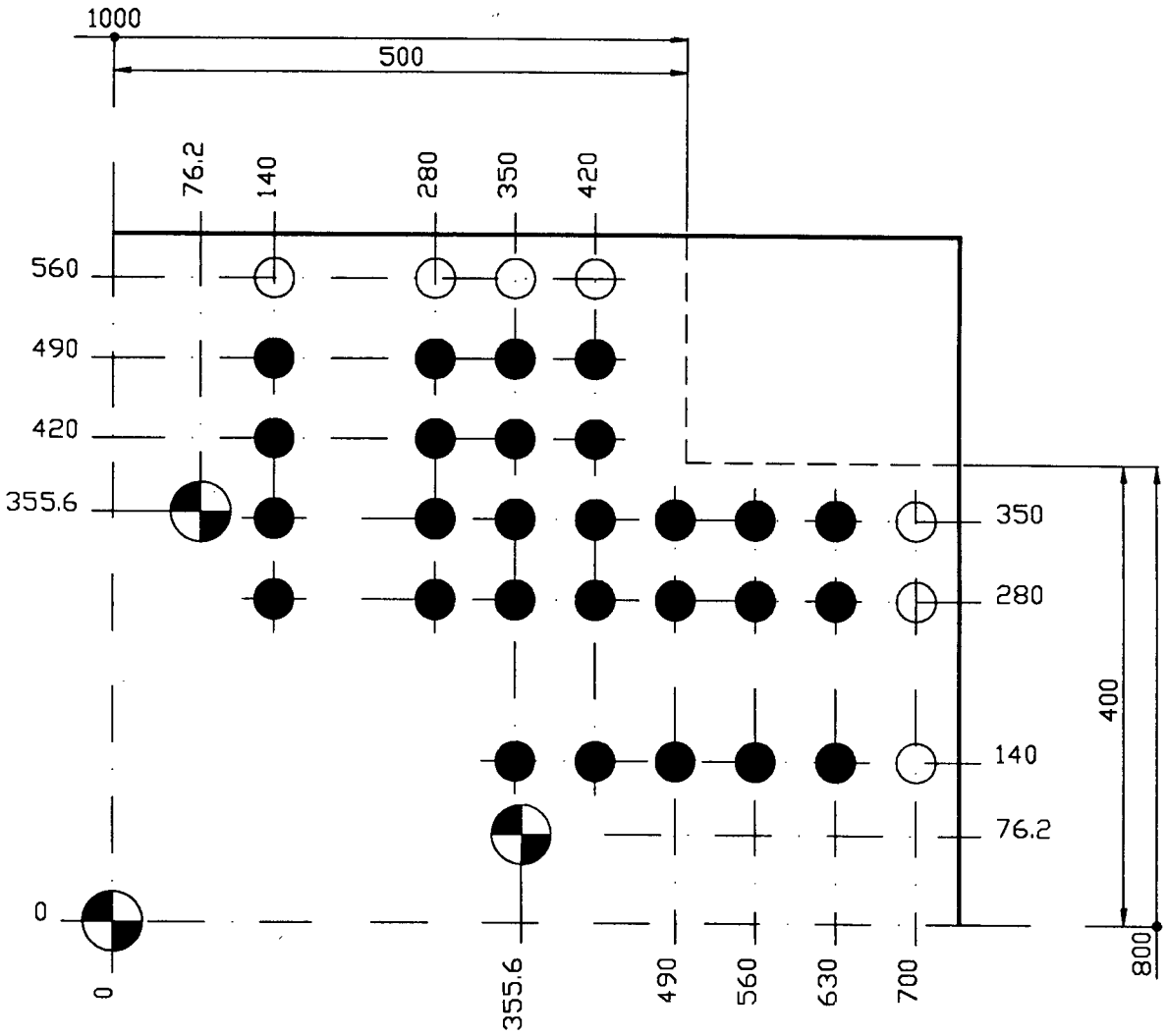
490
560
630

S 1000/800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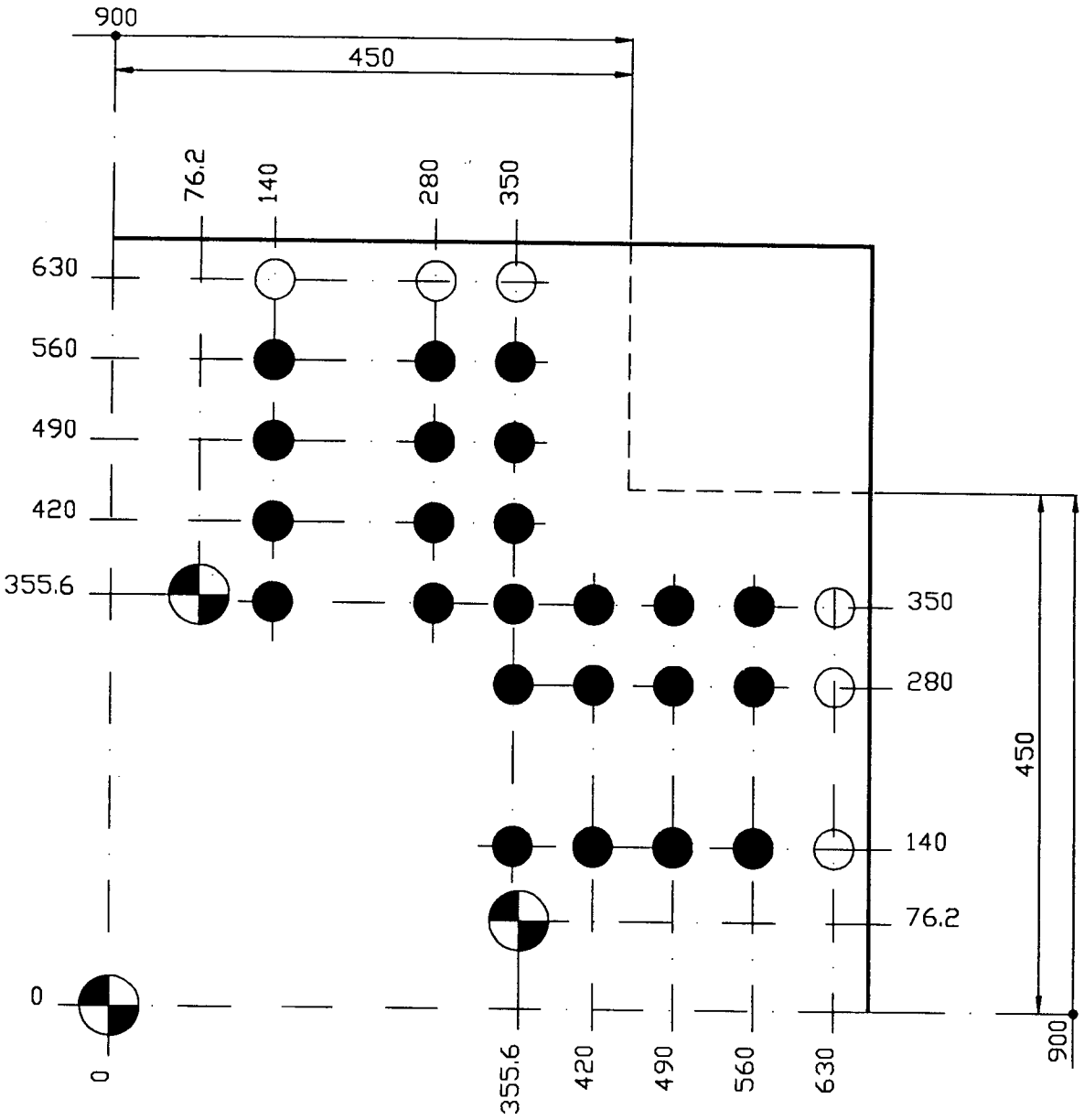
560
630
700
800

S 900/900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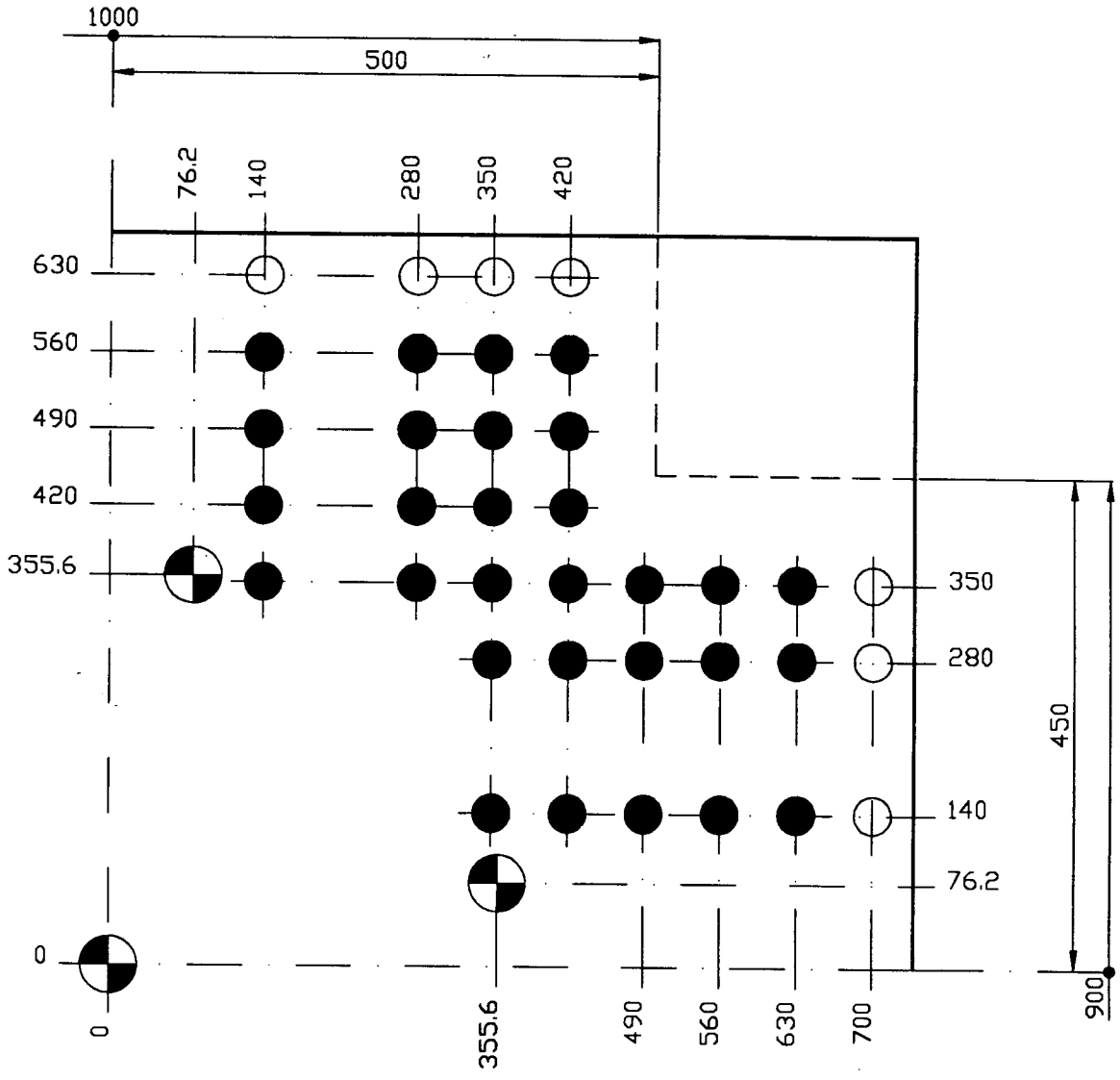
490
560
630
450
900

S 1000/900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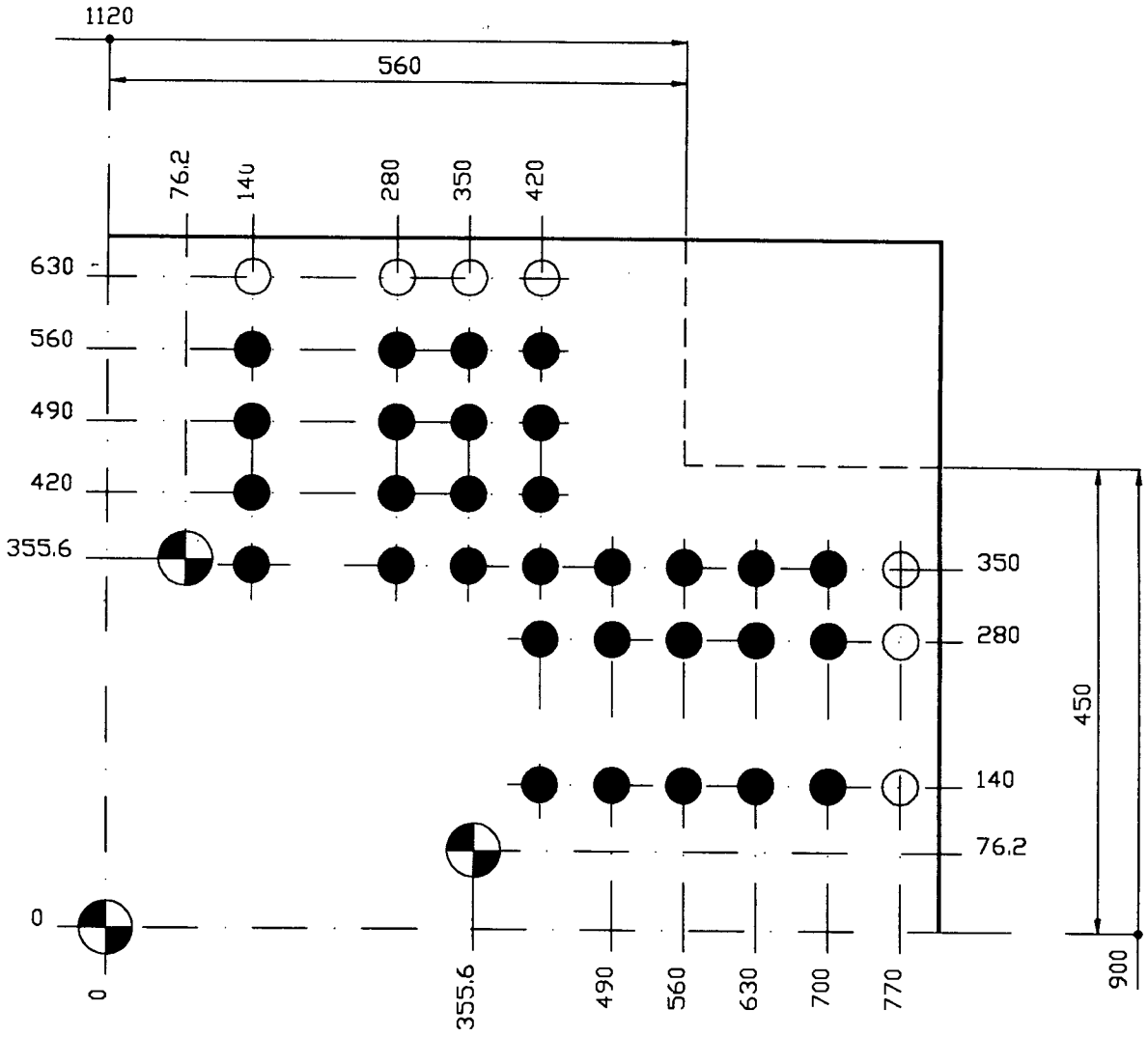
900

S 1120/900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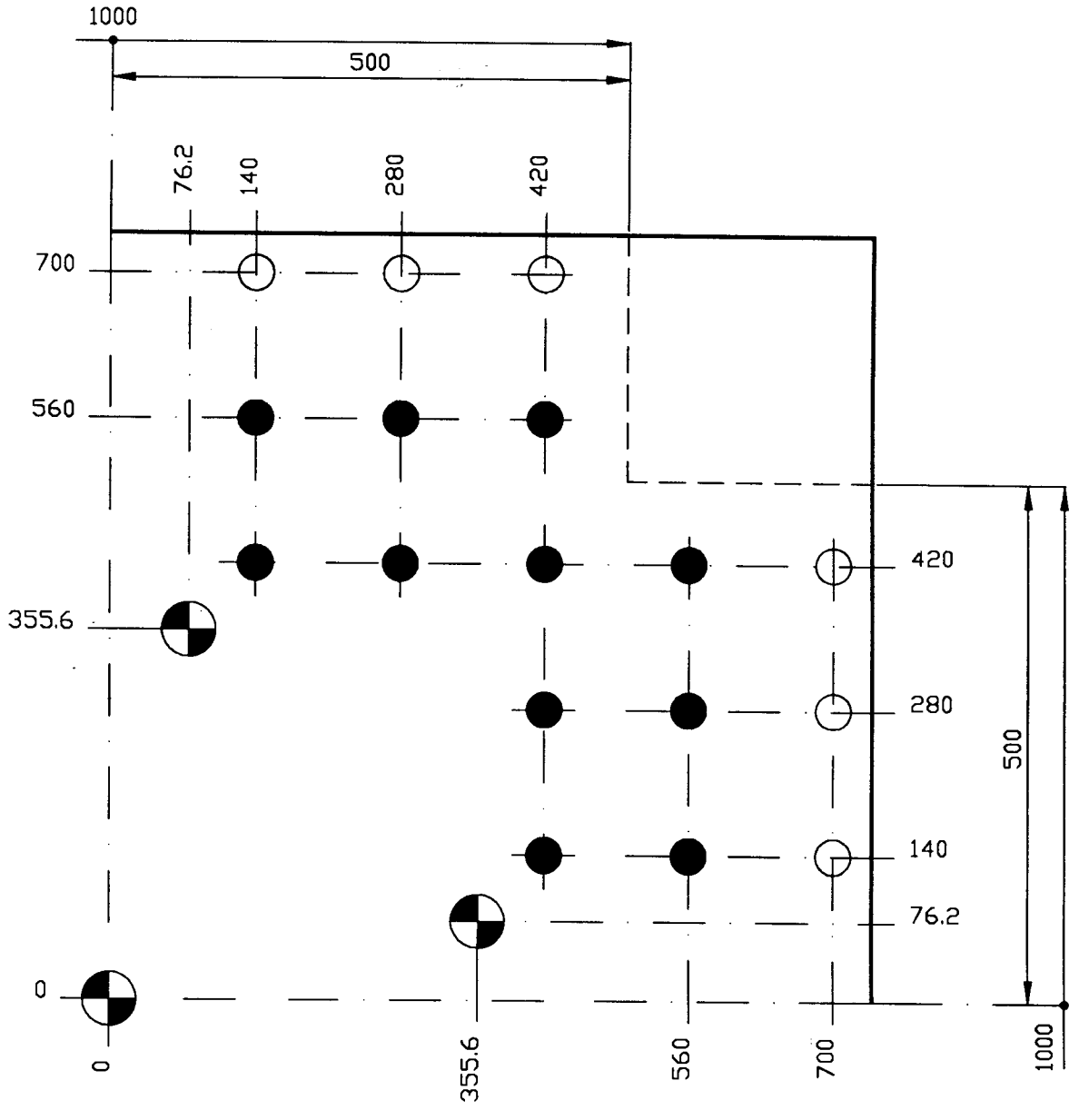
450
900

S 1000/1000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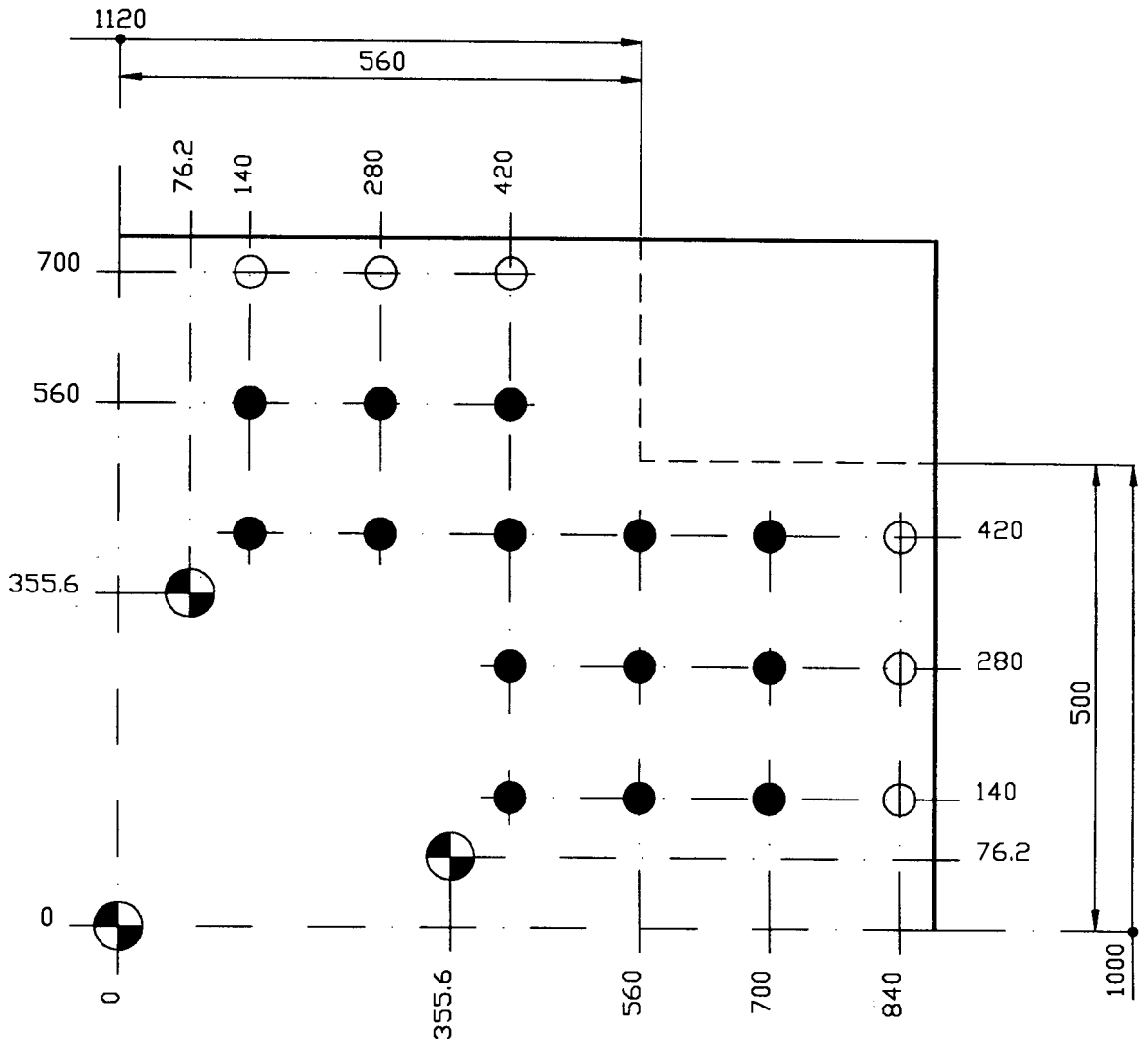
700
1000

S 1120/1000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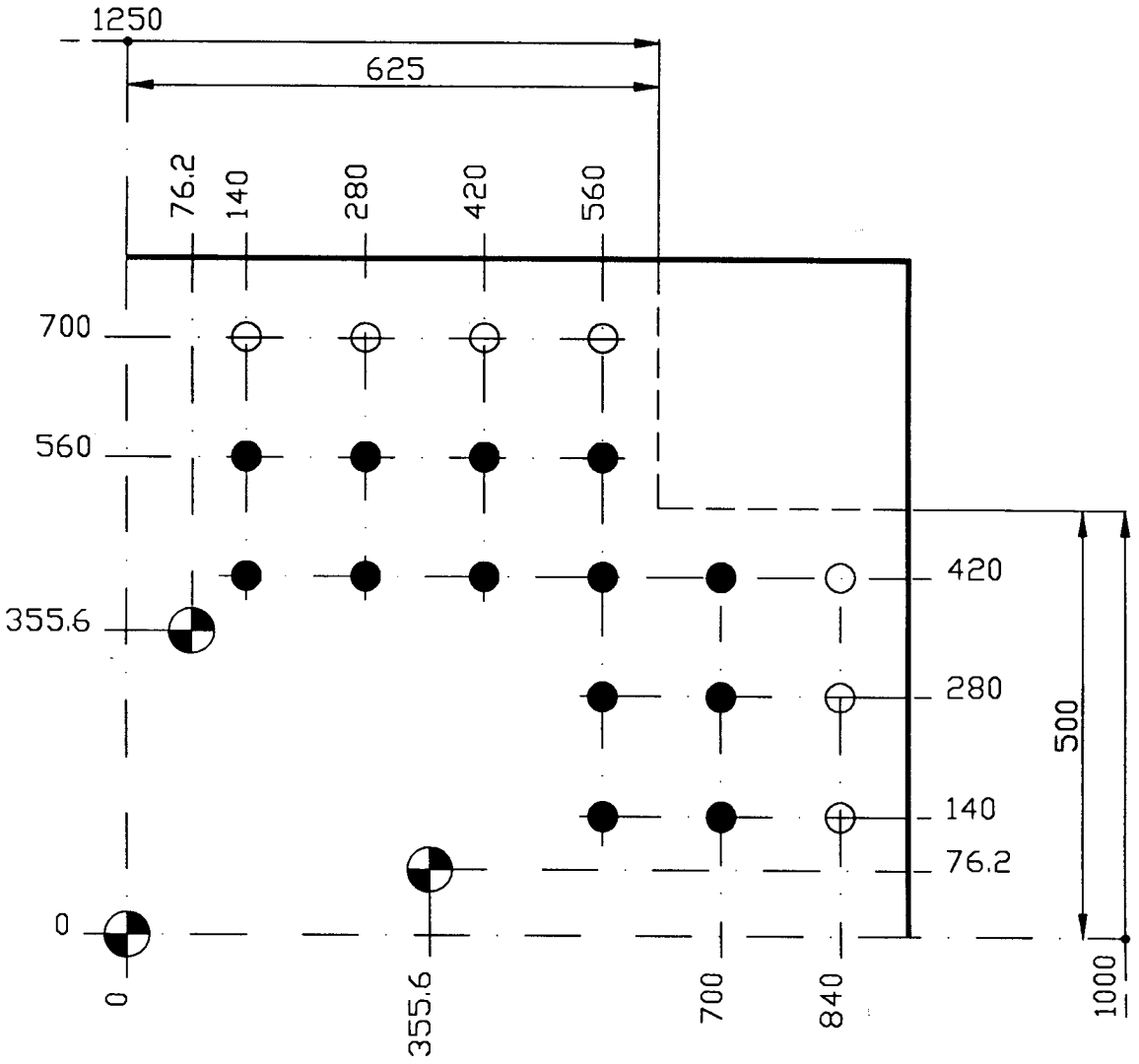
700
840

S 1250/1000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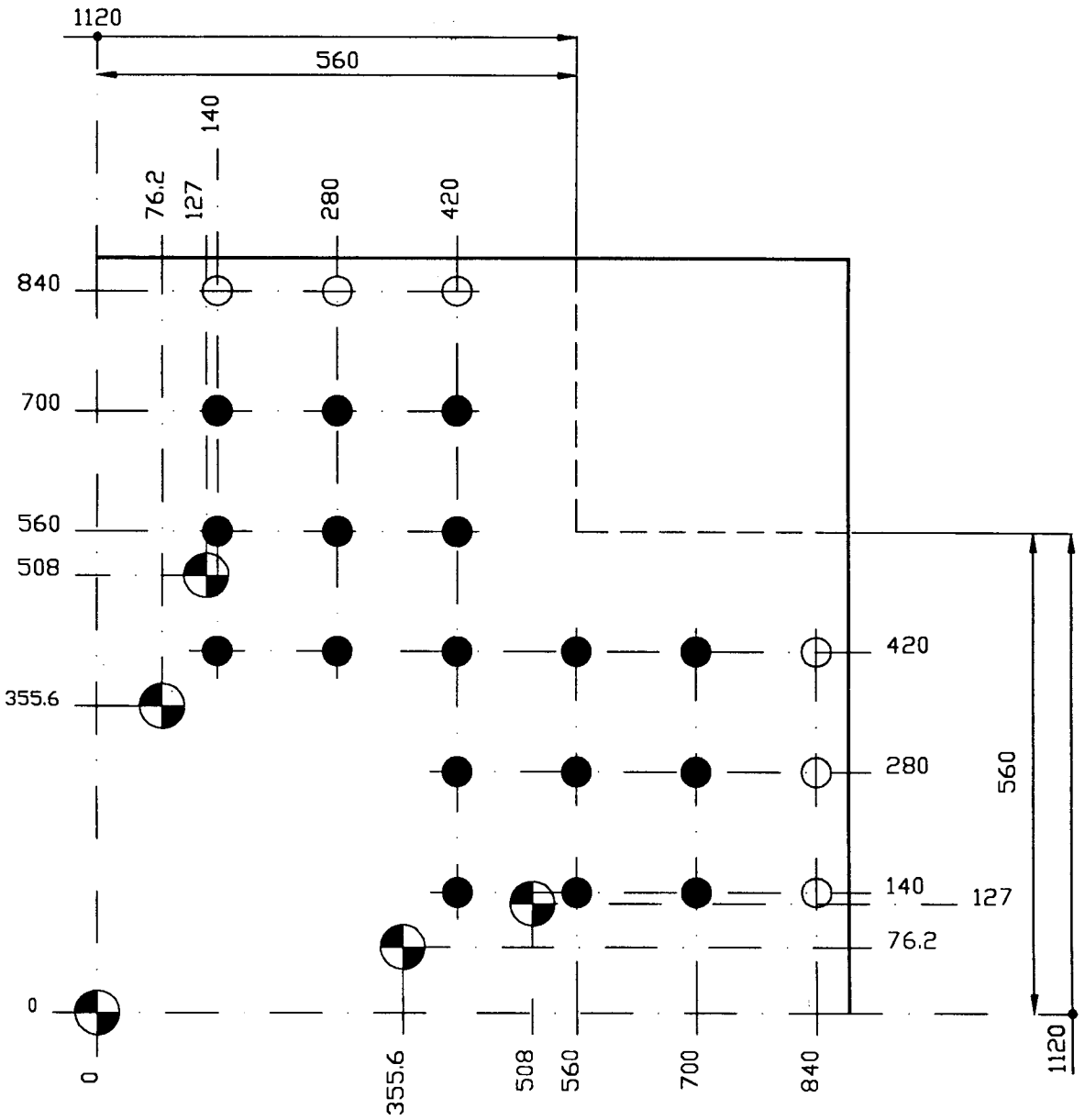
355.6
700
840
1000

S 1120/1120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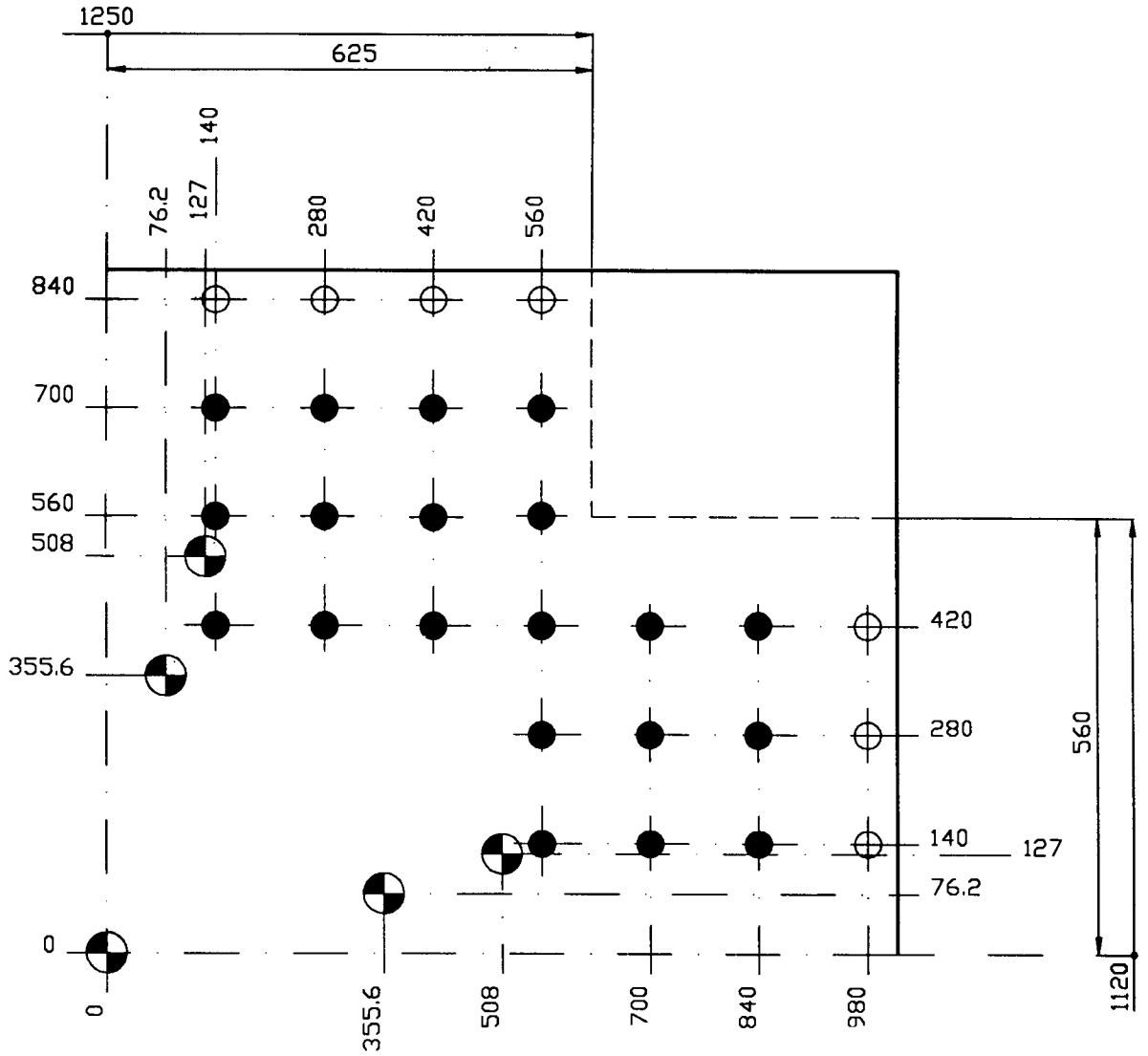
1120

S 1250/1120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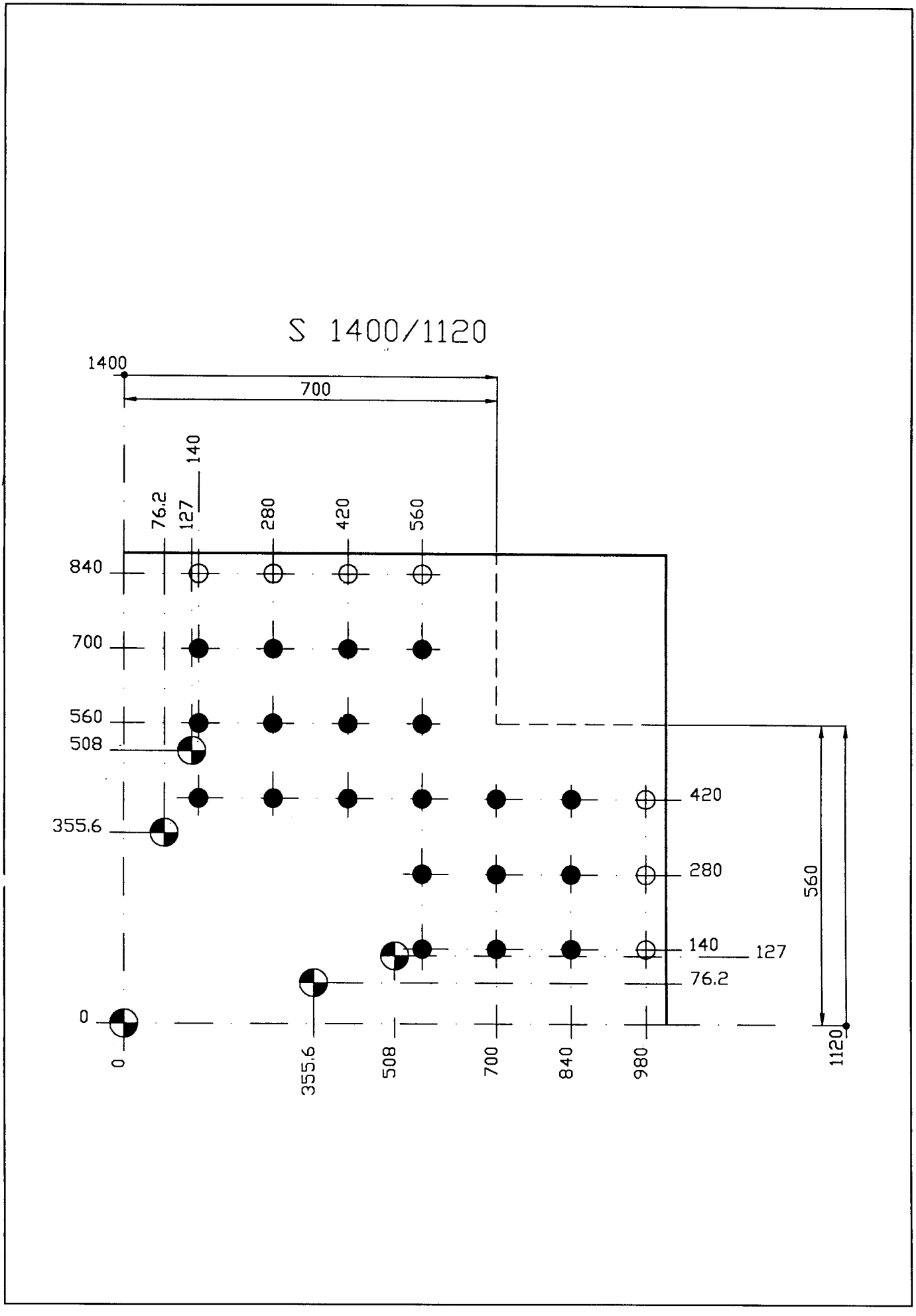
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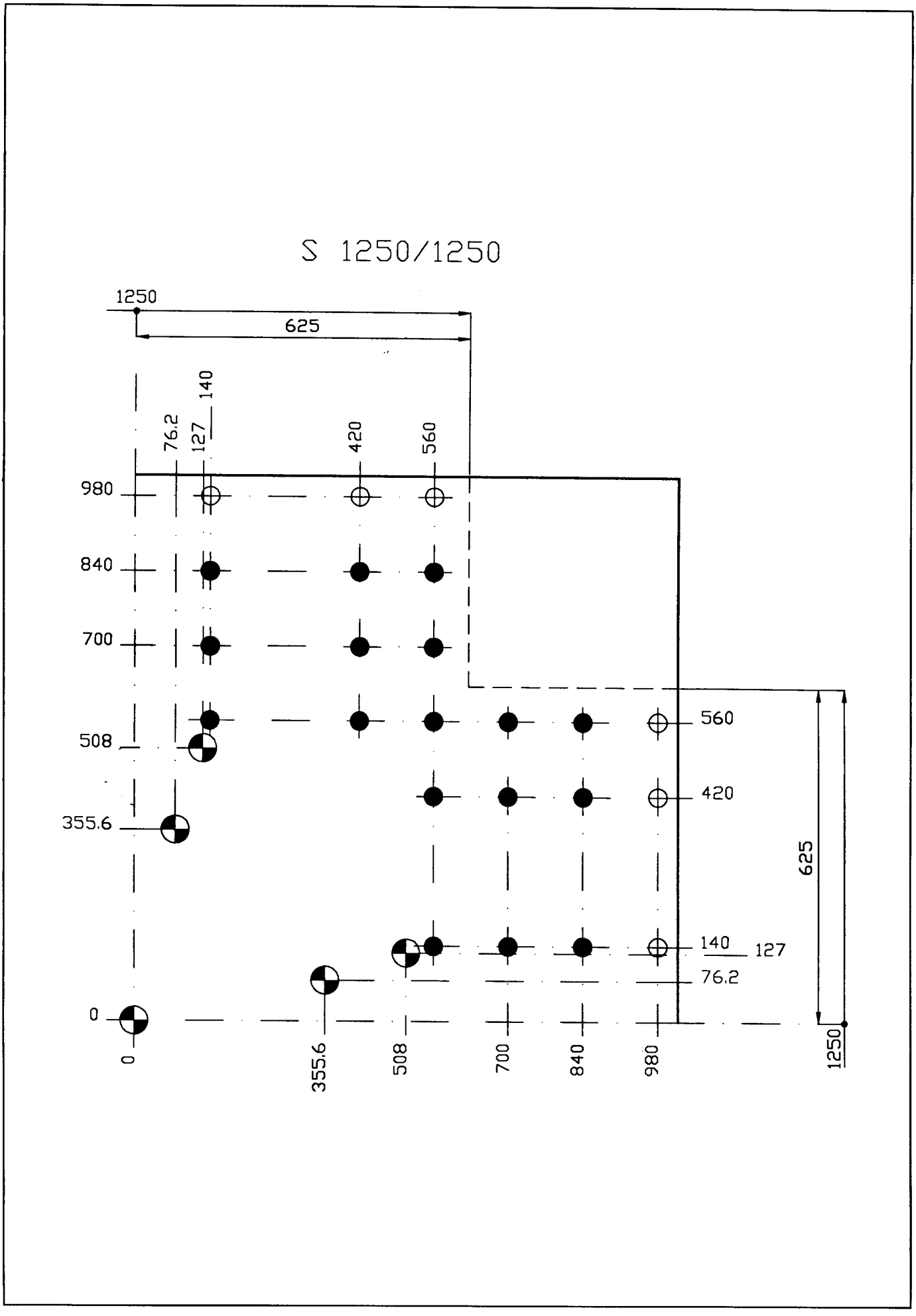
S 1250/1250
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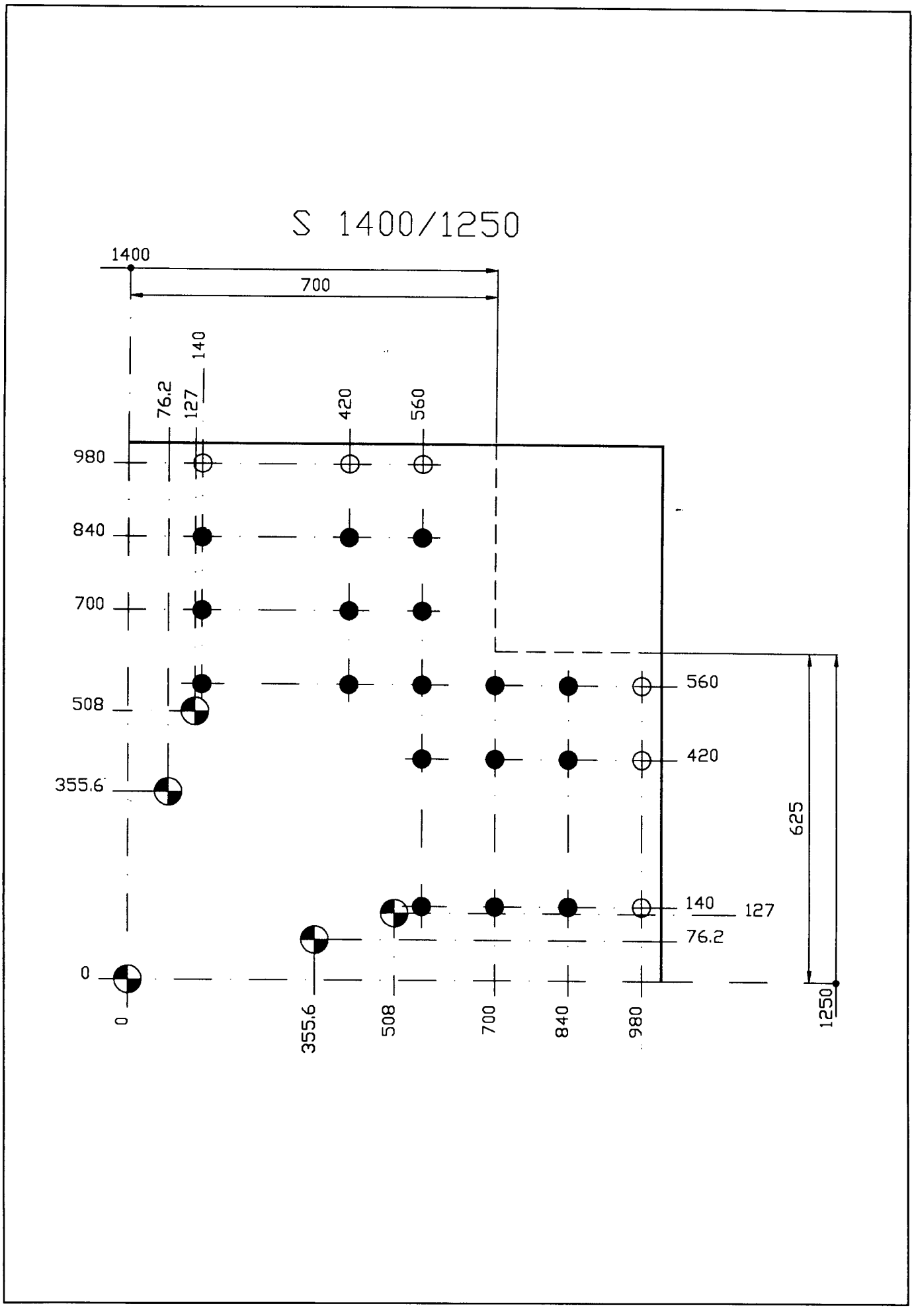
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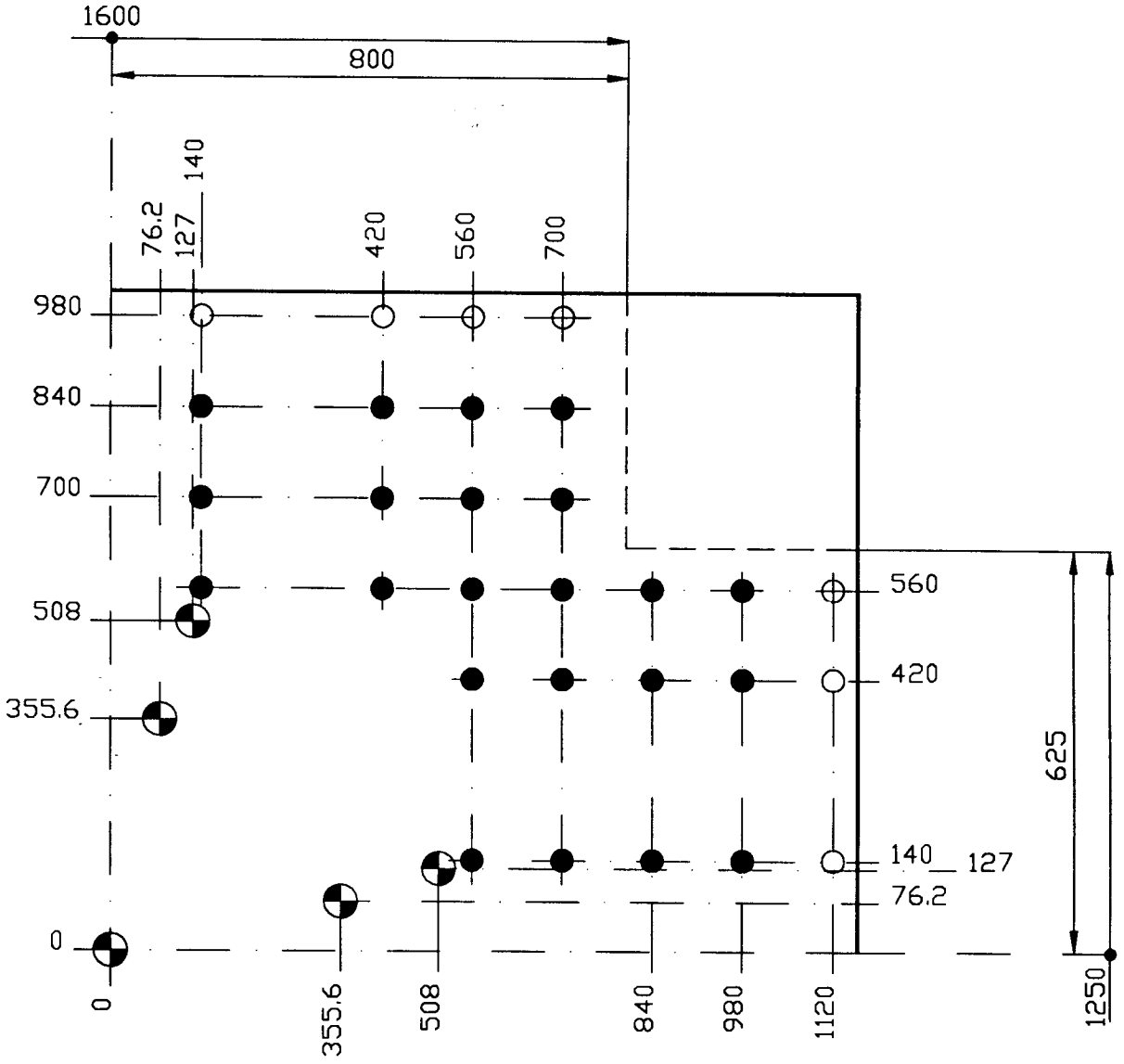
S 1600/1250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840
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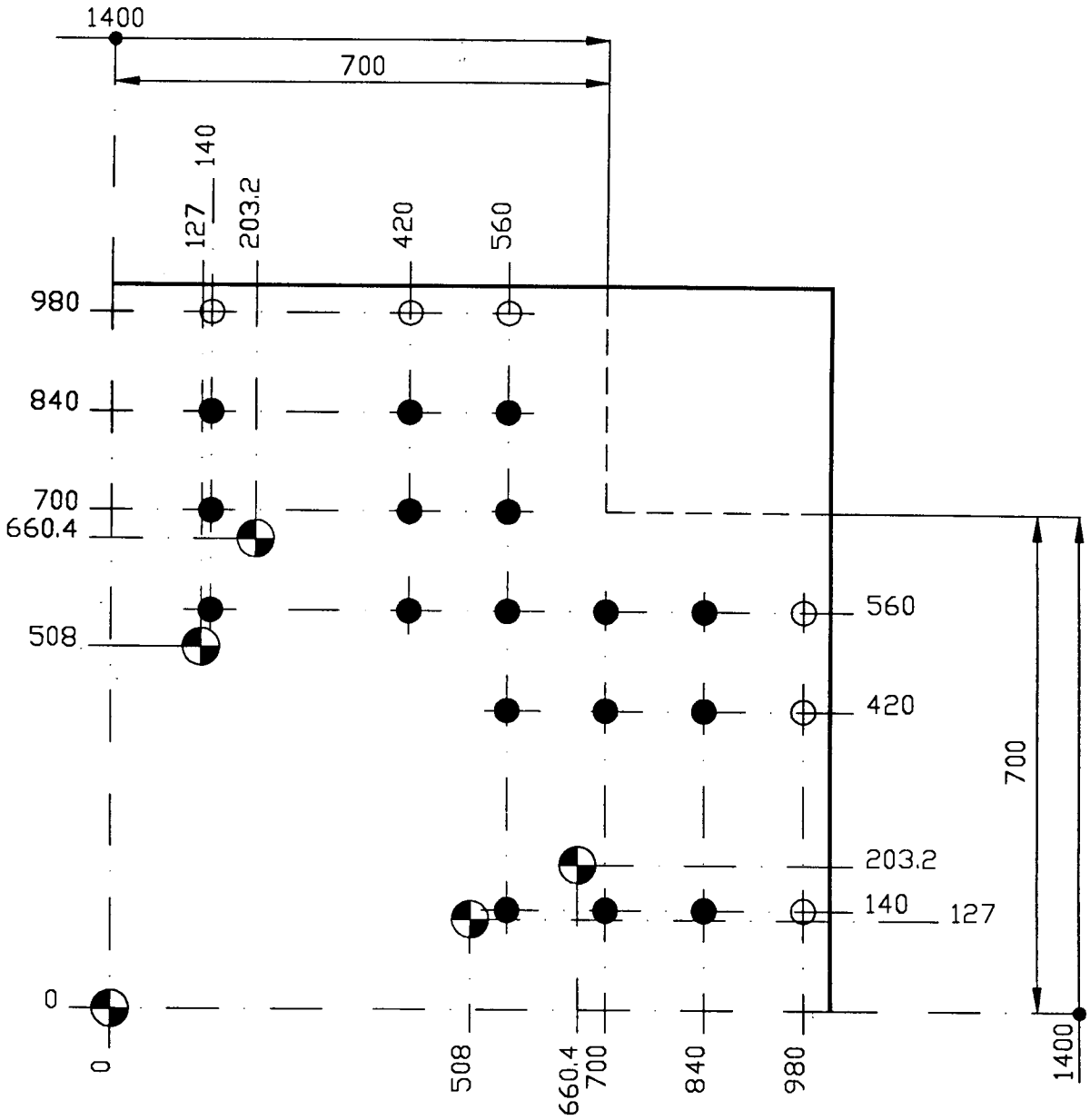
1120
1250

S 1400/1400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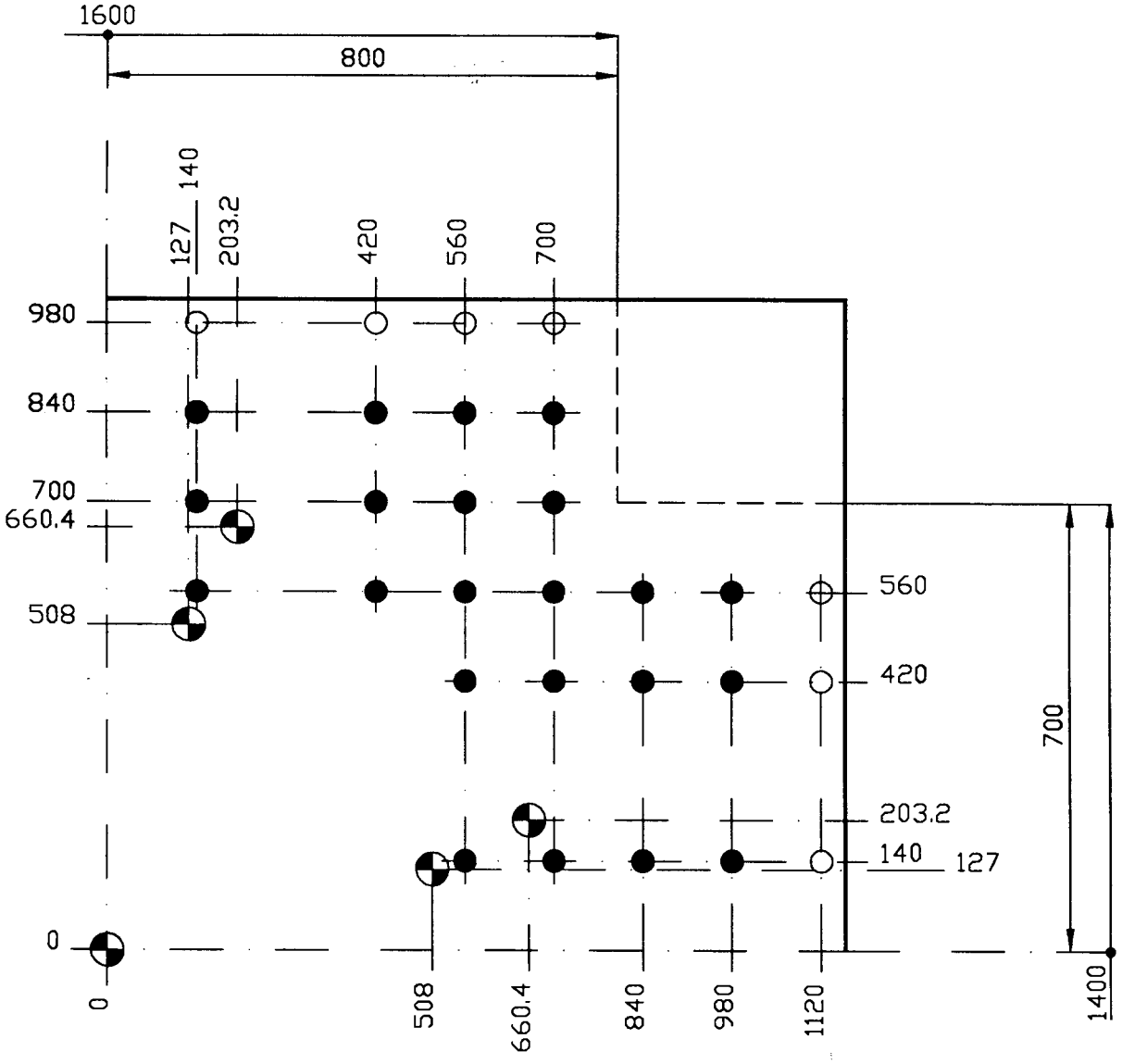
1400

S 1600/1400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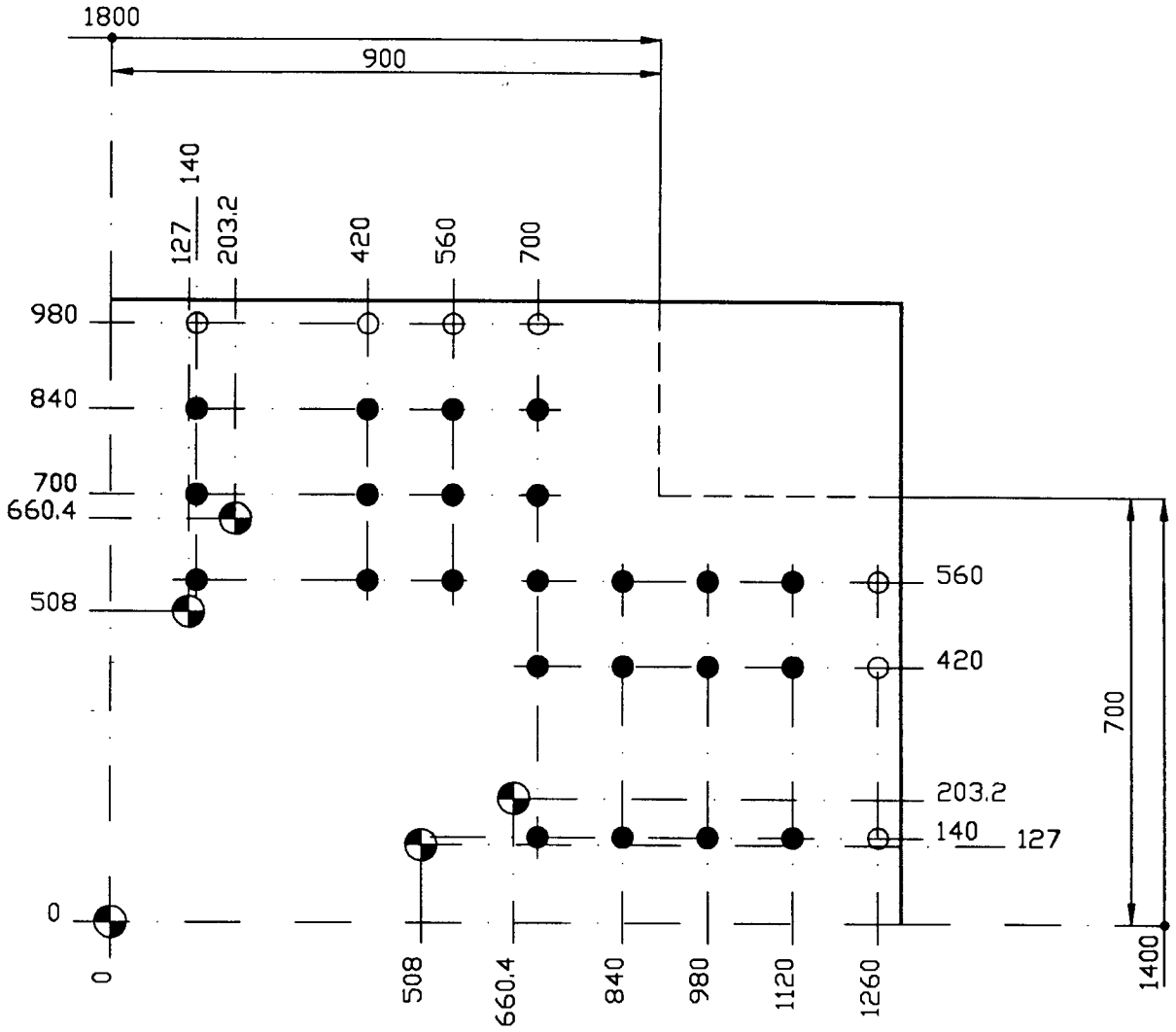
S 1800/1400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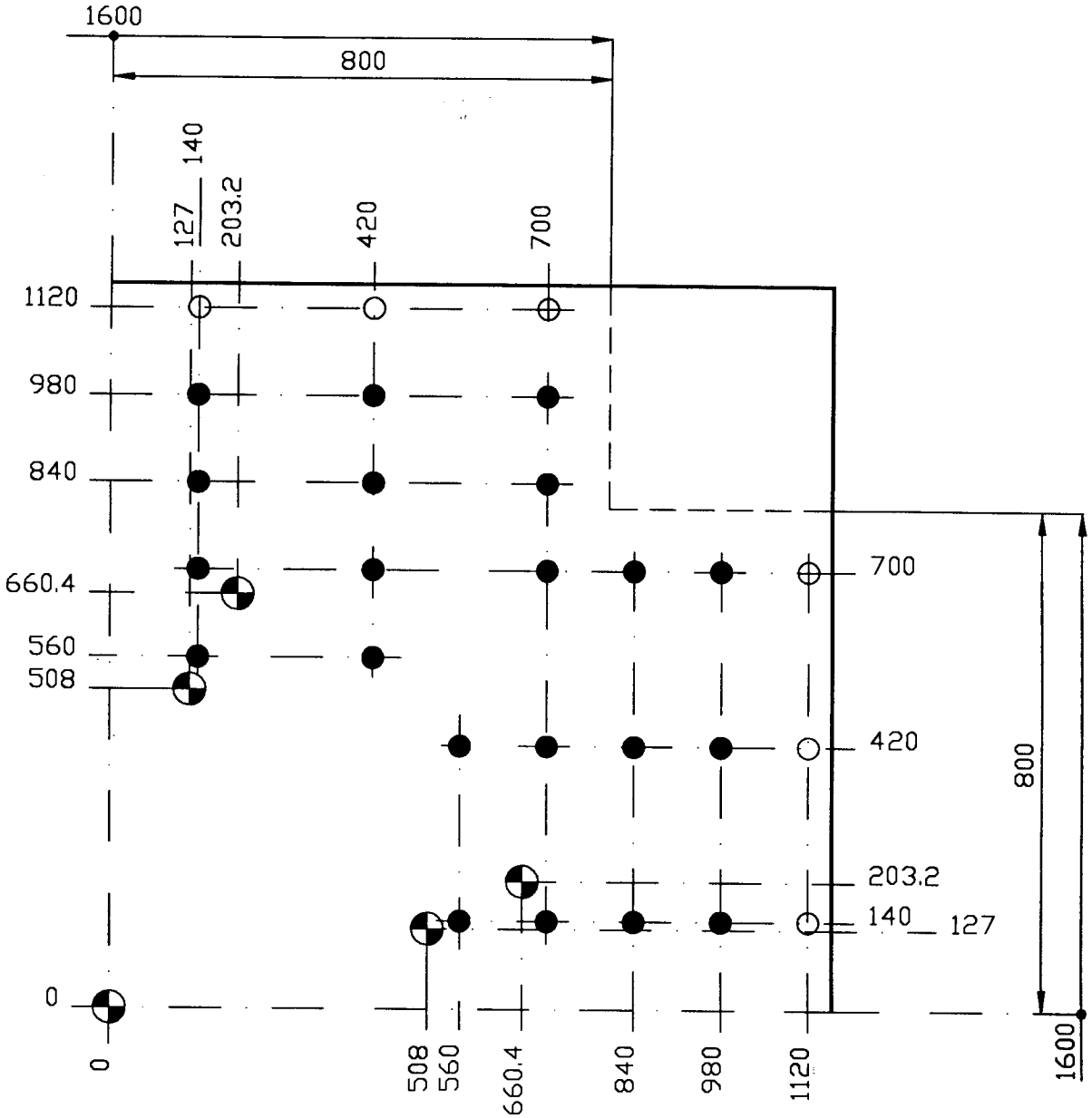
1400

S 1600/1600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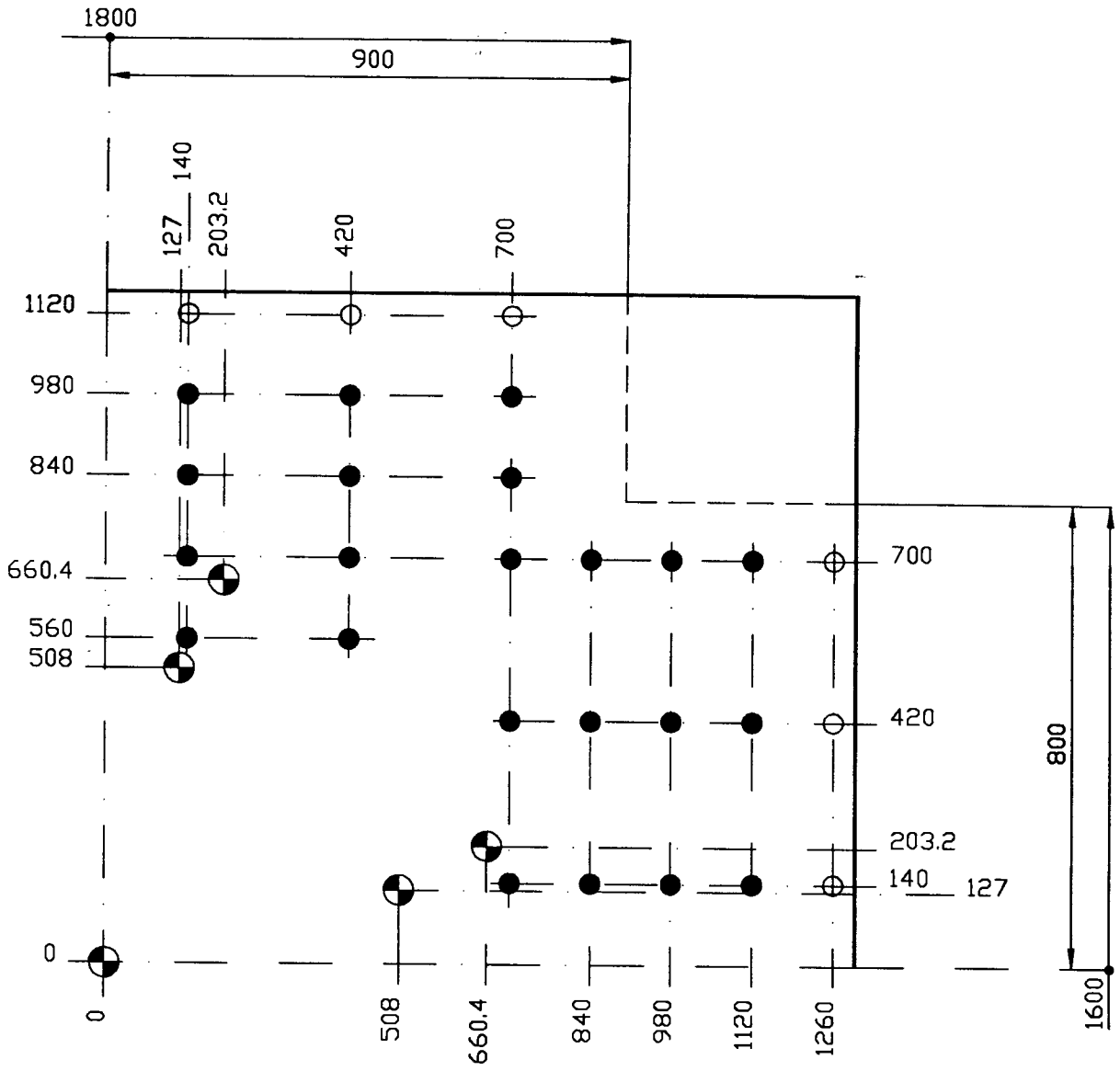
1120
1600

S 1800/1600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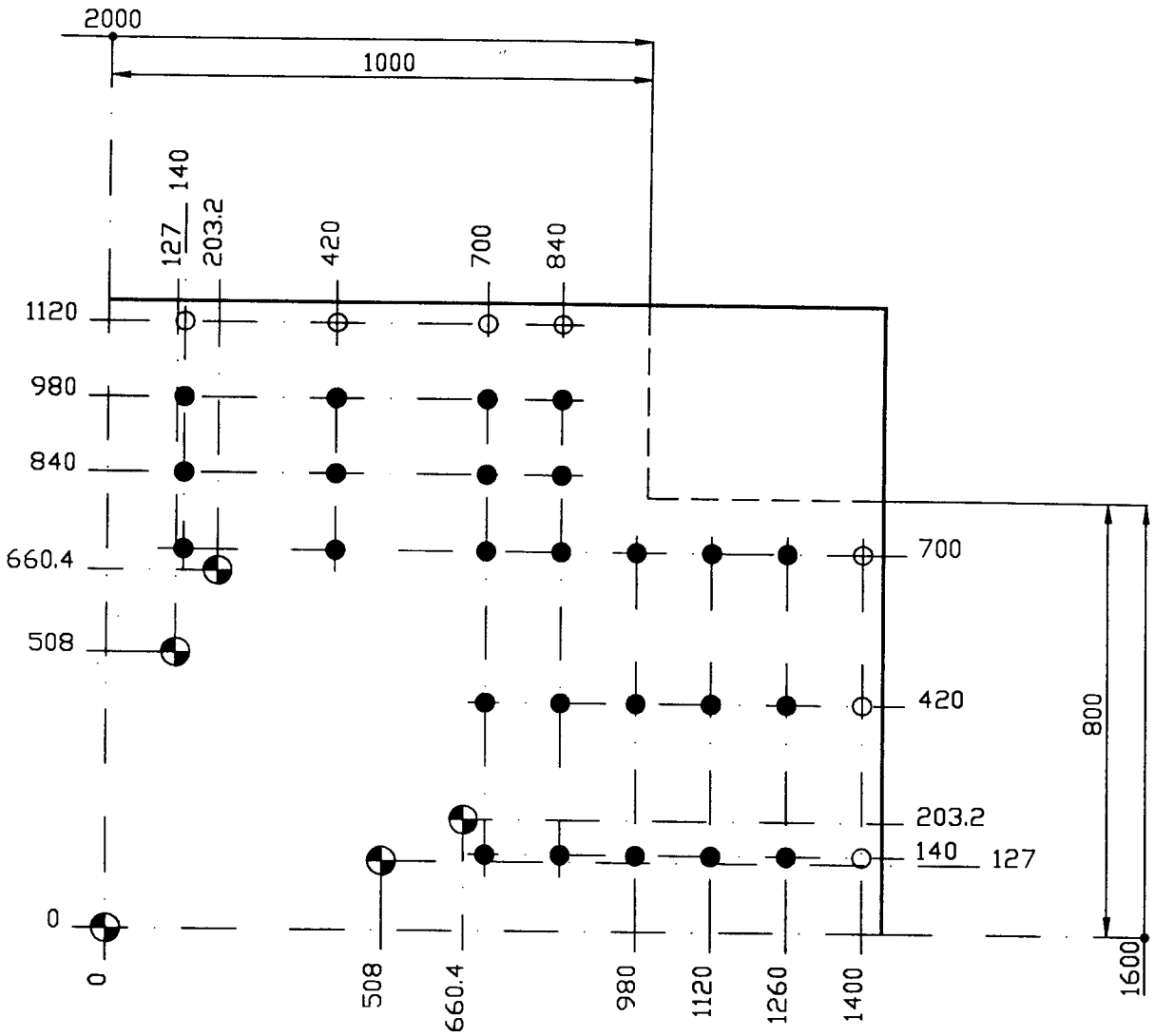
1600

S 2000/1600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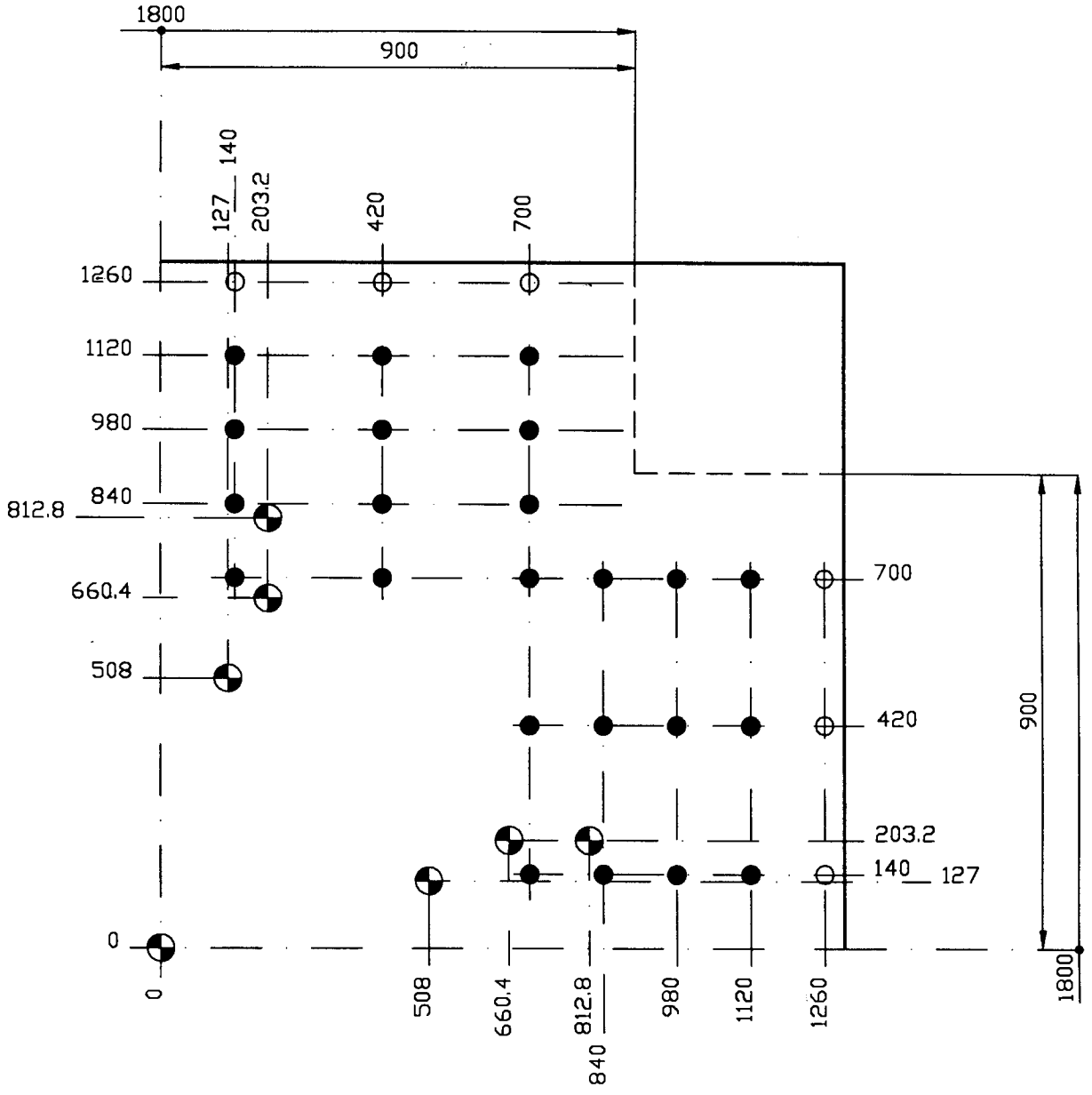
S 1800/1800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812.8
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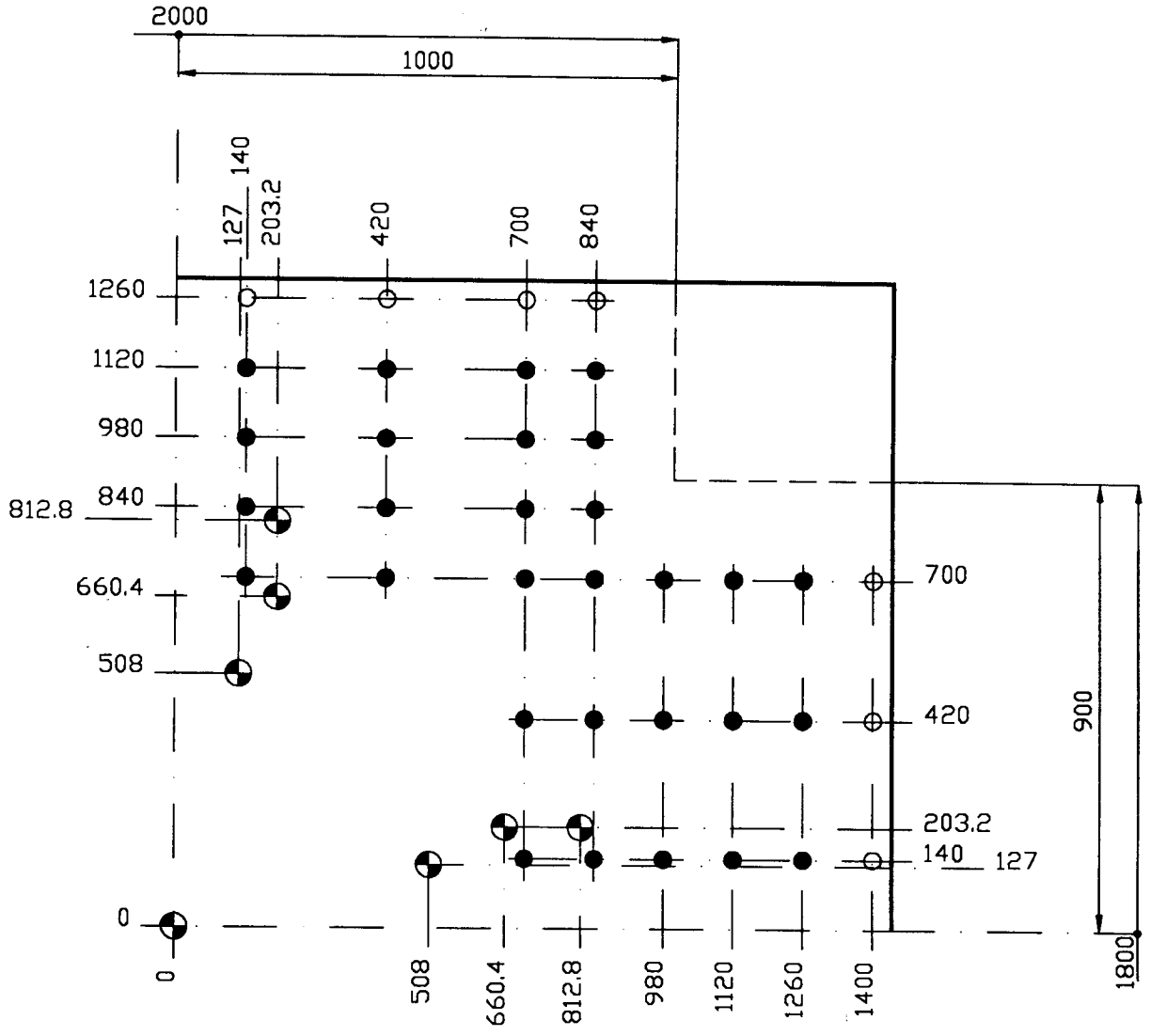
1260

S 2000/1800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1120
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660.4
508
700
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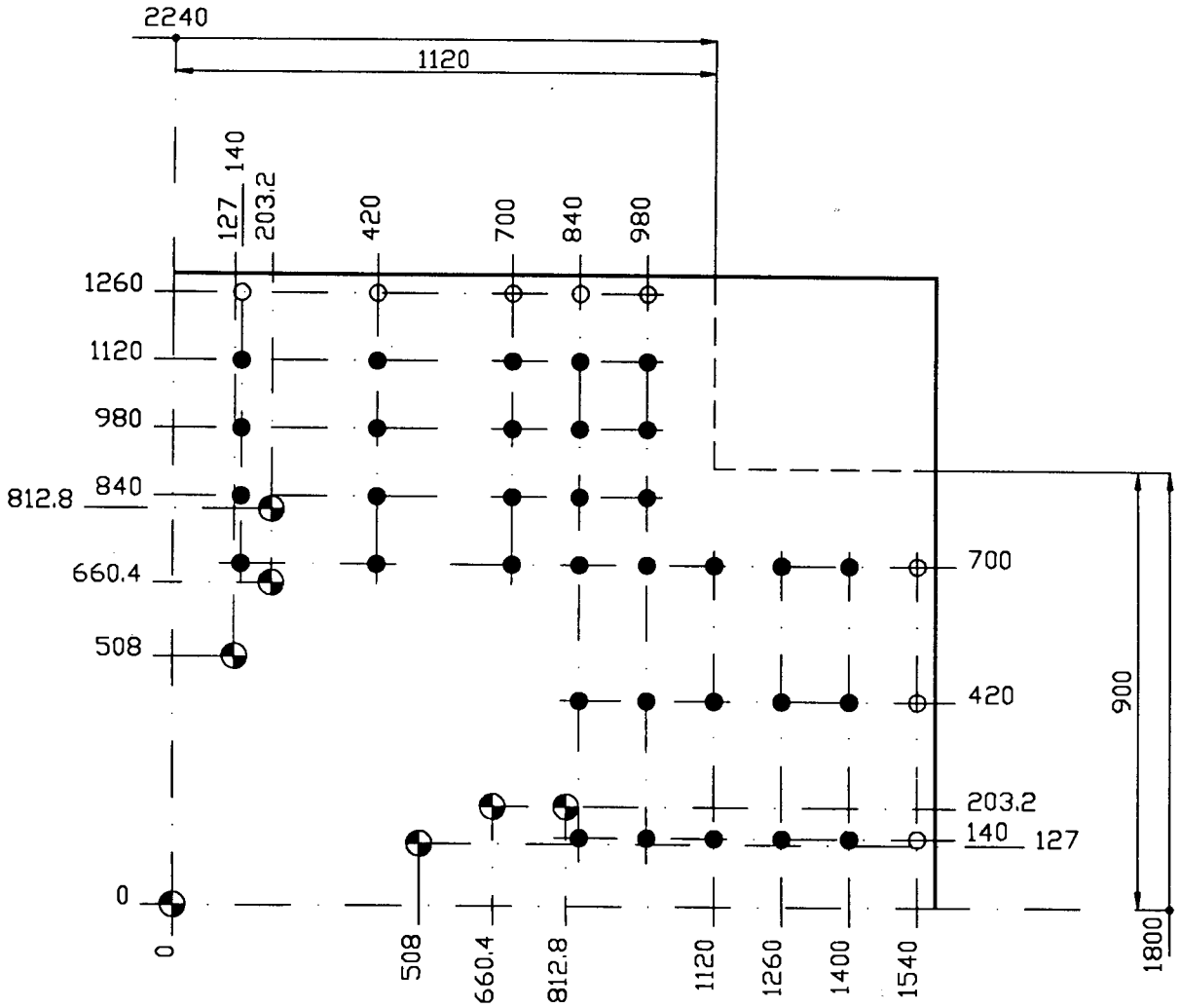
127
0
0
900
1800
508
660.4
812.8
980
1120
1260
1400

S 2240/1800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203.2
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840
980
1260
1120
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812.8
840
660.4
508
0
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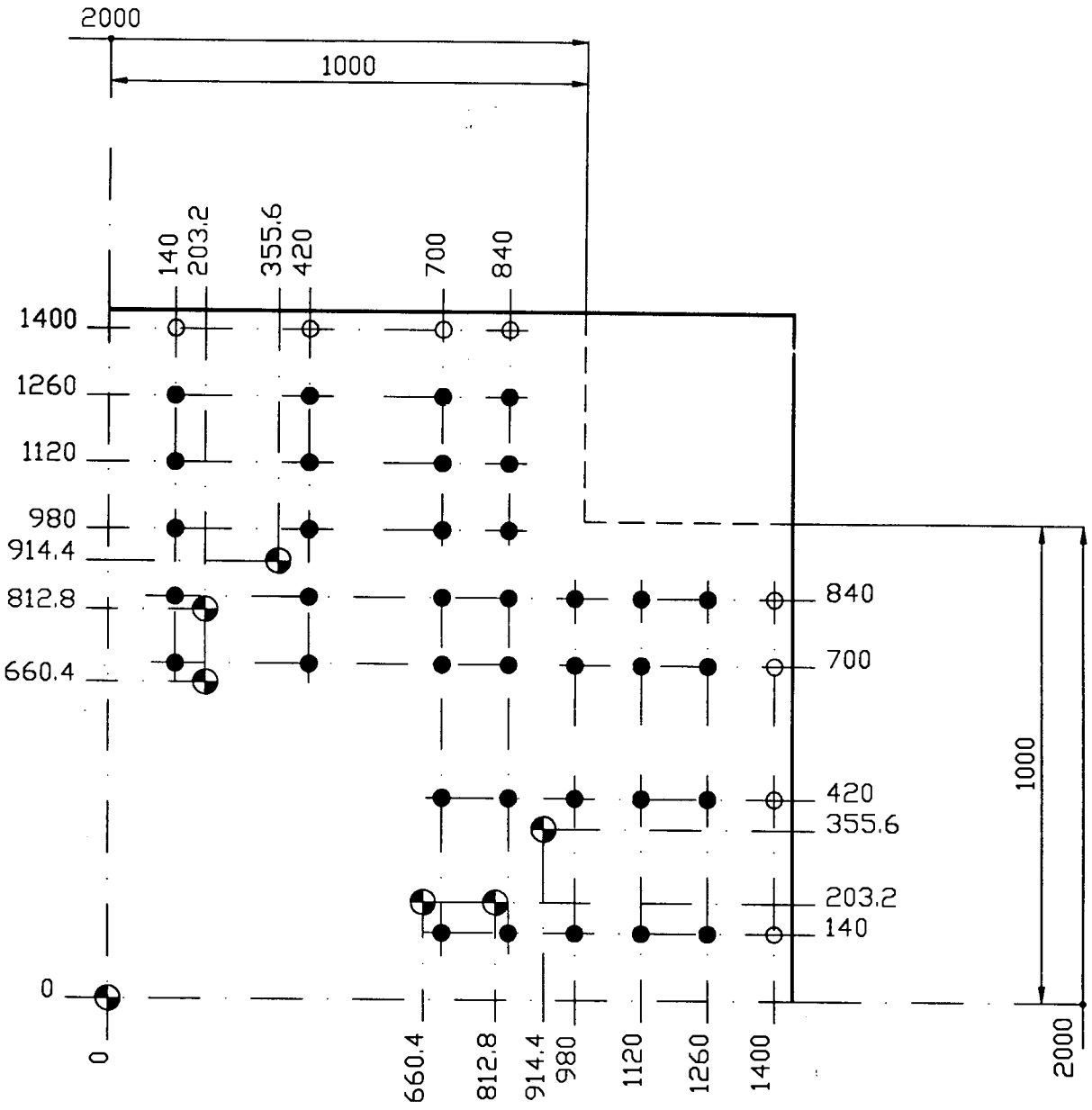
127
900
1800
0
508
660.4
812.8
1120
1260
1400
1540

S 2000/2000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1120
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914.4
812.8
660.4
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355.6
203.2
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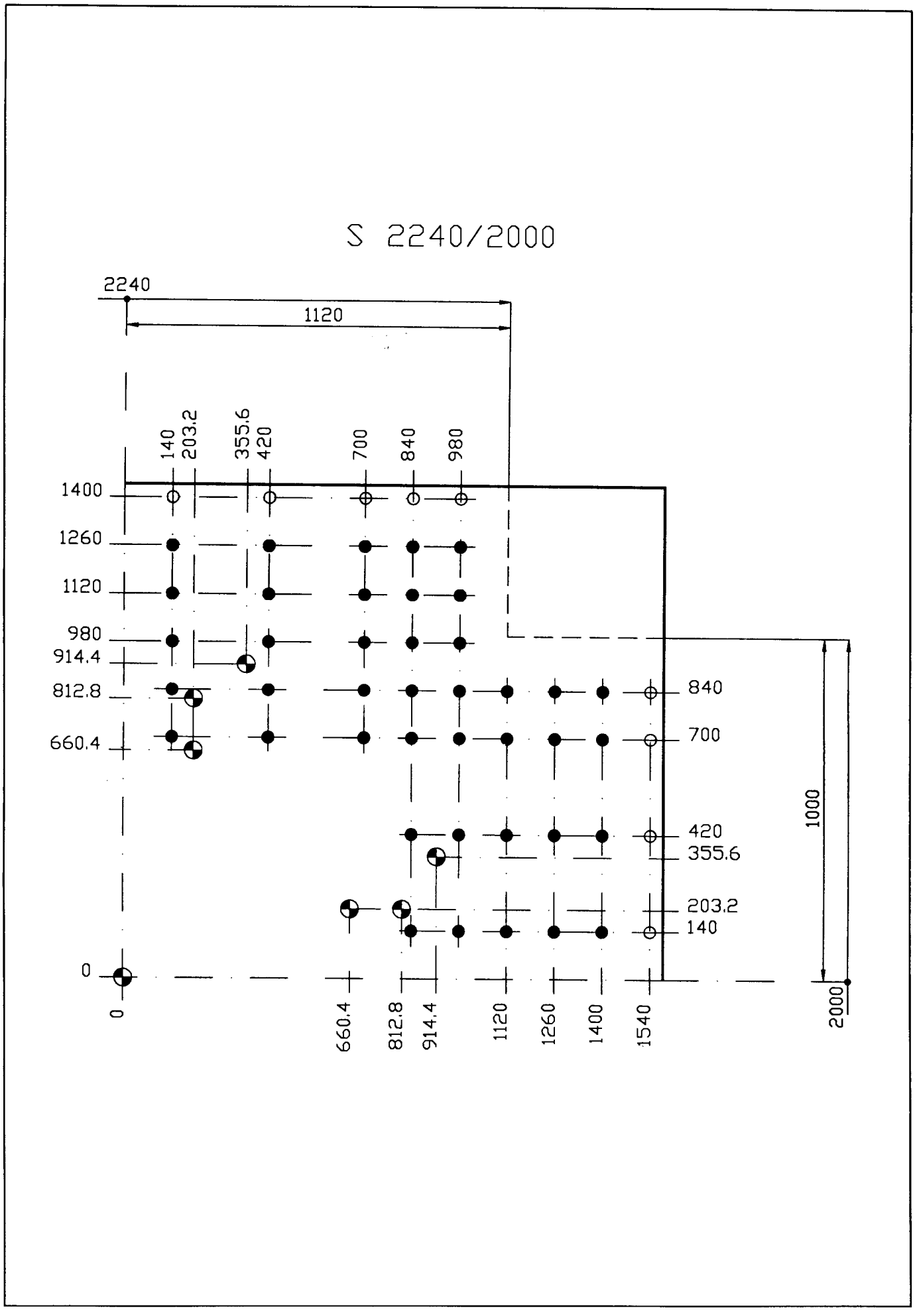
1000
2000
660.4
812.8
914.4
980
1120
1260
1400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914.4
812.8
660.4
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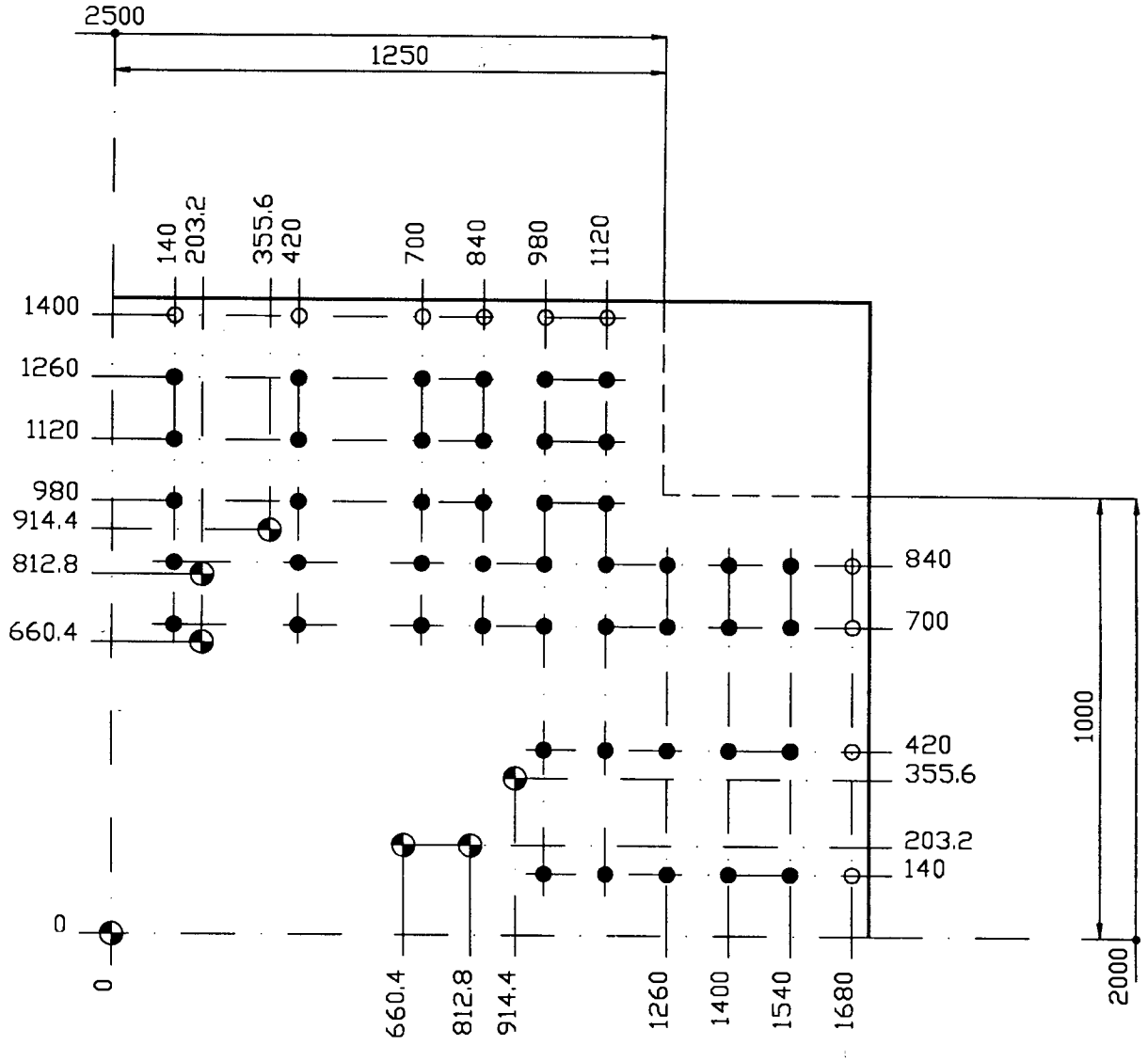
140
1000
2000

S 2500/2000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203.2
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980
1120
1400
1260
1120
980
914.4
812.8
660.4
840
700
420
355.6
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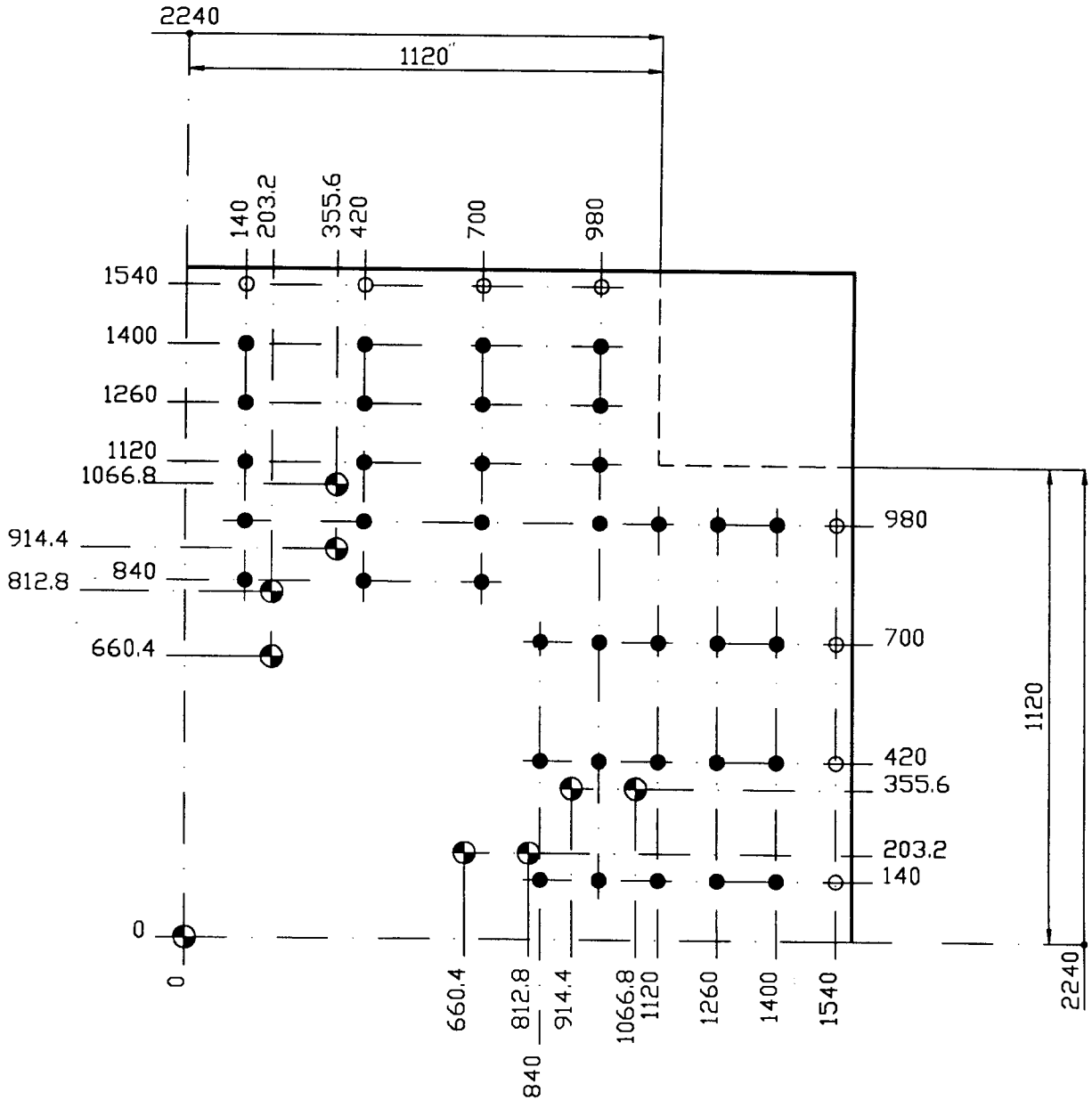
1400
1540
1680
2000

S 2240/2240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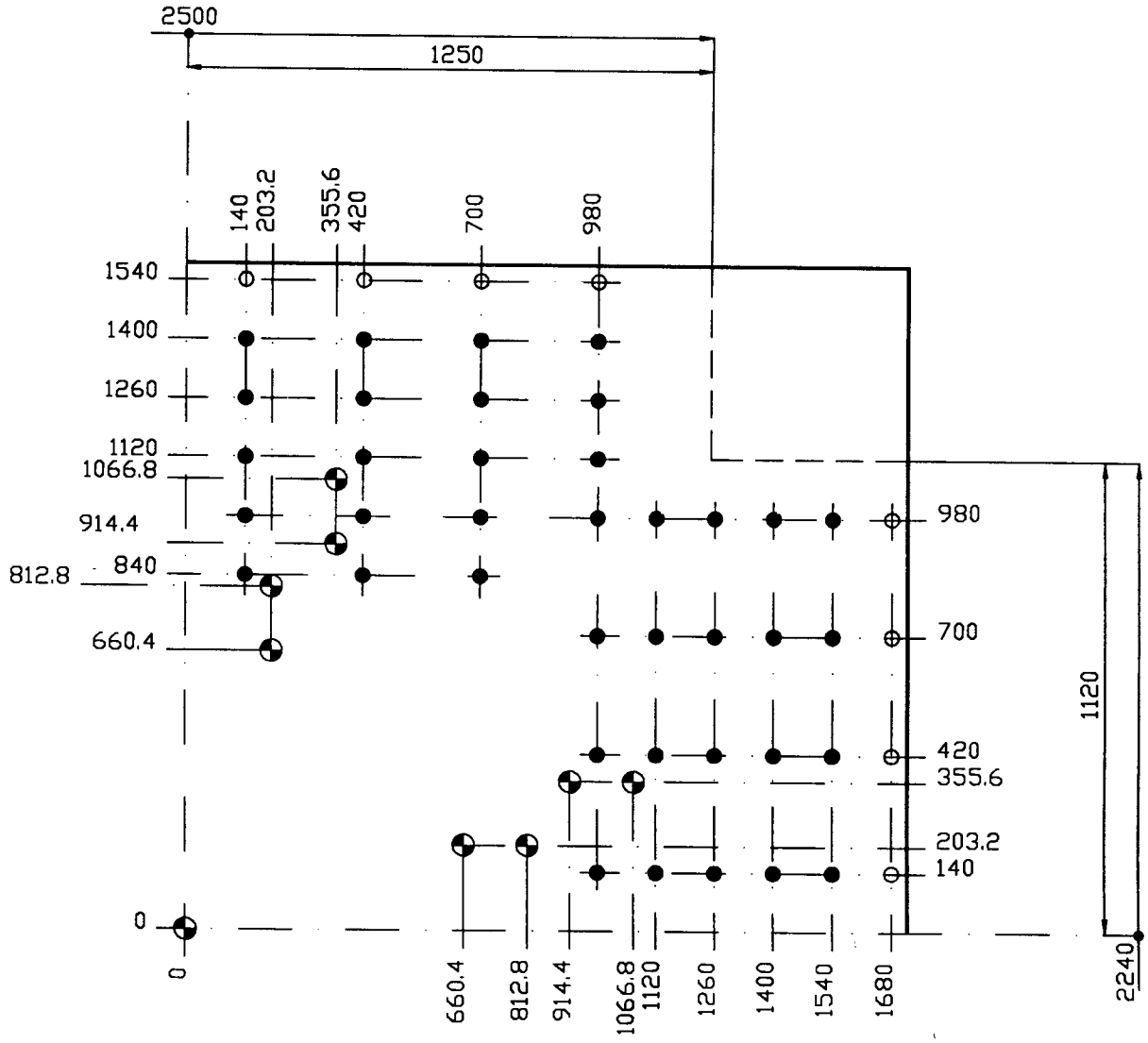
S 2500/2240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355.6
203.2
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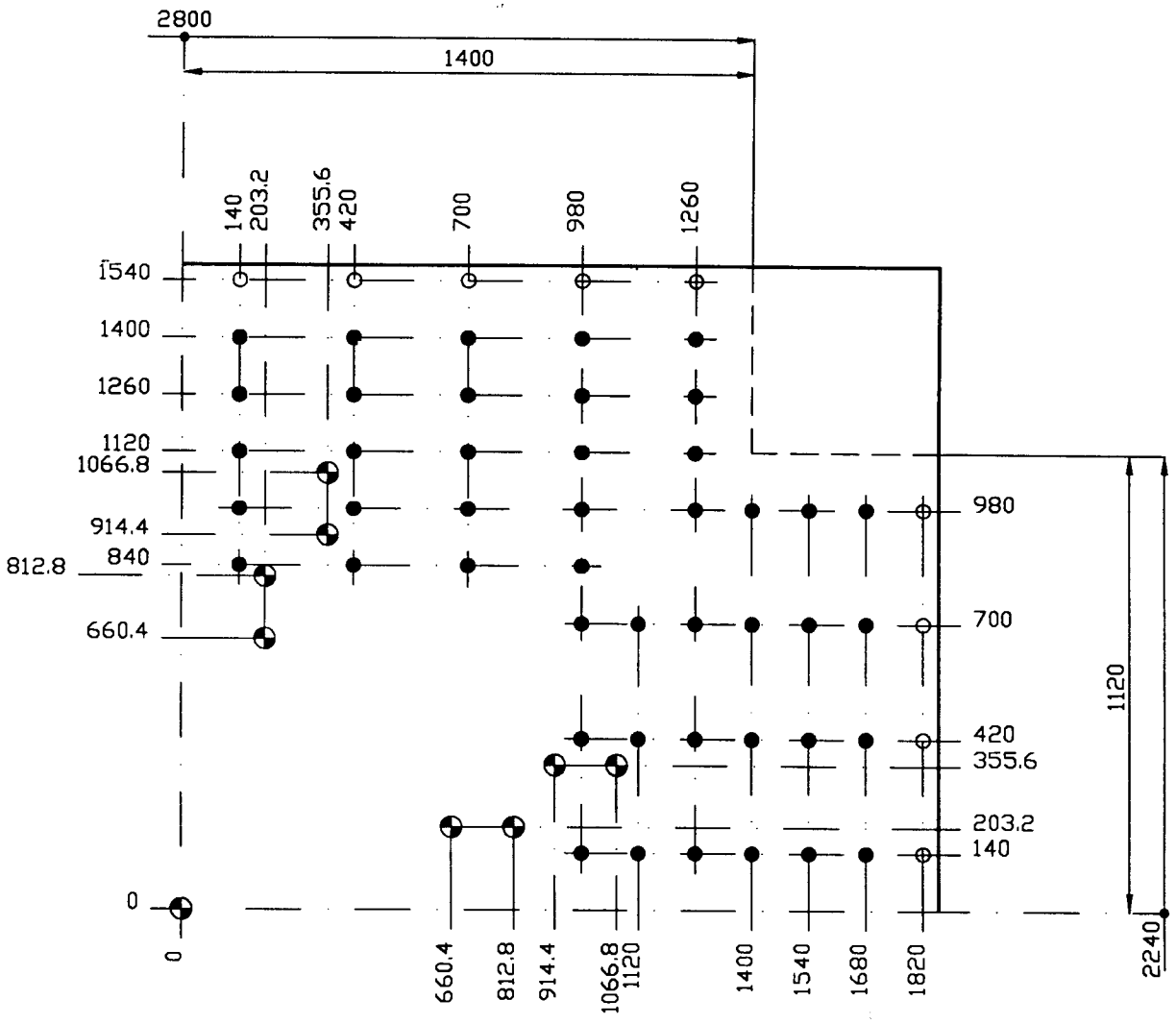
S 2800/2240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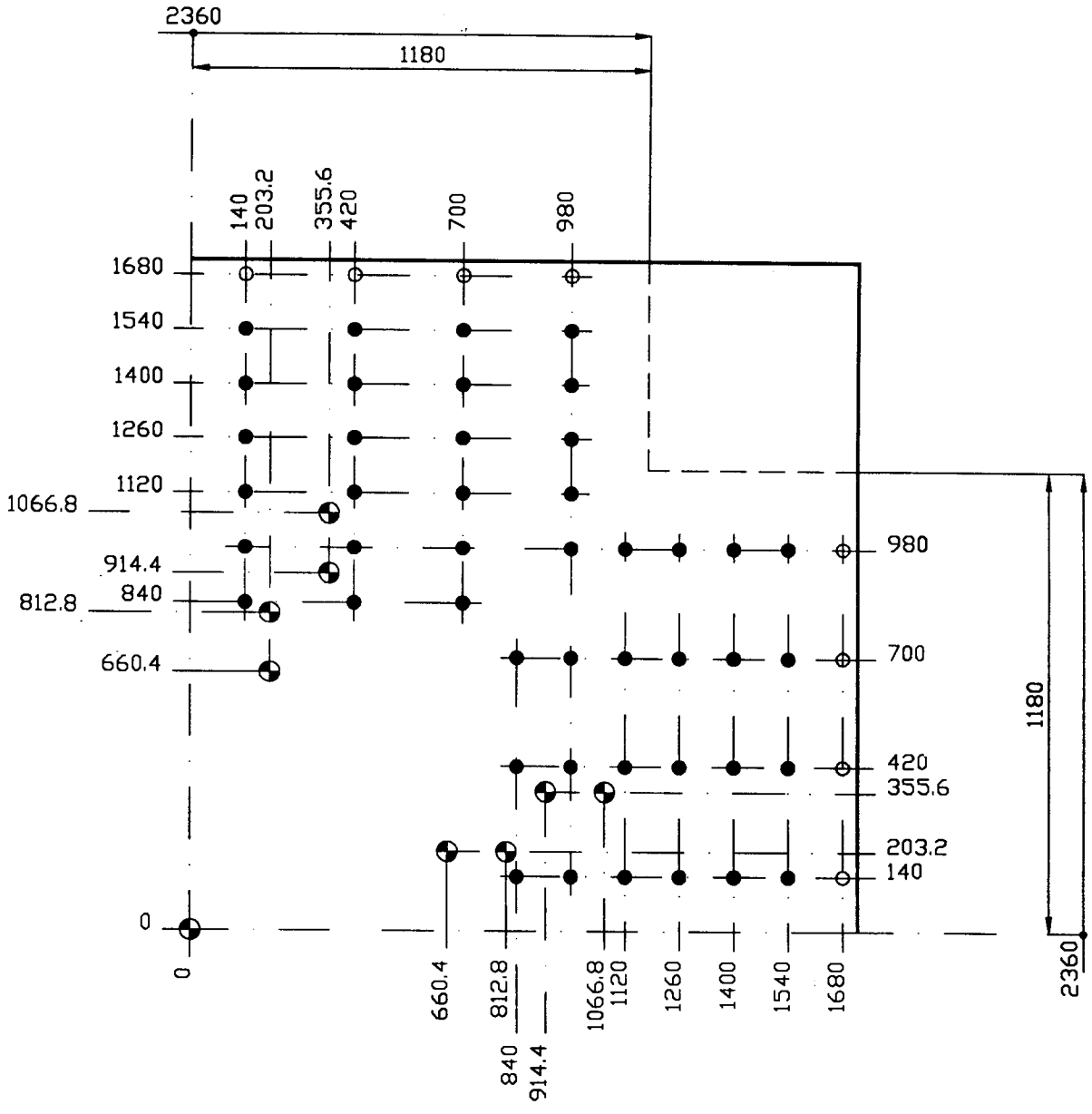
1540
1680
1820
2240

S 2360/2360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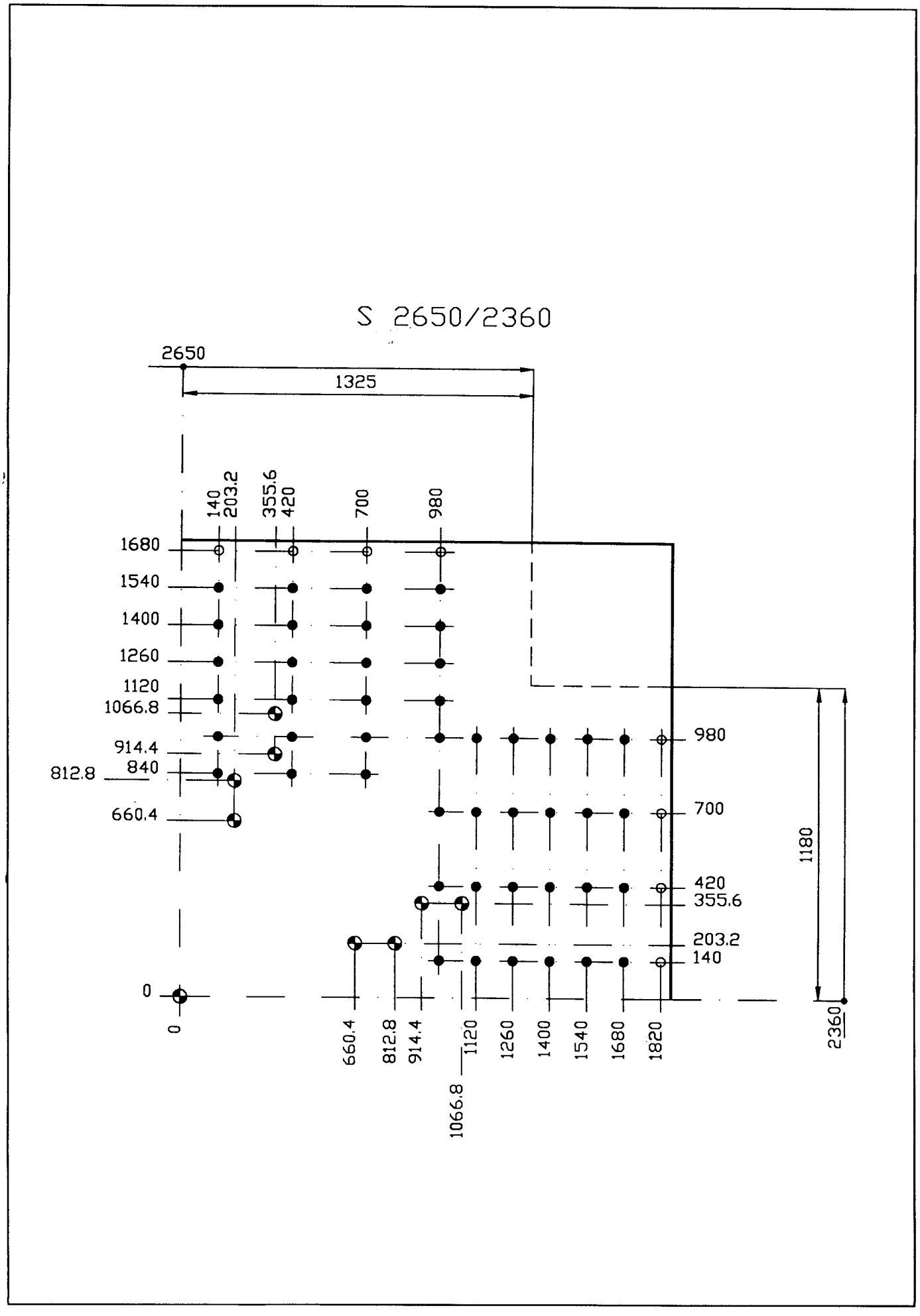
1680


S 2650/2360
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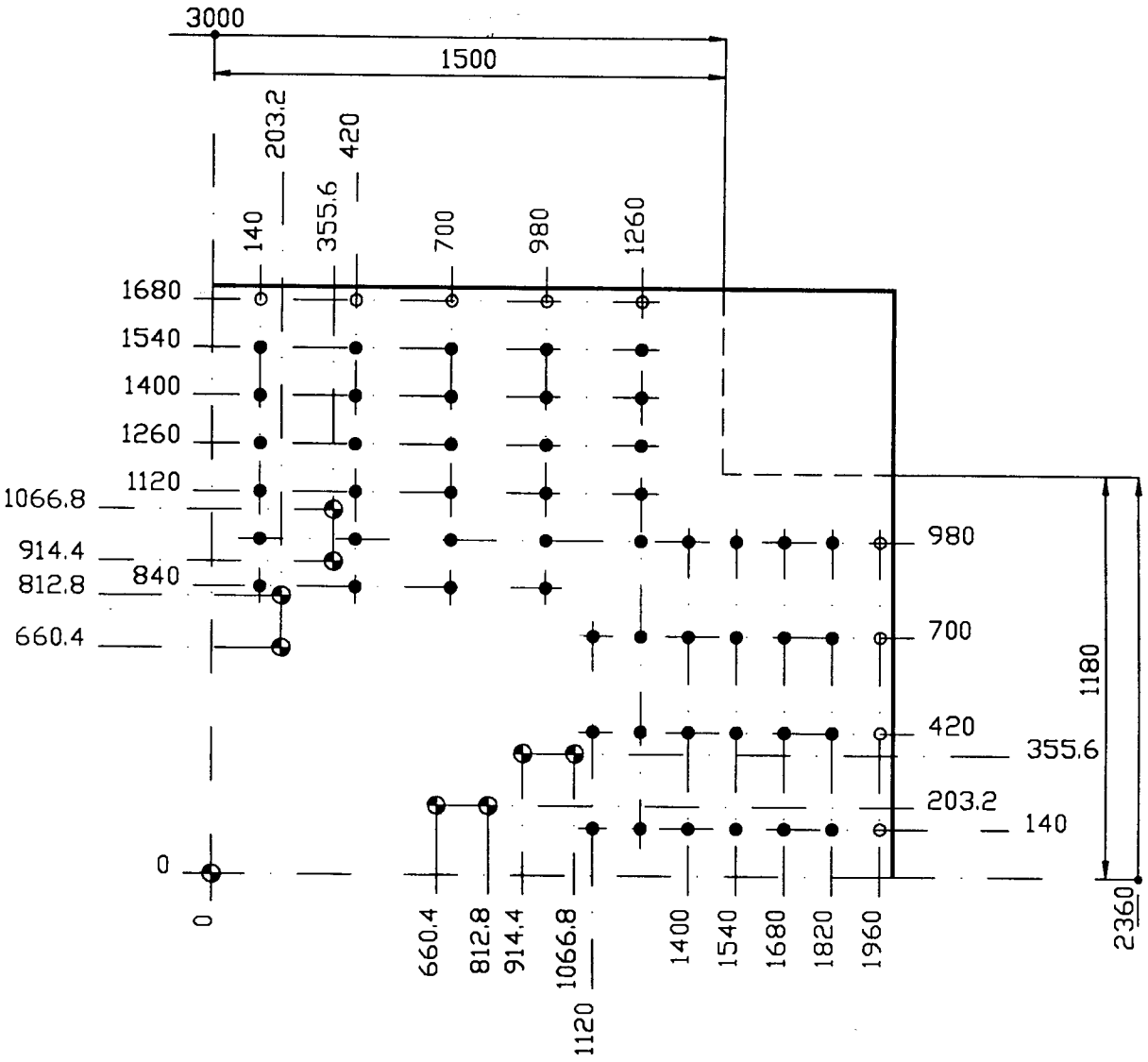
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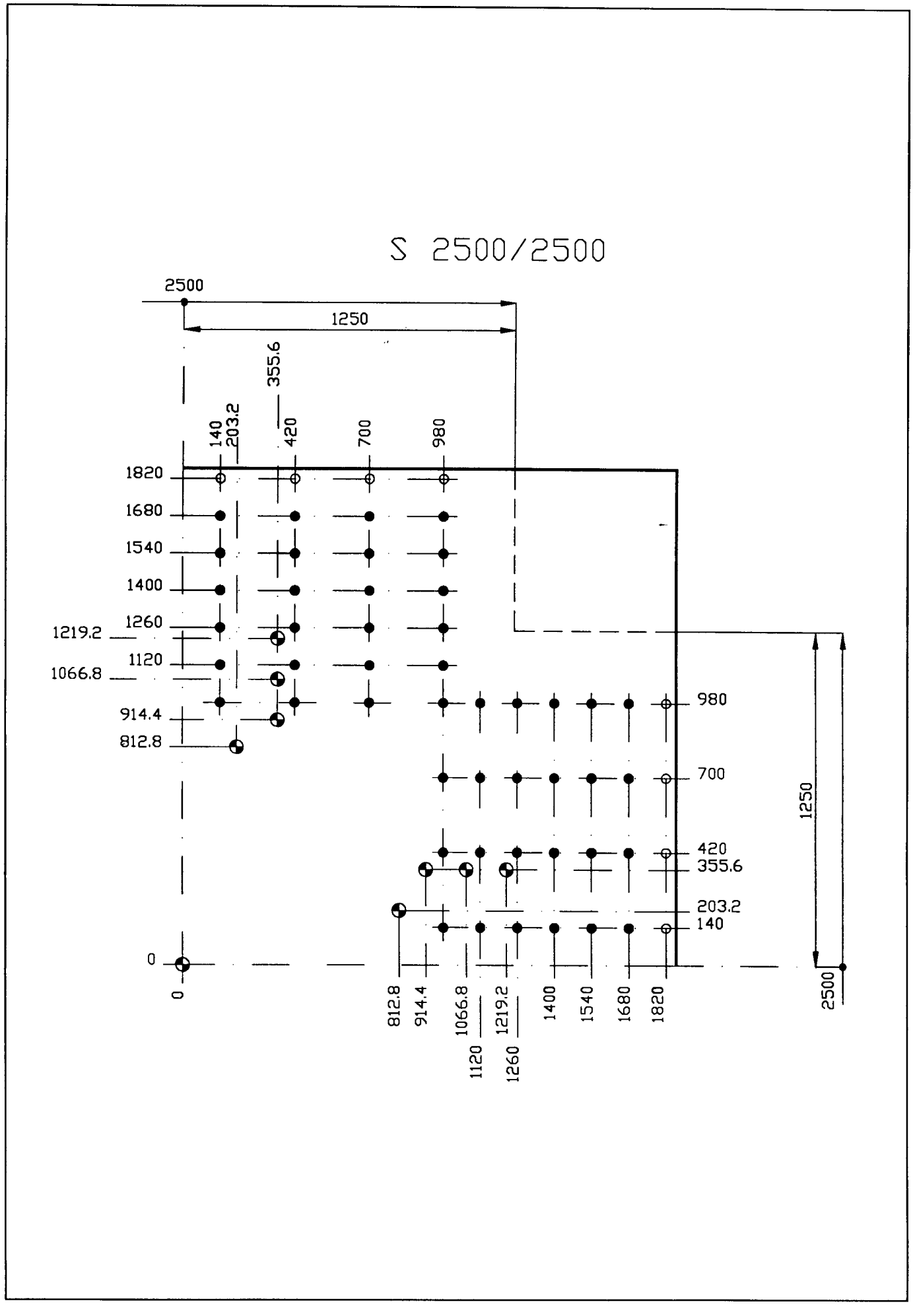
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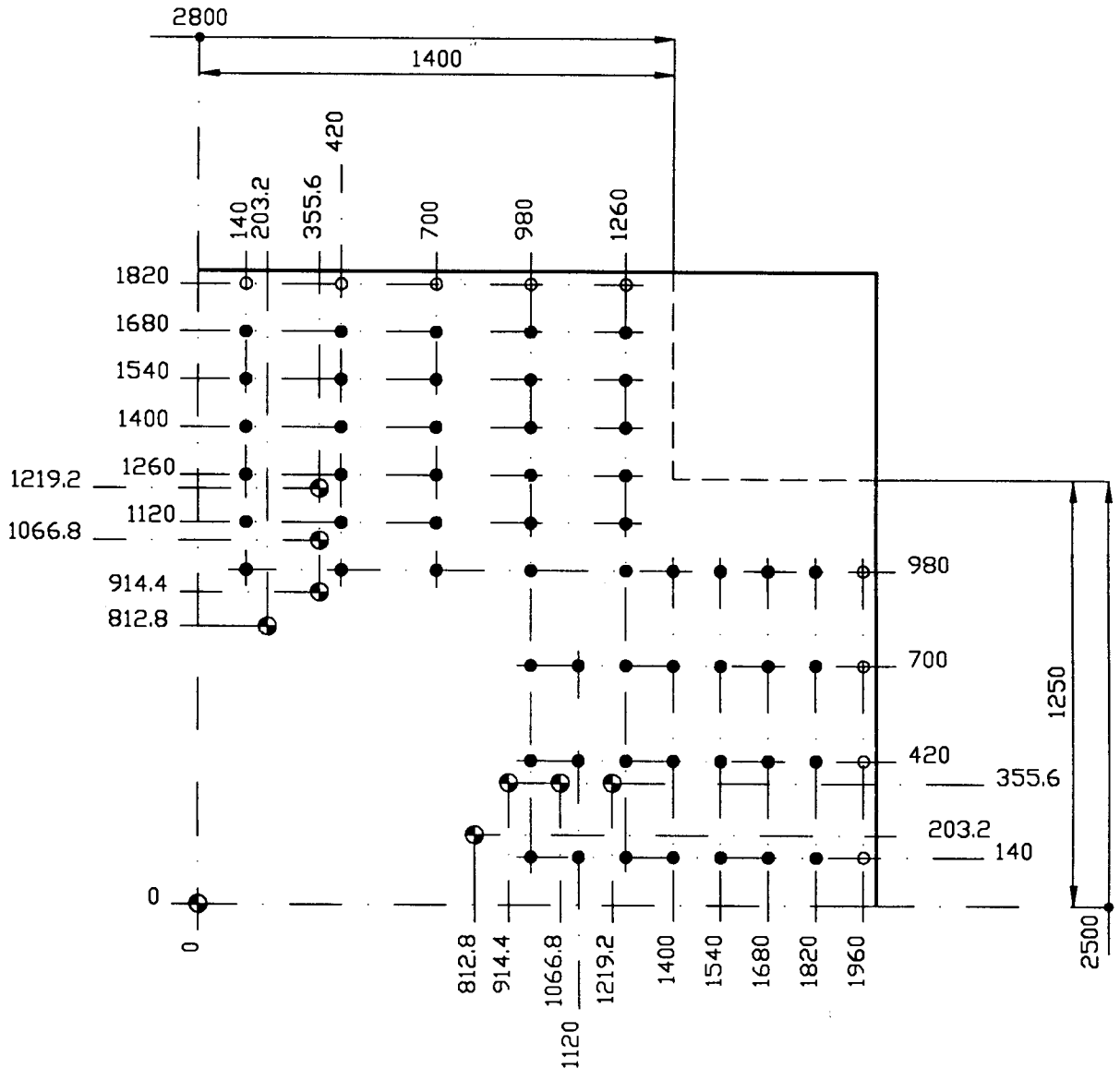
S 2800/2500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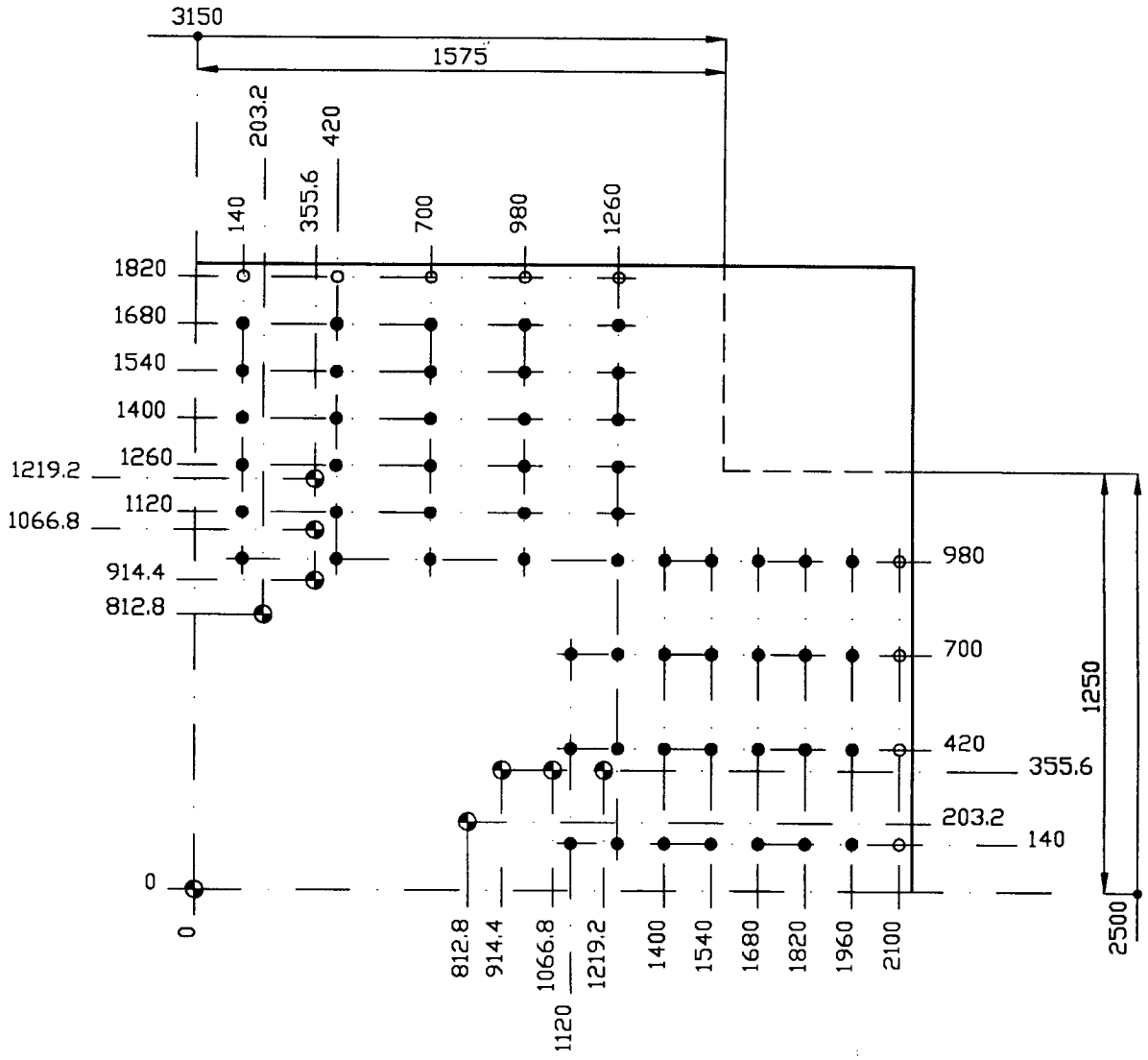
S 3150/2500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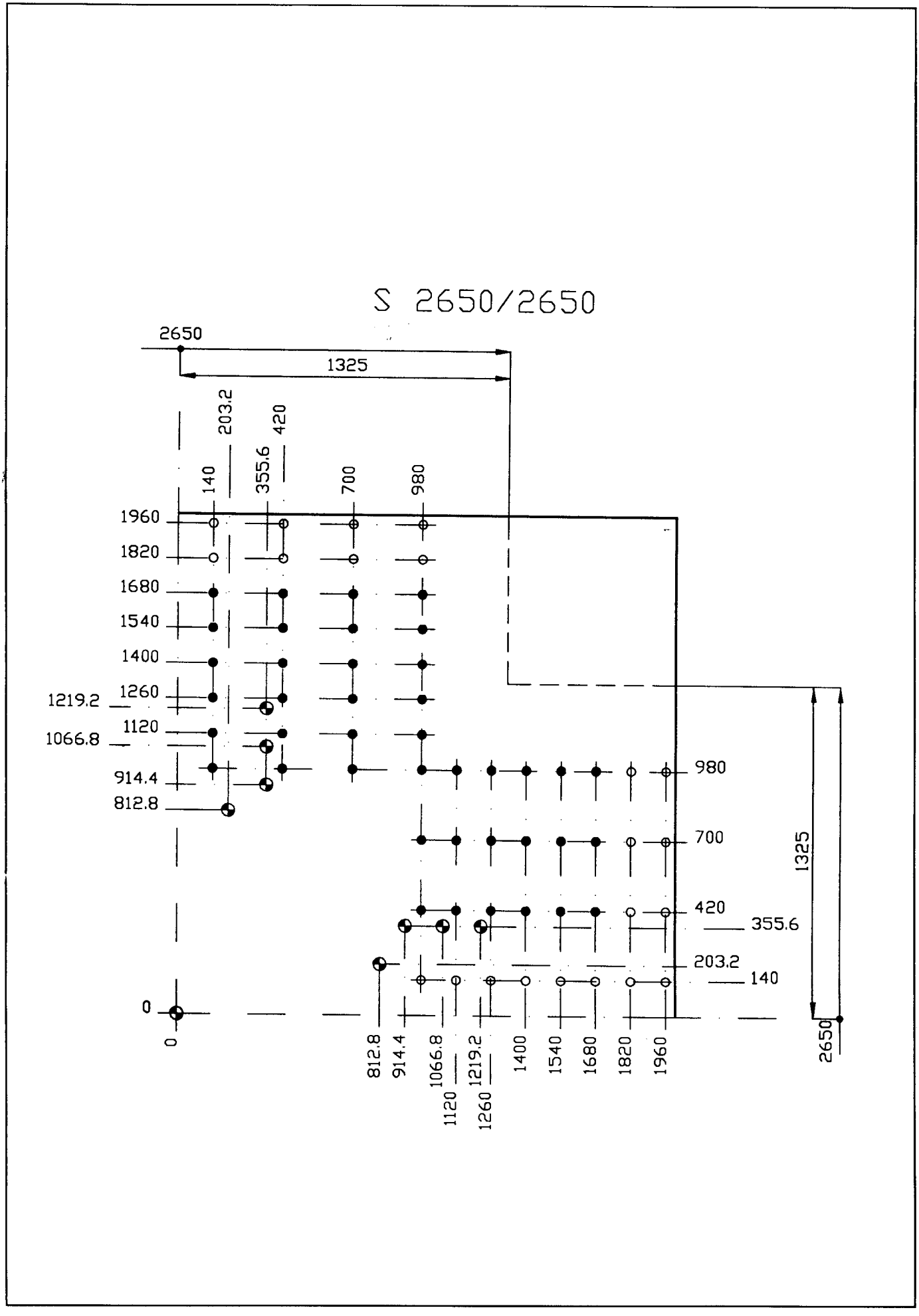
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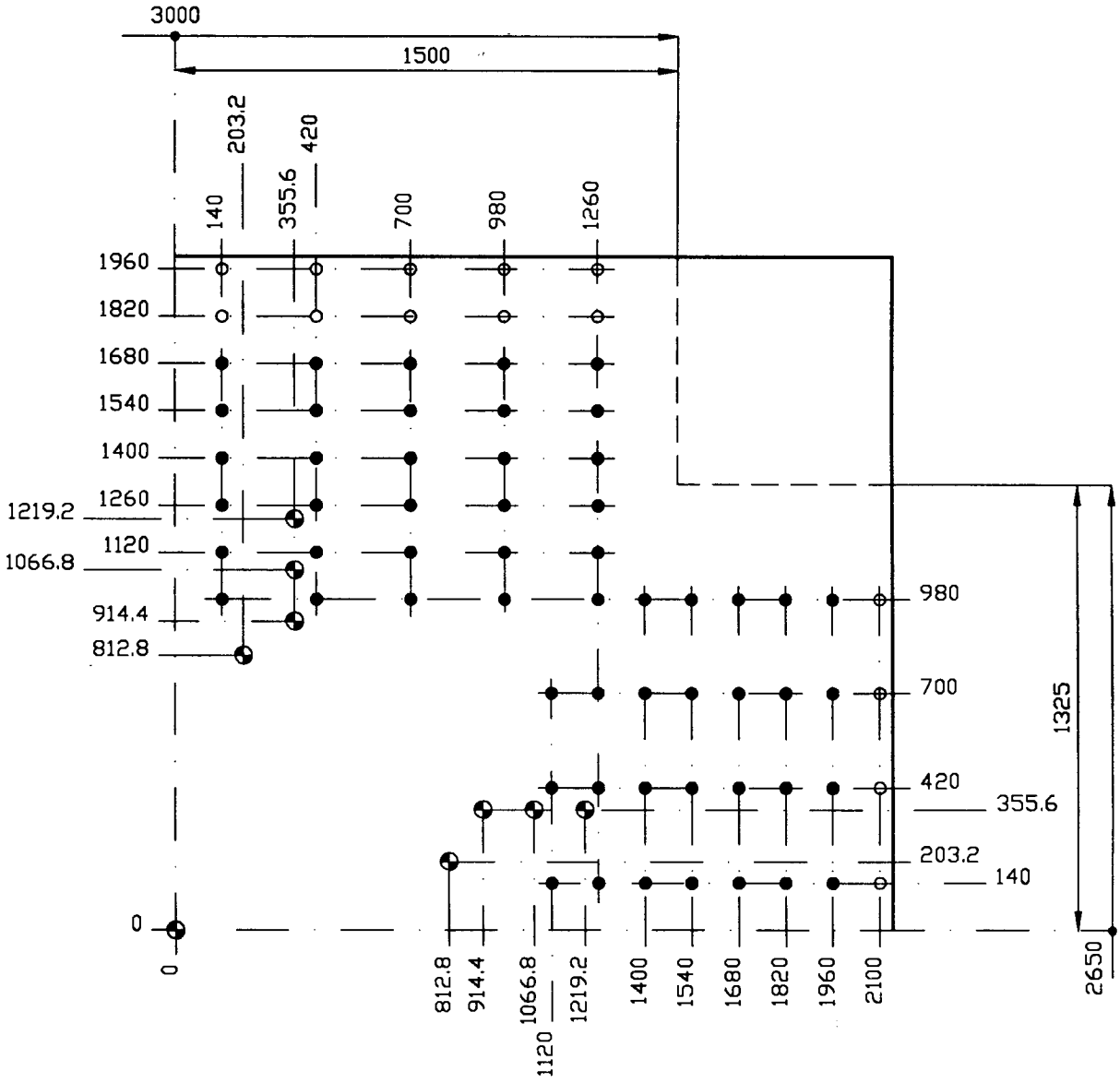
S 3000/2650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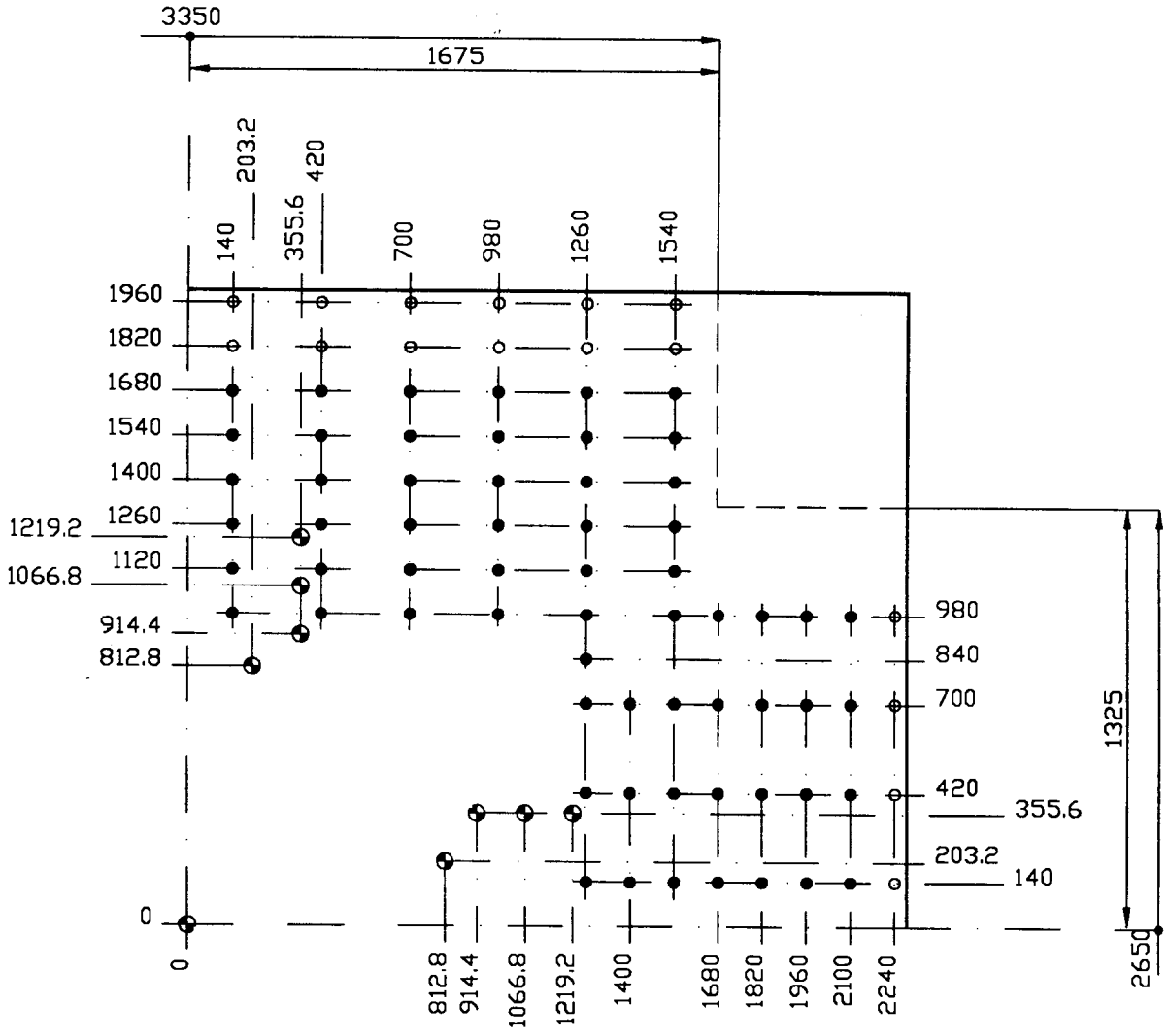
S 3350/2650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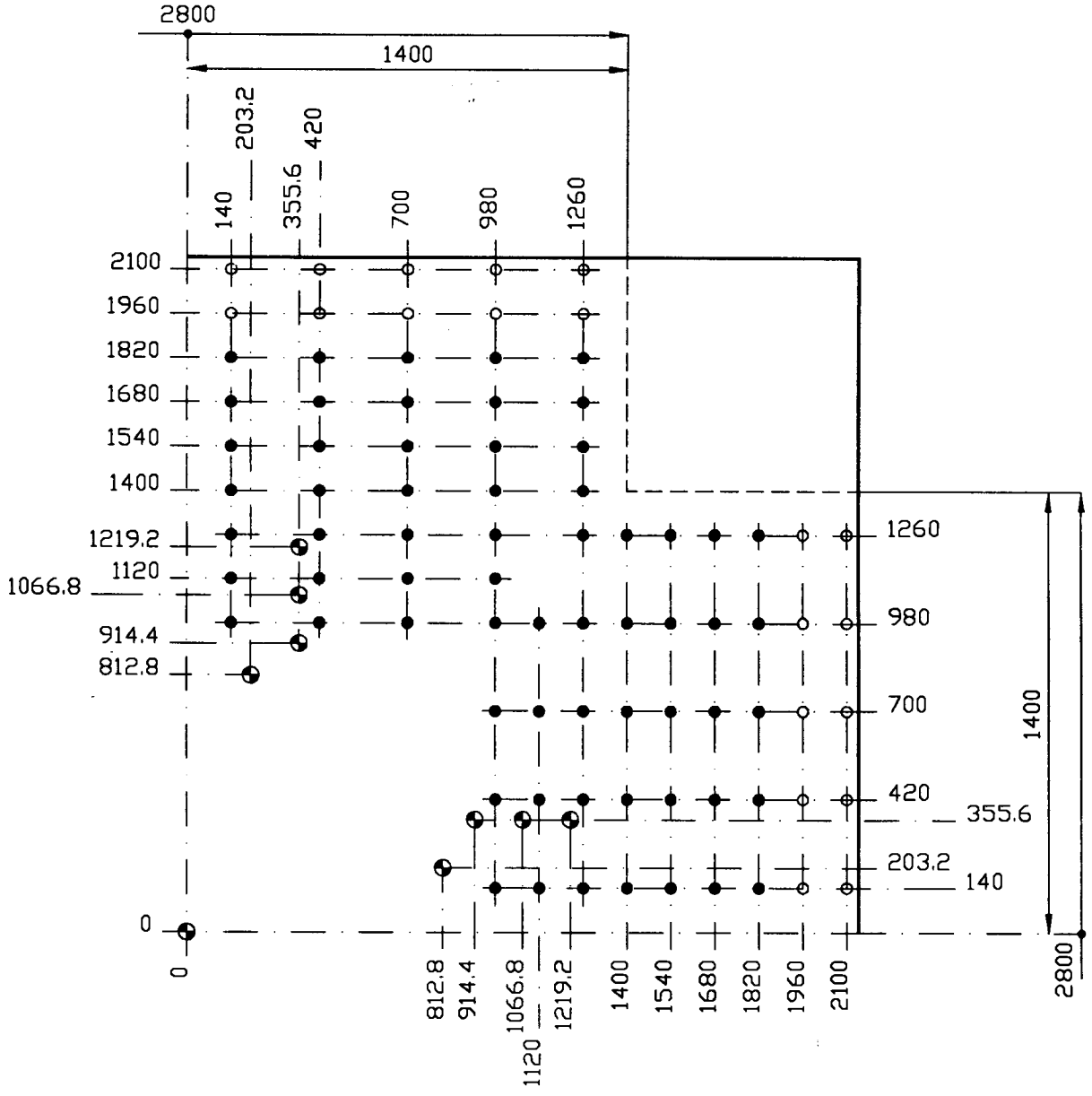
S 2800/2800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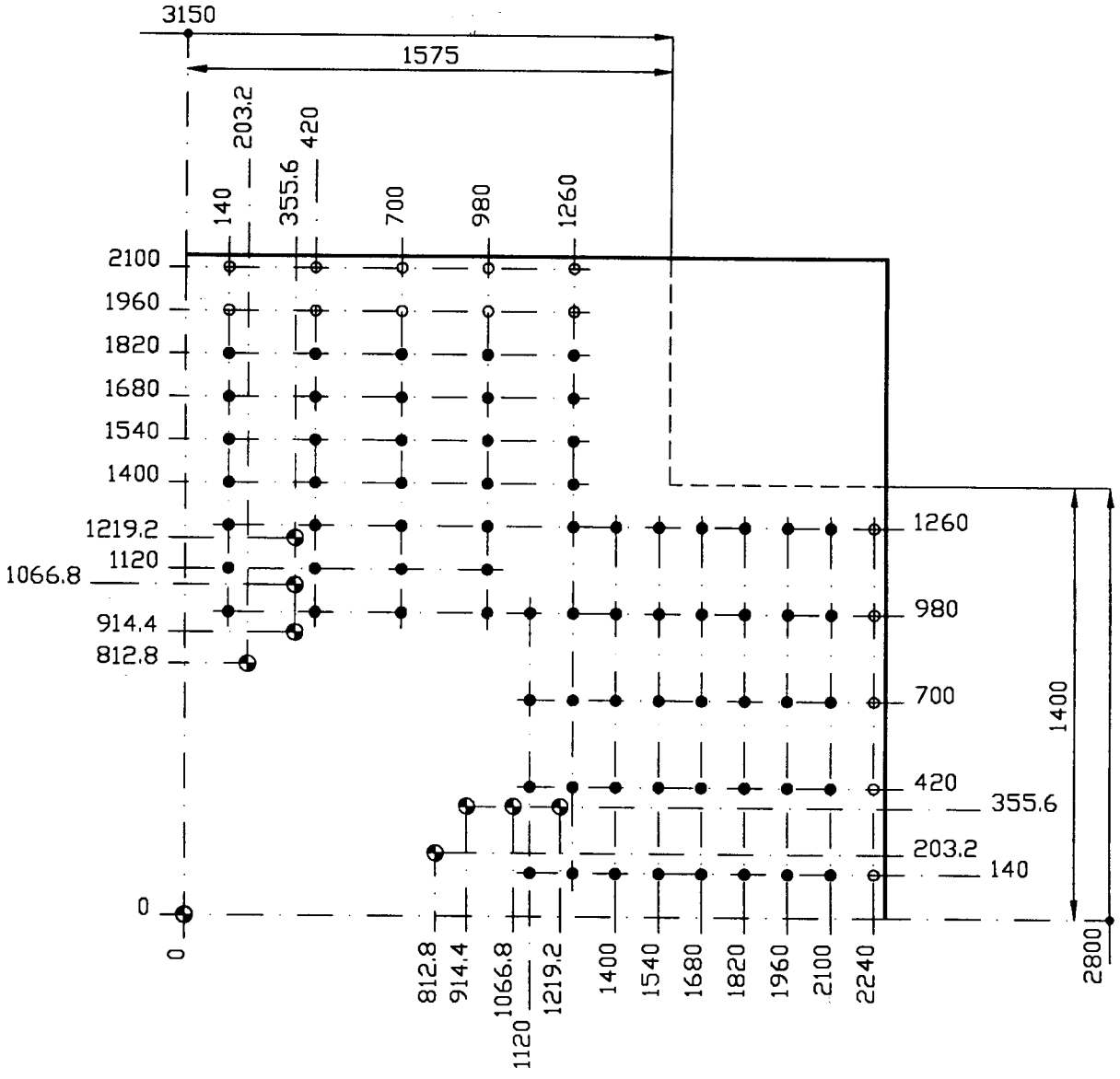
S 3150/2800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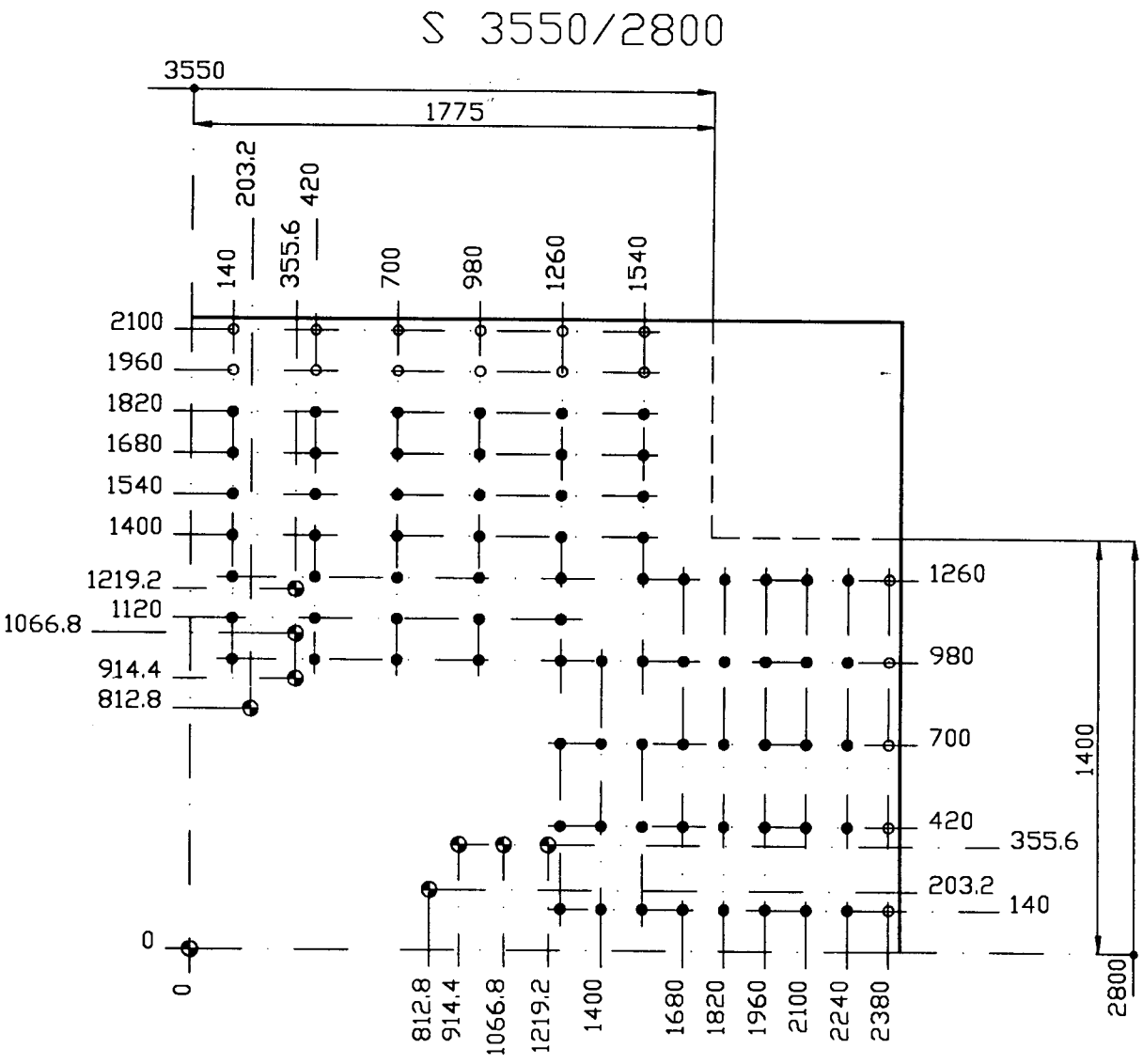
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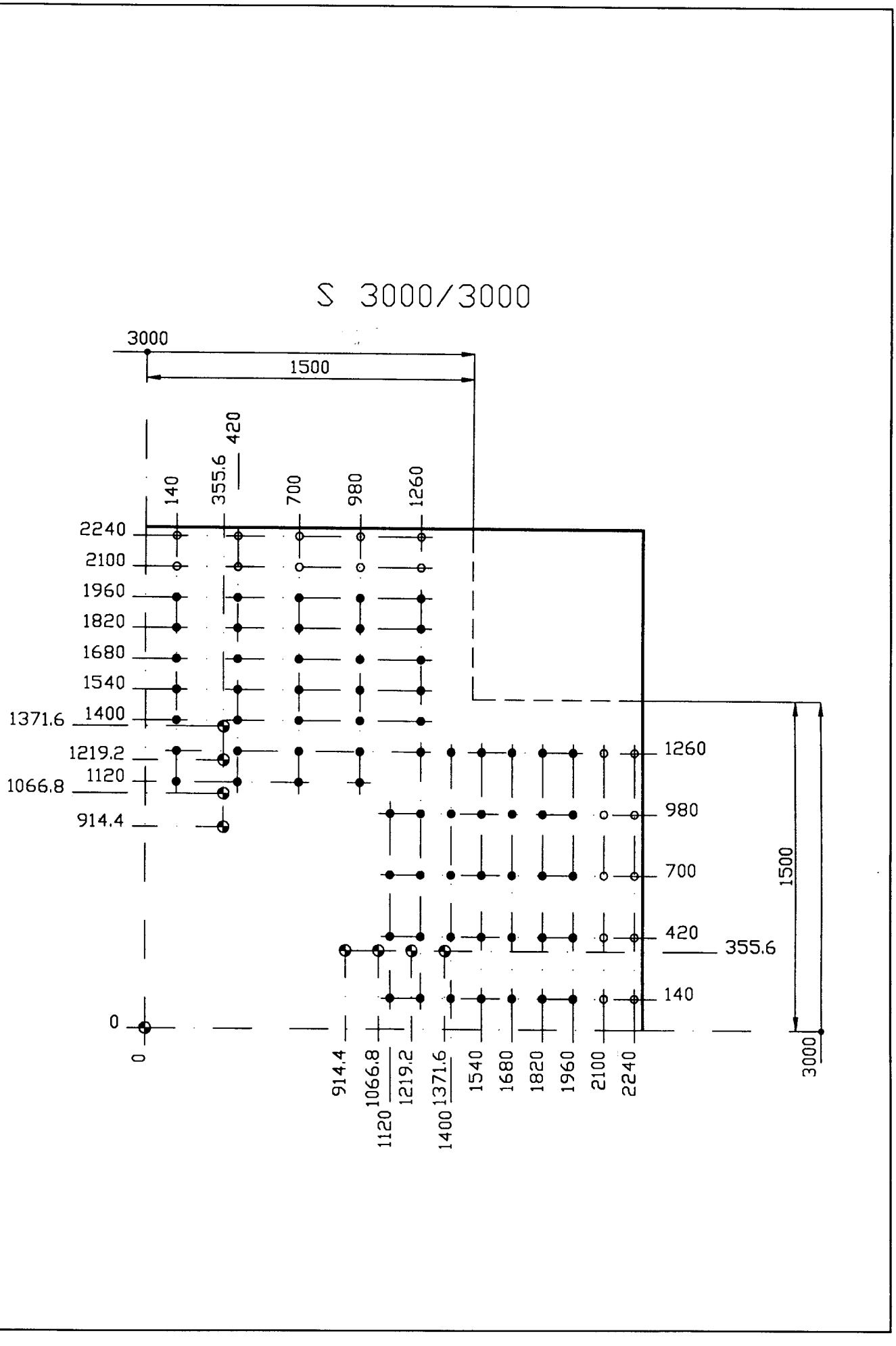
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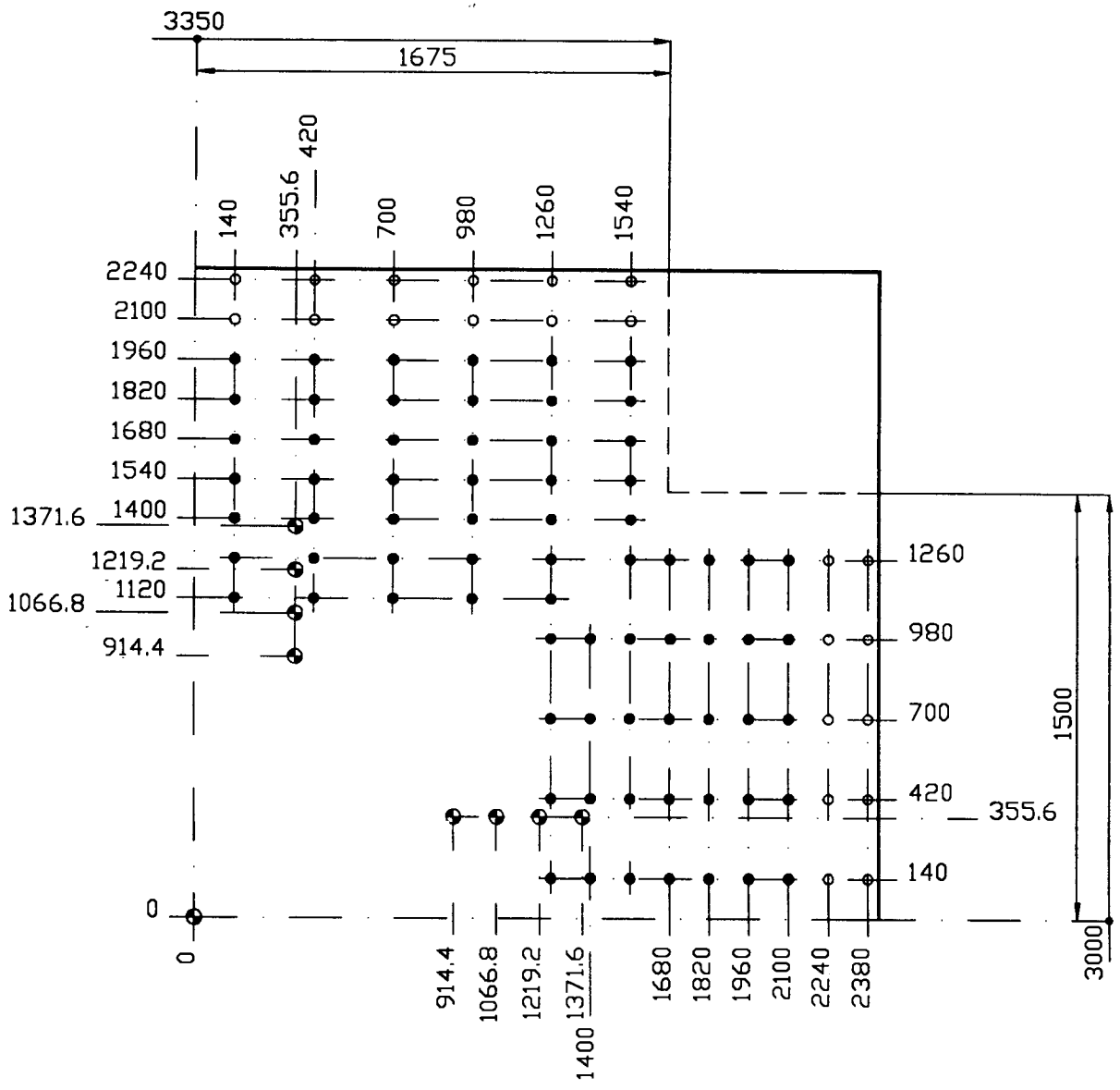
S 3350/3000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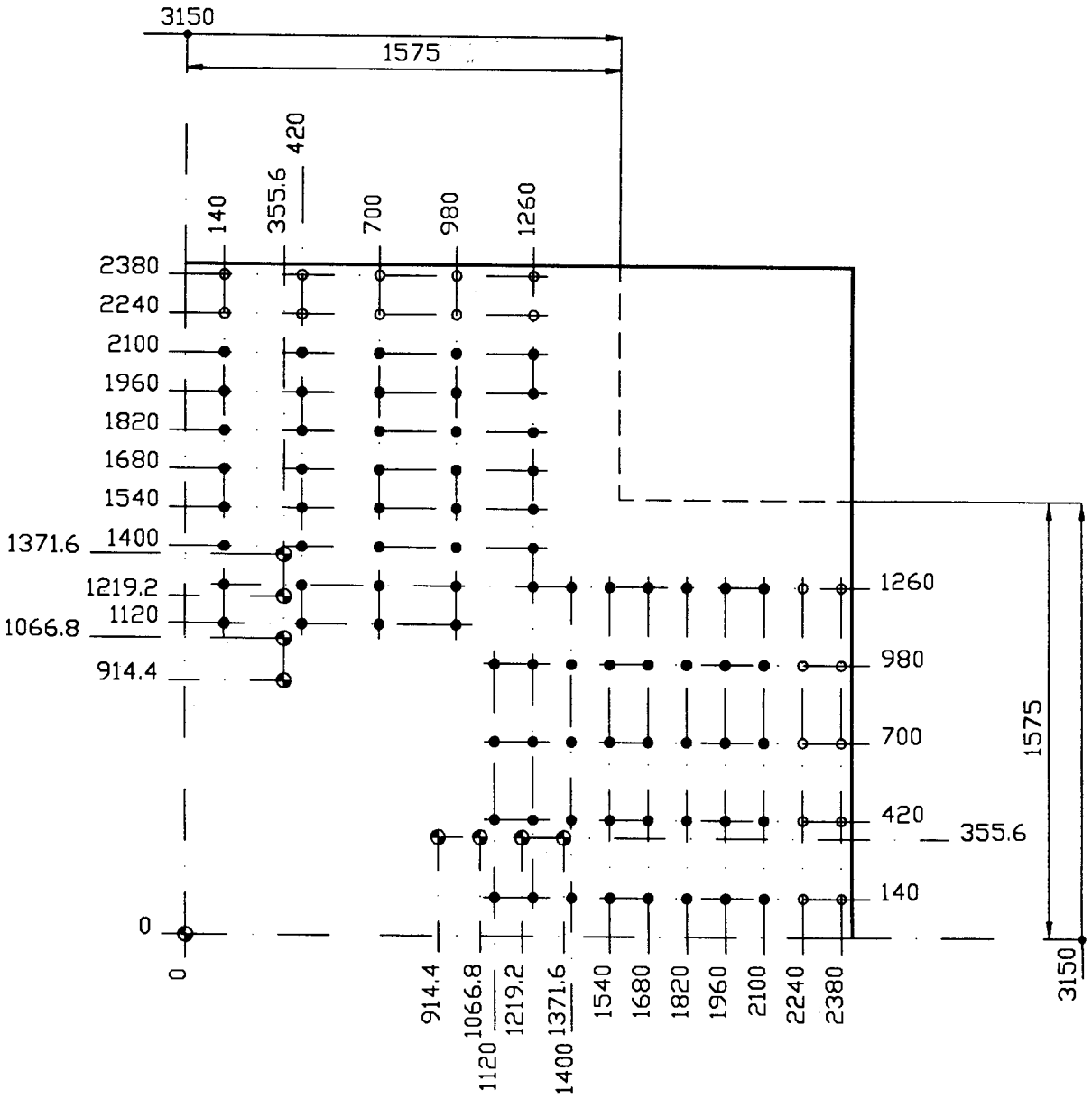
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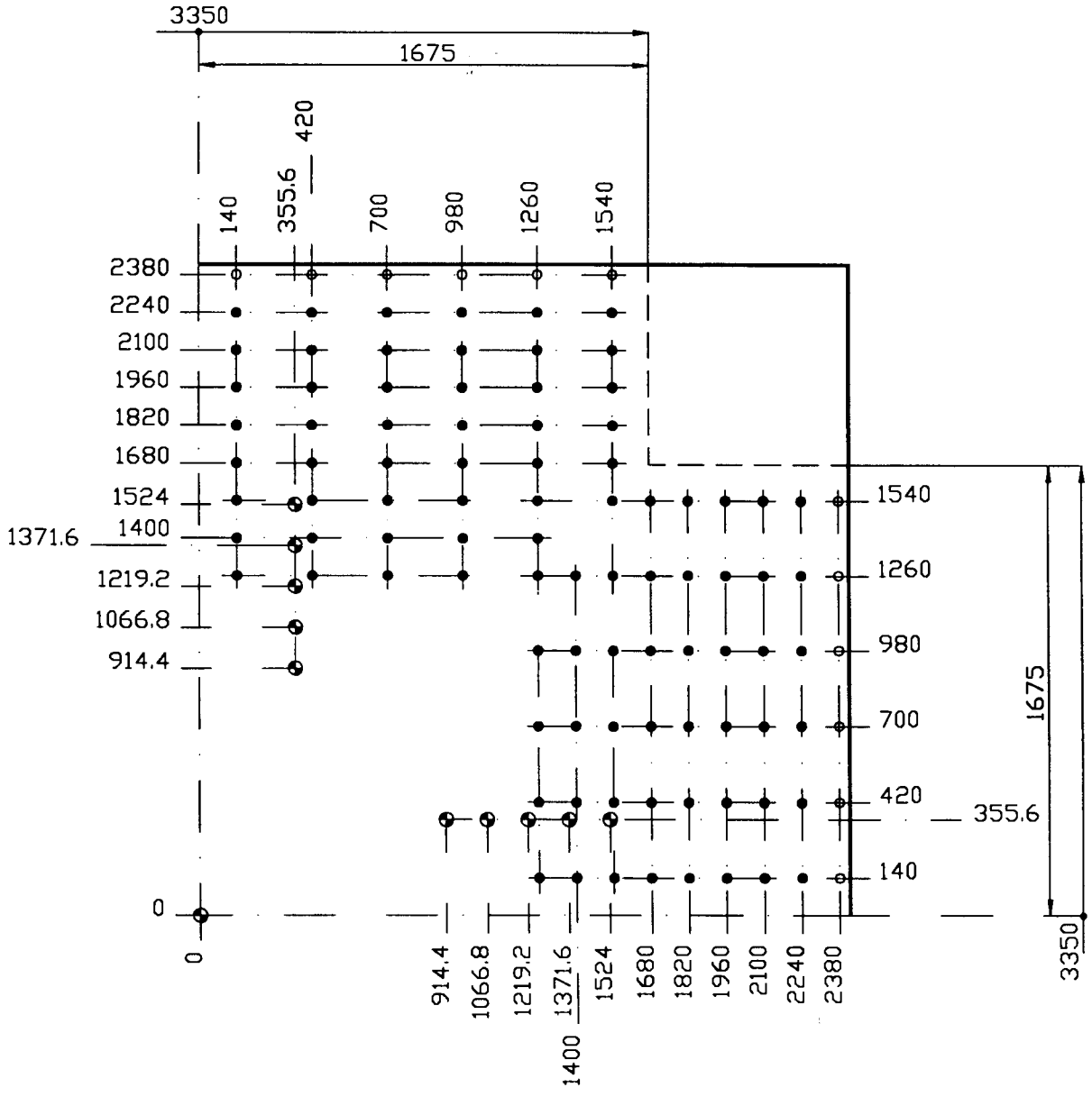
S 3350/3350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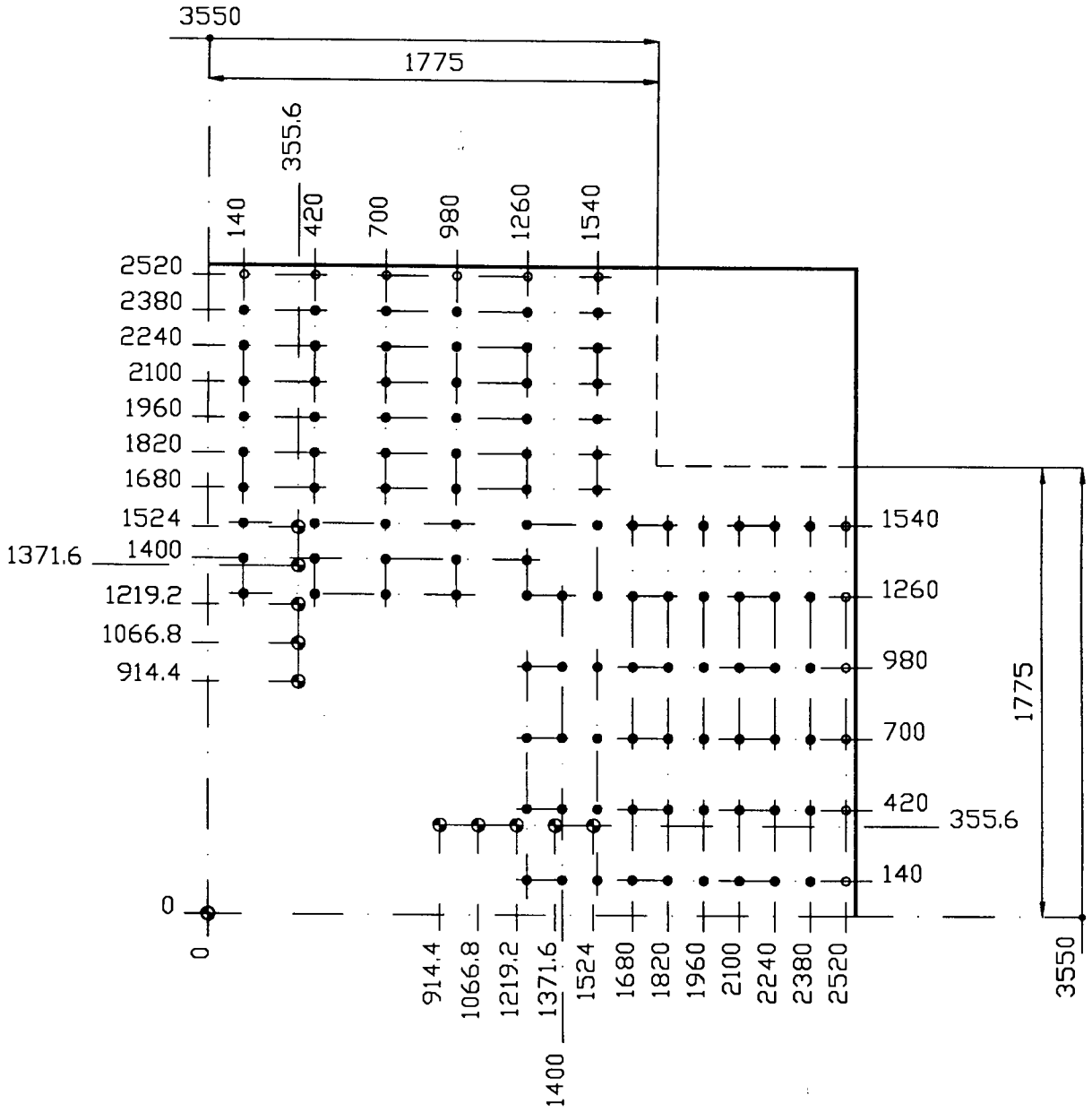
S 3550/3550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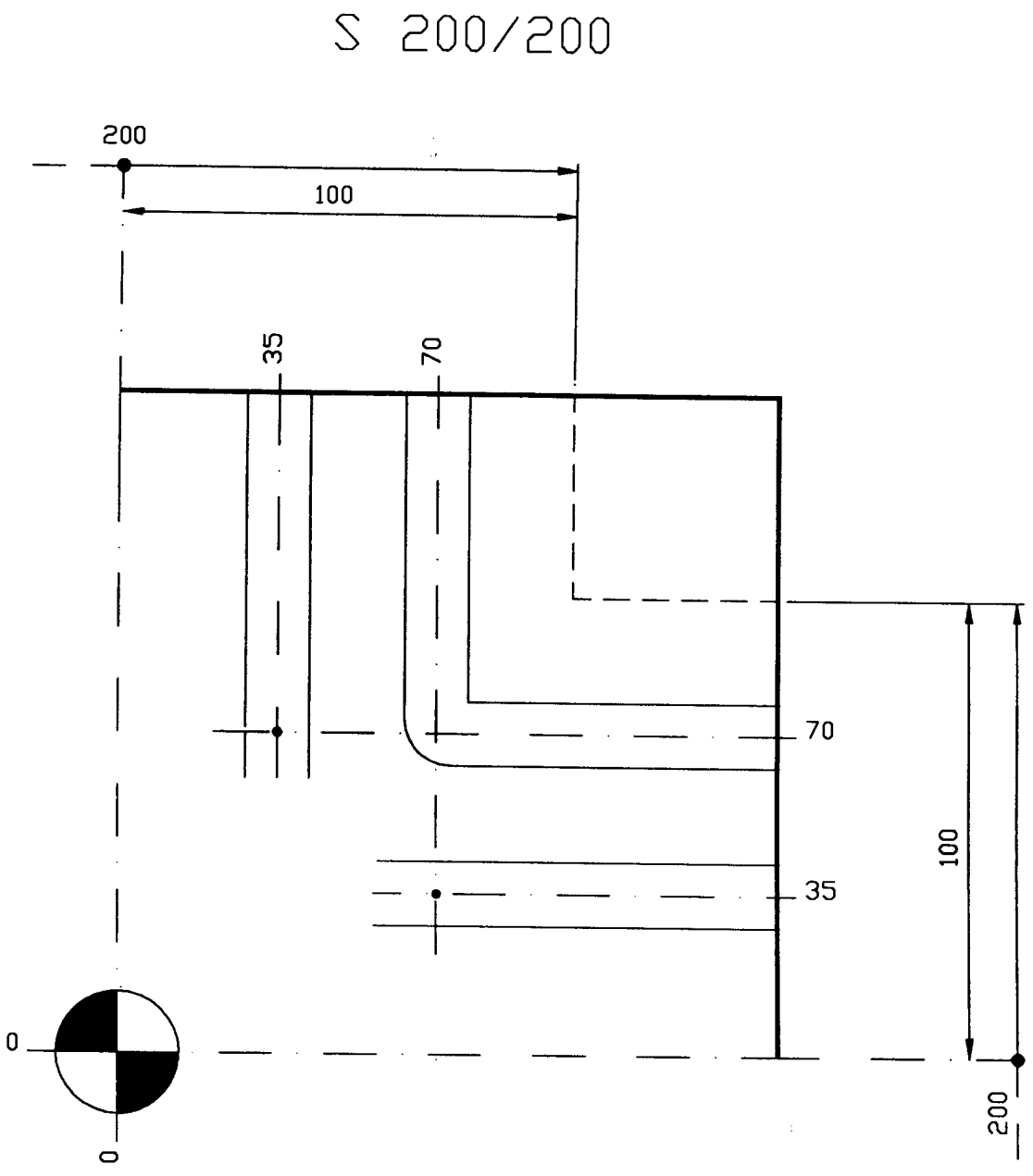
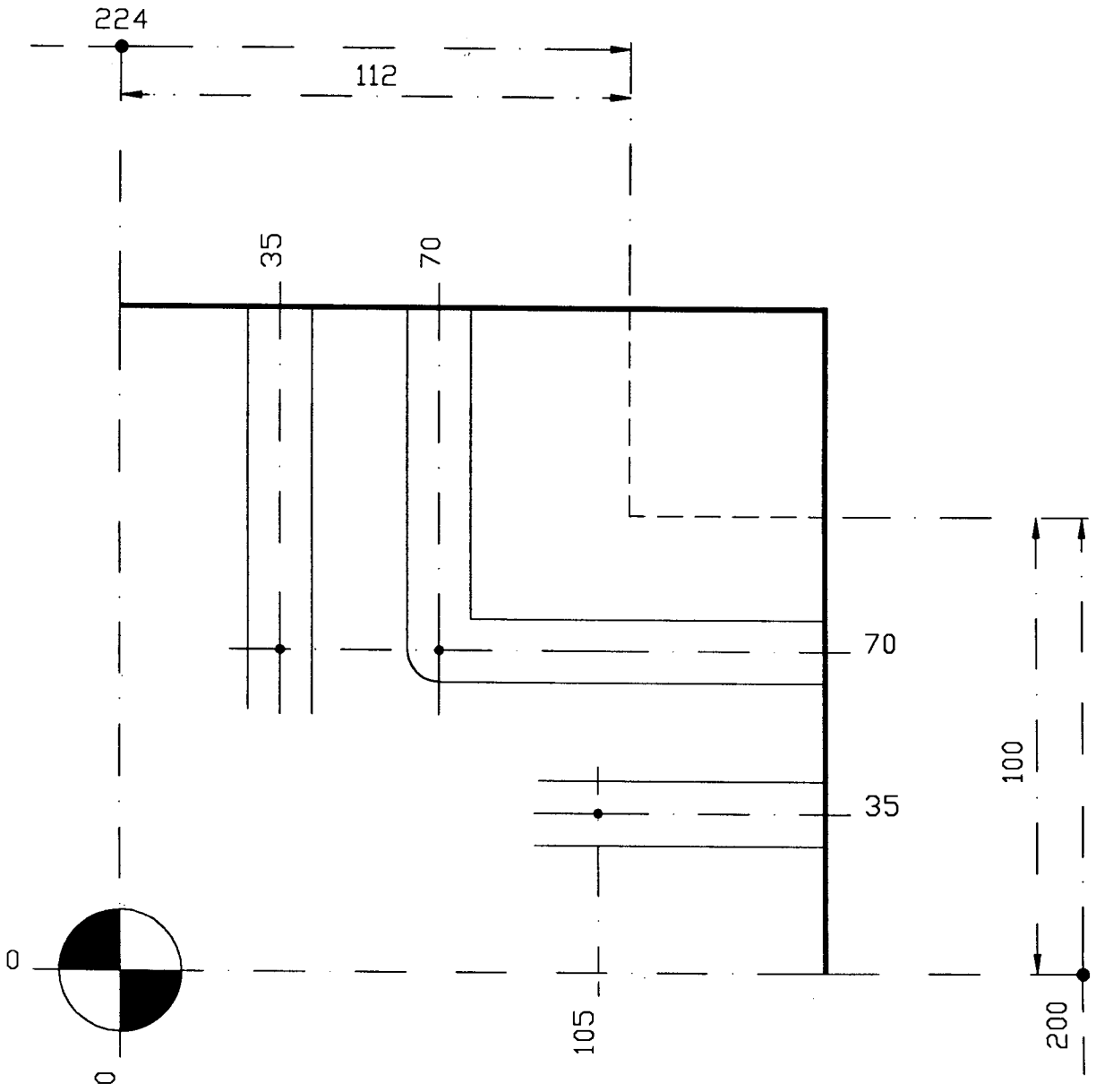
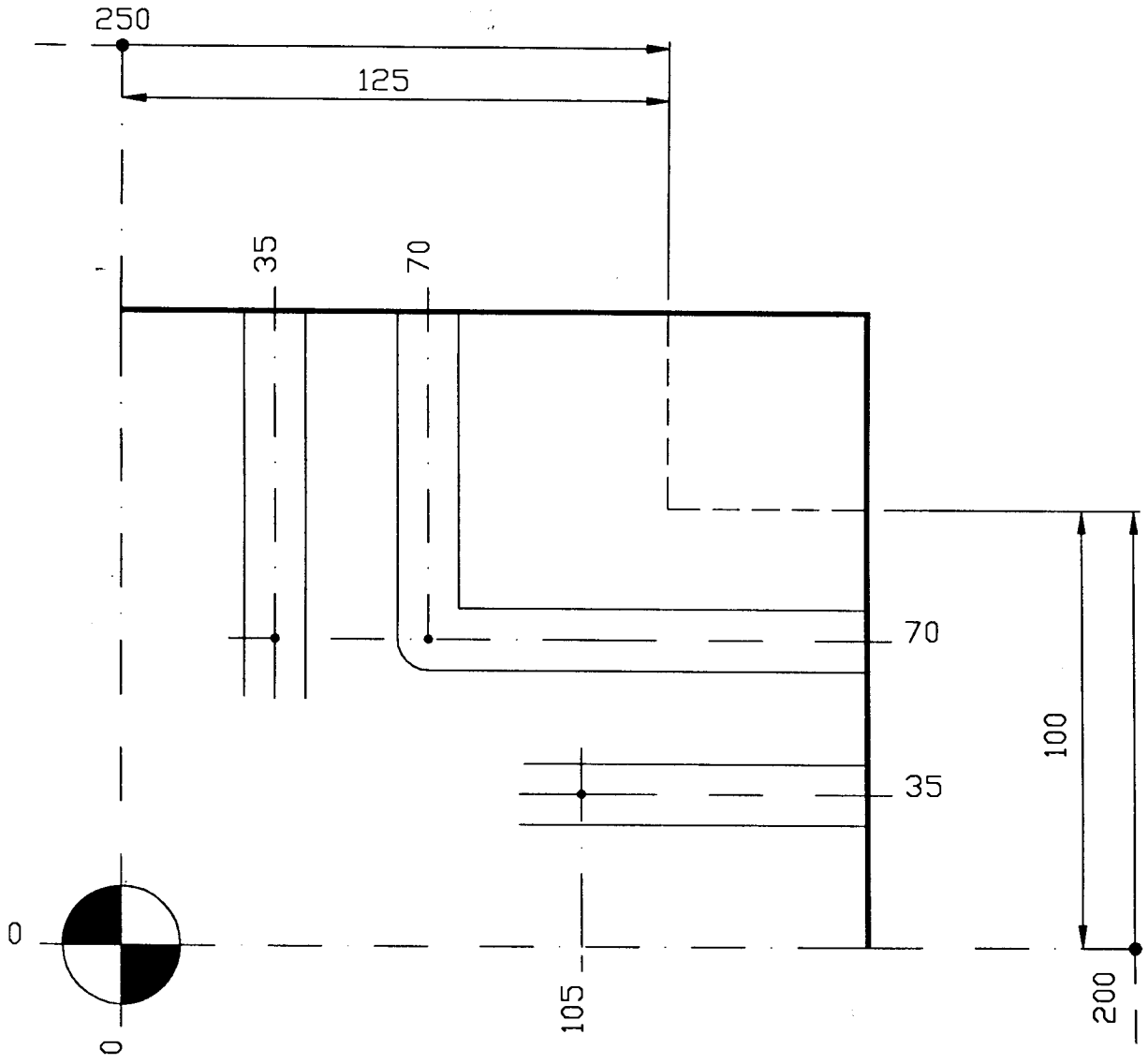
2.6 T-slot patterns



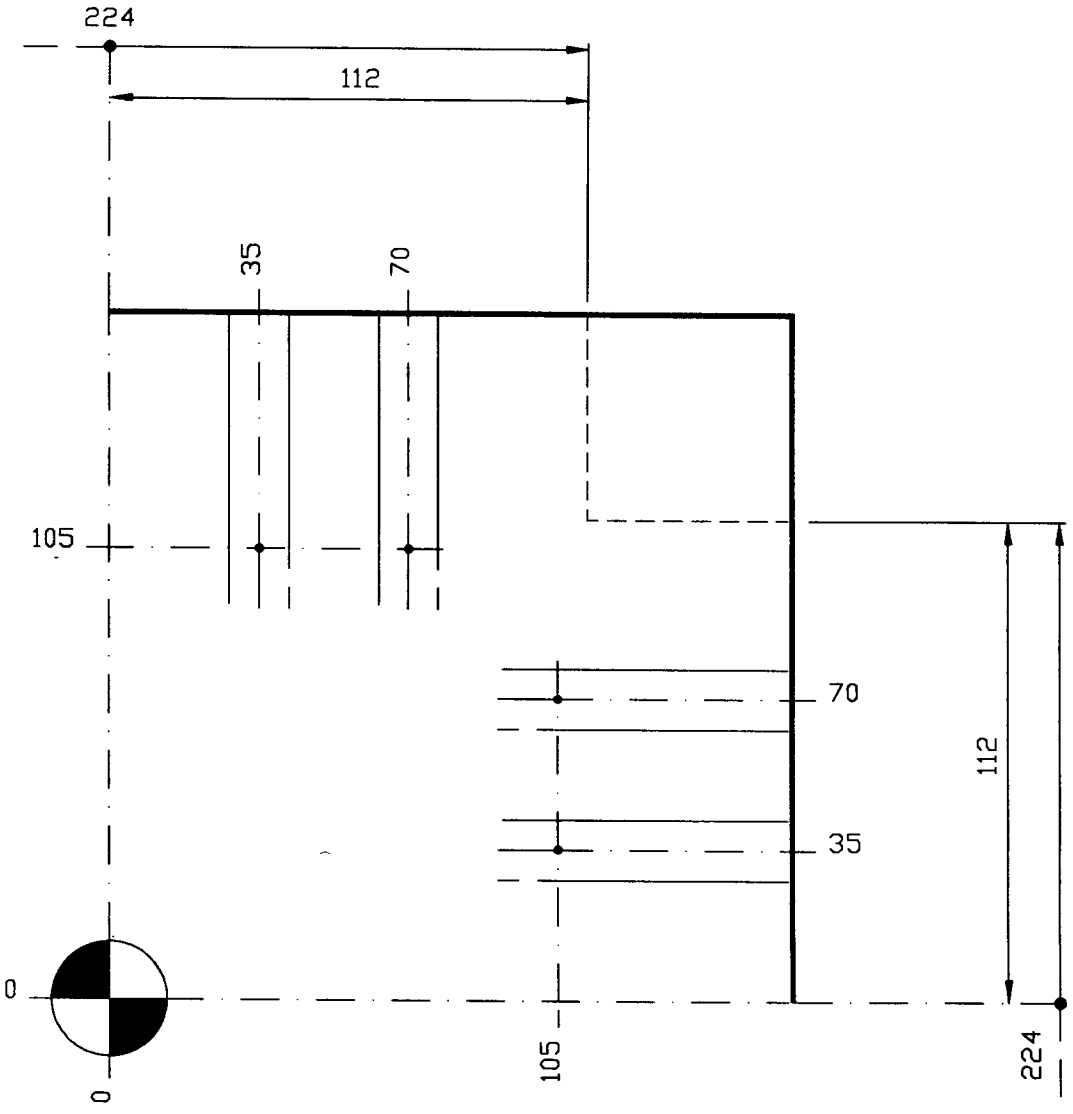
S 224/200



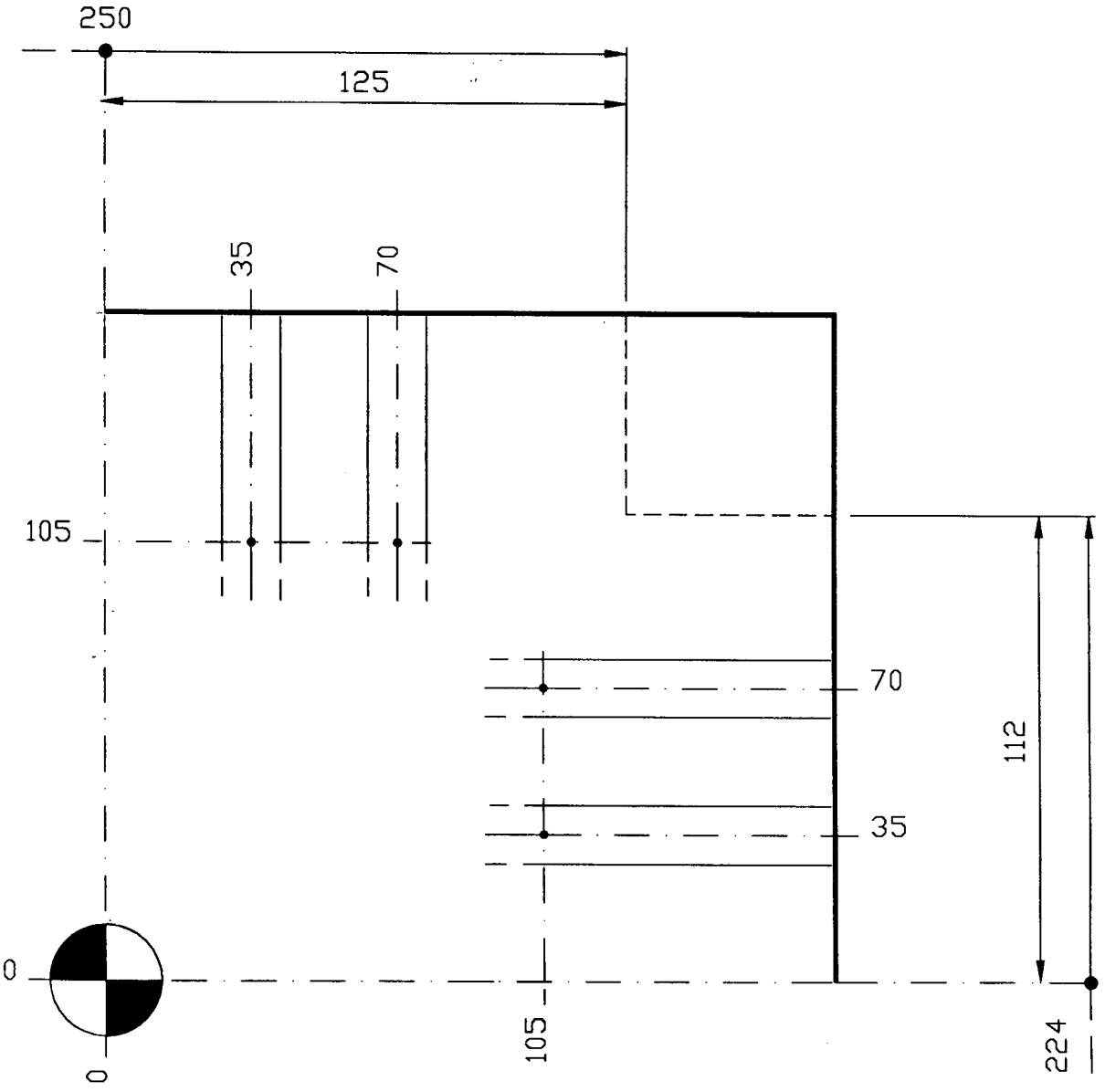
S 250/200



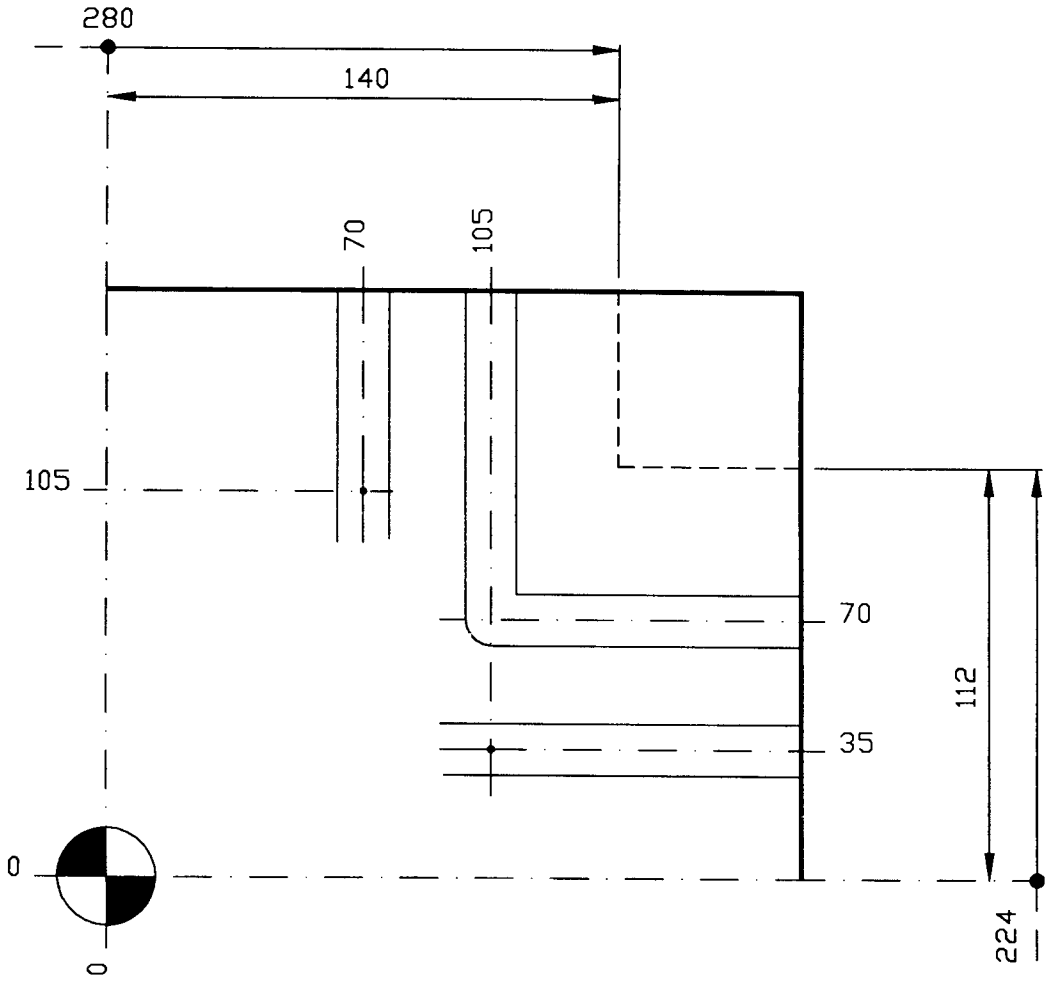
S 224/224



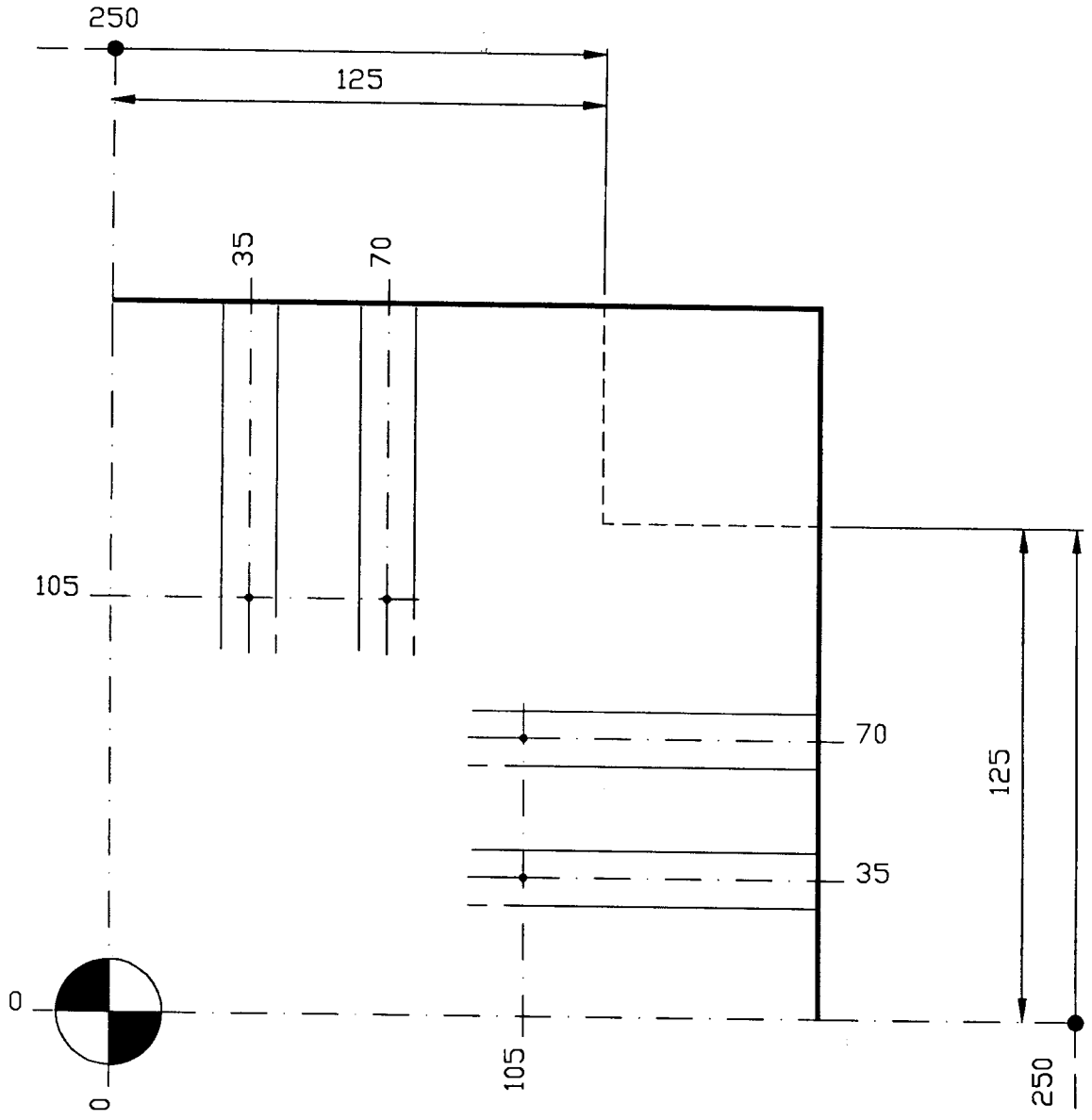
S 250/224



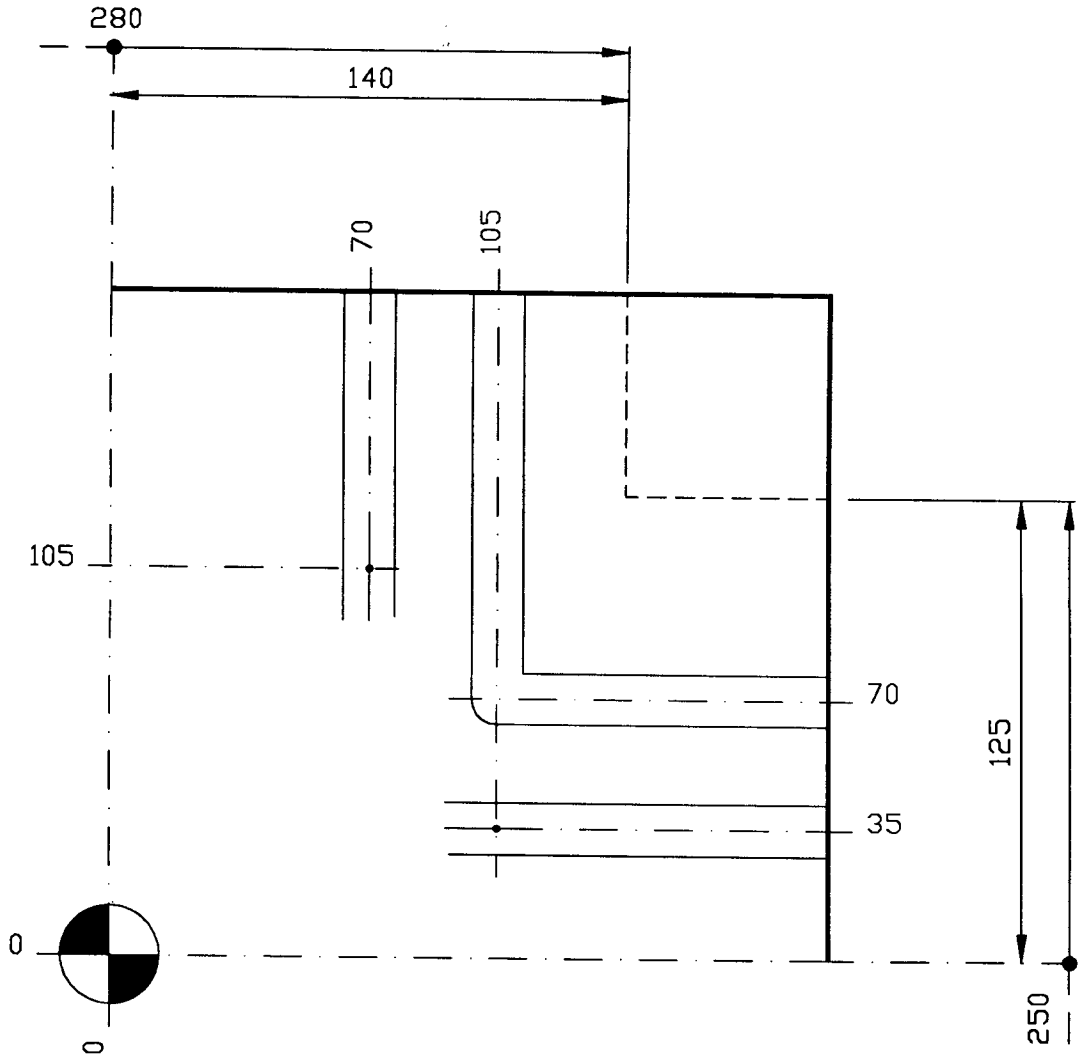
S 280/224



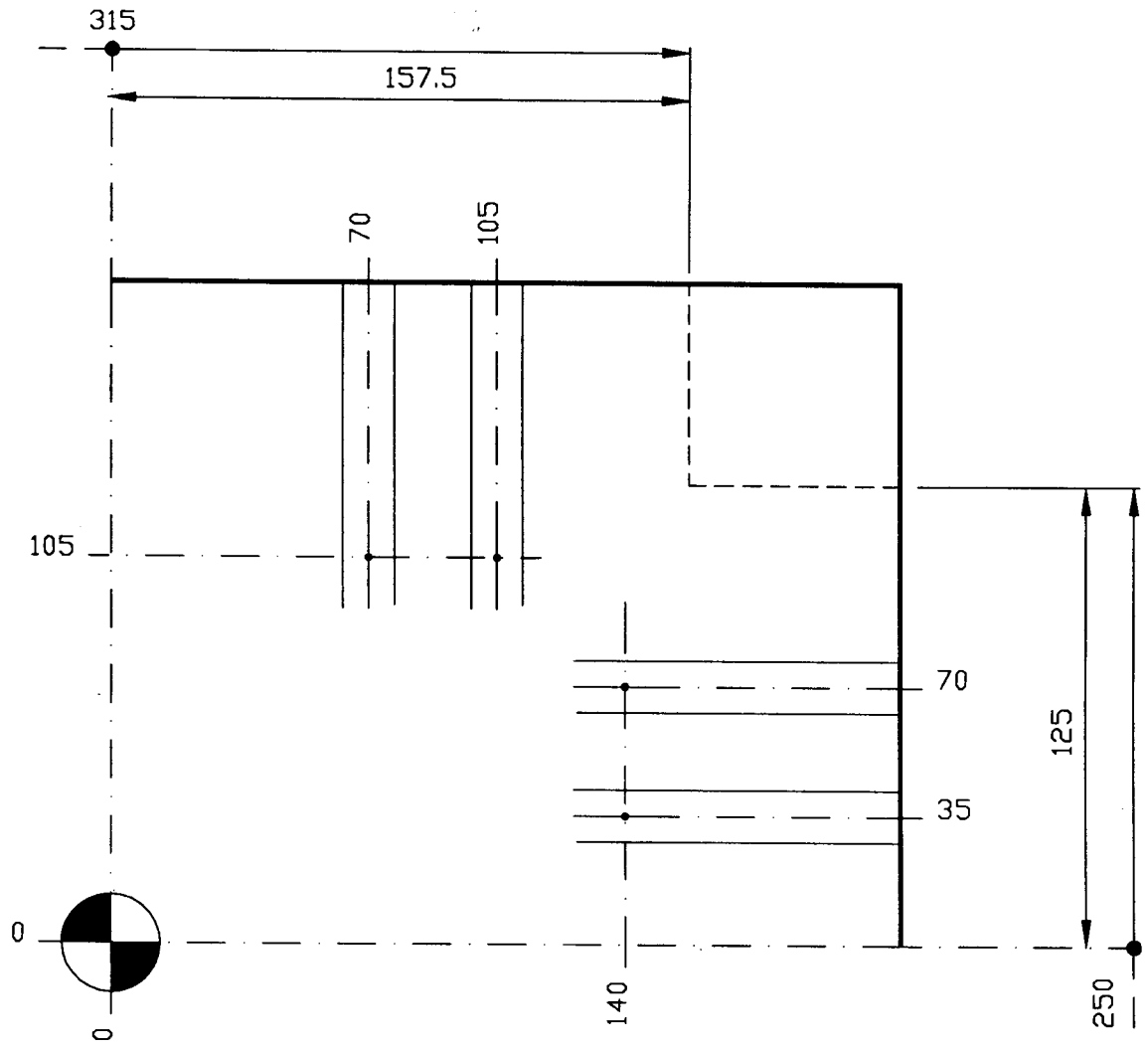
S 250/250



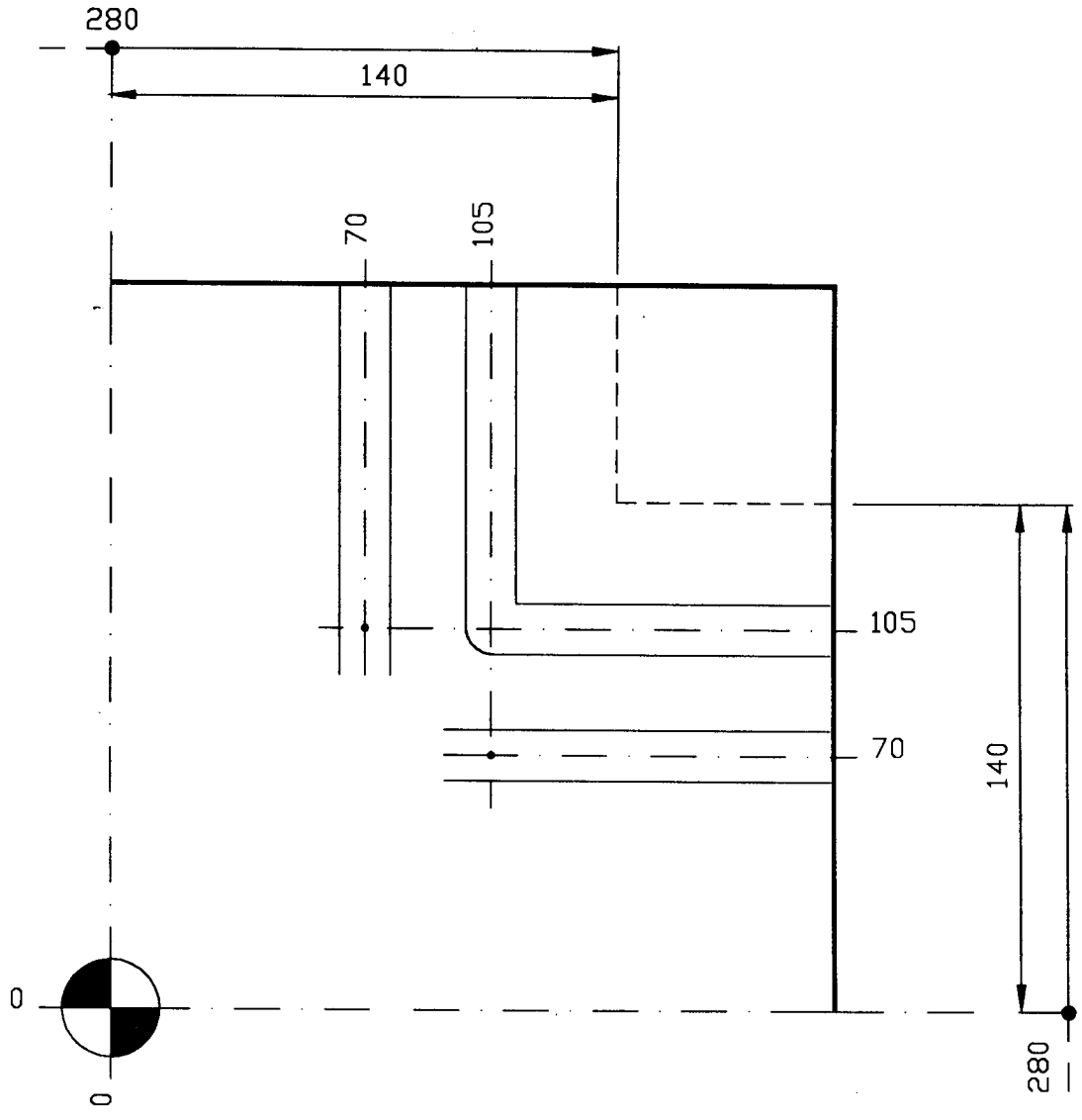
S 280/250



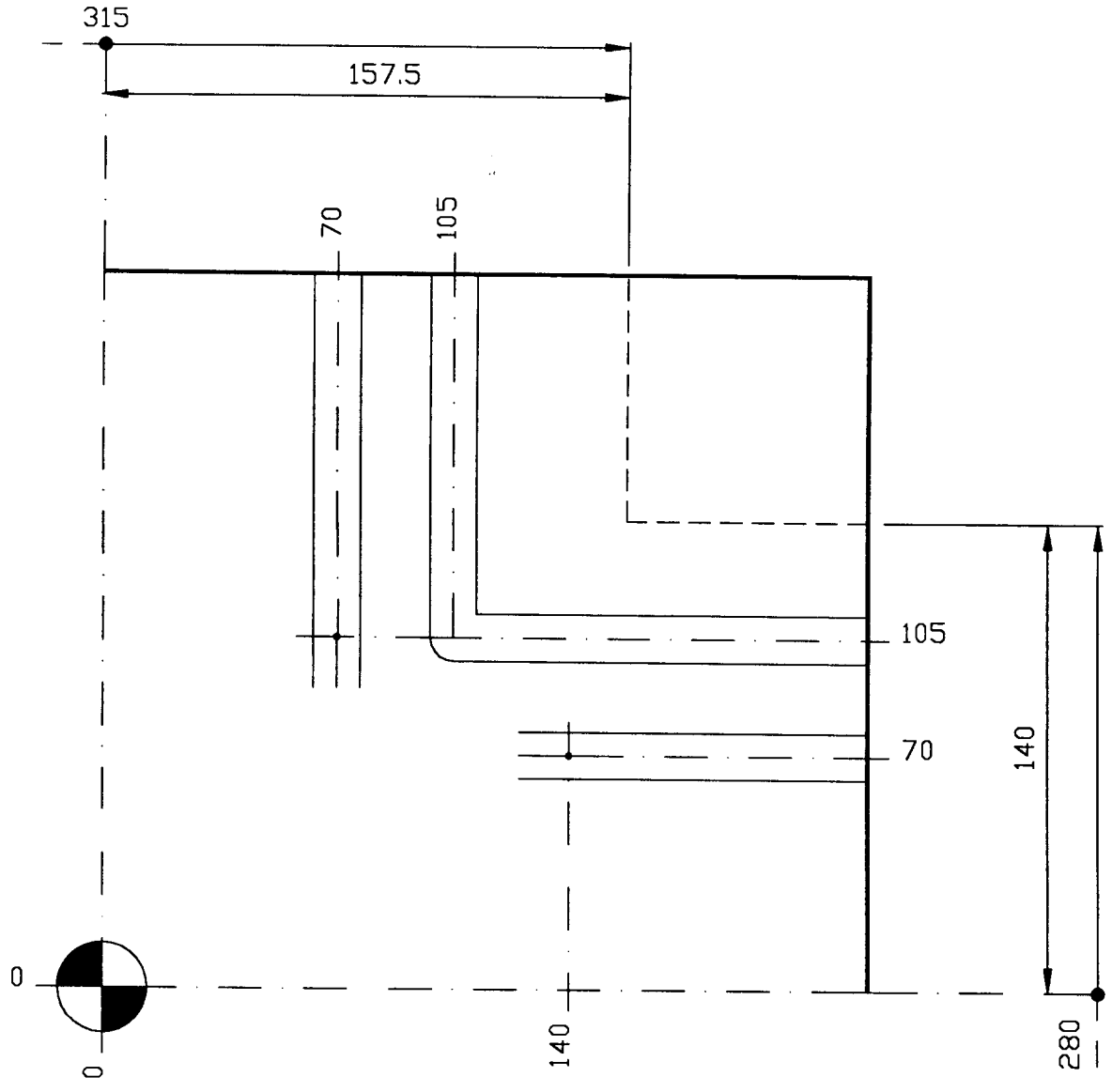
S 315/250



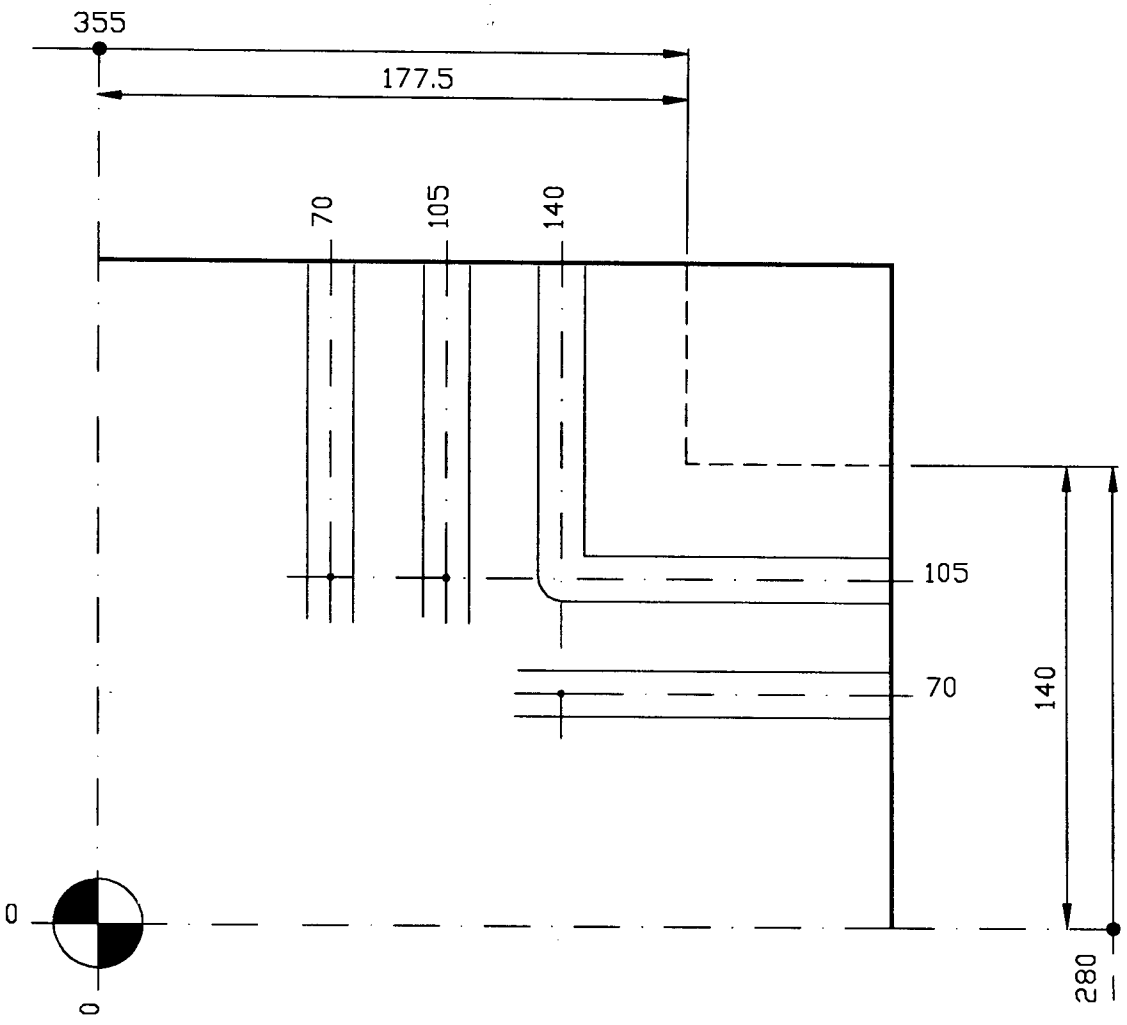
S 280/280



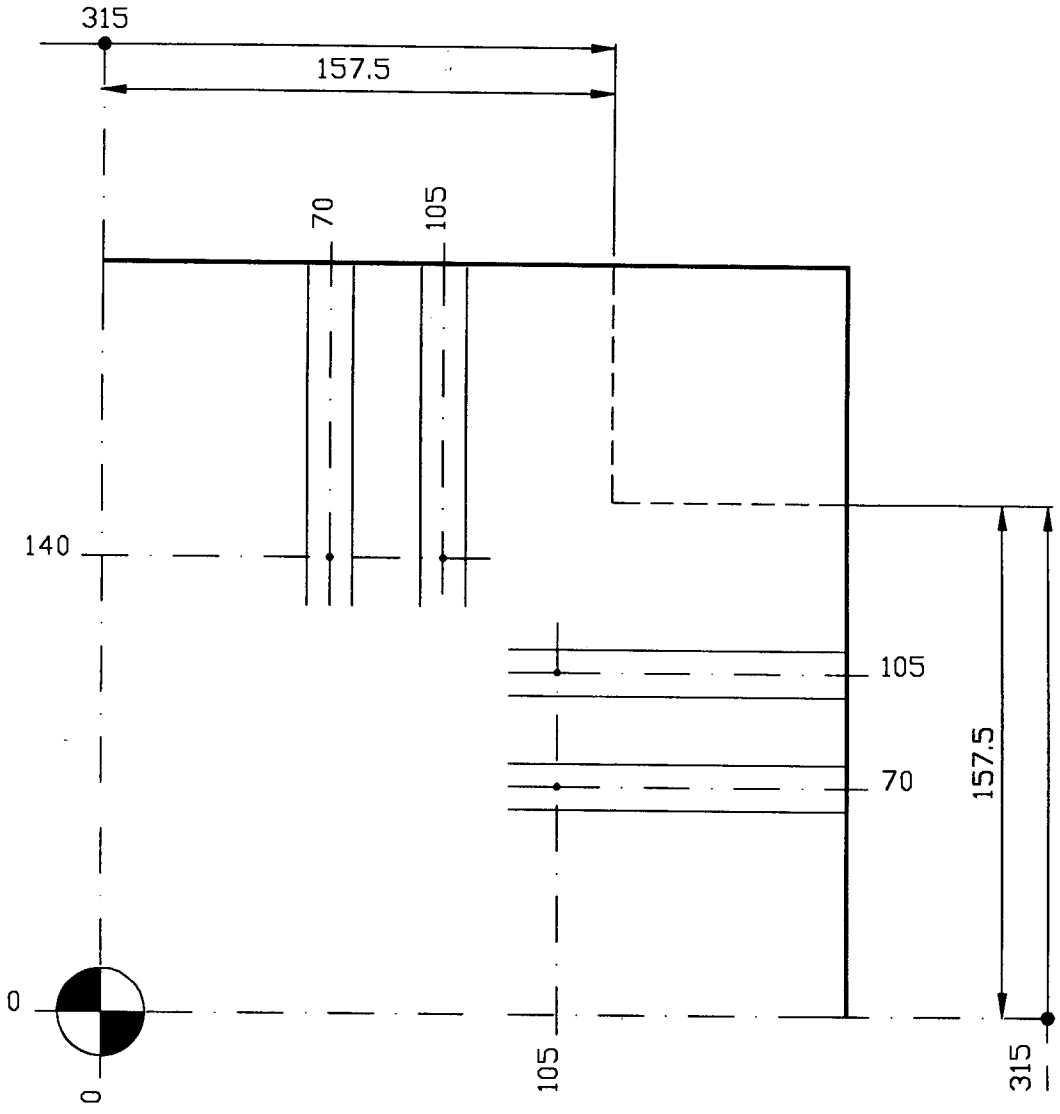
S 315/280



S 355/280



S 315/315



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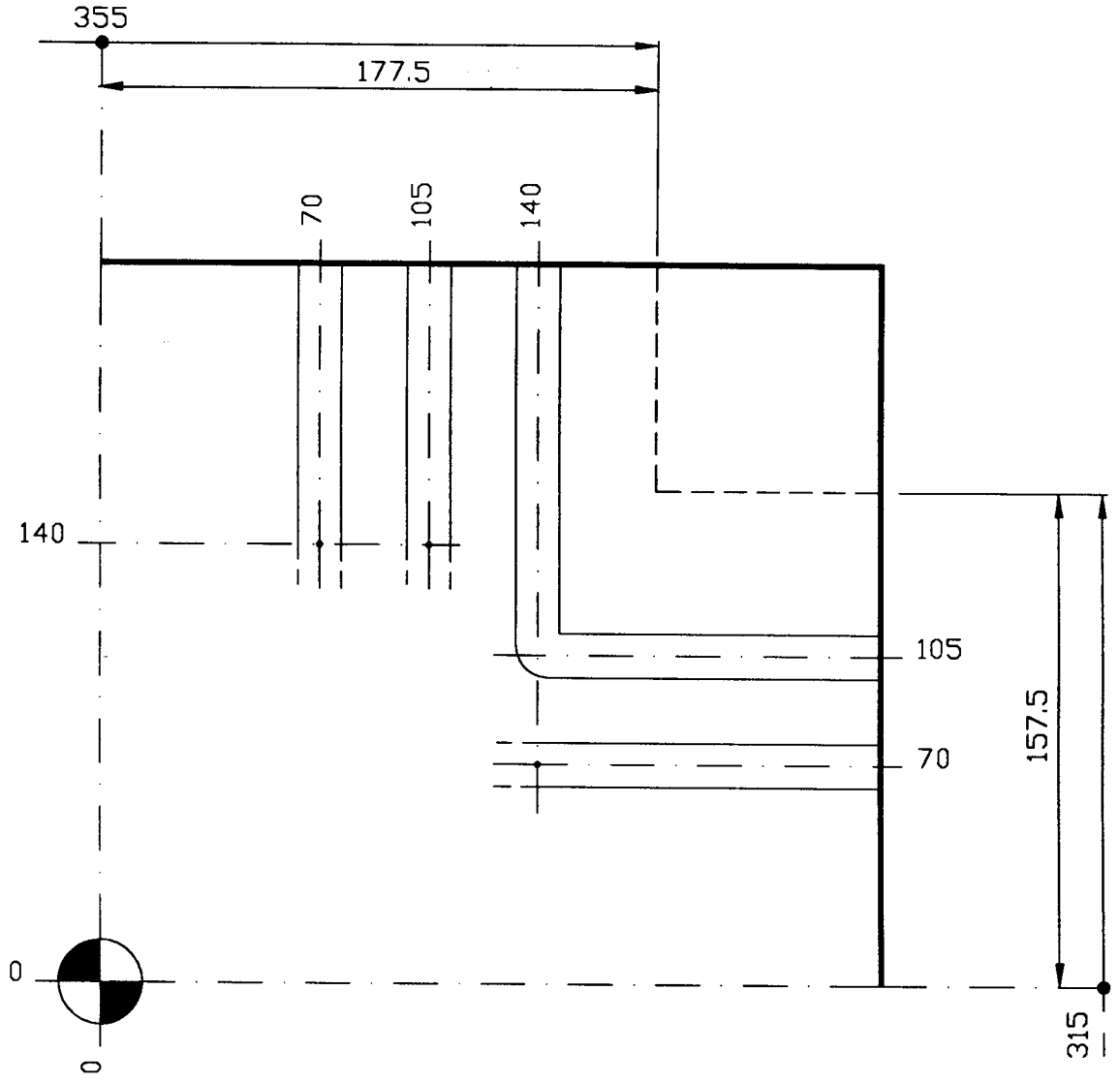
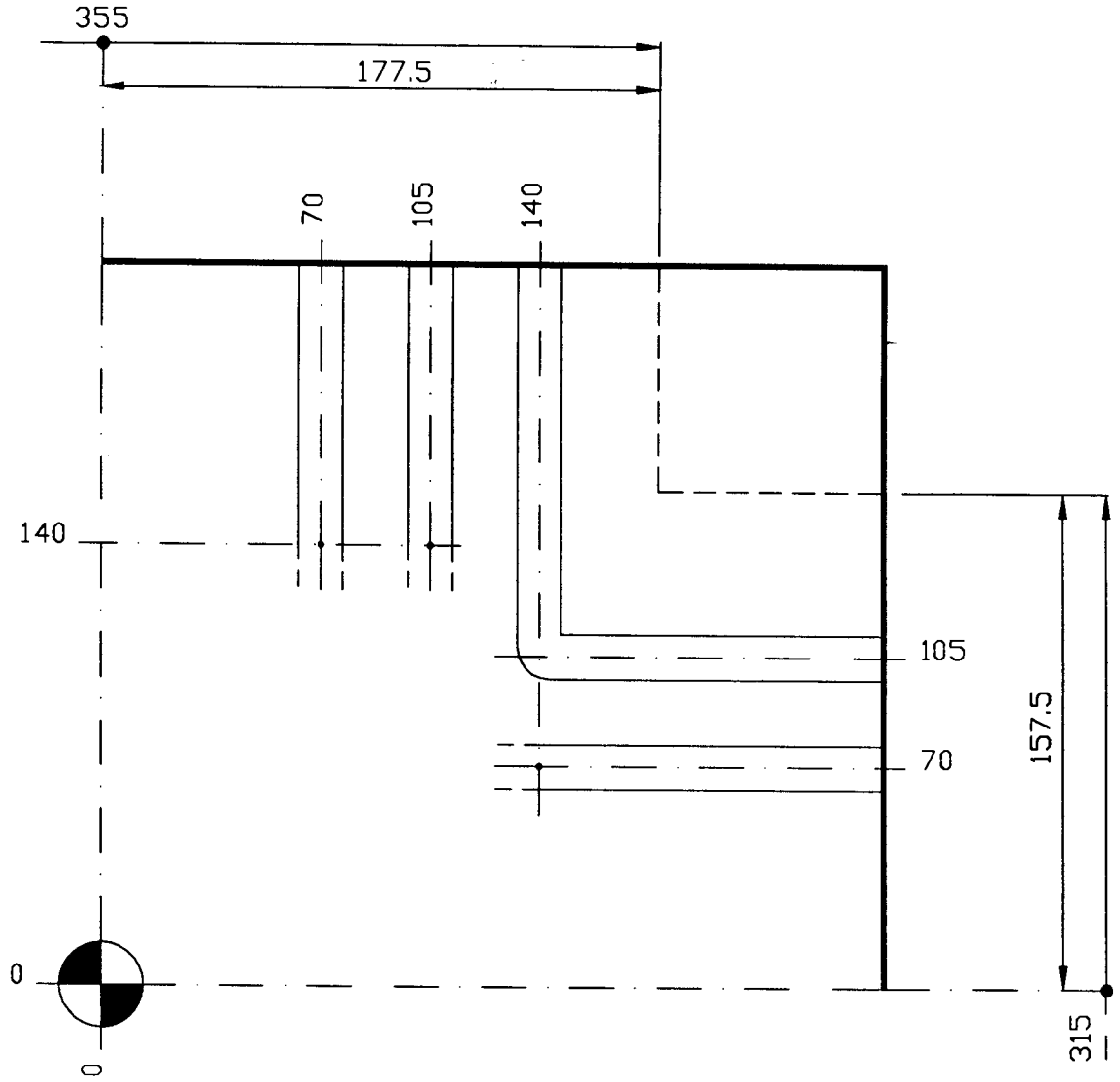
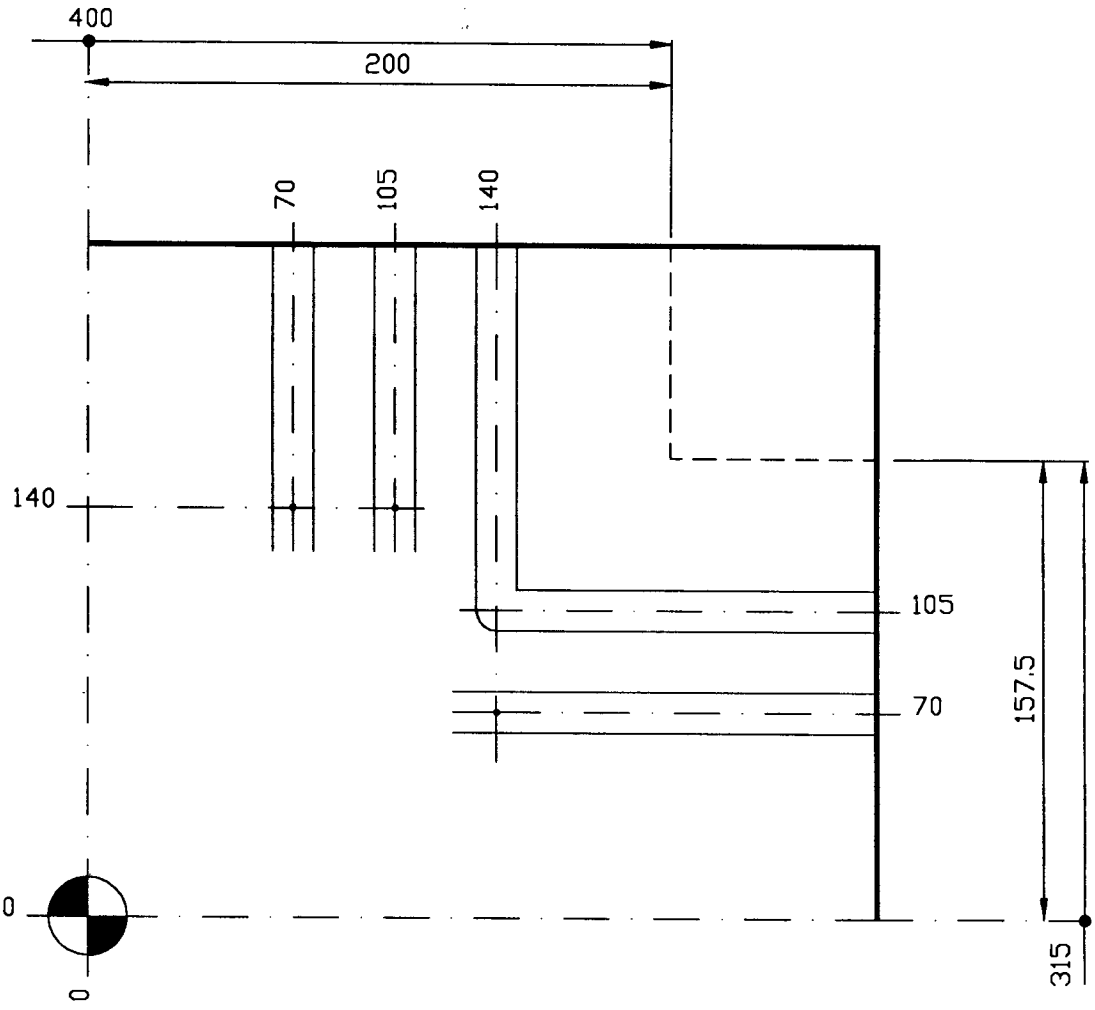


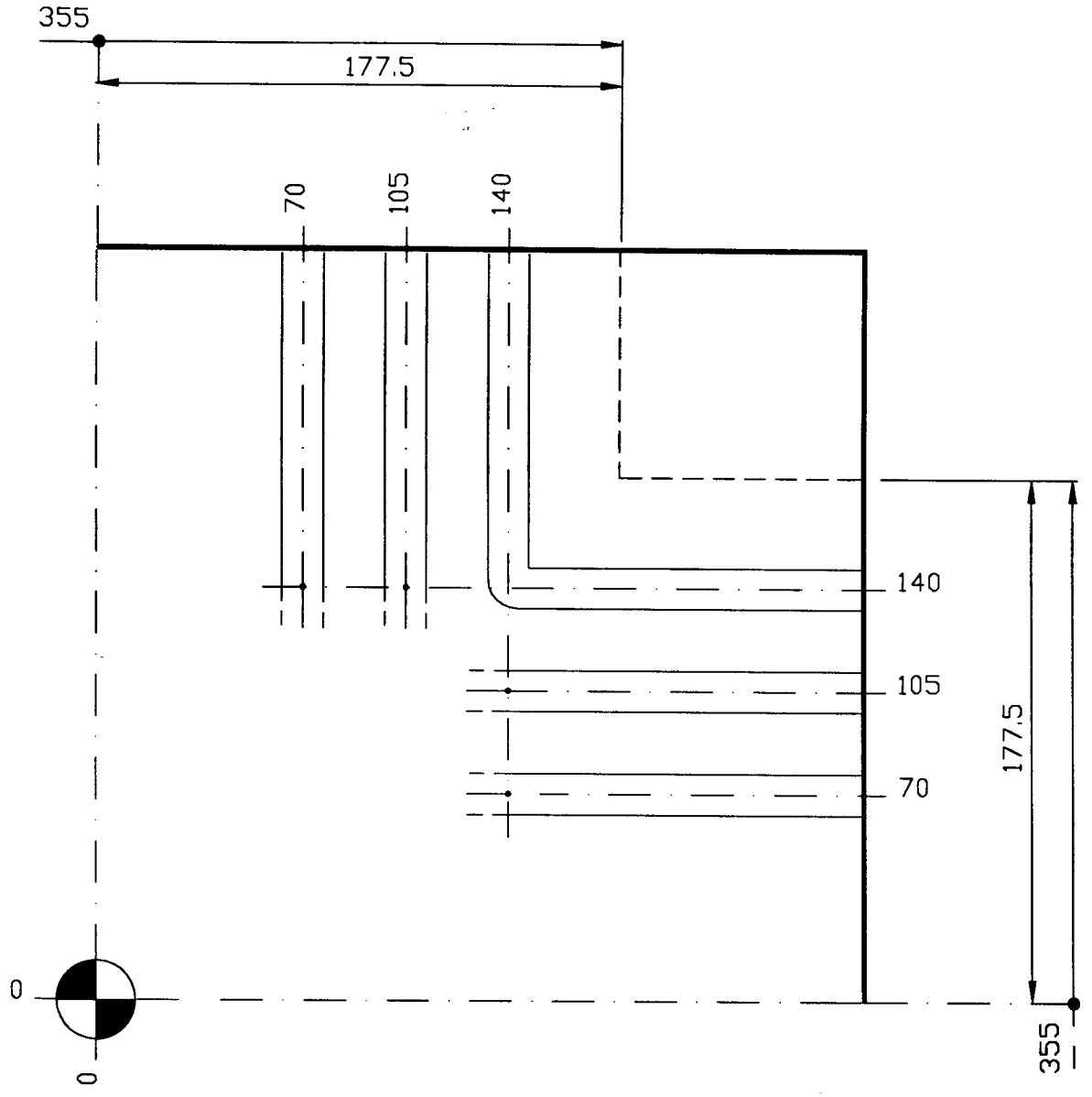
S 355/315



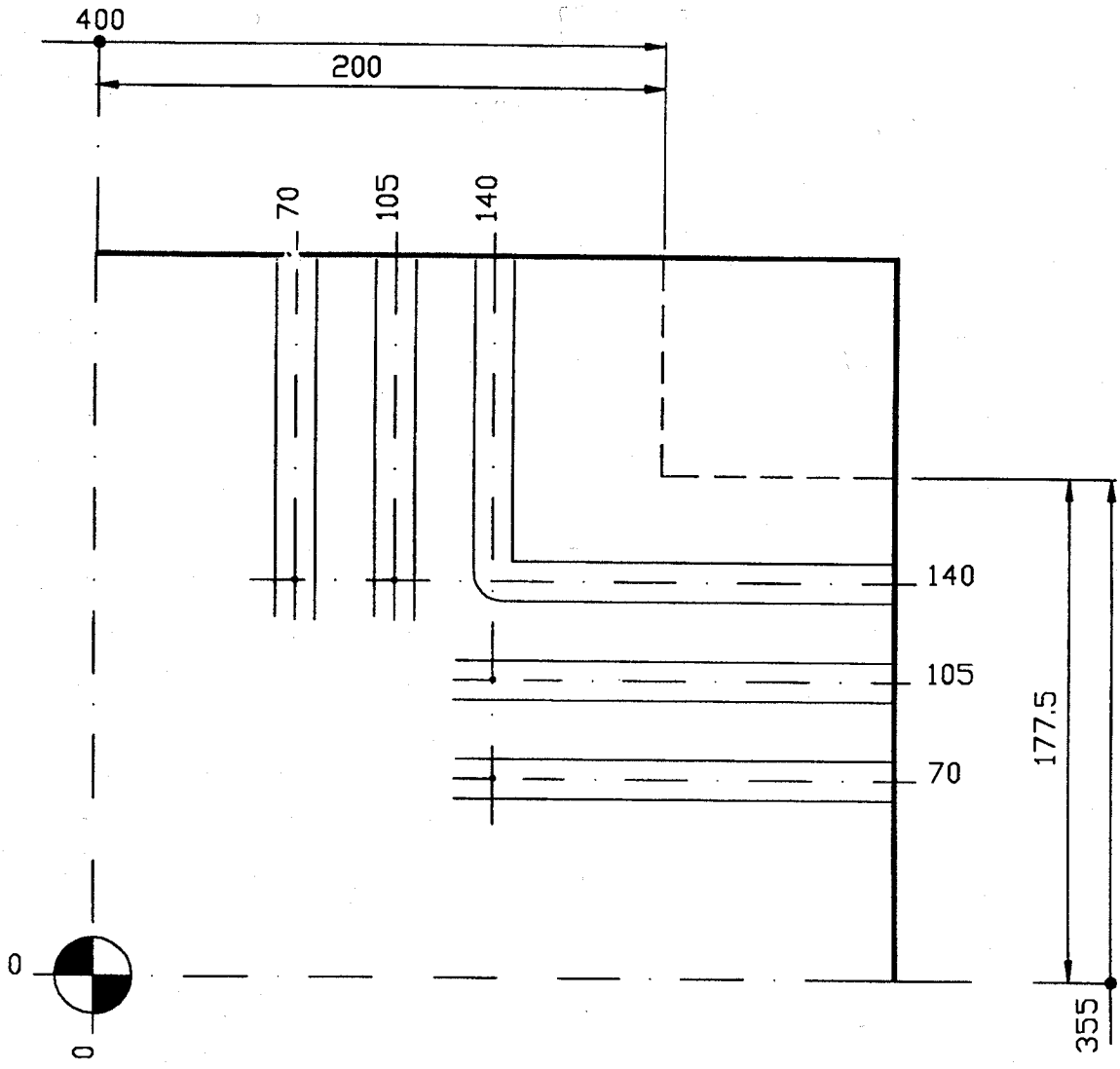
S 400/315



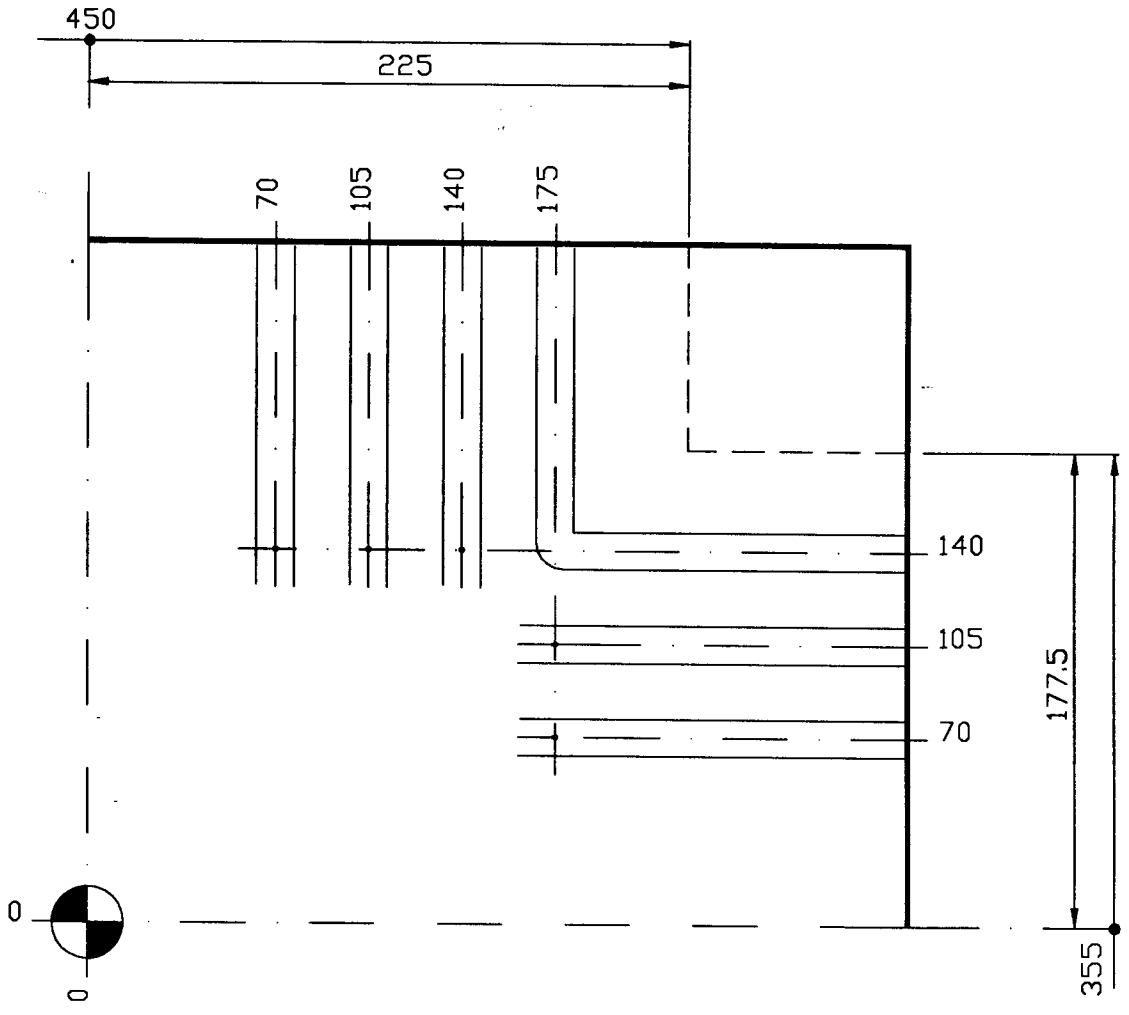
S 355/355



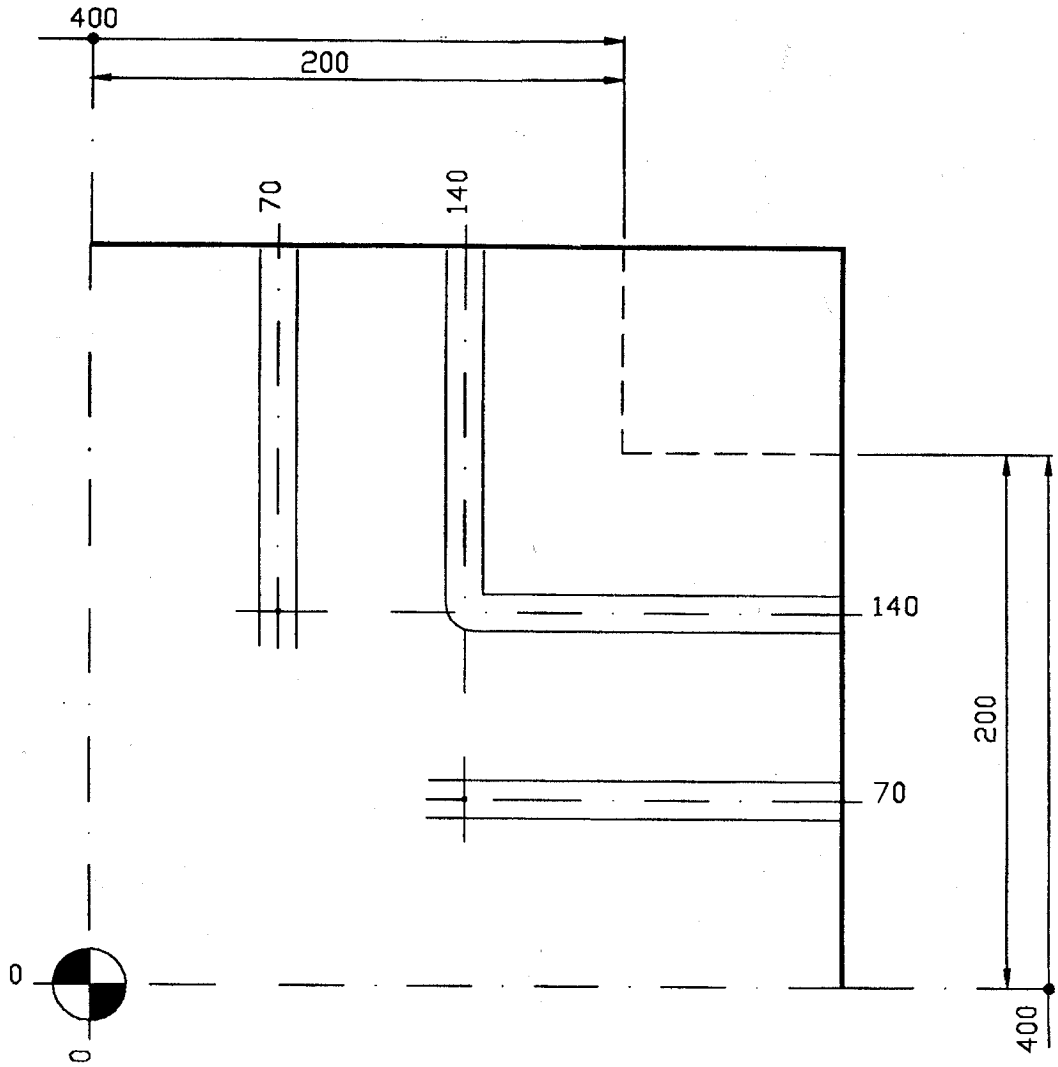
S 400/355



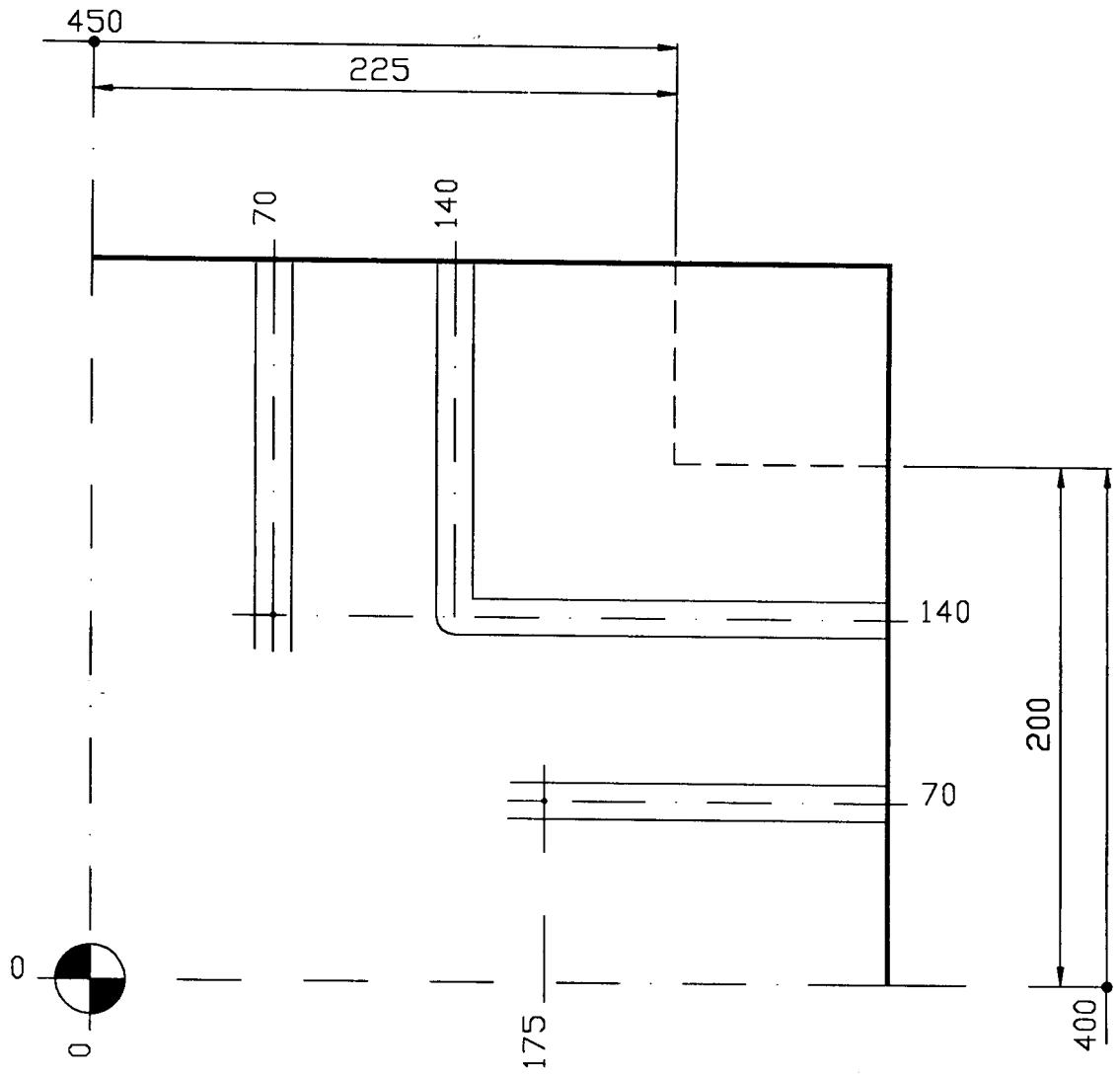
S 450/355



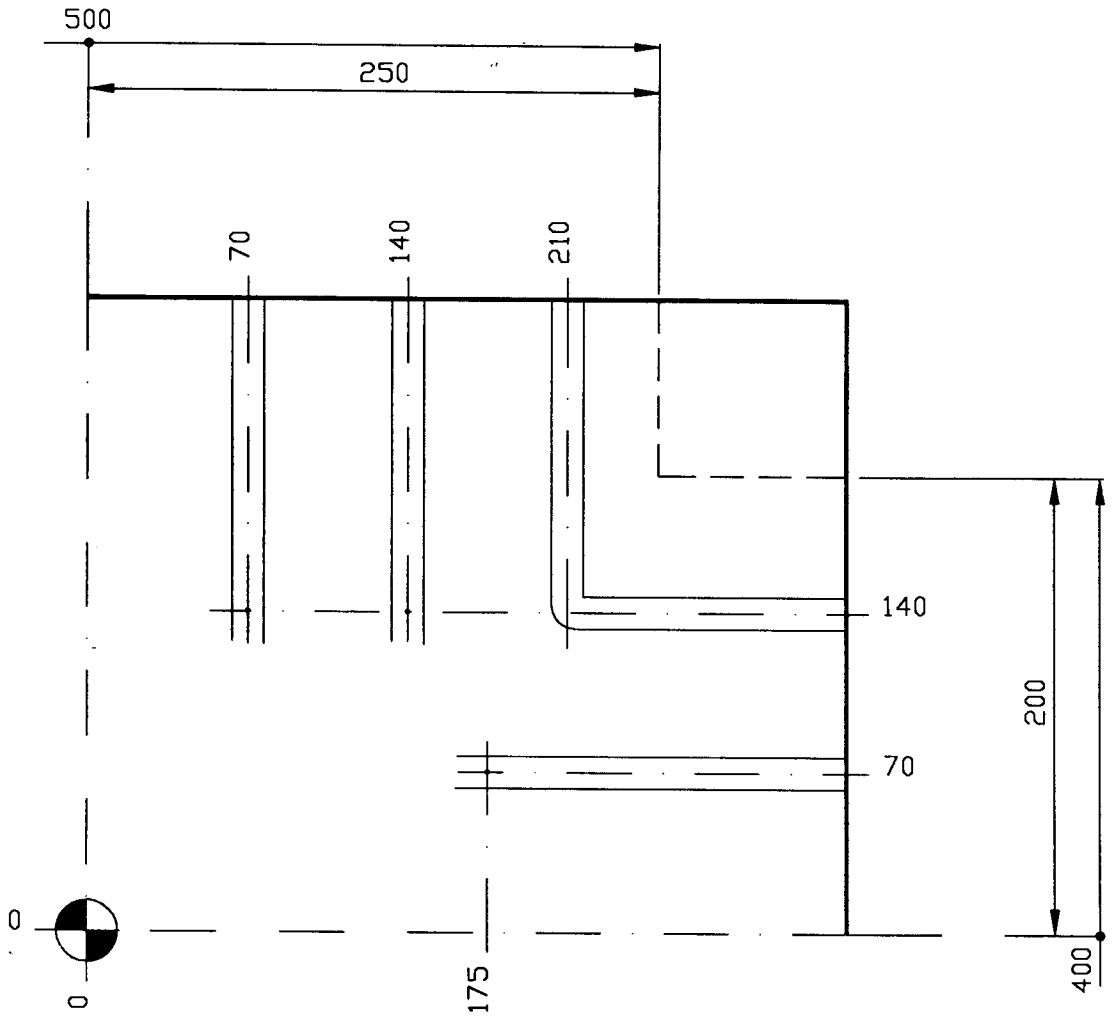
S 400/400



S 450/400



S 500/400



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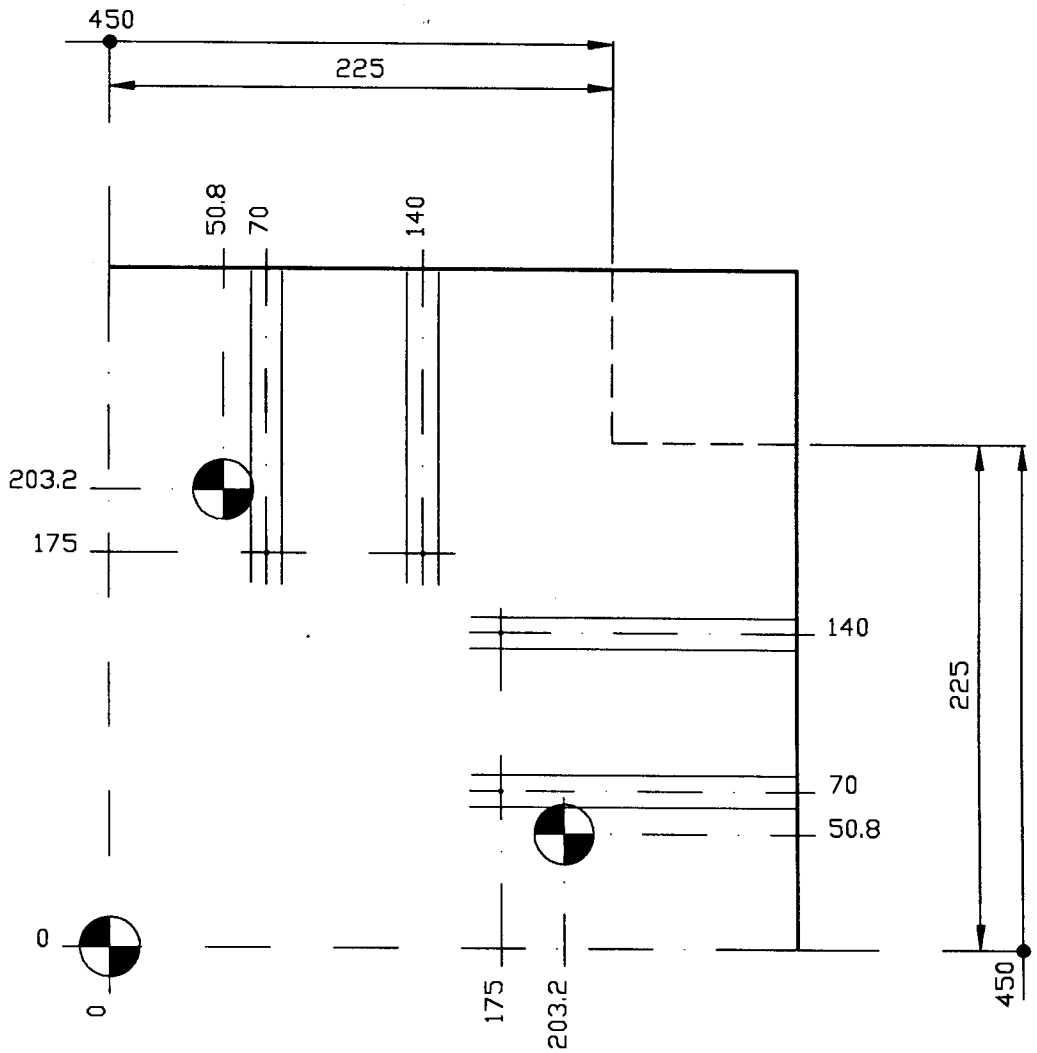

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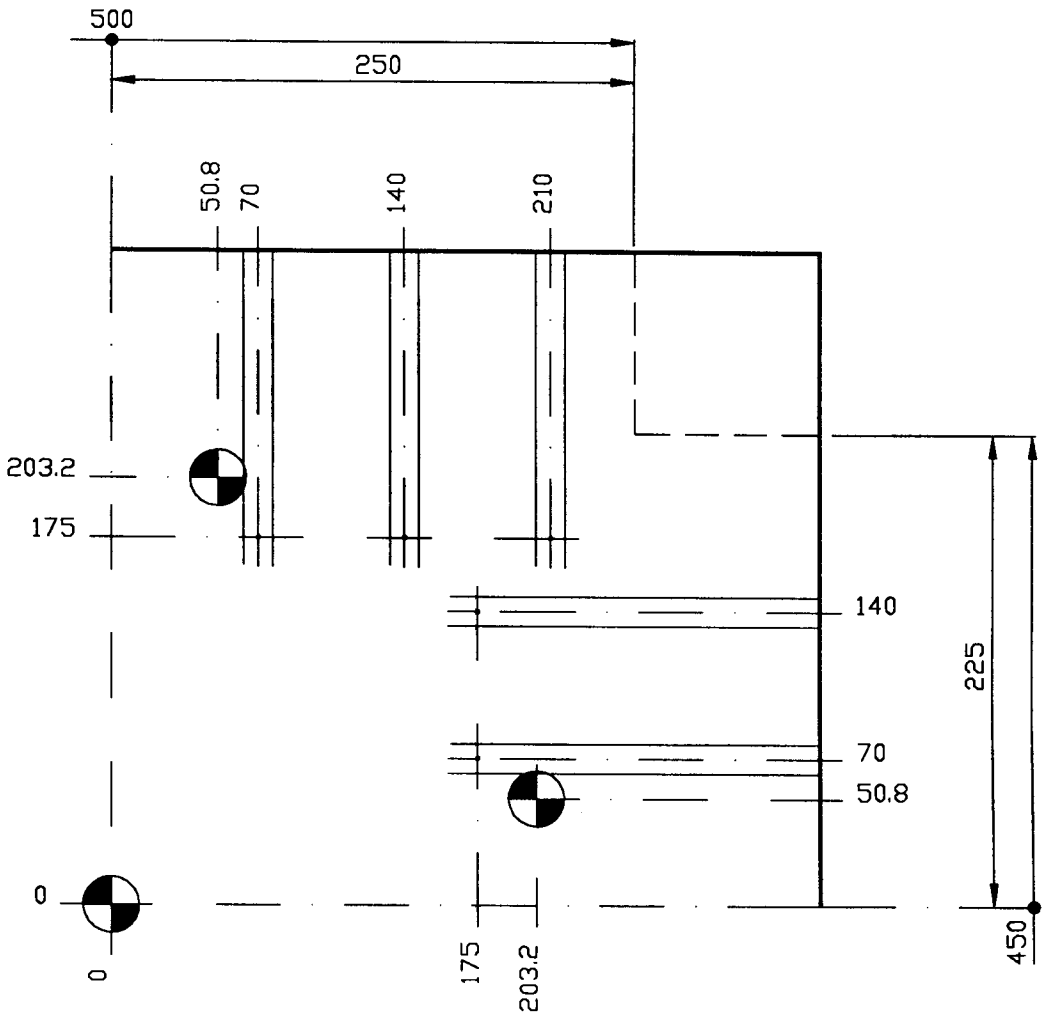
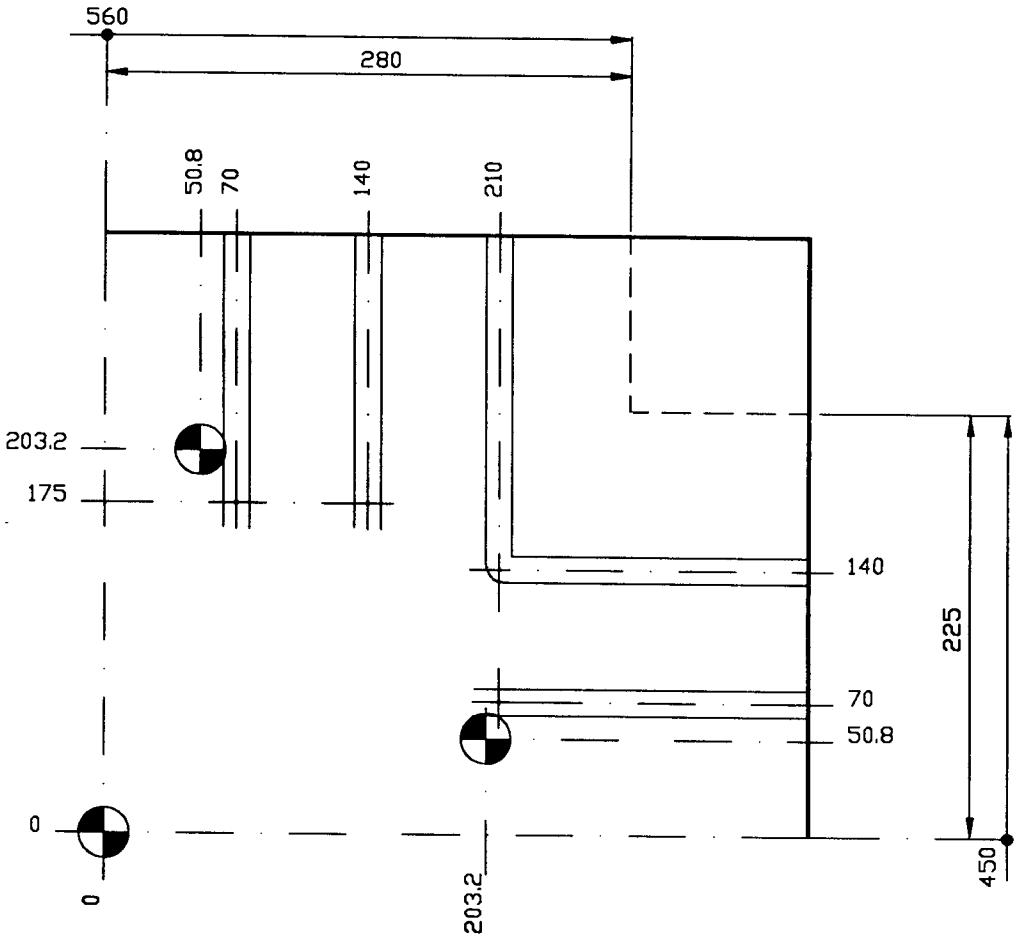
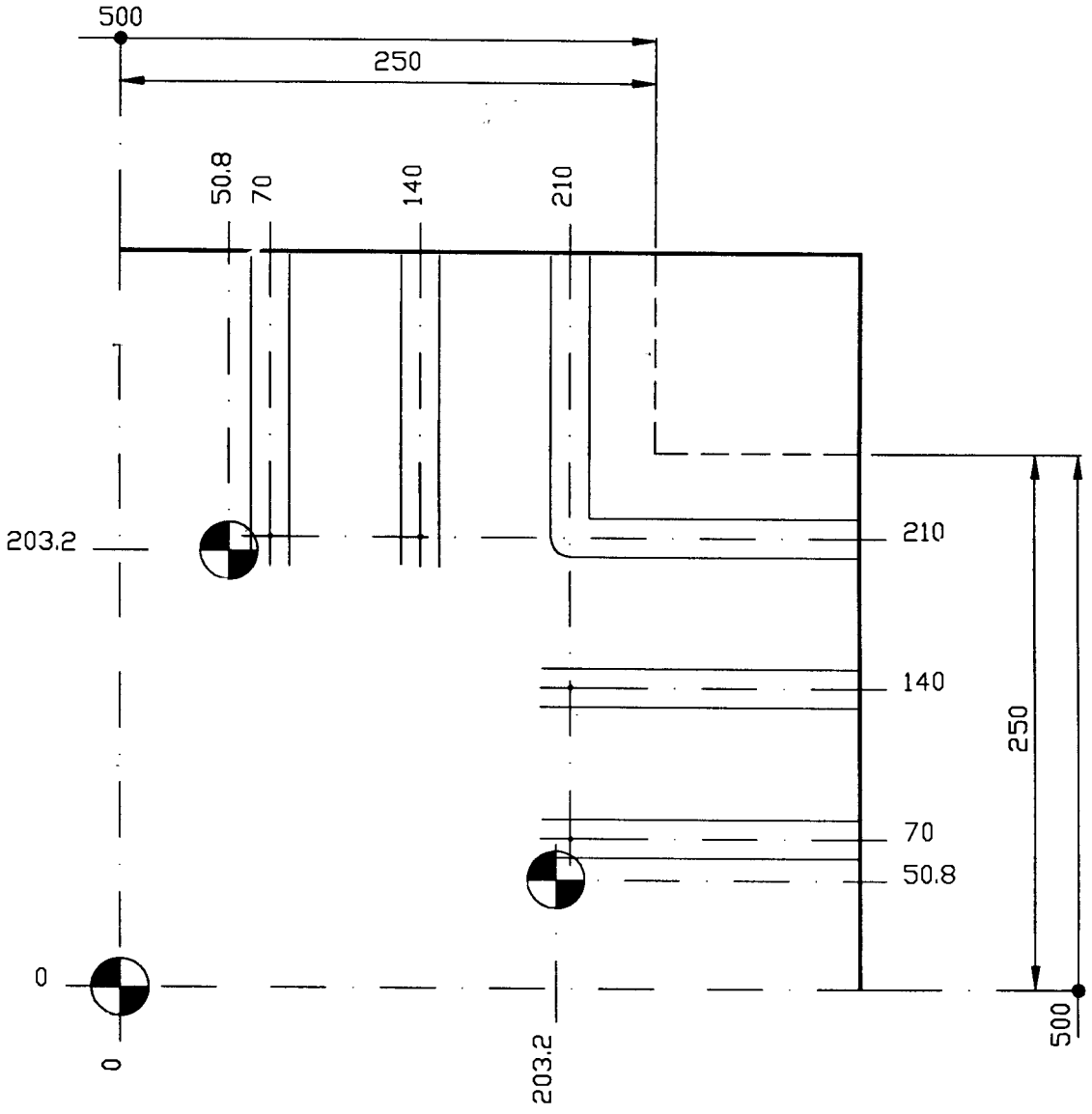


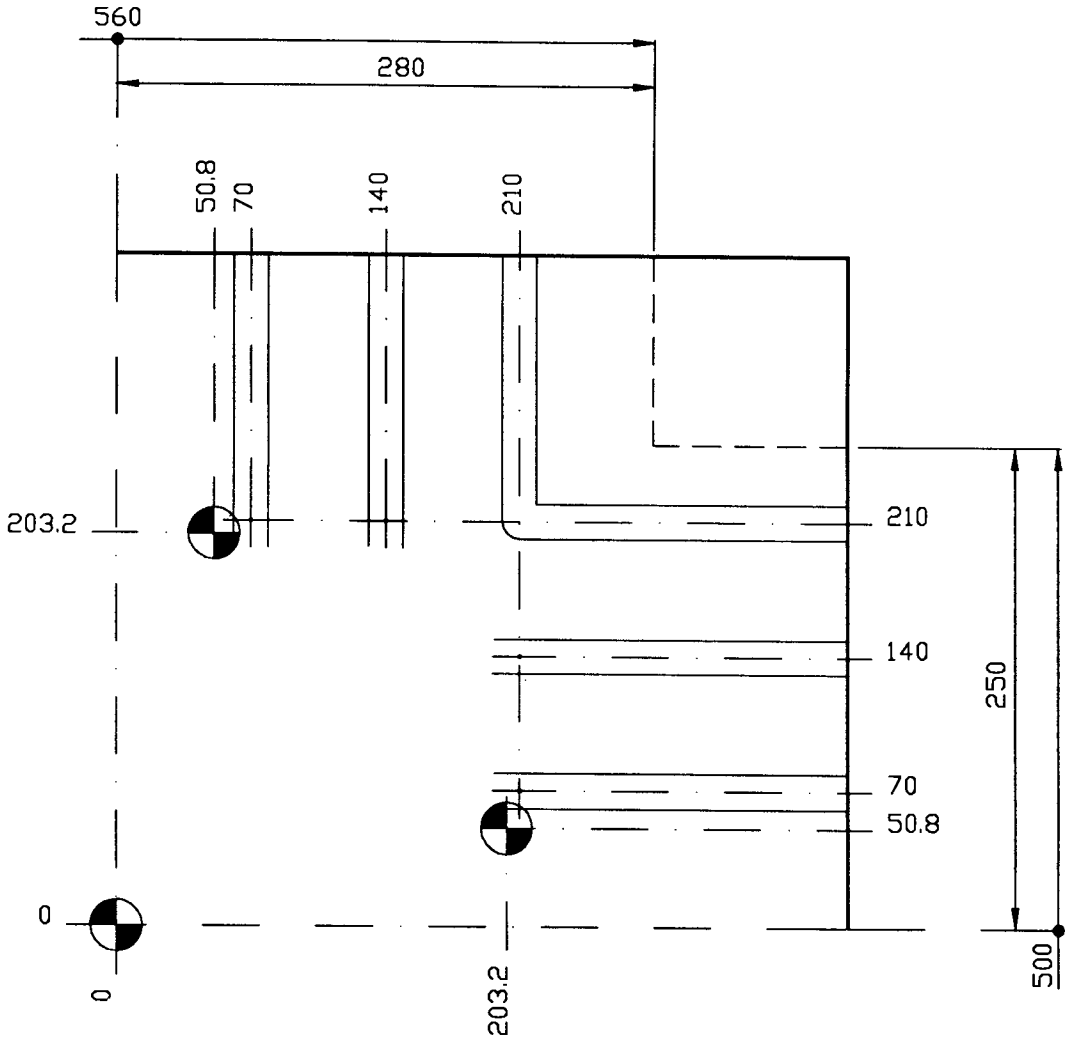
S 560/450



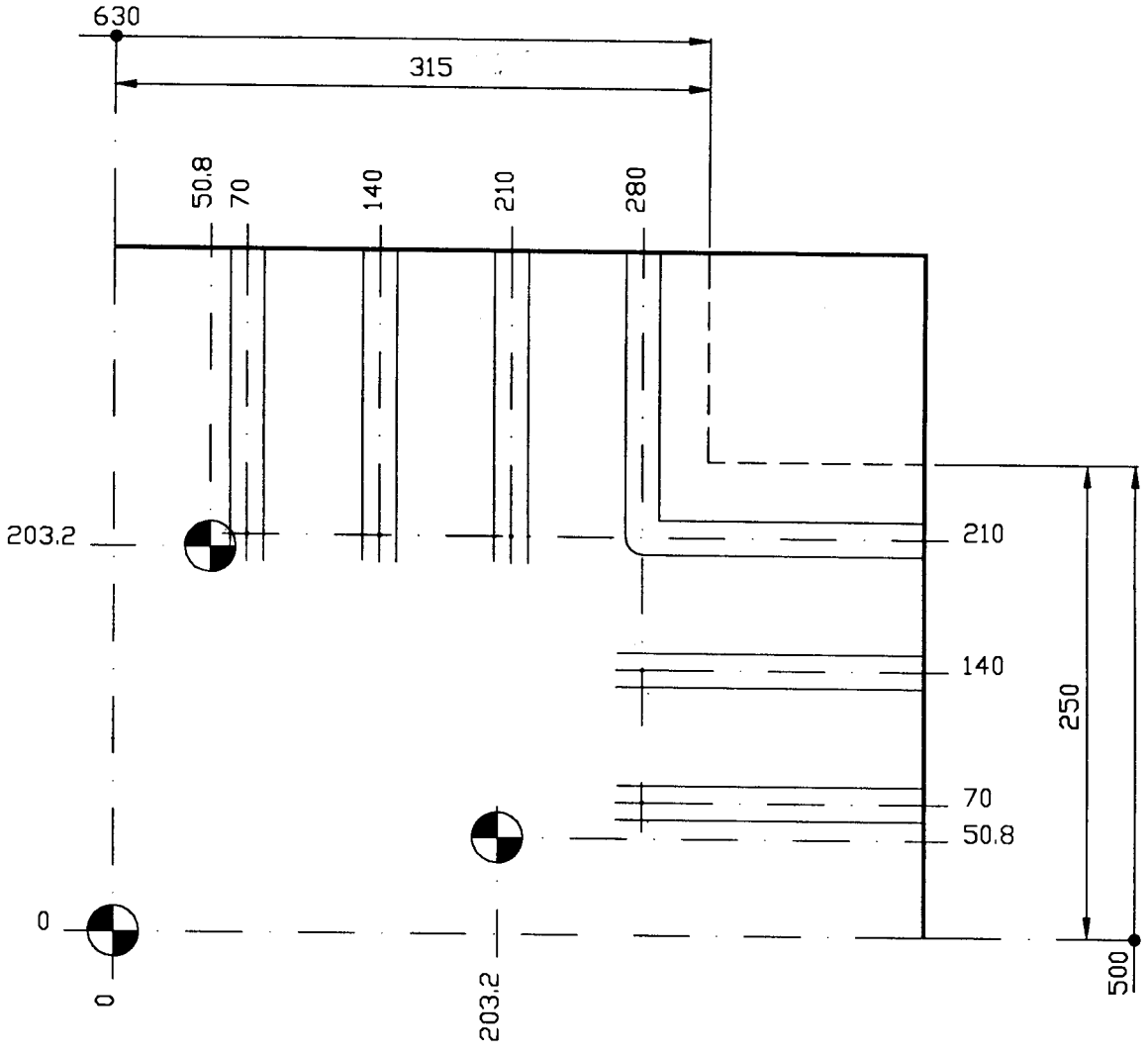
S 500/500



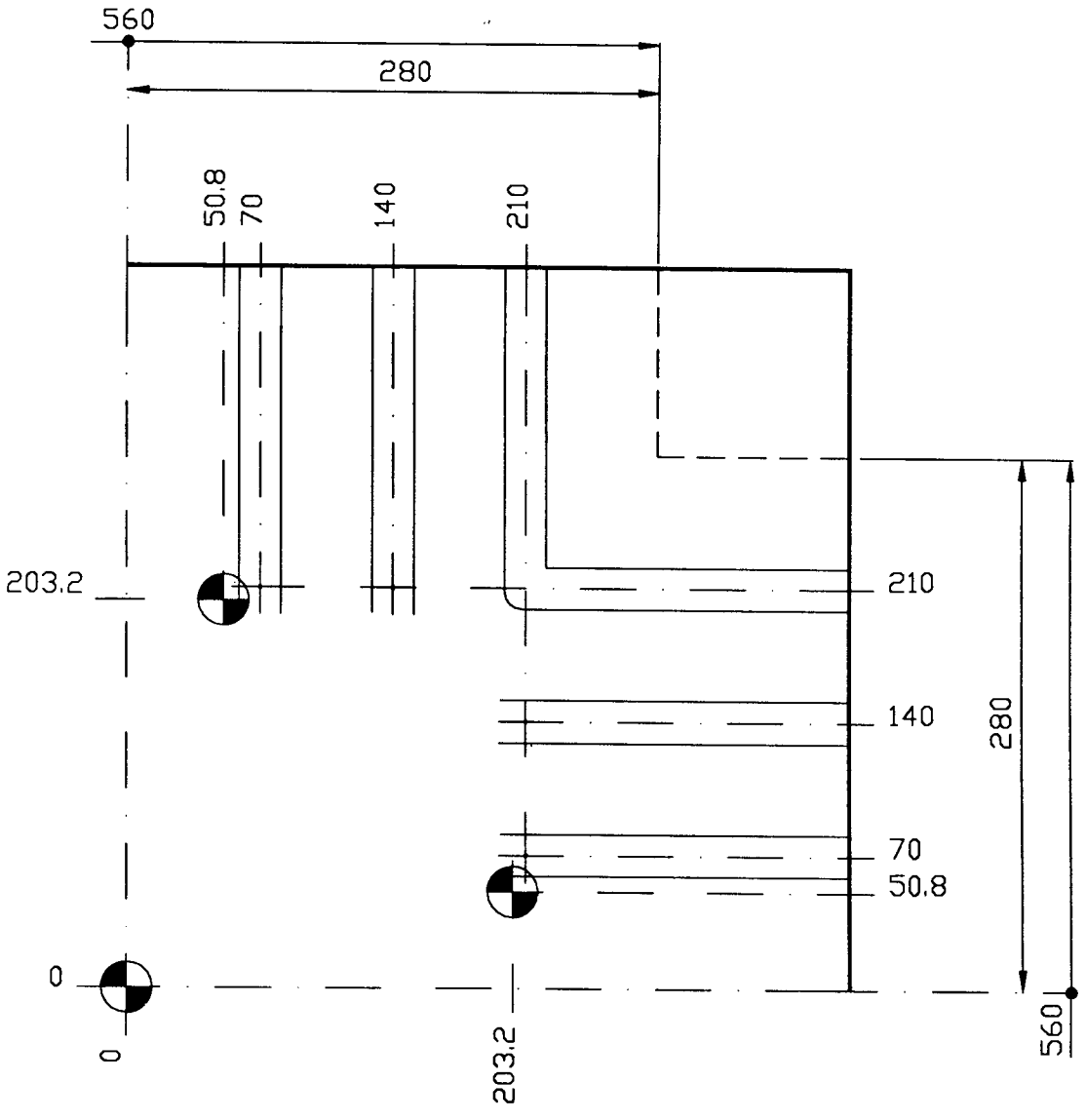
S 560/500



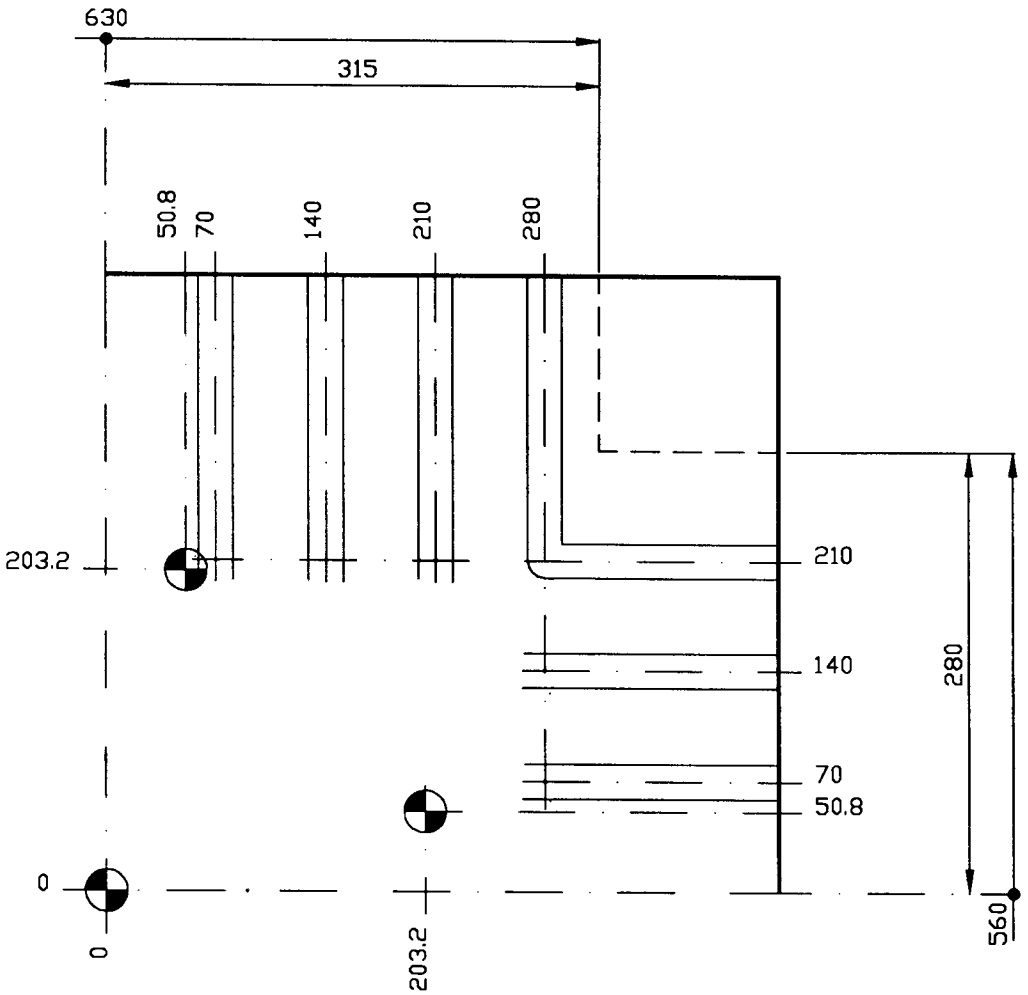
S 630/500



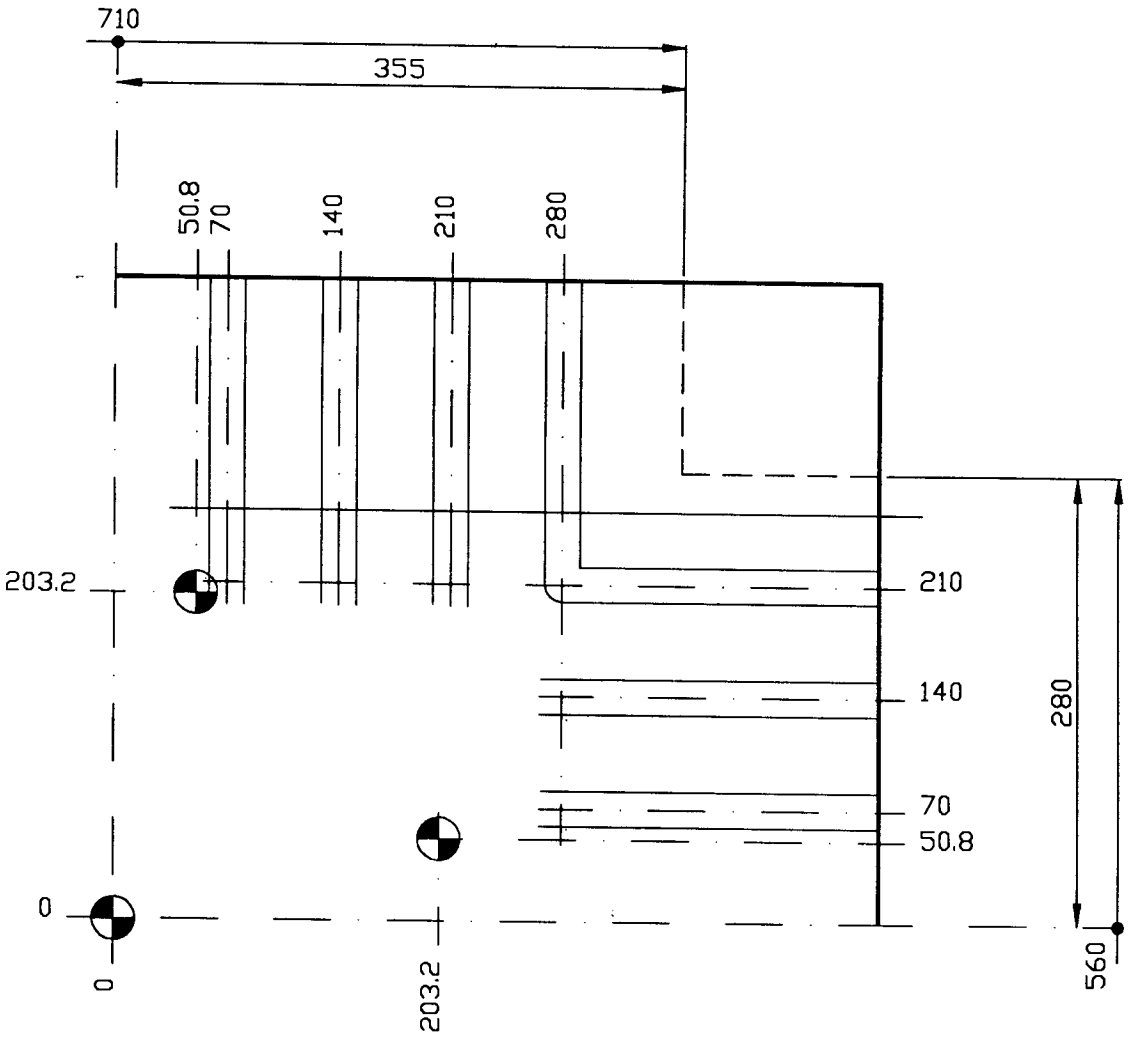
S 560/560



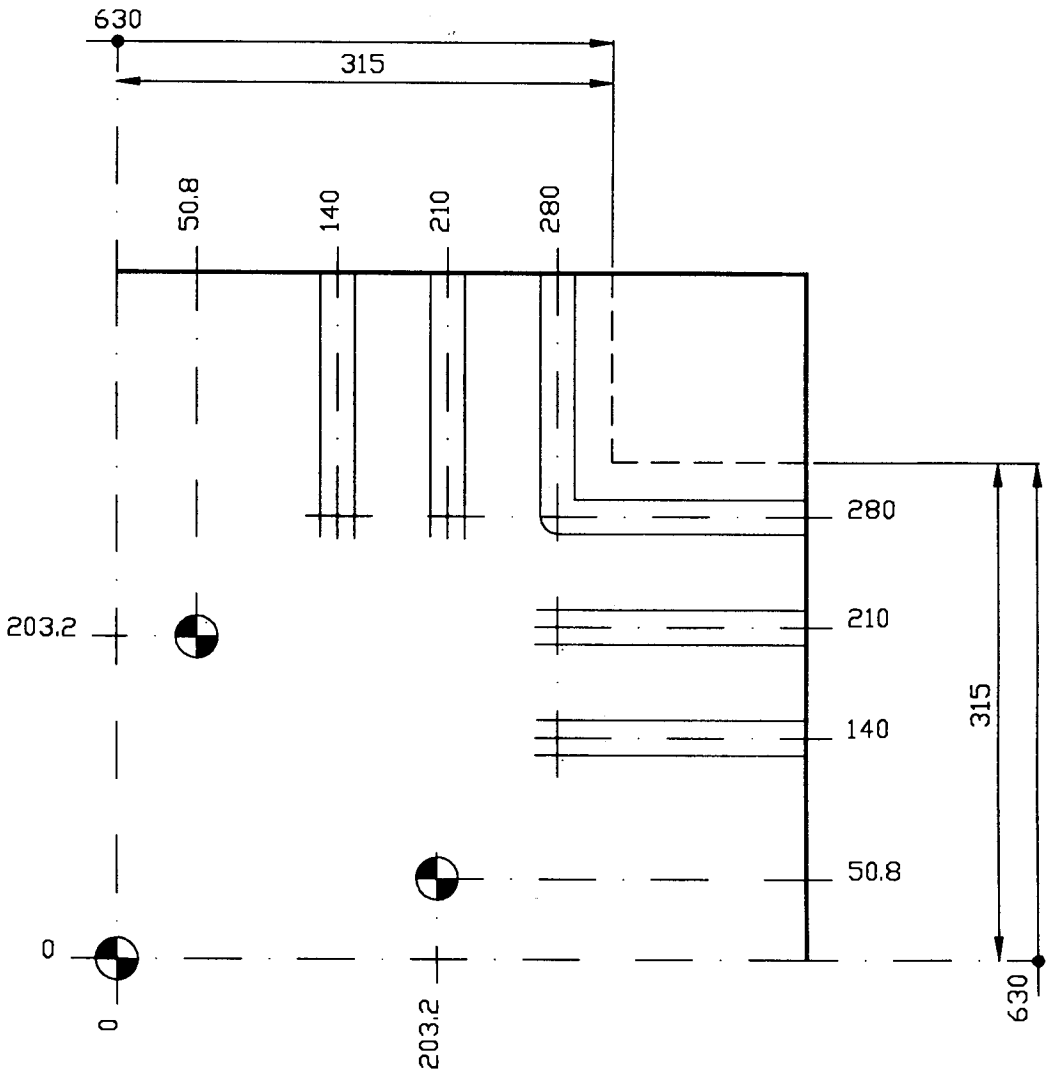
S 630/560



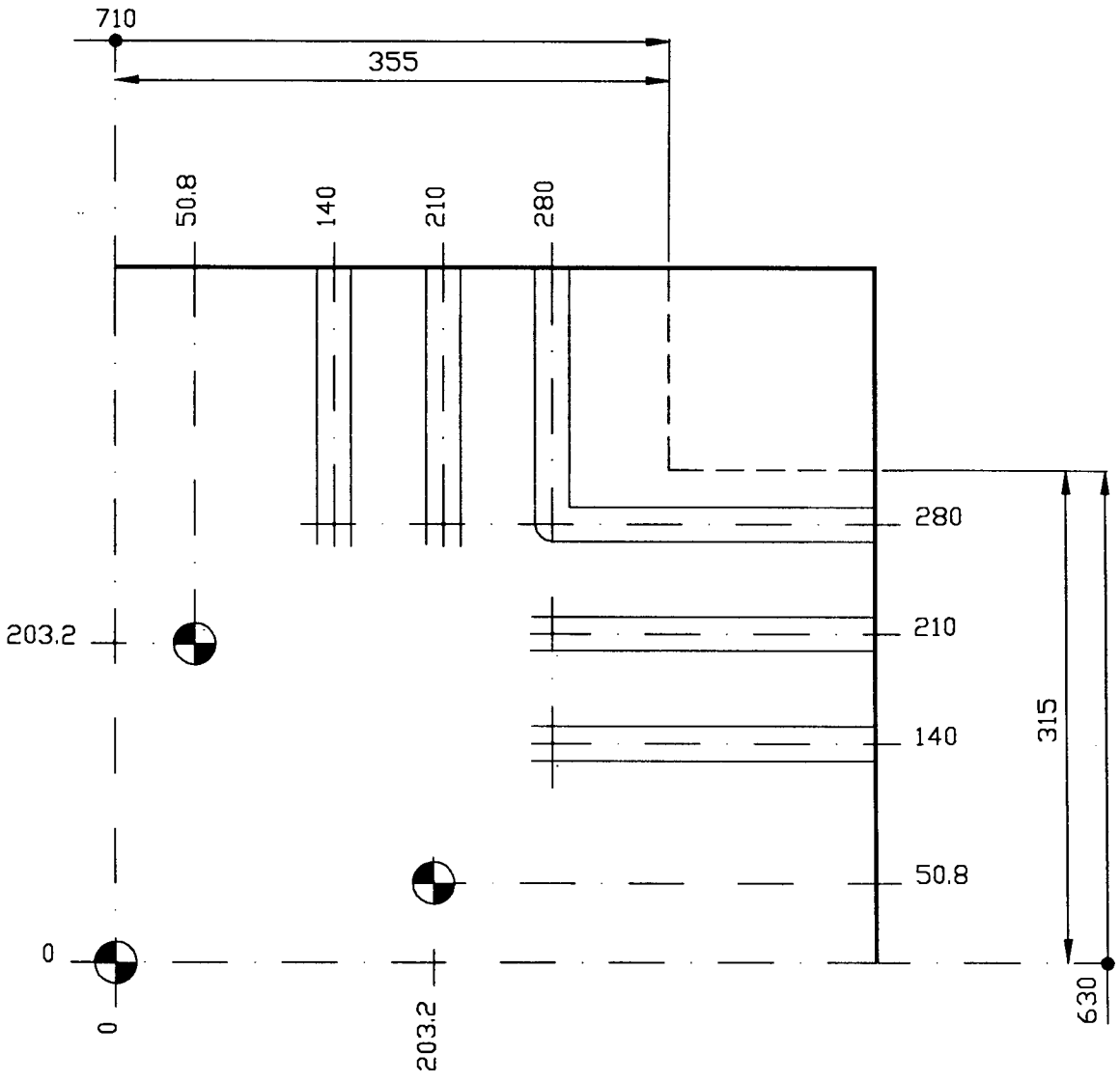
S 710/560



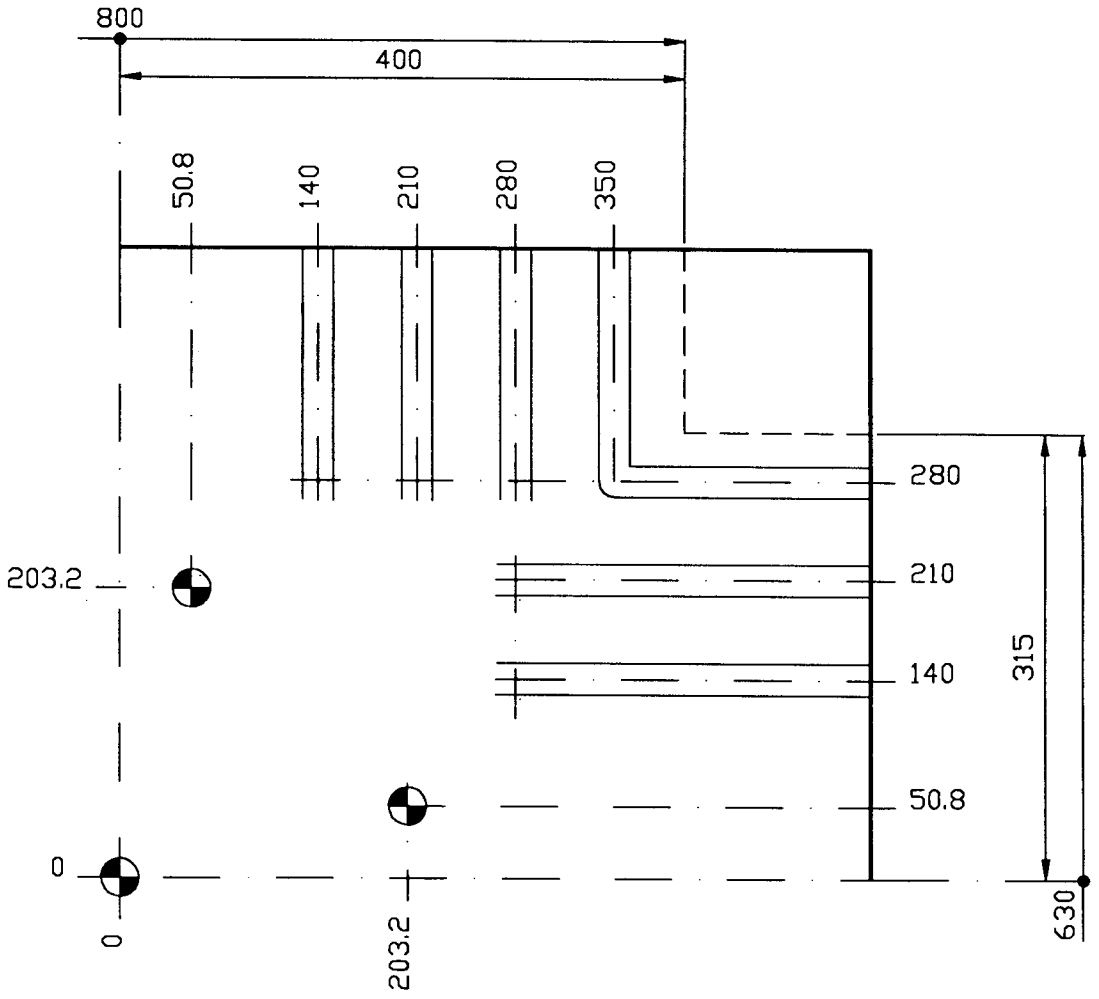
S 630/630



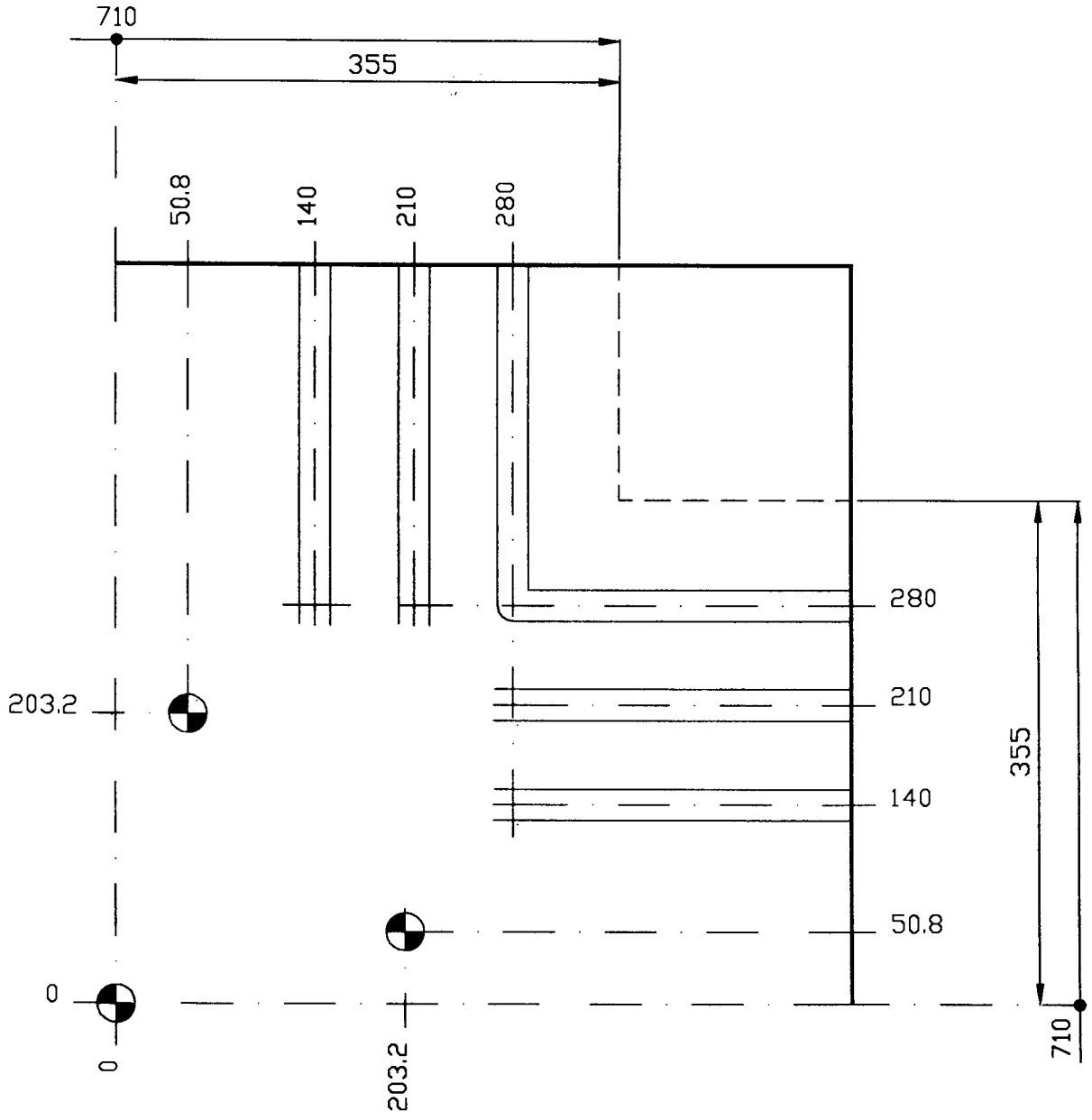
S 710/630



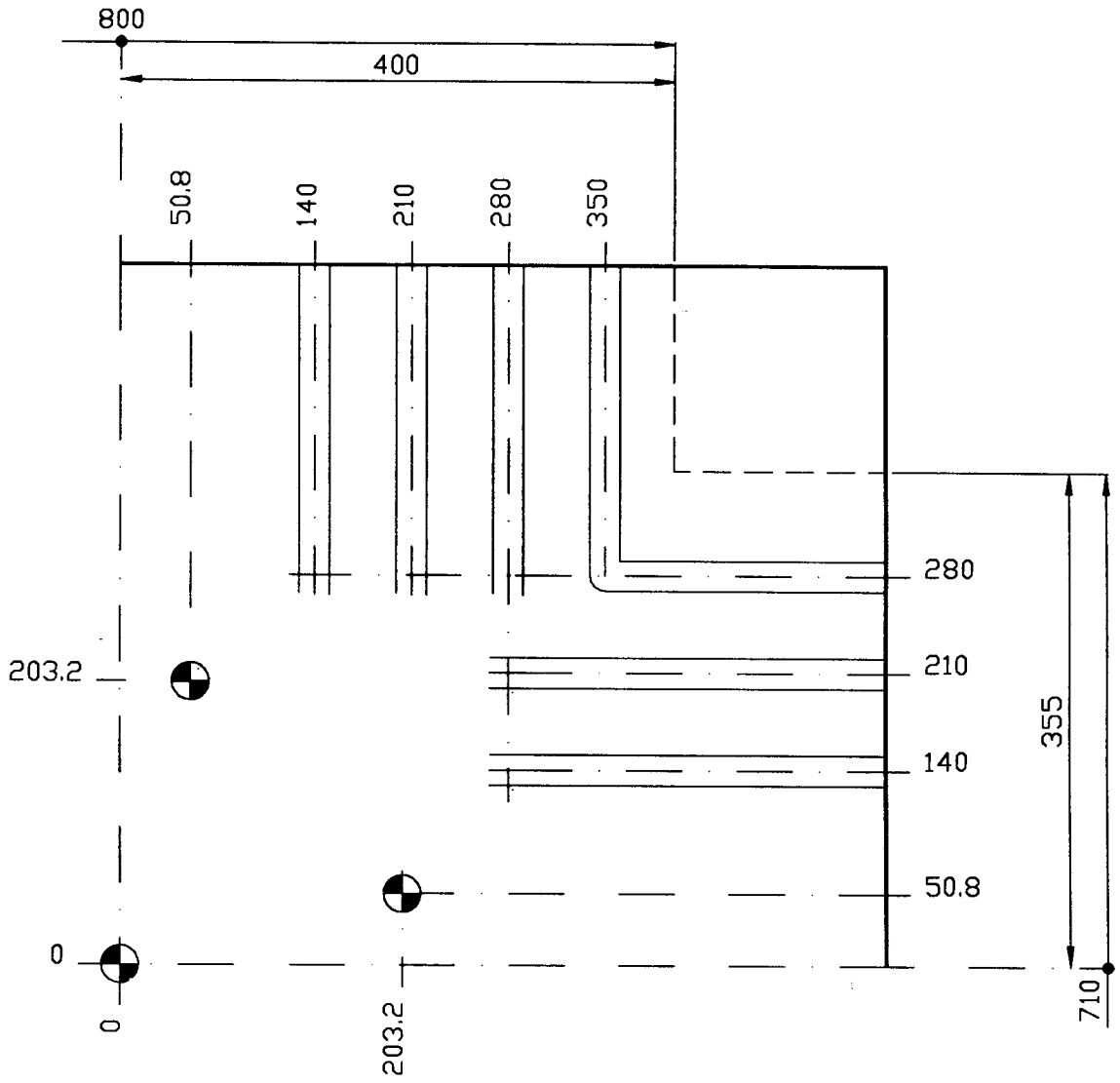
S 800/630



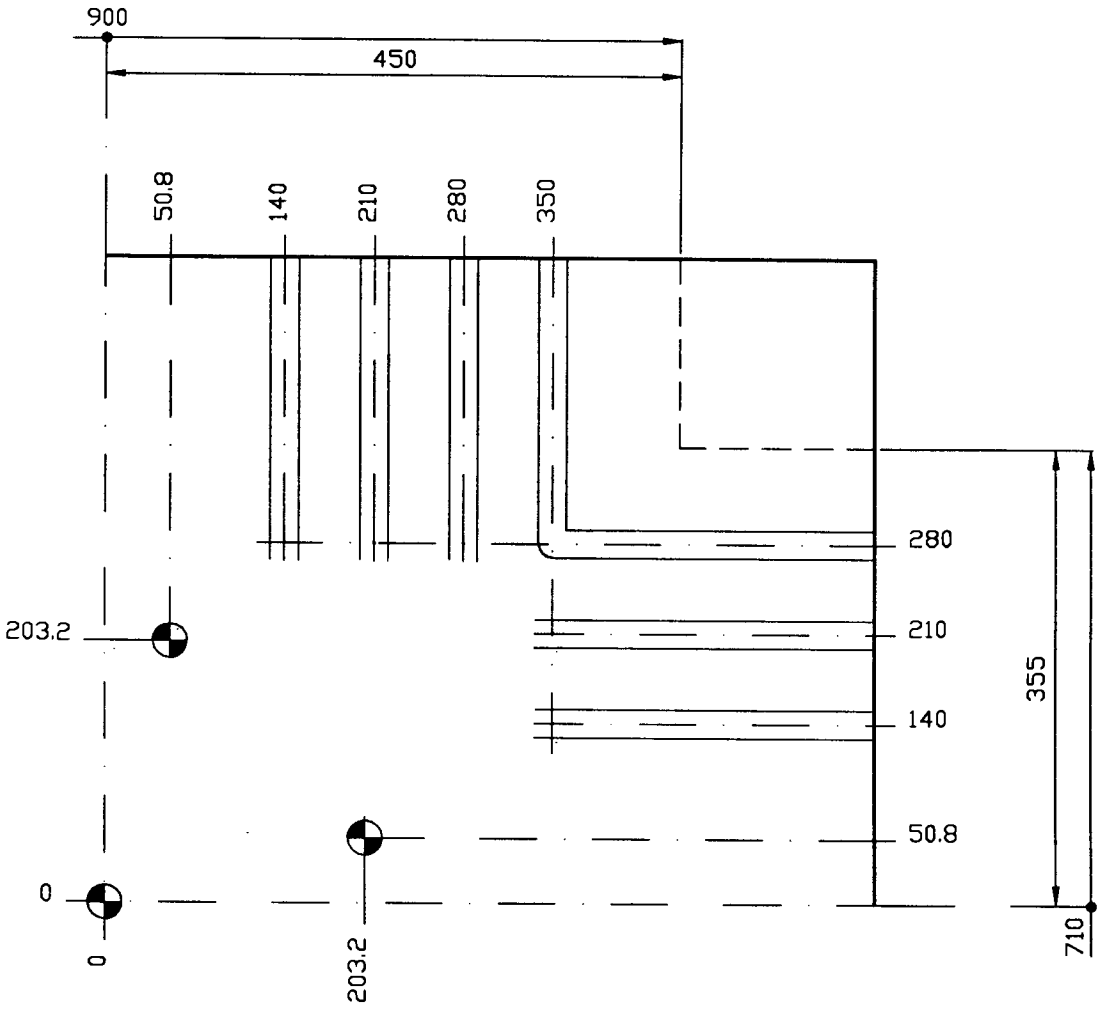
S 710/710



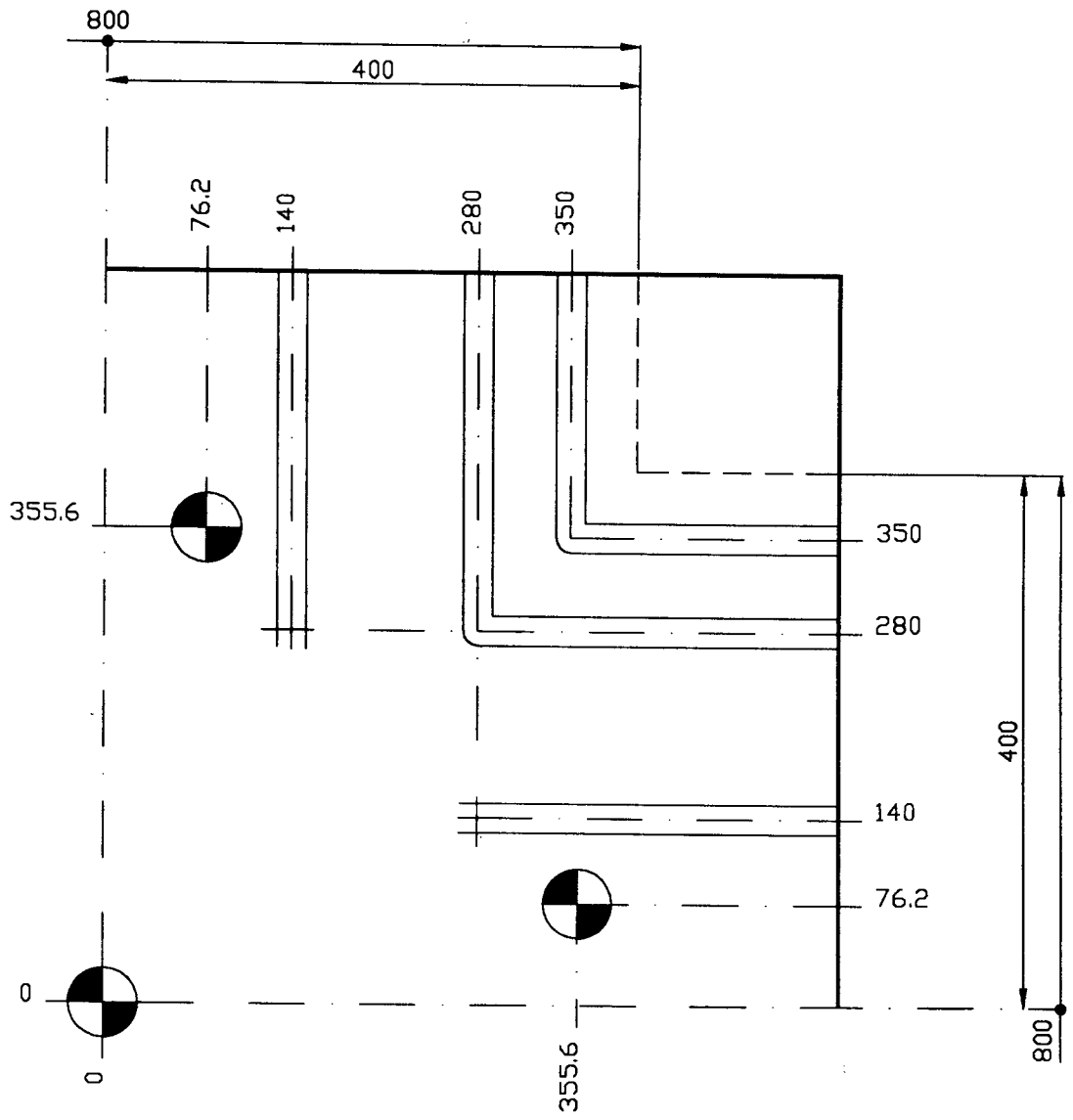
S 800/710



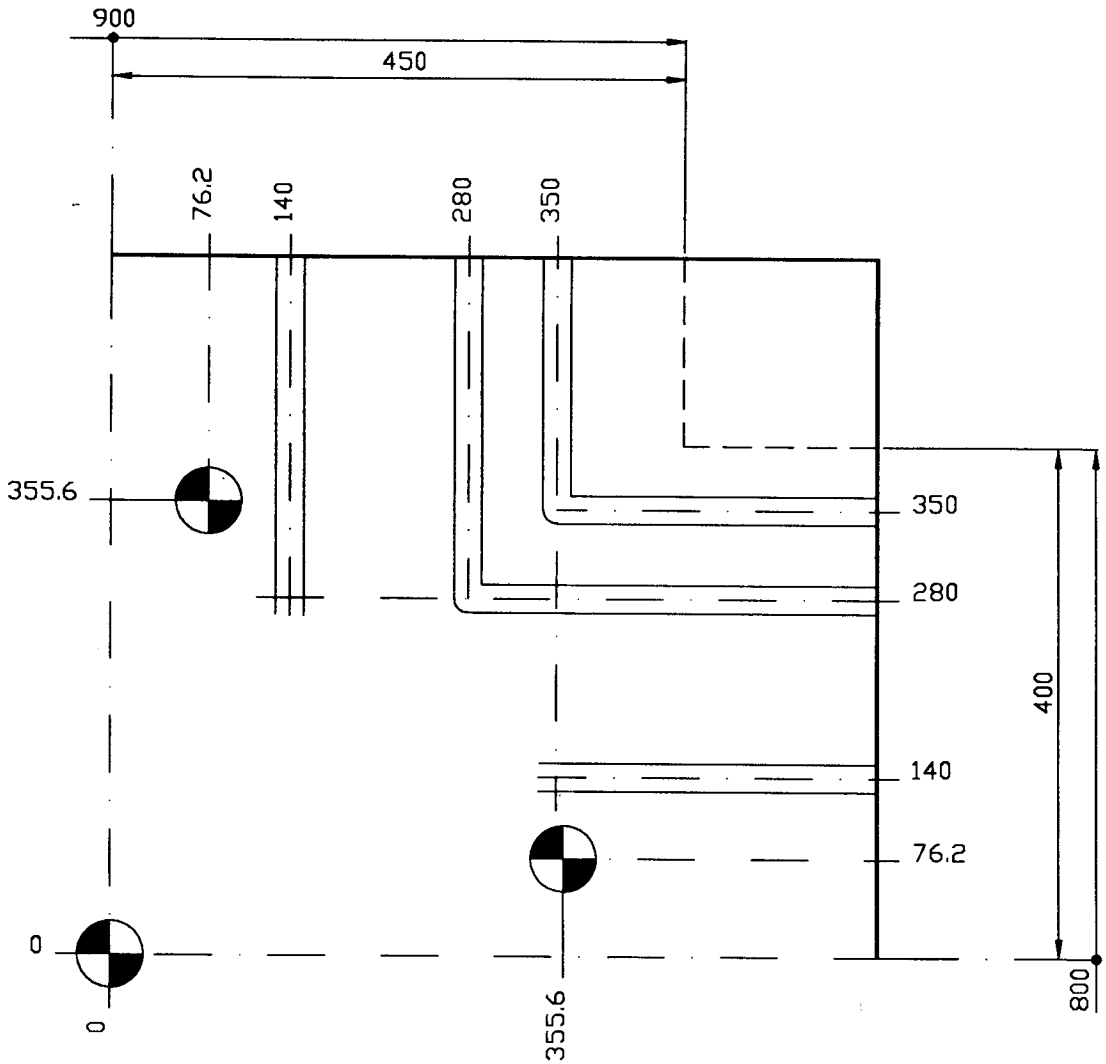
S 900/710



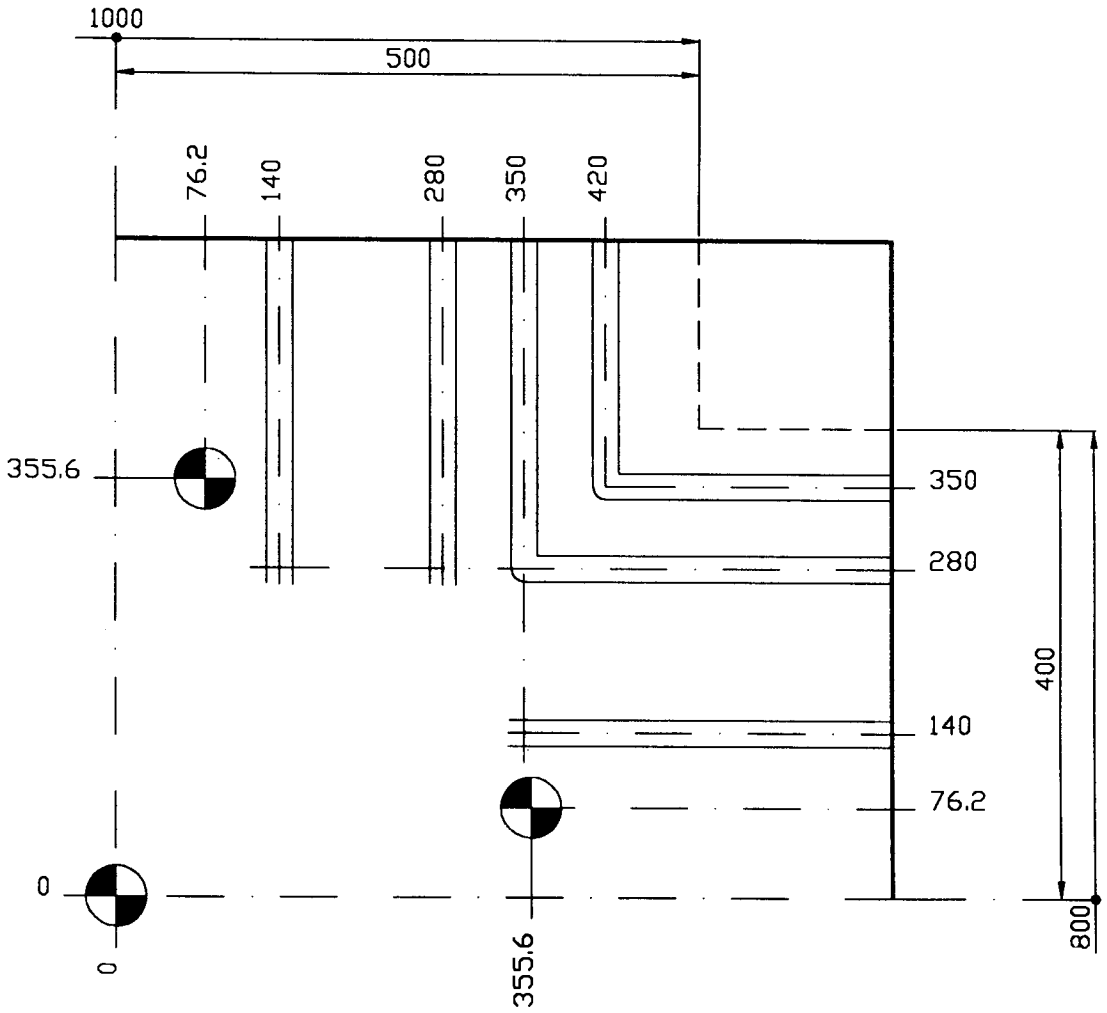
S 800/800



S 900/800



S 1000/800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355.6
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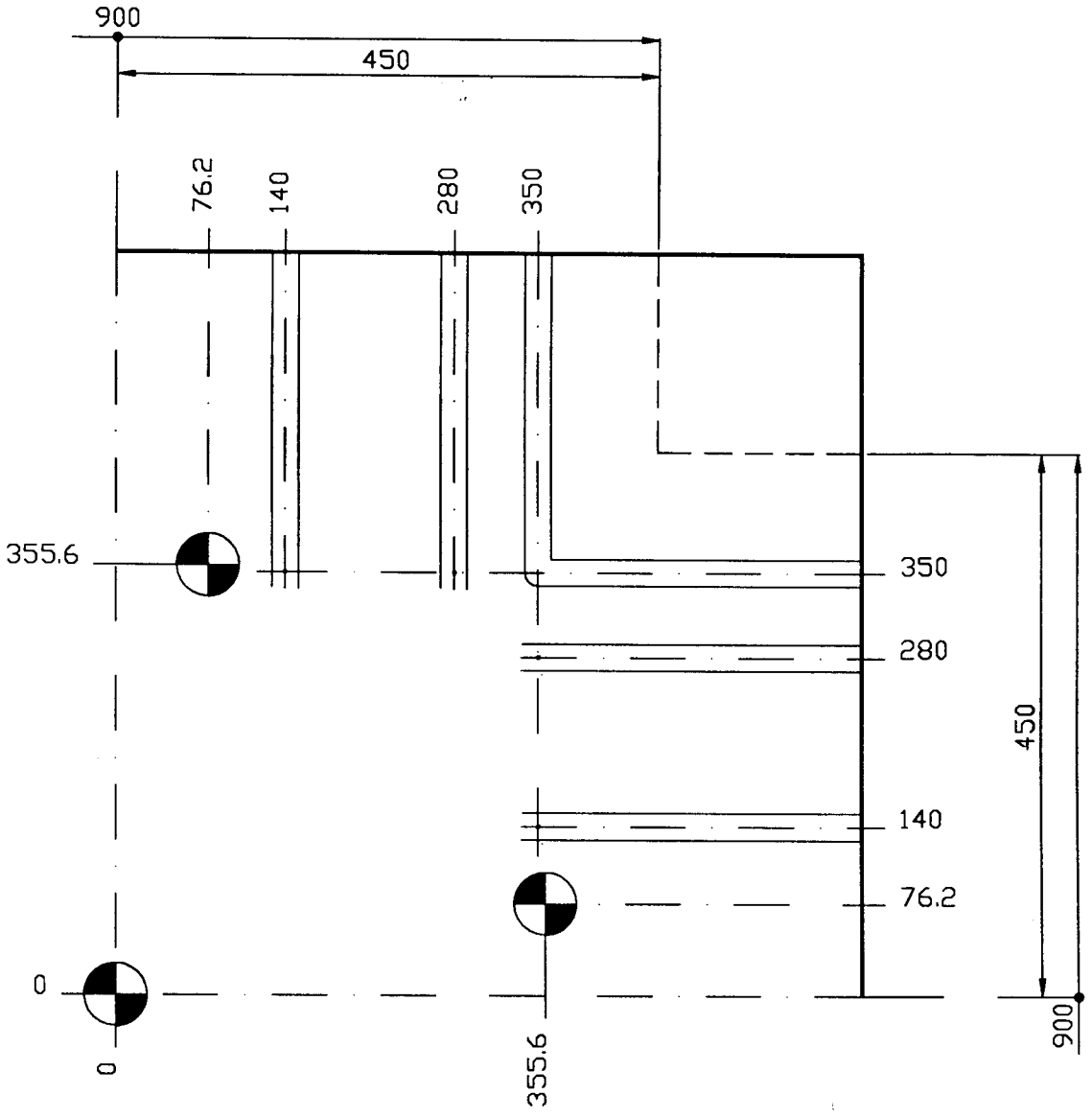
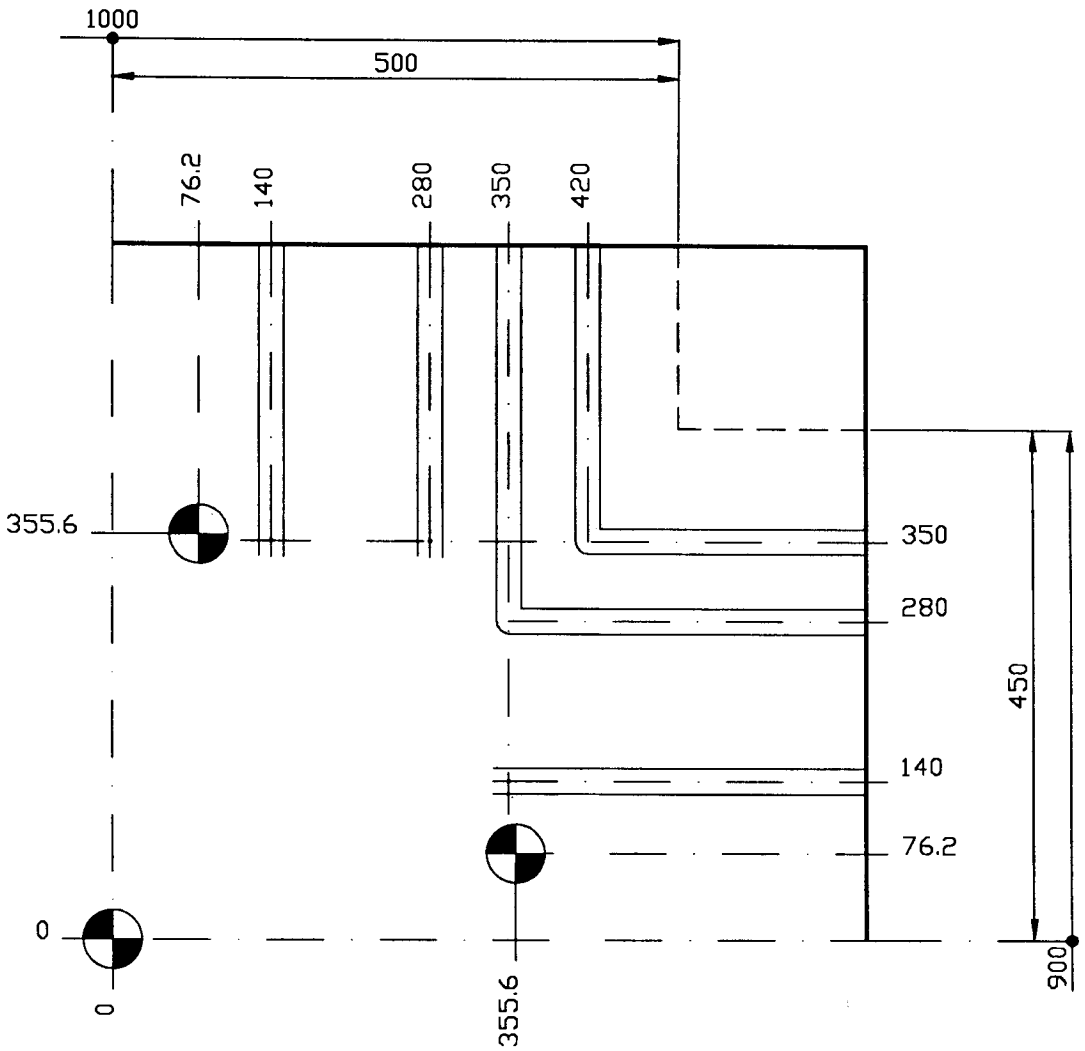
140
76.2
400
0
0
355.6
800

S 900/900



S 1000/900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0
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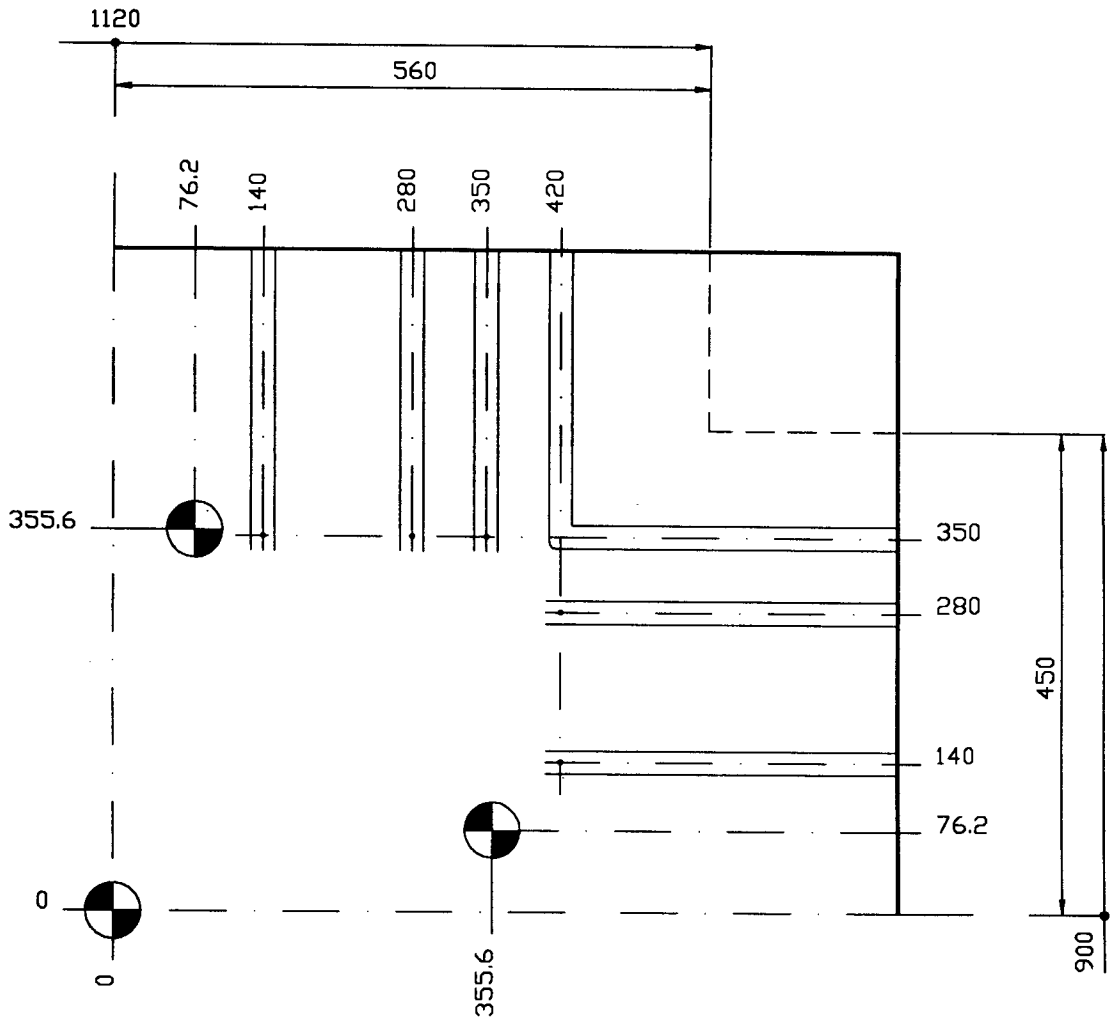
355.6
900

S 1120/900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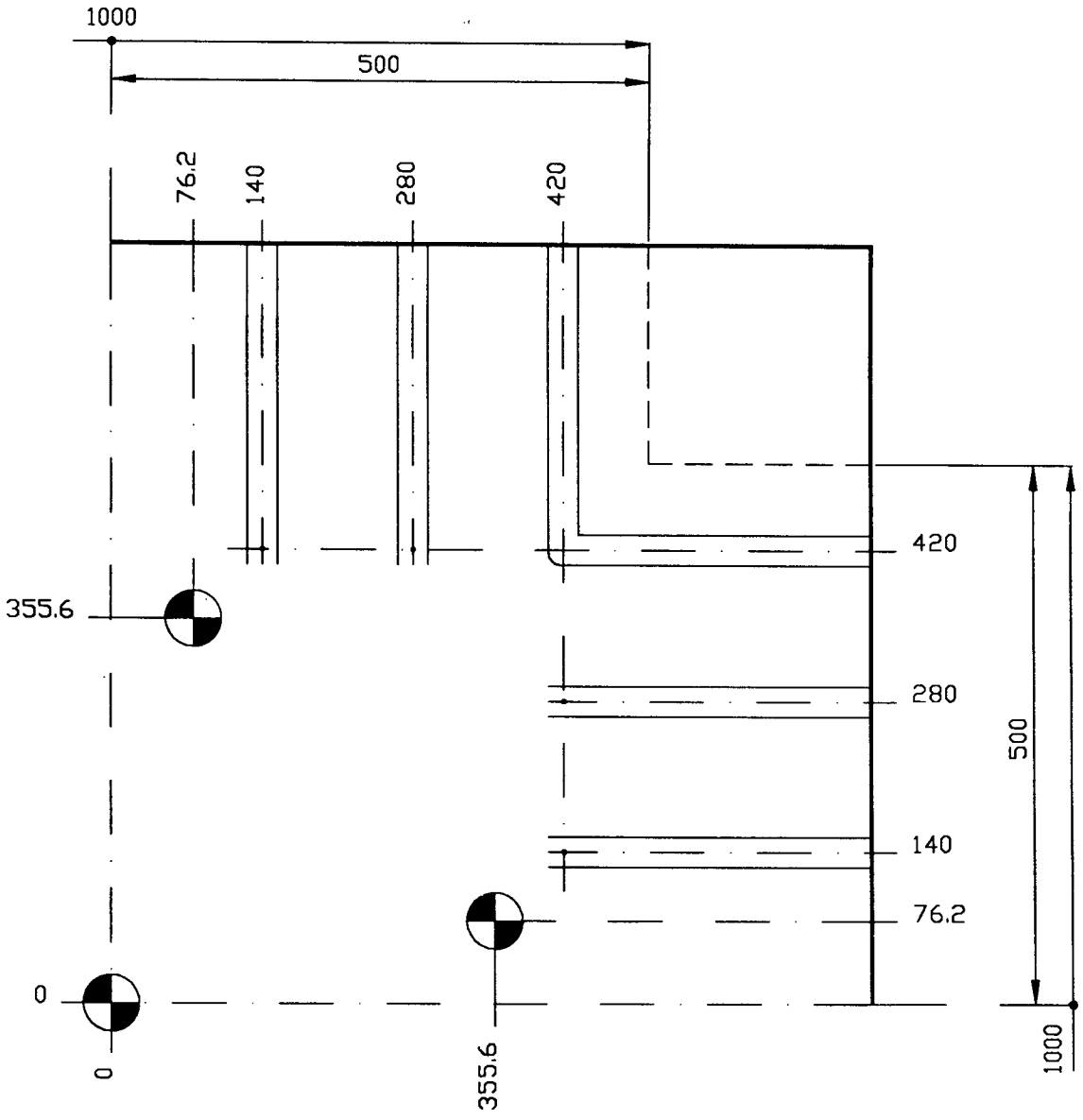
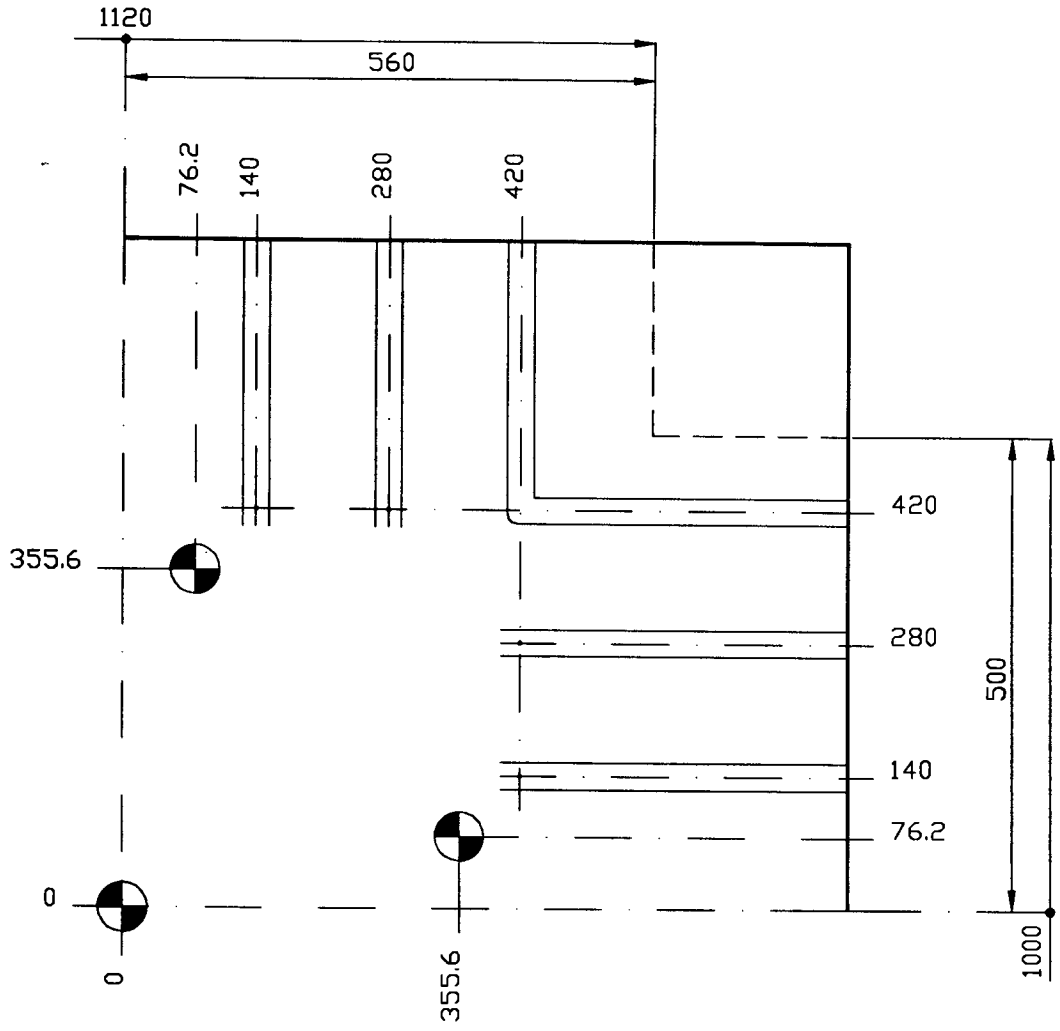
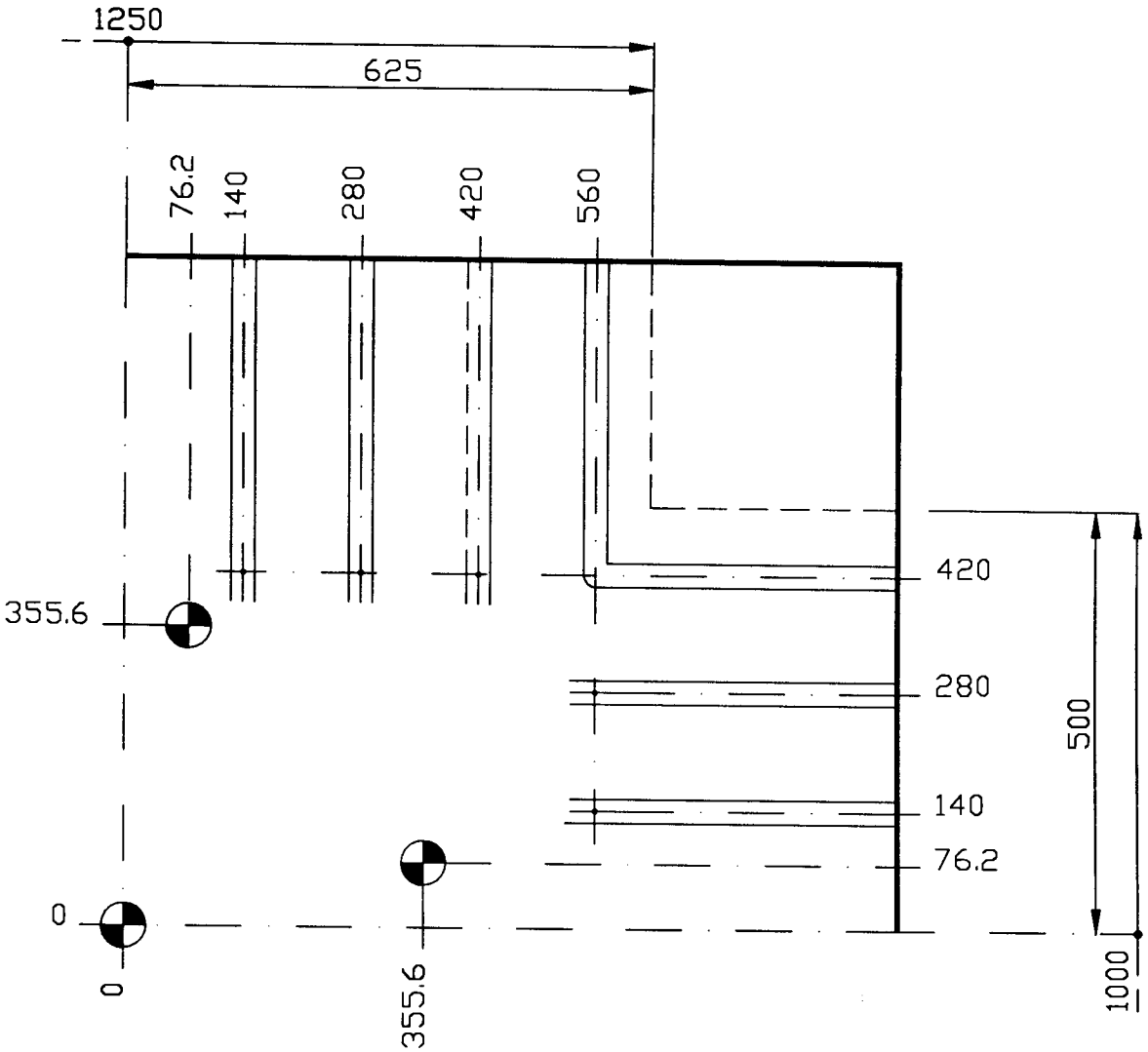
S 1000/1000



S 1120/1000



S 1250/1000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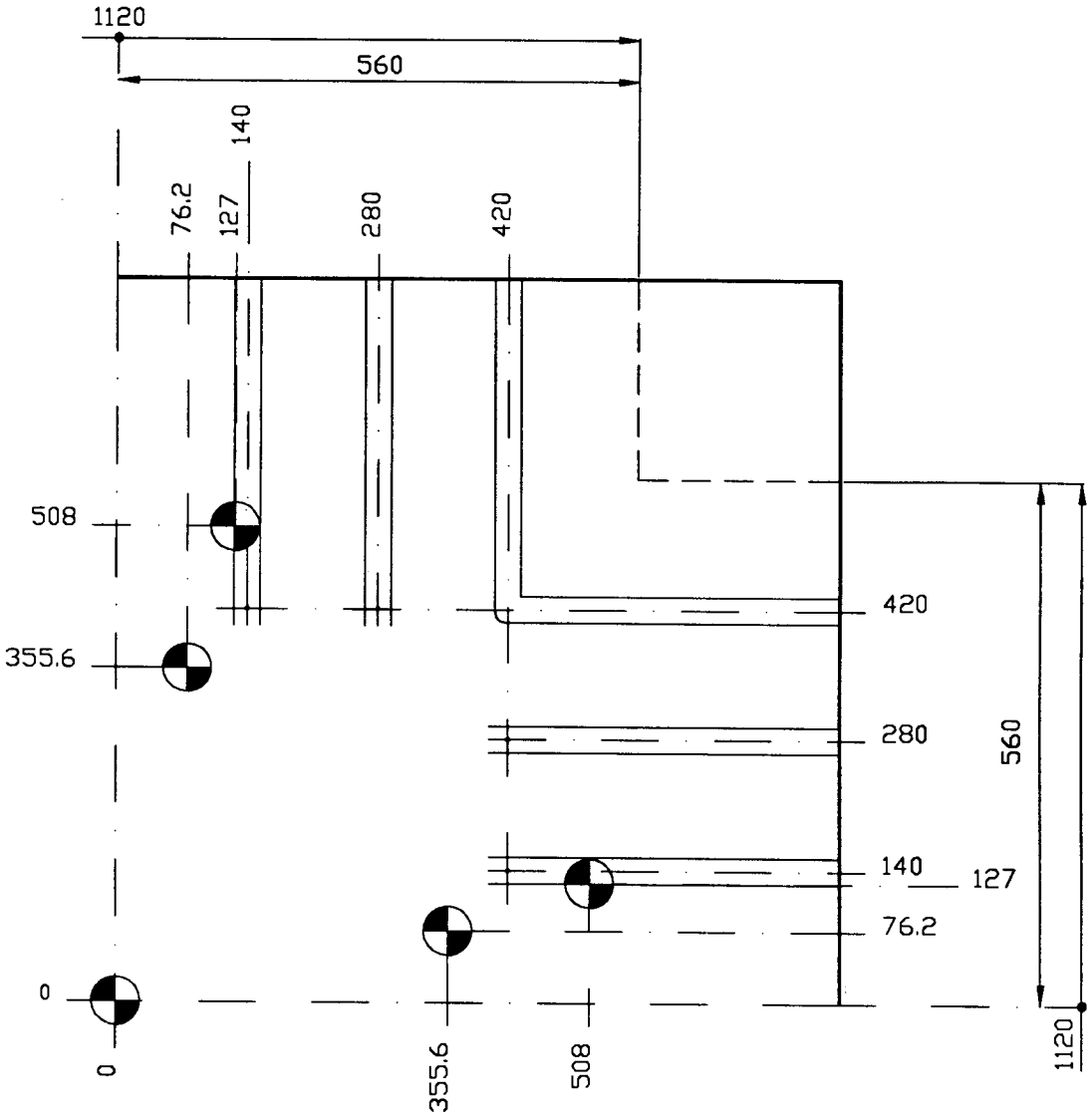
1000

S 1120/1120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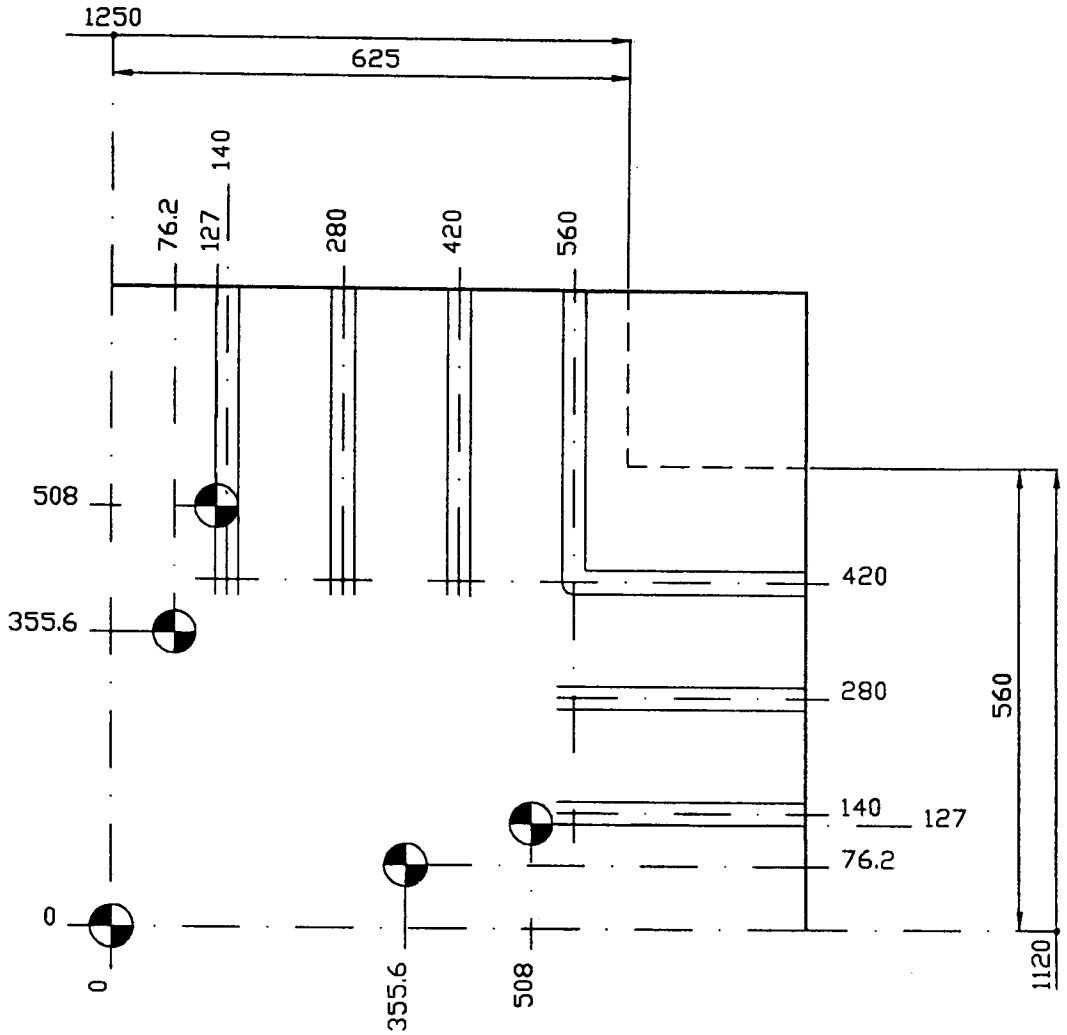
1120

S 1250/1120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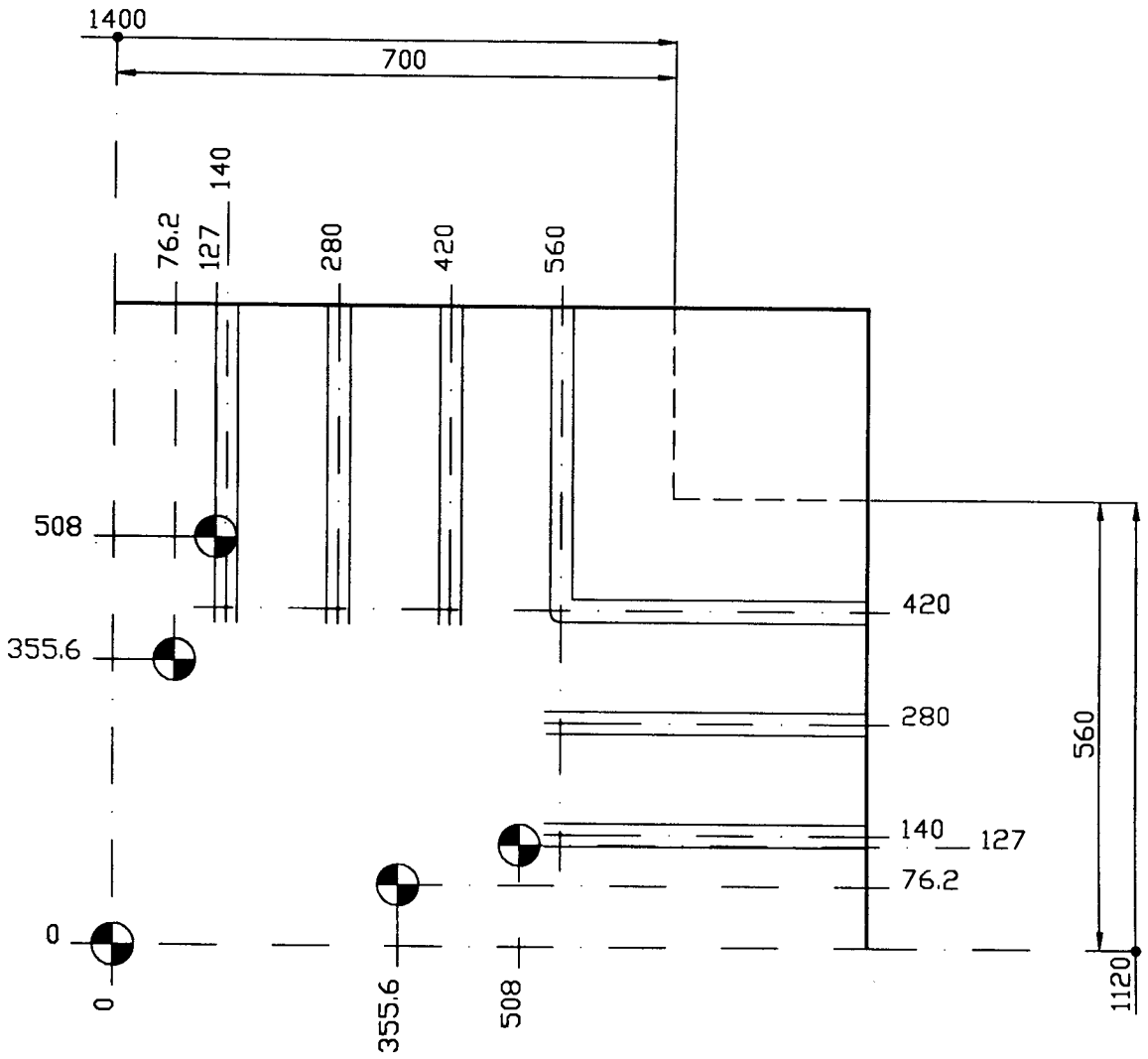
S 1400/1120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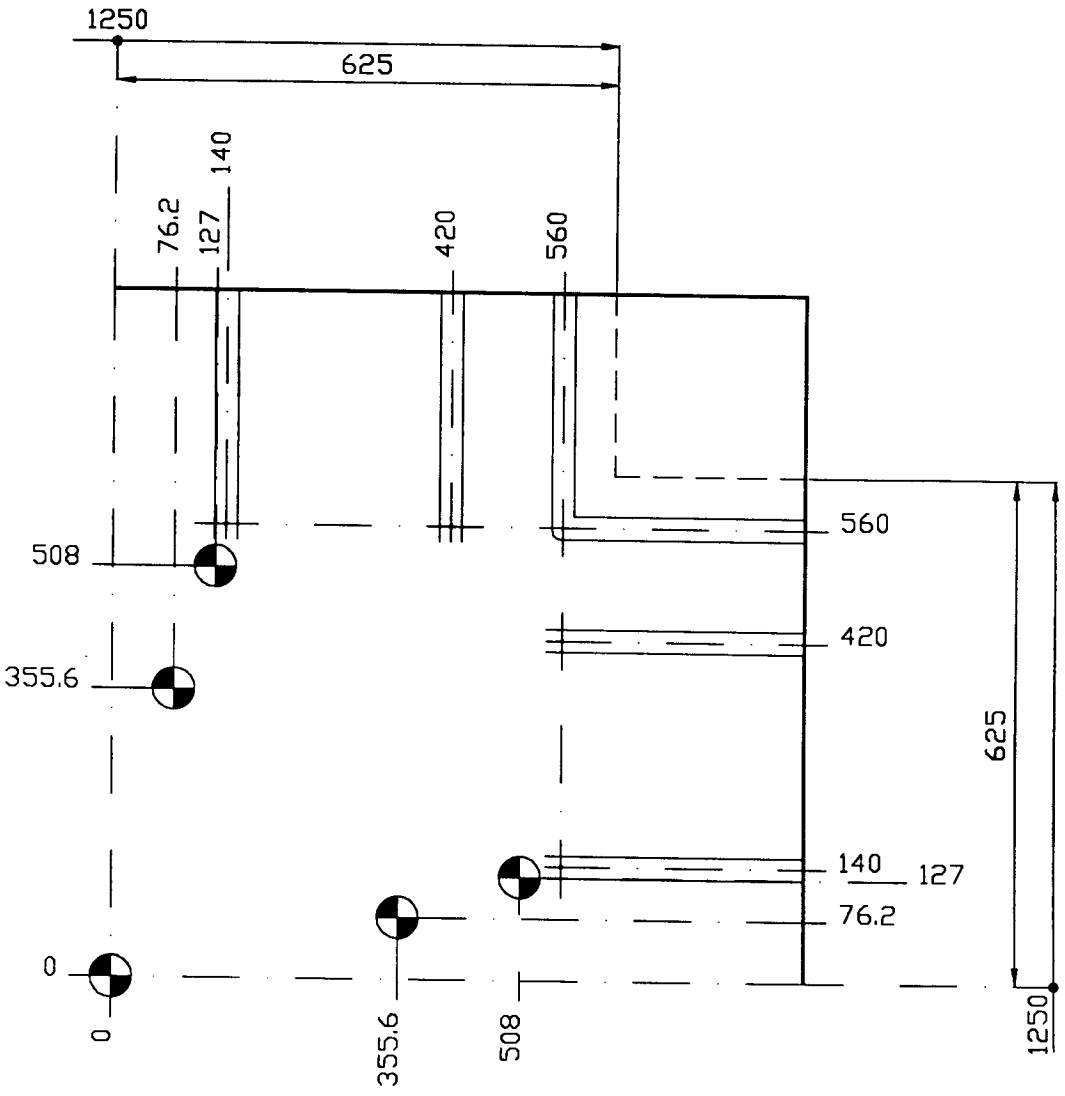
1120

S 1250/1250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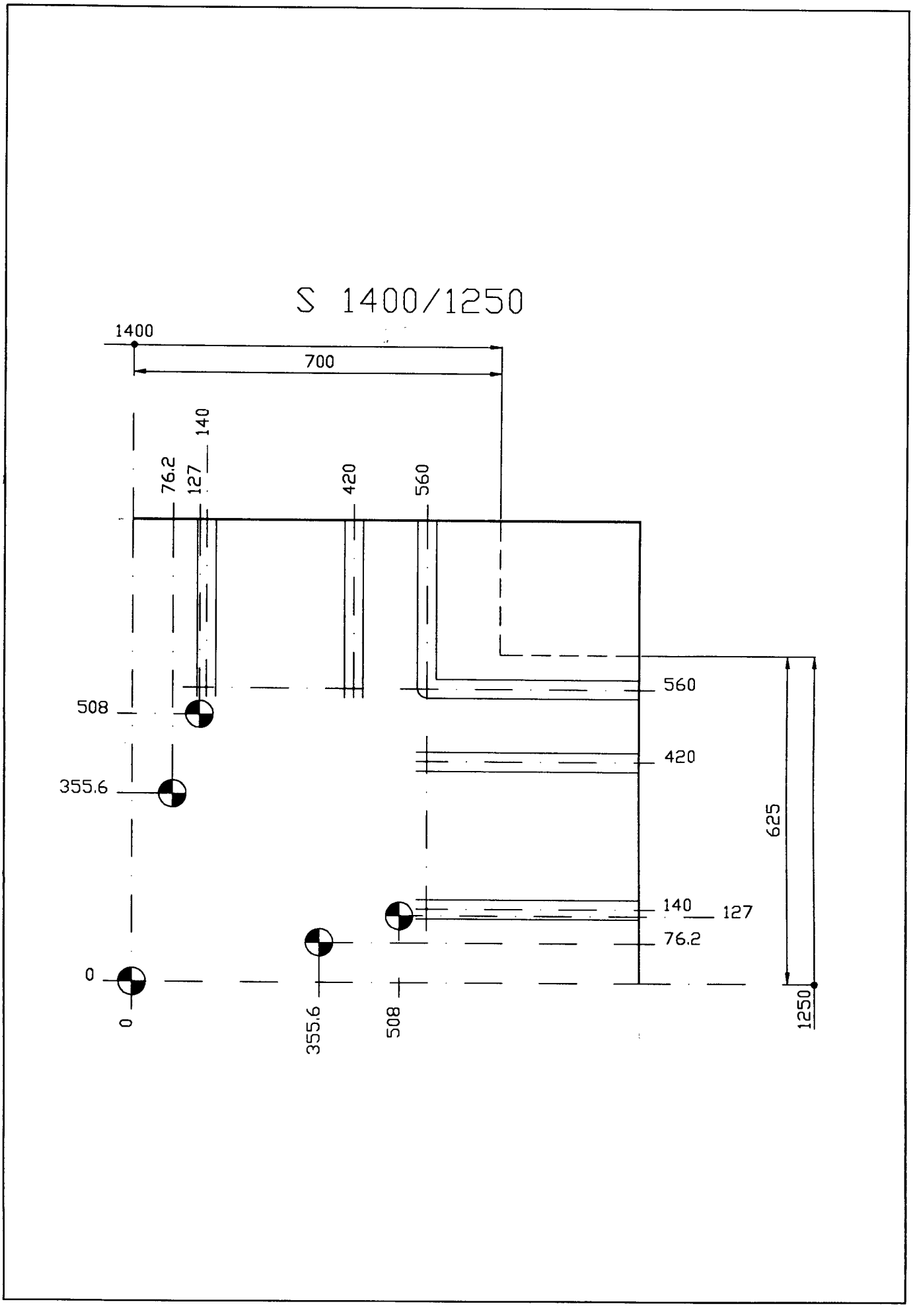
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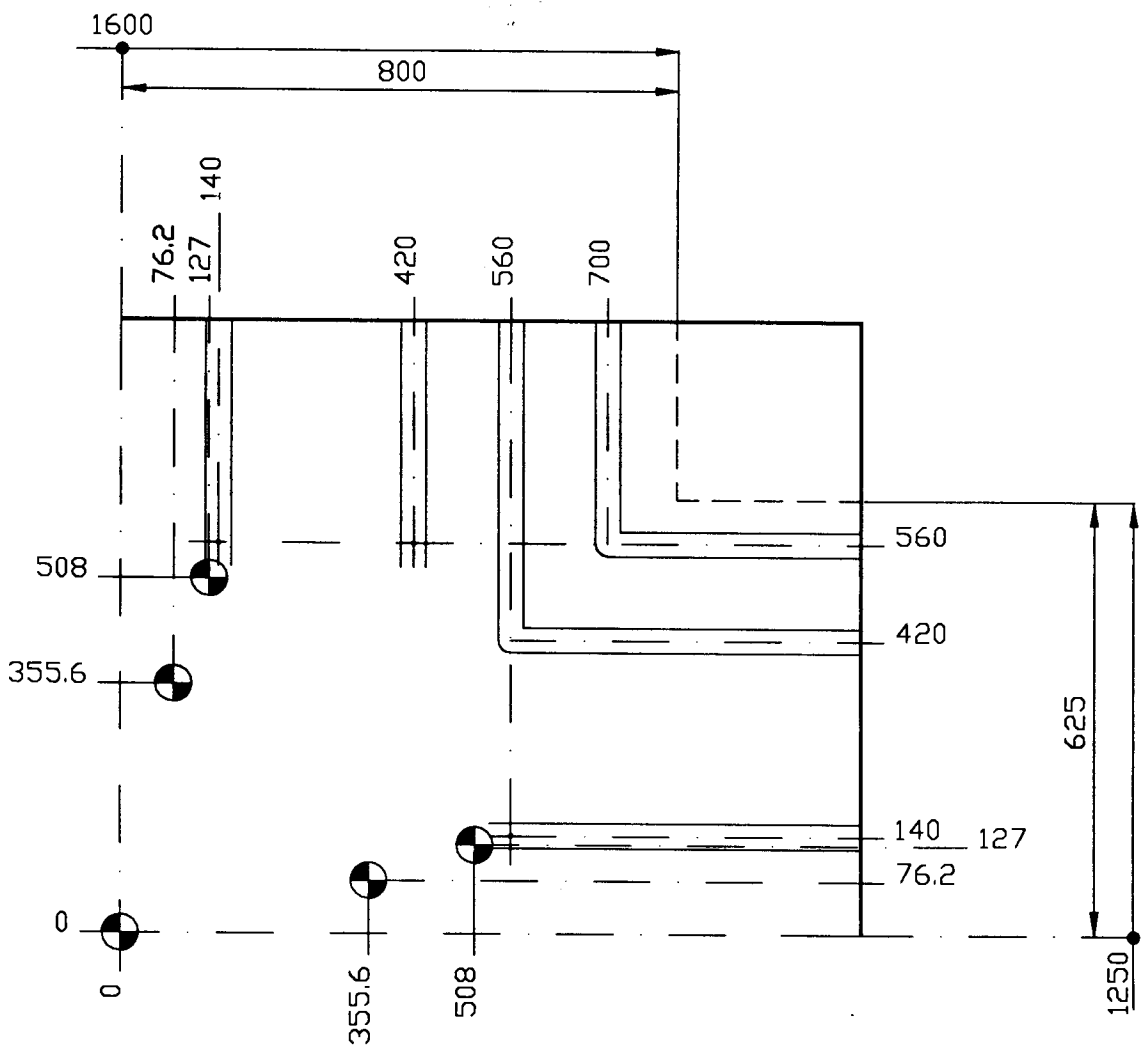
S 1600/1250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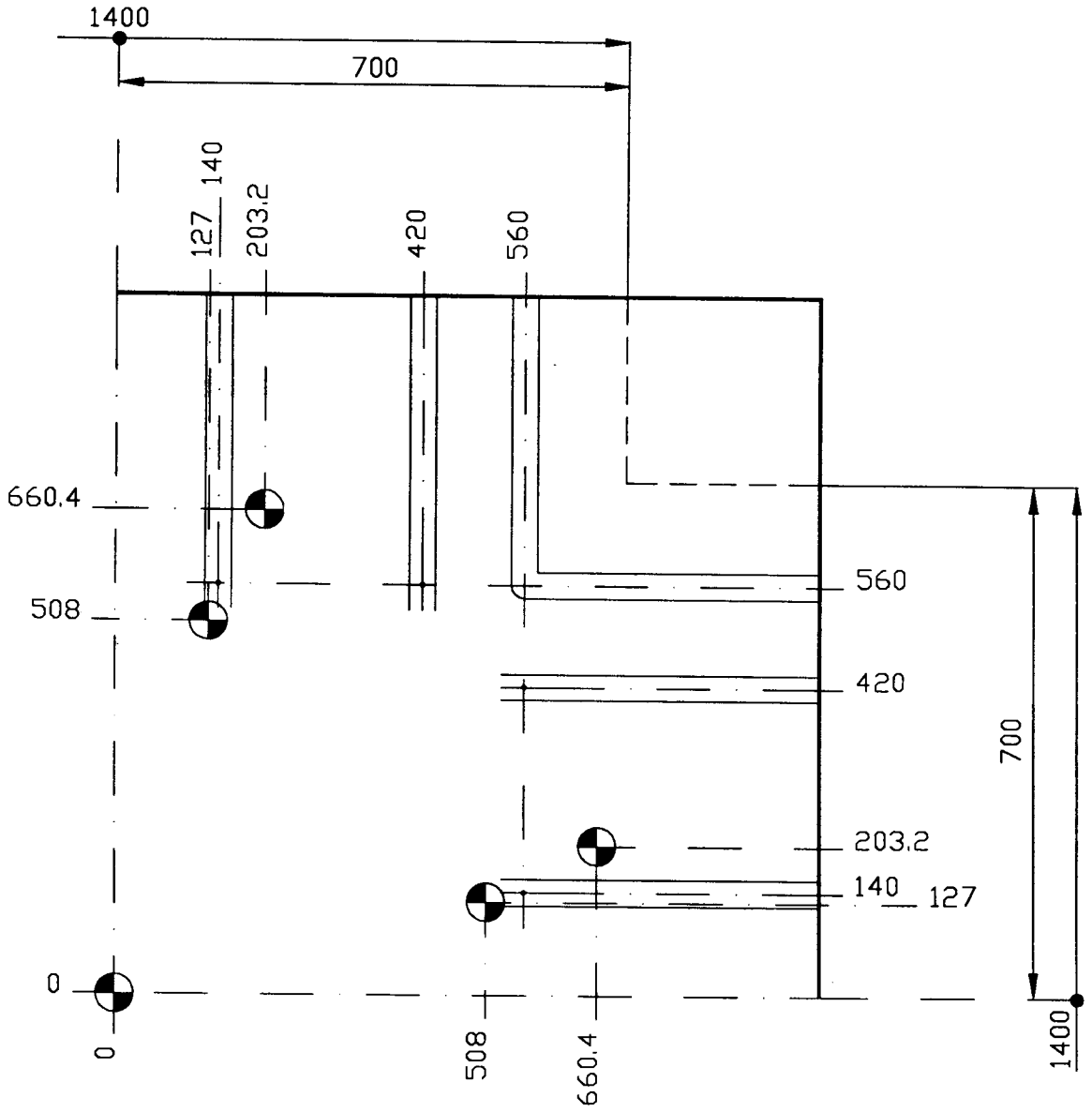
1250

S 1400/1400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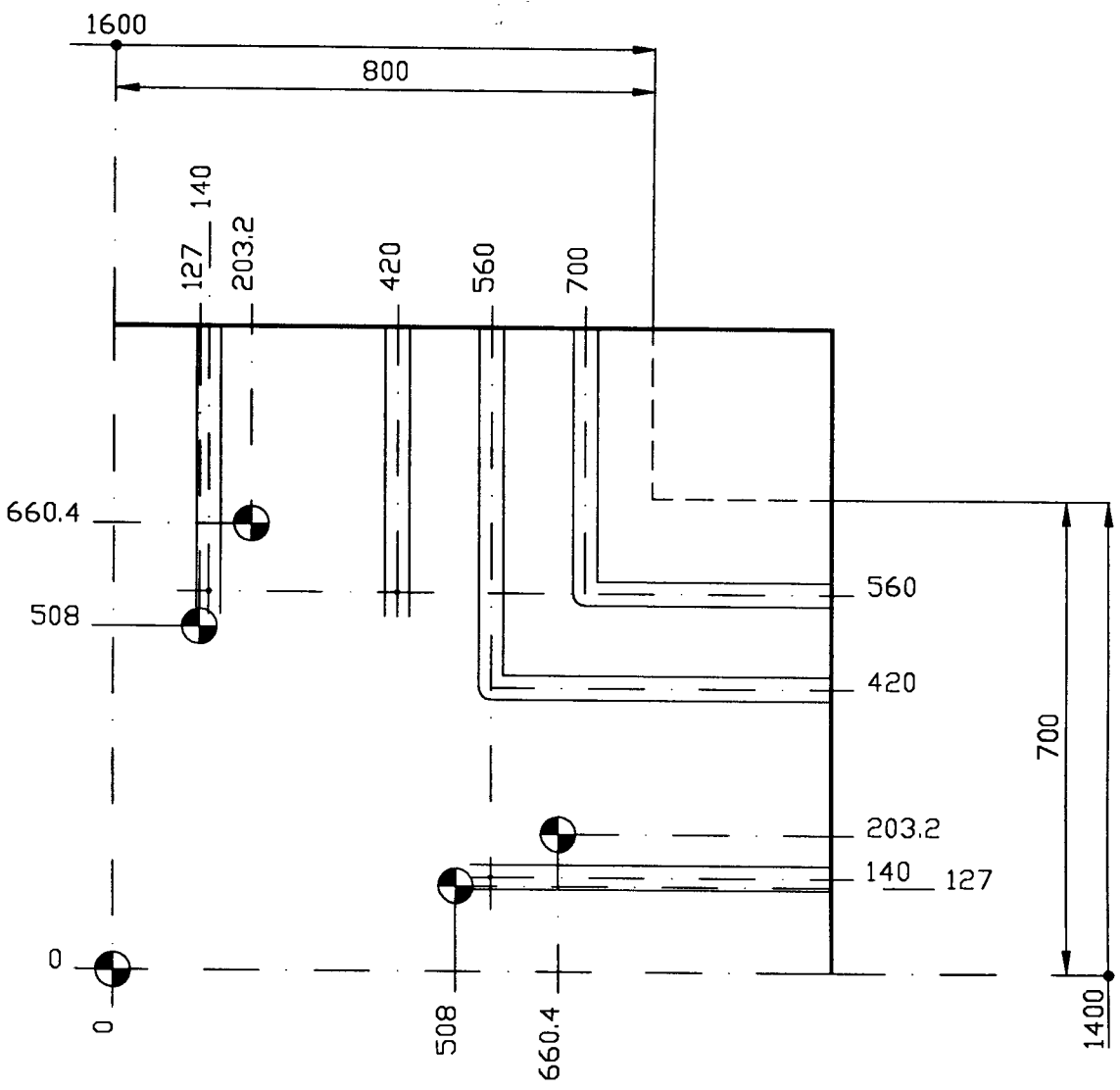
S 1600/1400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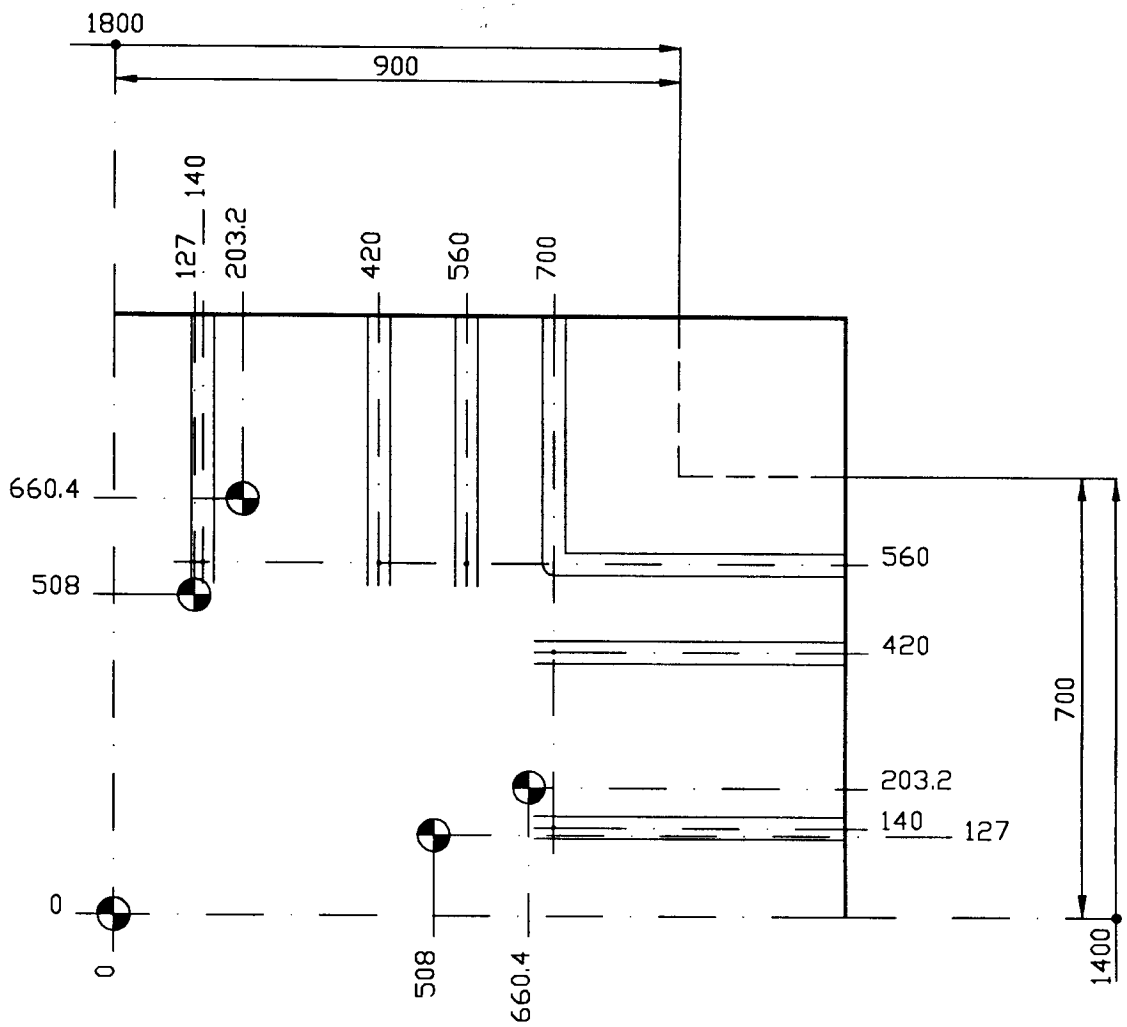
S 1800/1400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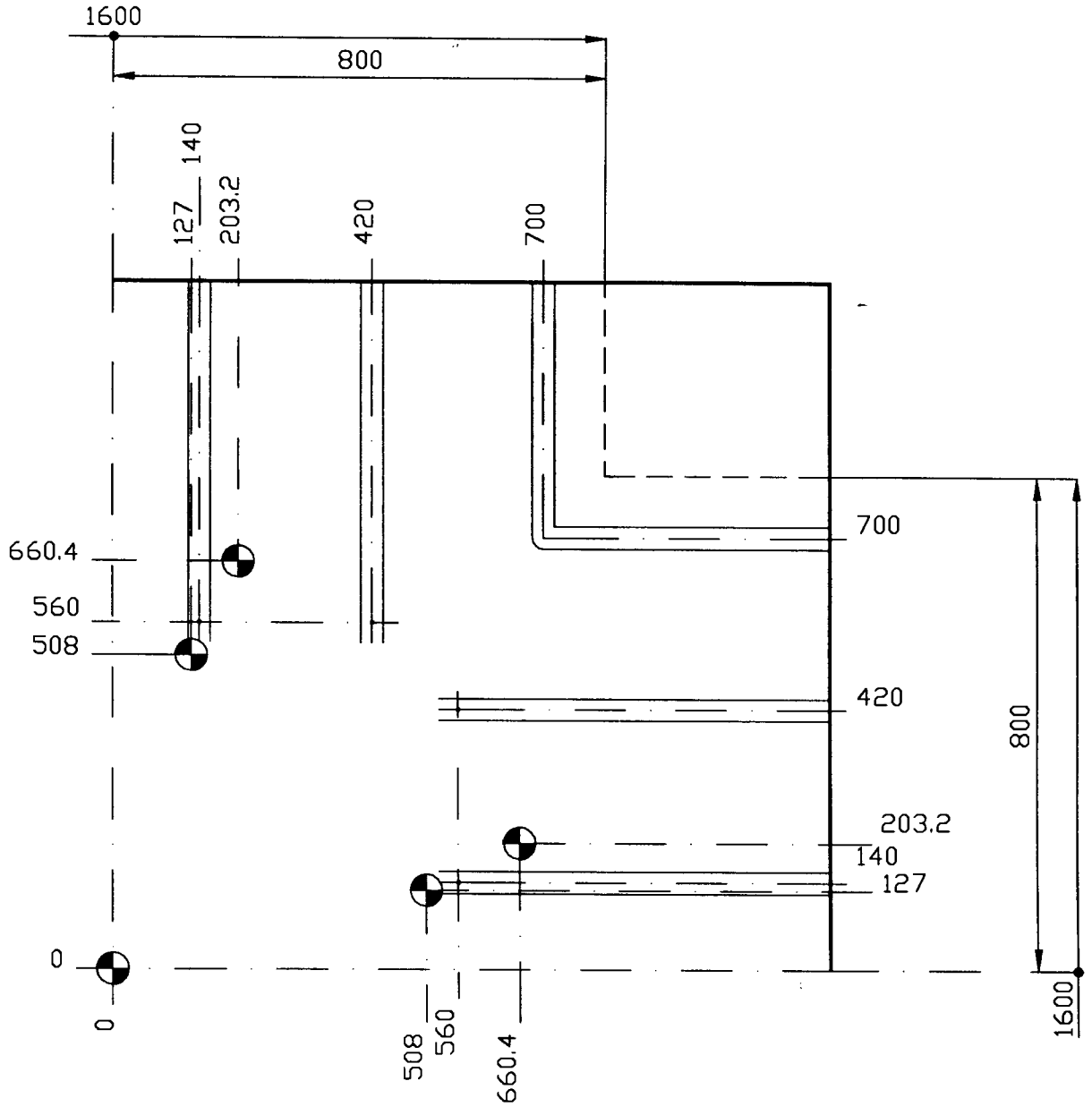
S 1600/1600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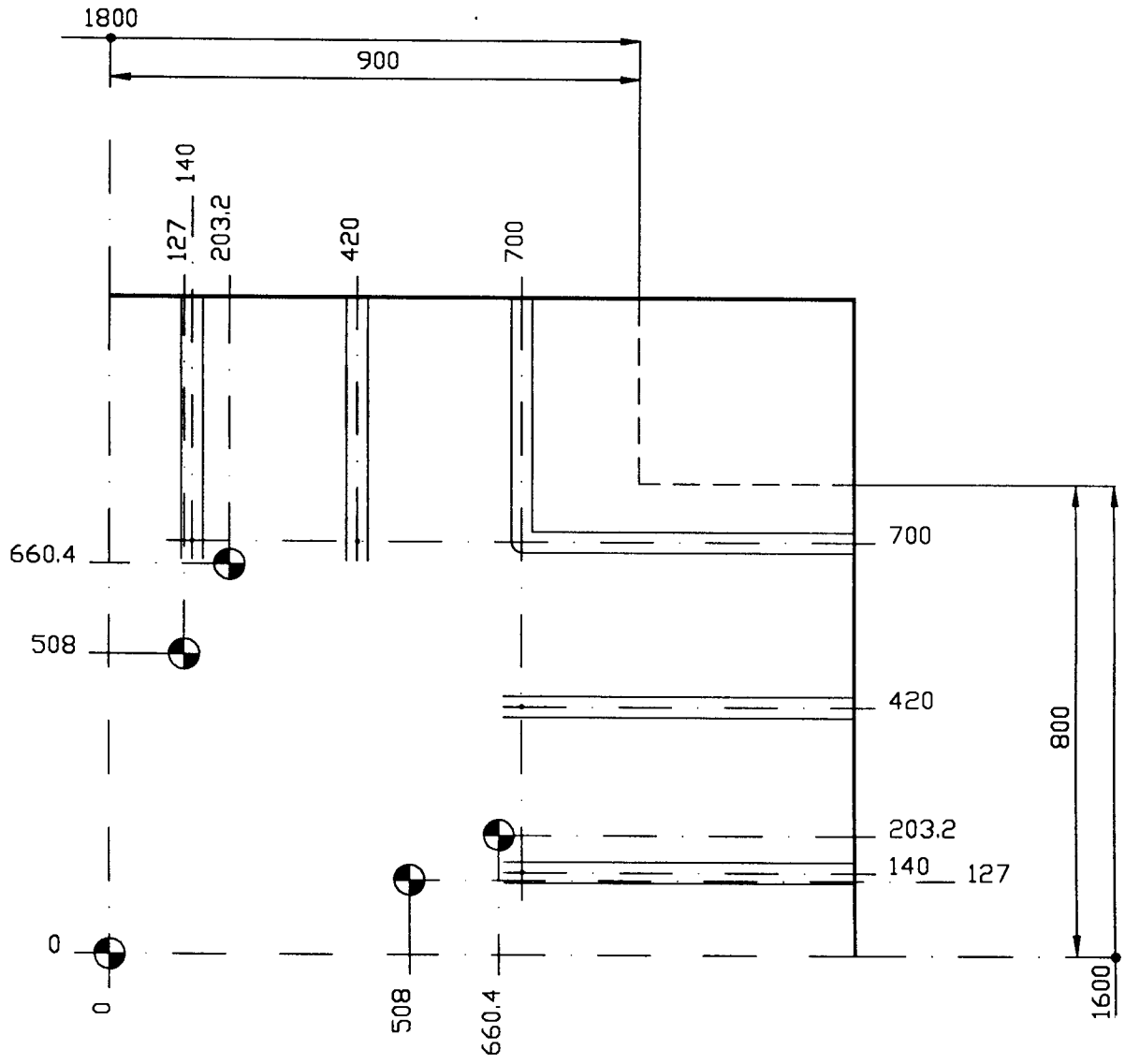
660.4
1600

S 1800/1600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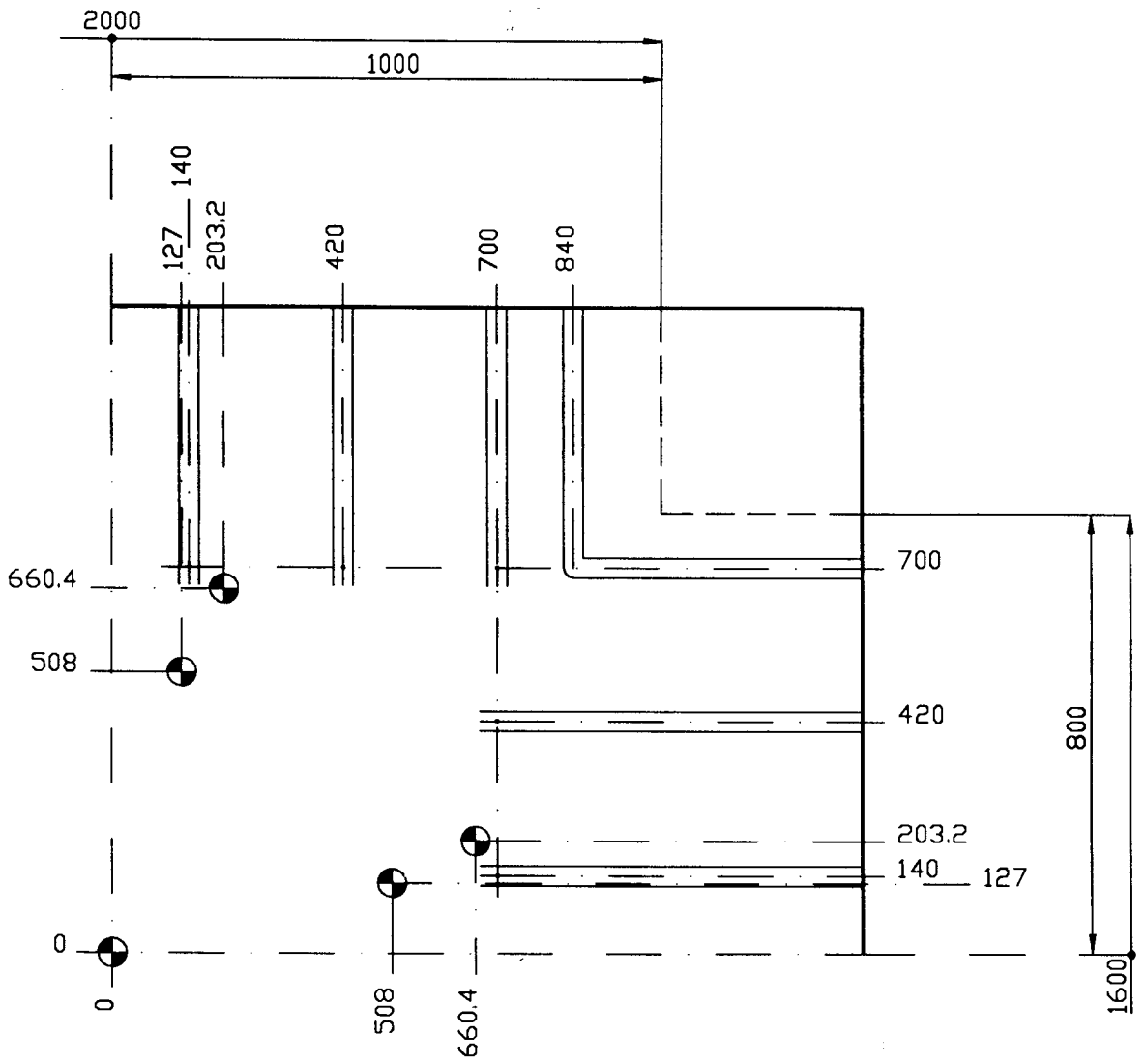
S 2000/1600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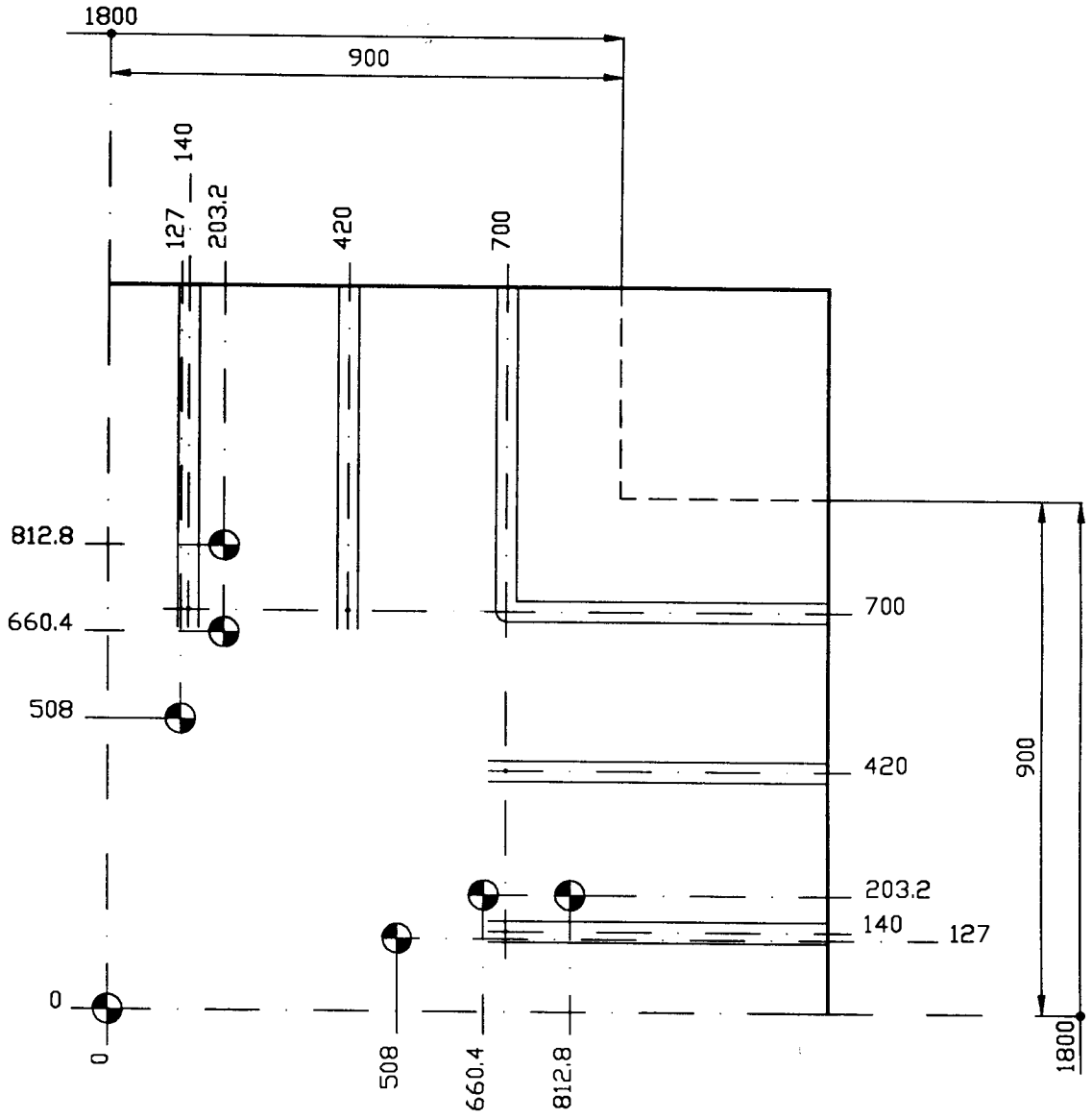
1600

S 1800/1800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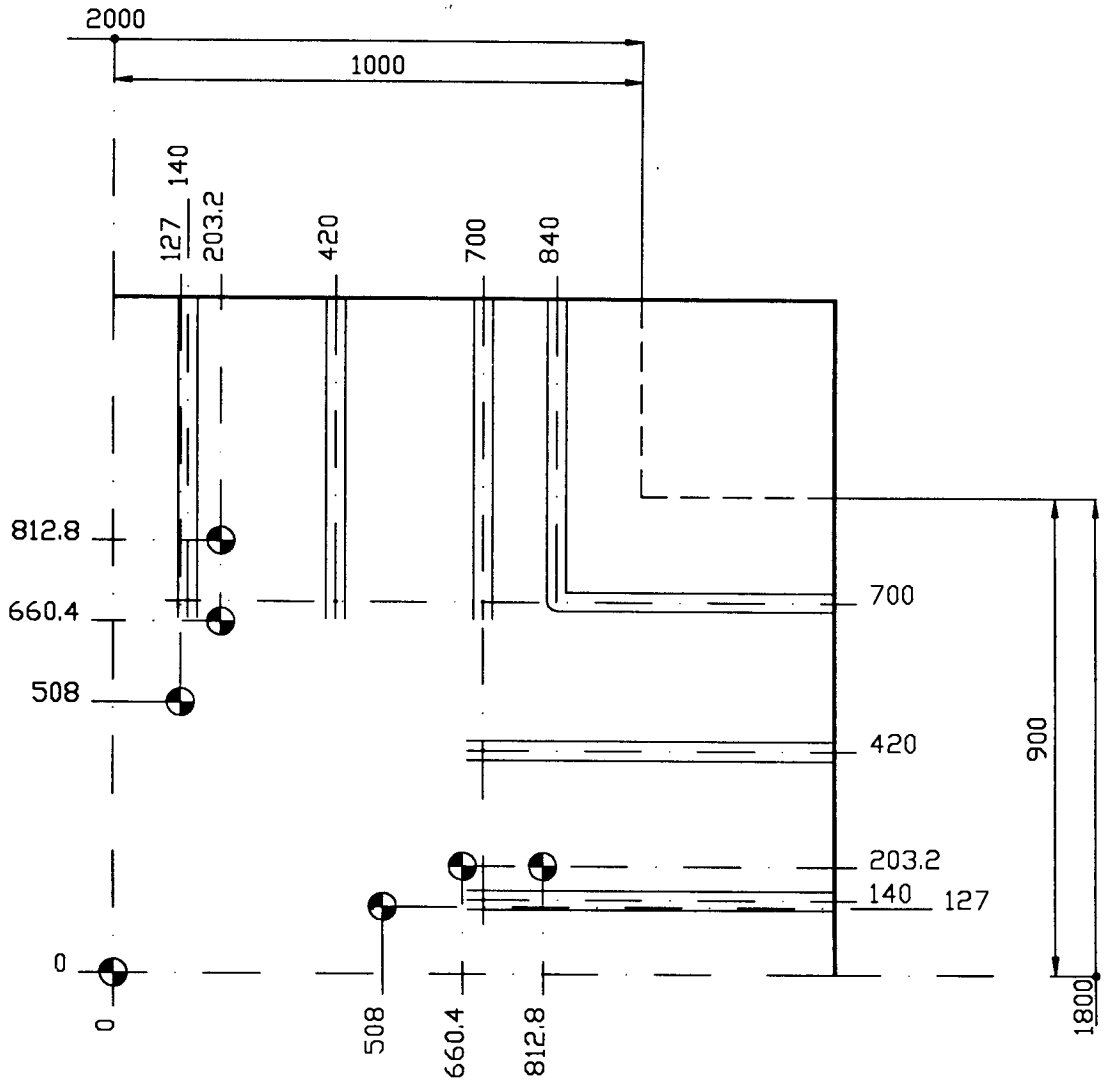
900
1800

S 2000/1800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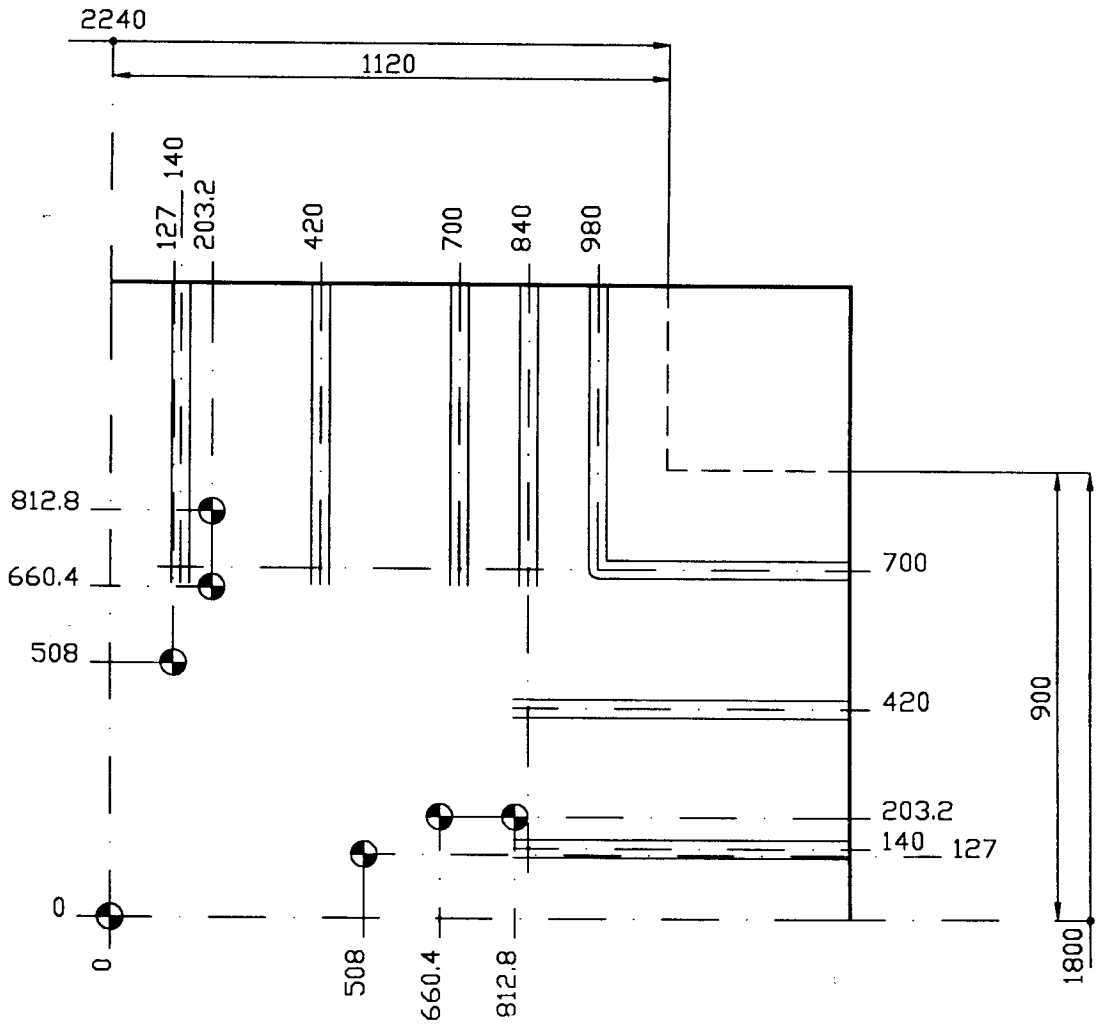
660.4
812.8
1800

S 2240/1800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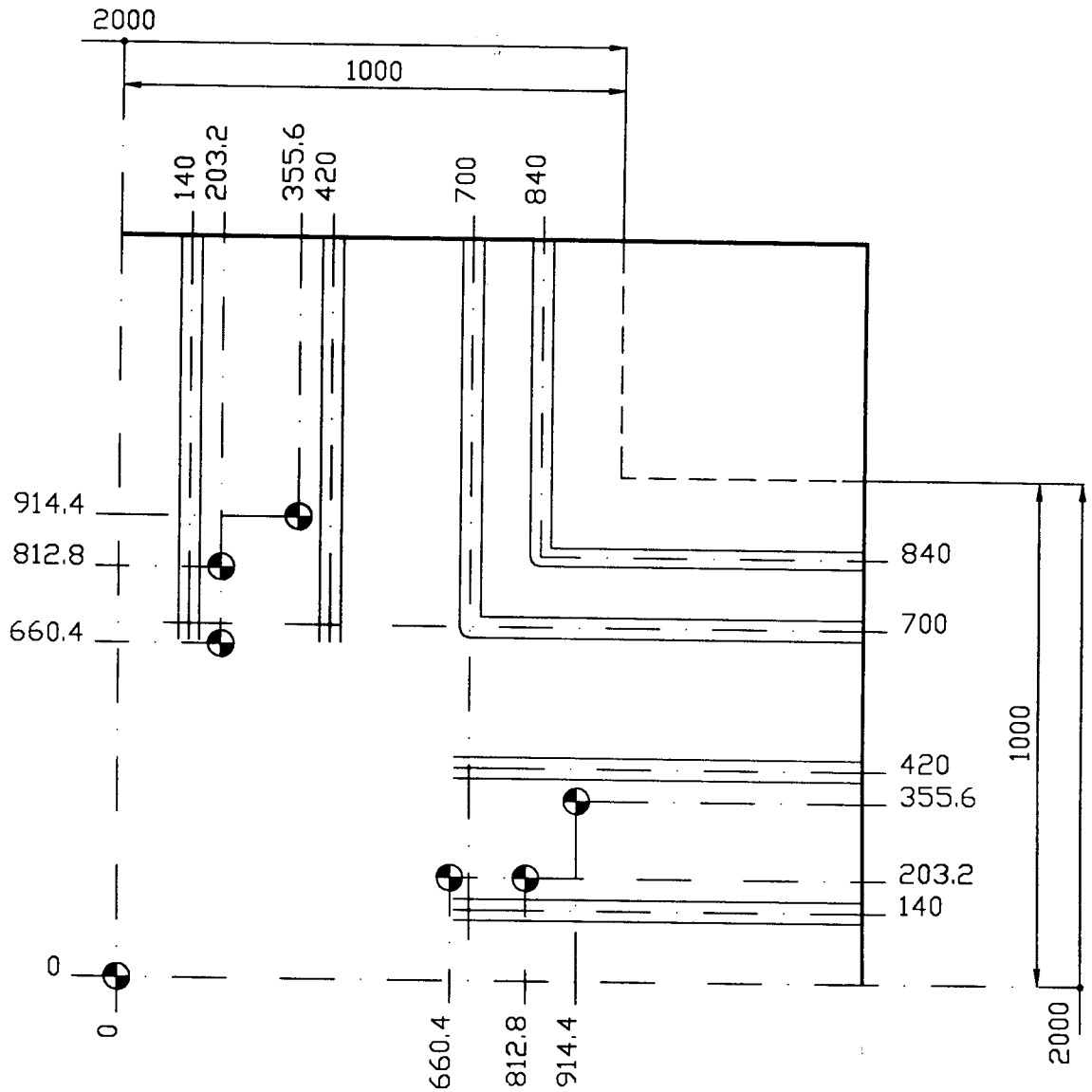
127
900
1800
0
508
660.4
812.8

S 2000/2000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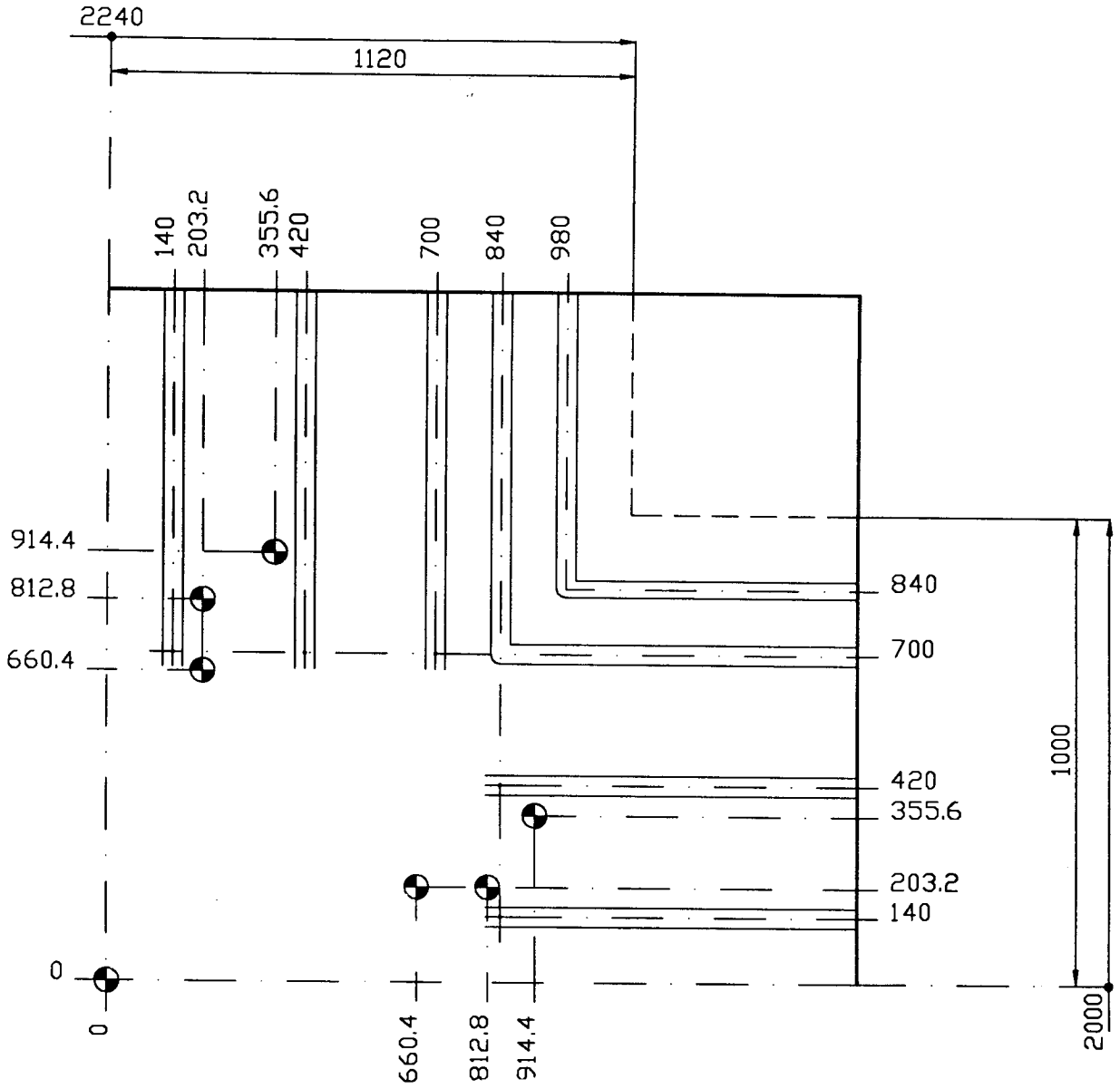
812.8
914.4
2000

S 2240/2000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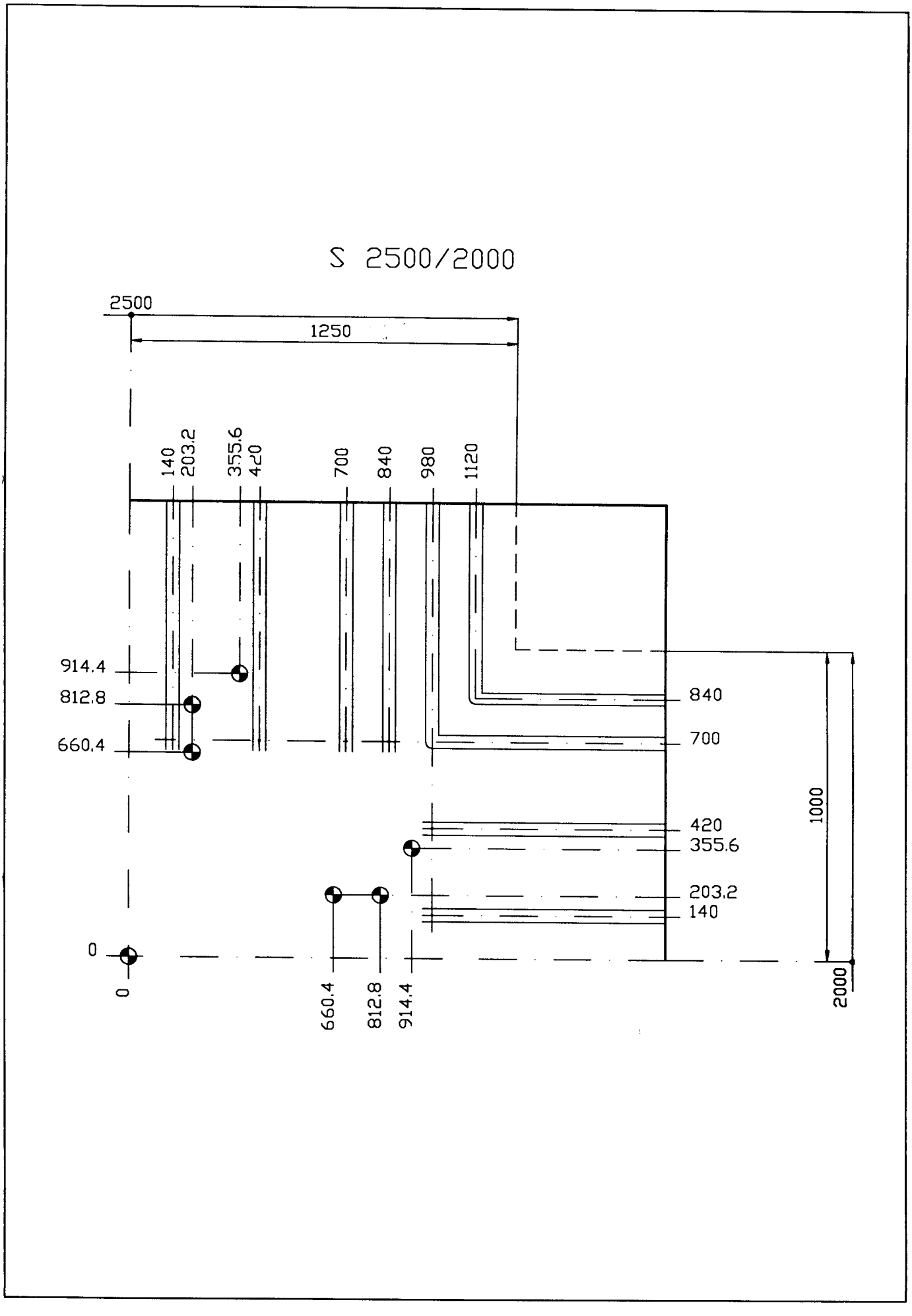
812.8
914.4
2000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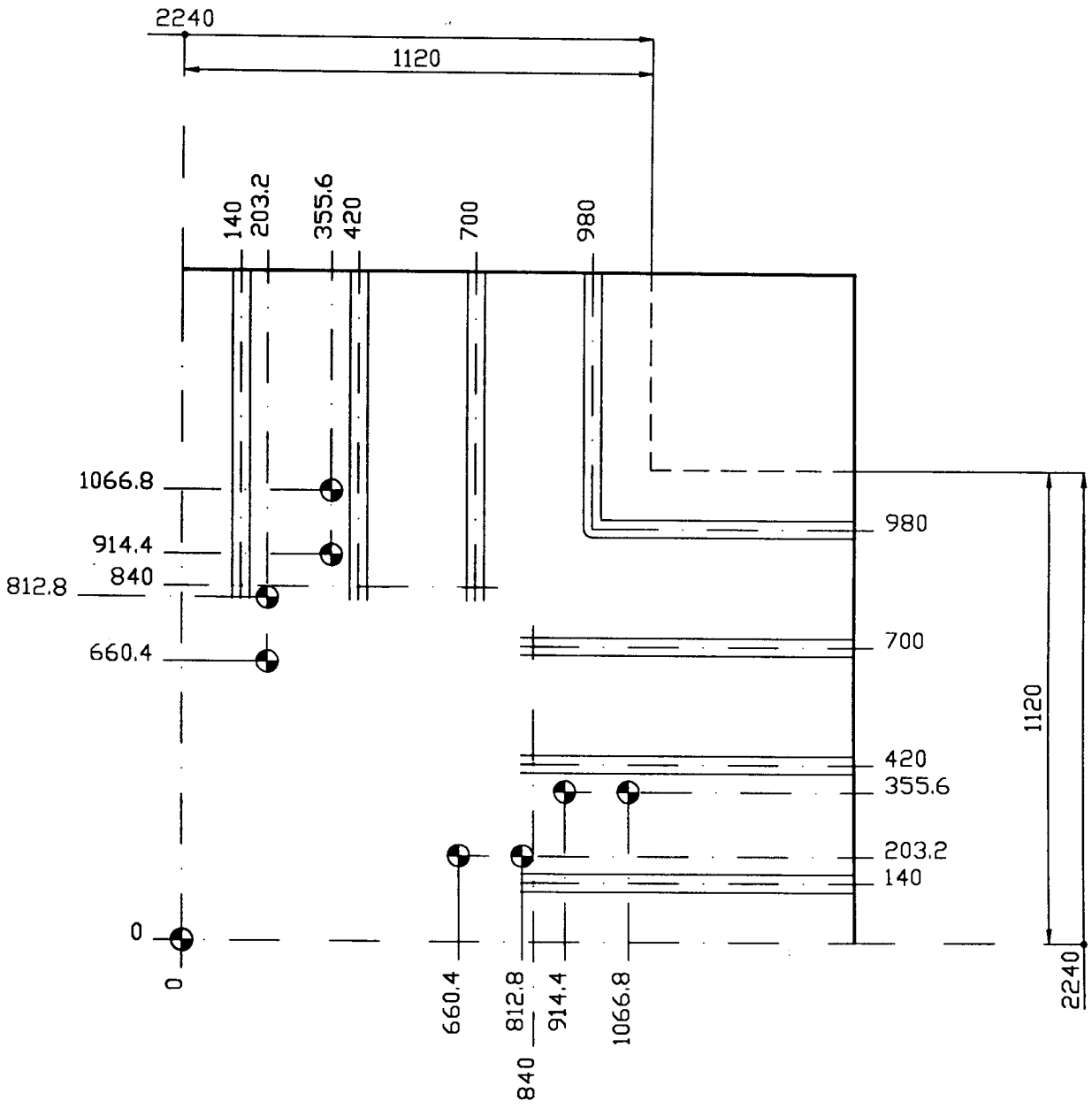
812.8
914.4
2000

S 2240/2240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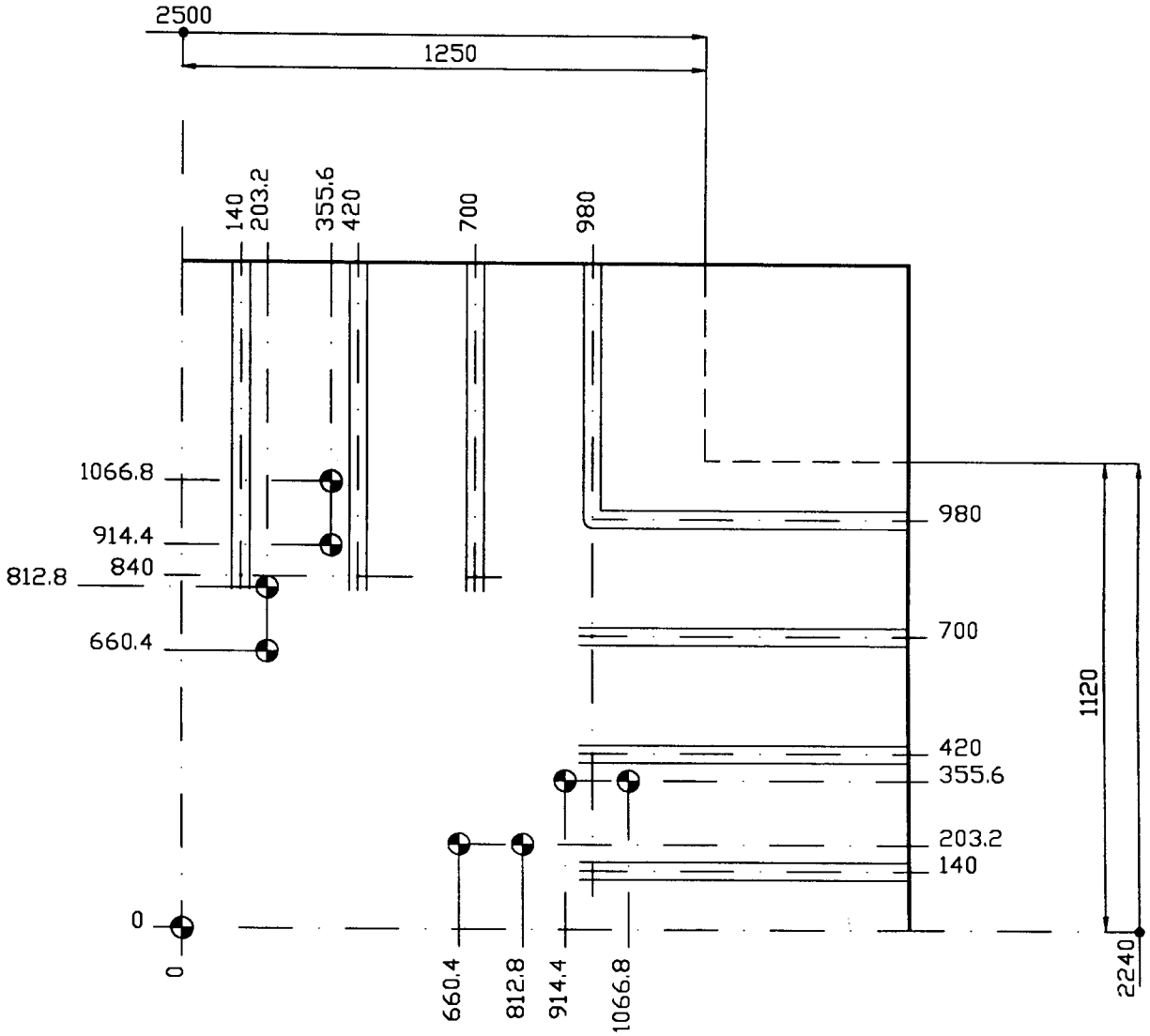
S 2500/2240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914.4
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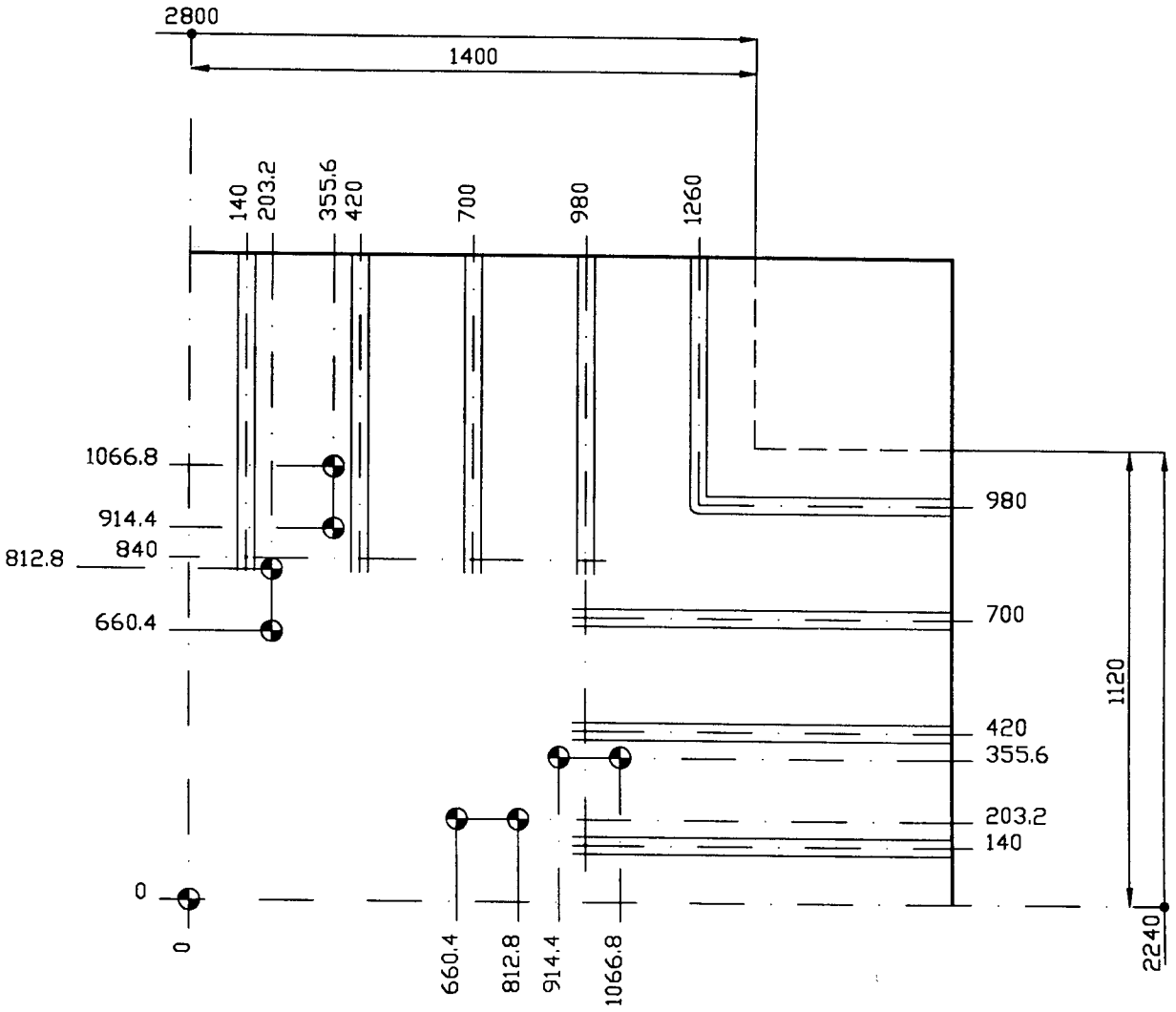
2240

S 2800/2240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914.4
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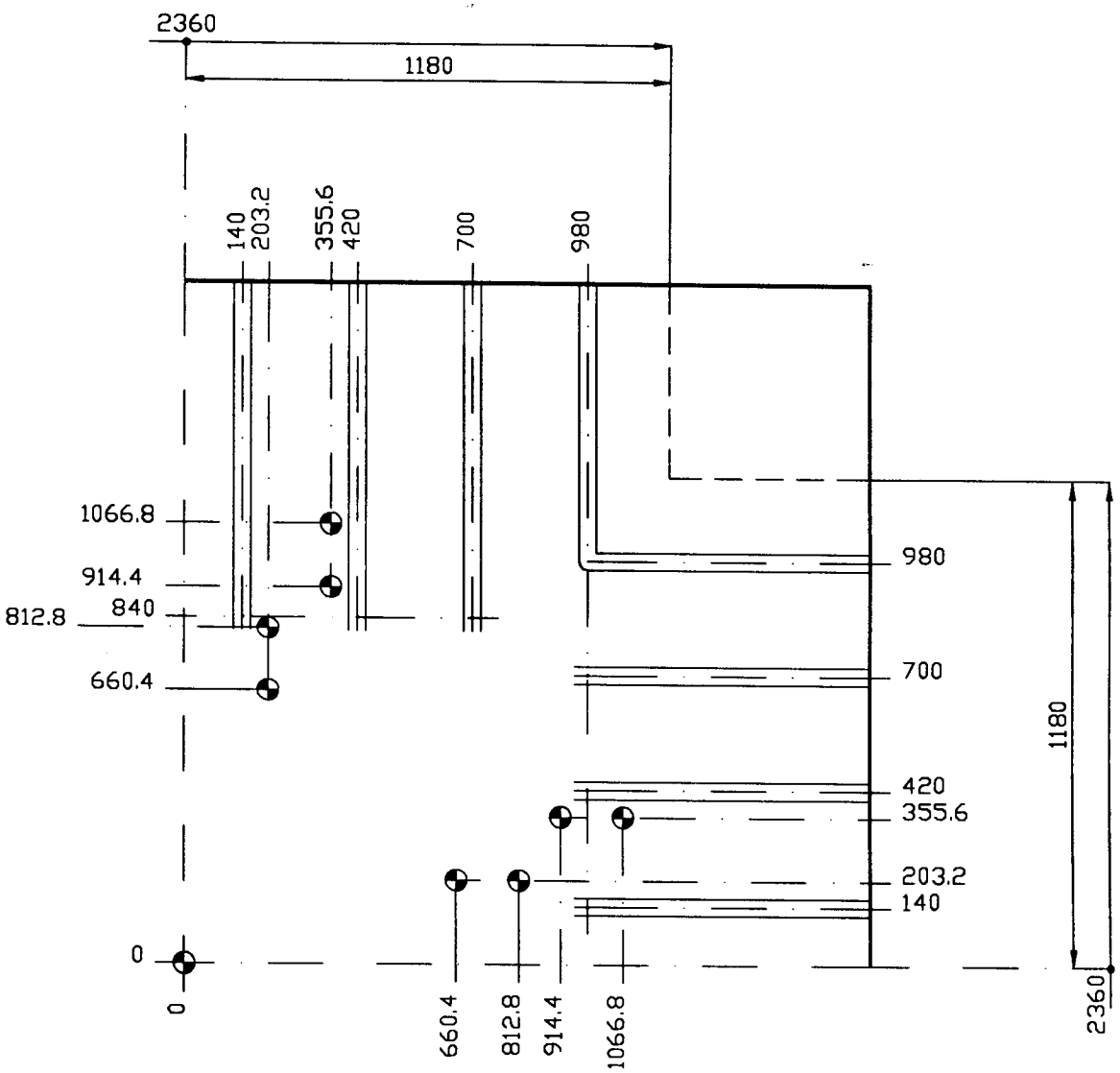
2240

S 2360/2360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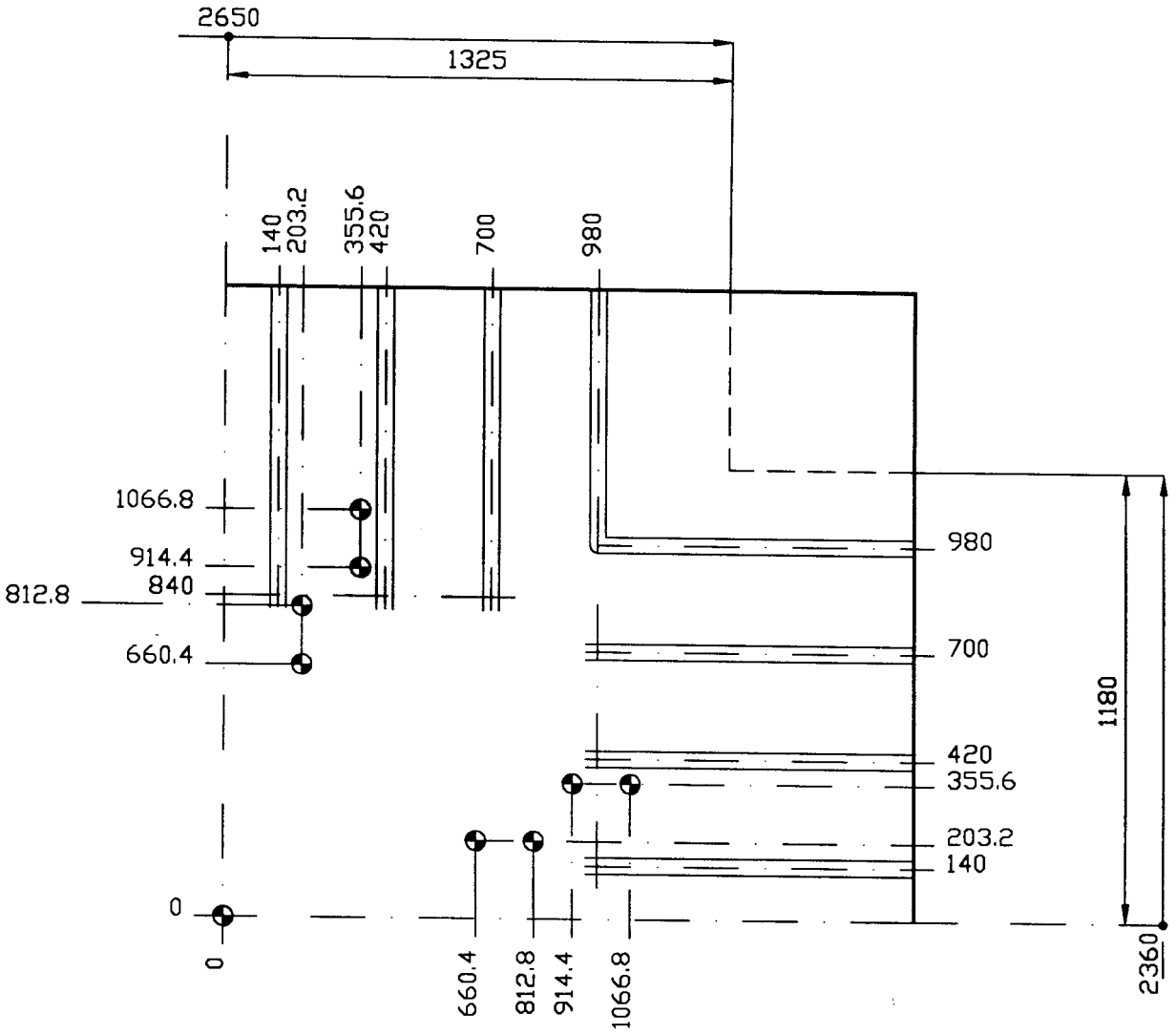
1066.8
2360

S 2650/2360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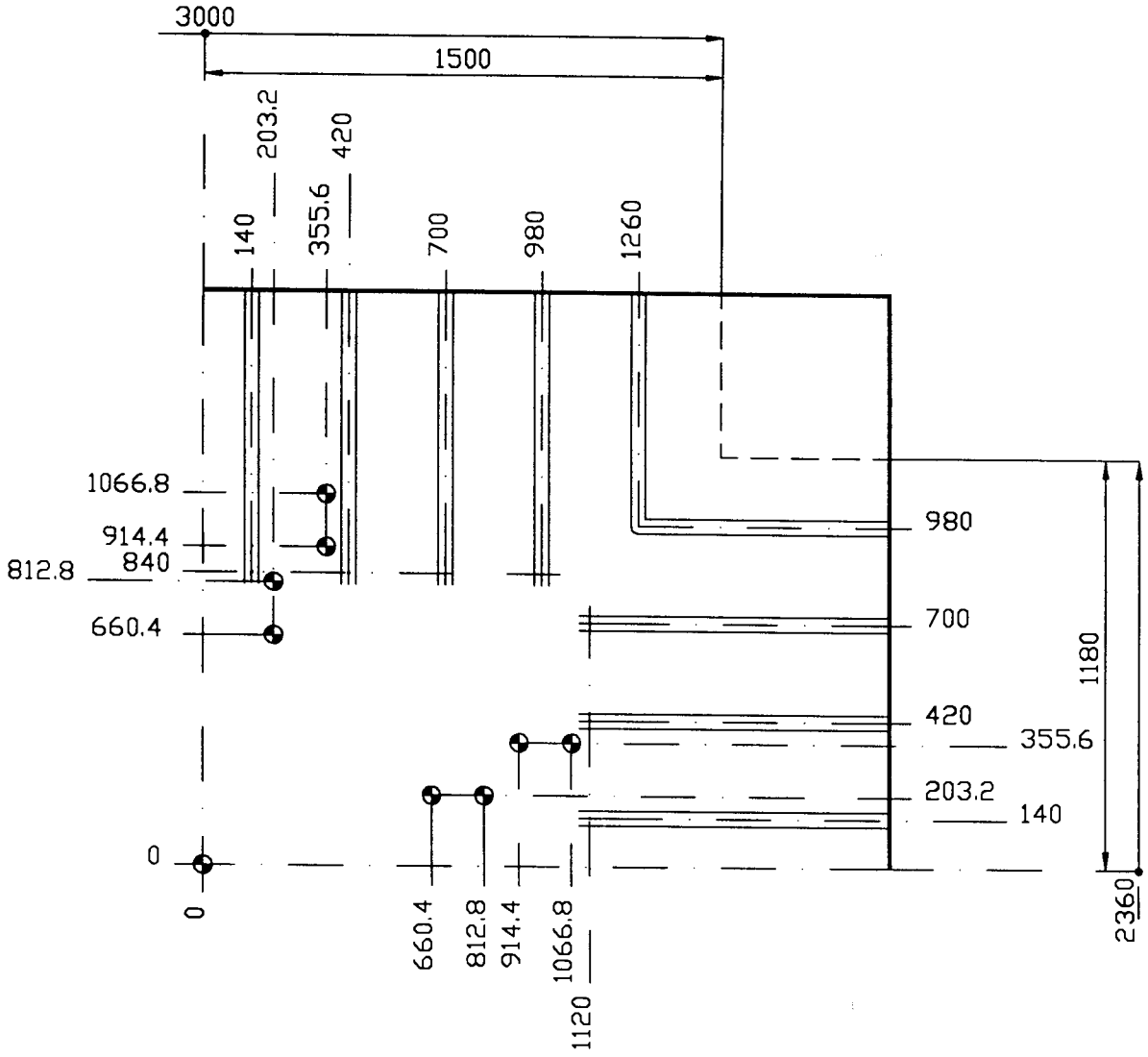
2360

S 3000/2360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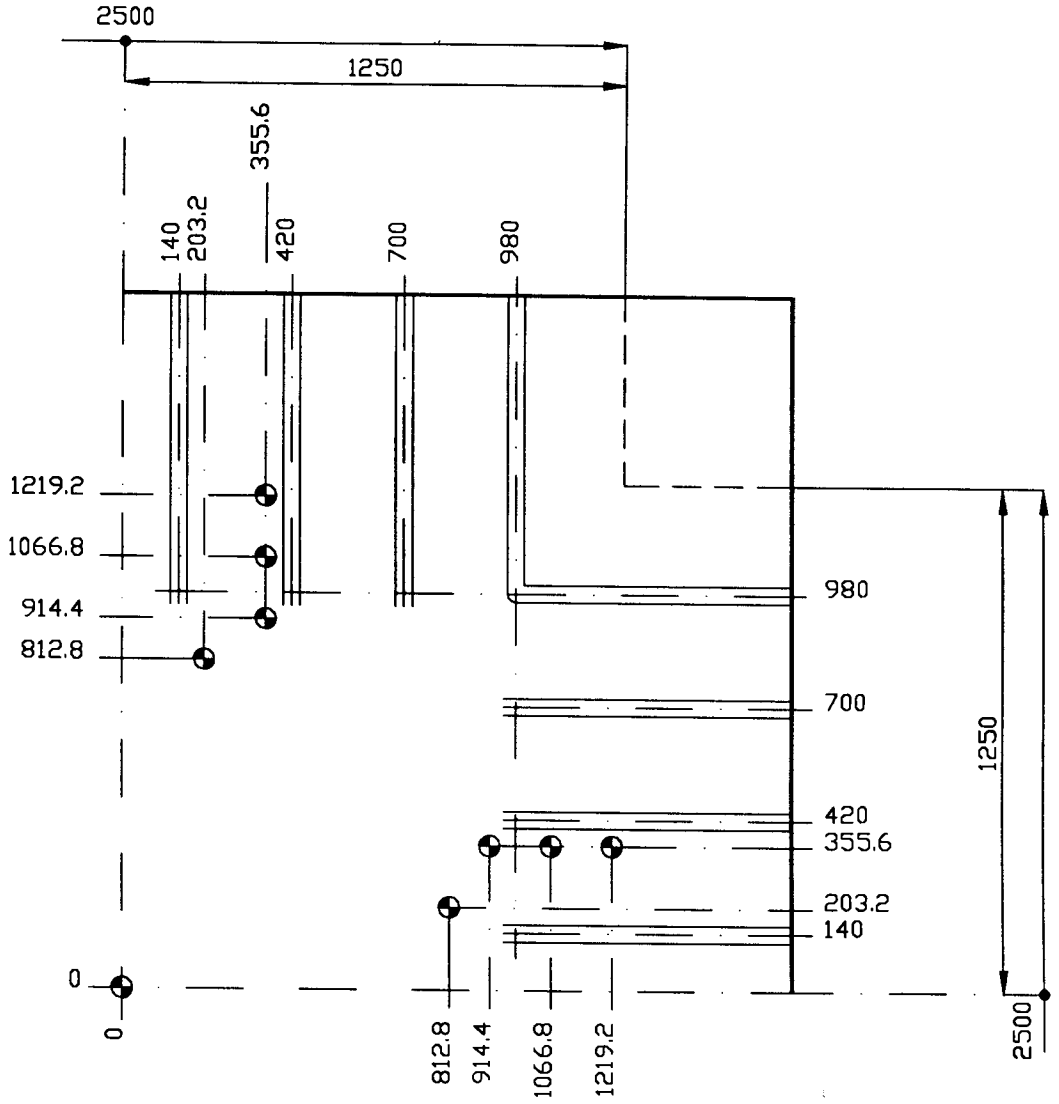
S 2500/2500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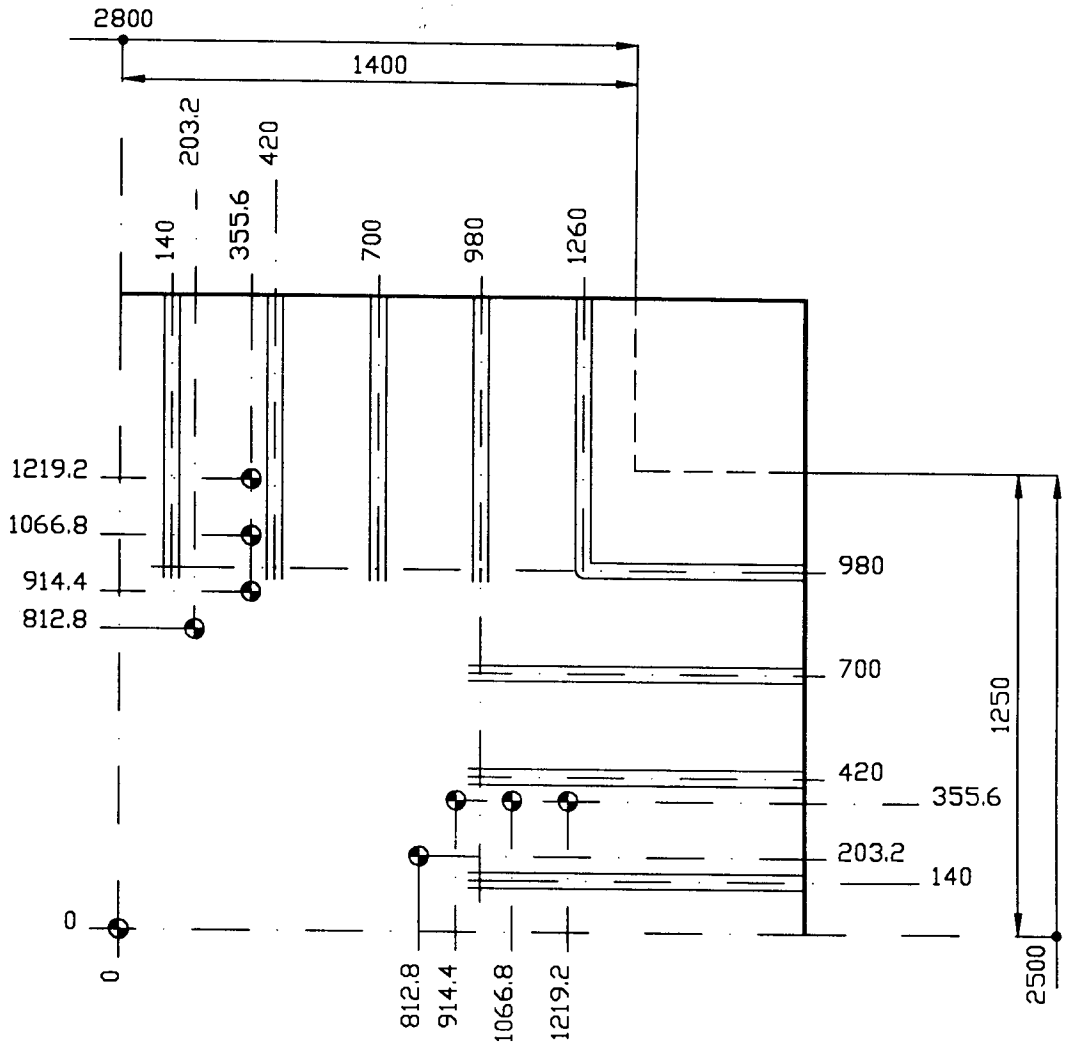
S 2800/2500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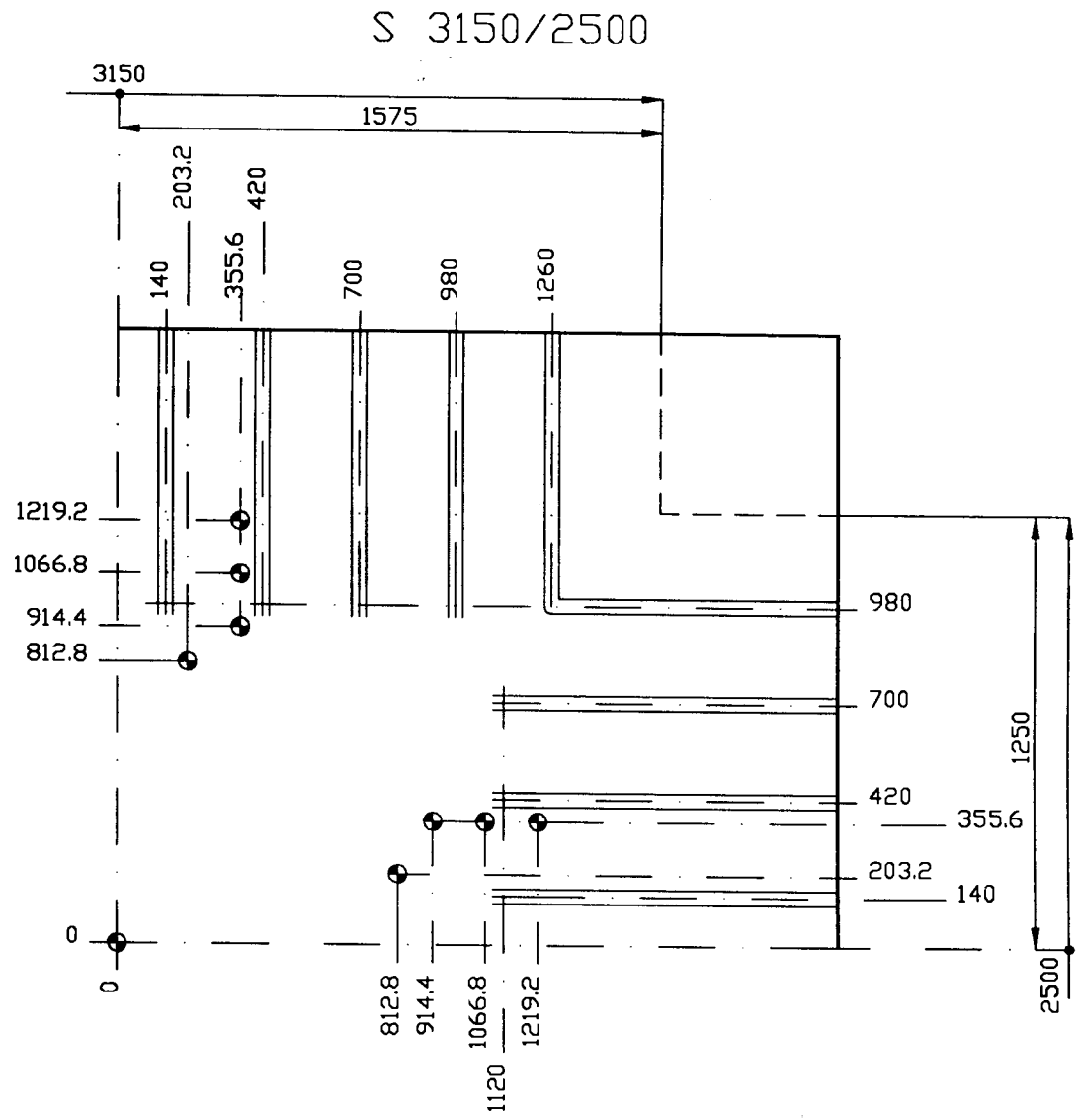
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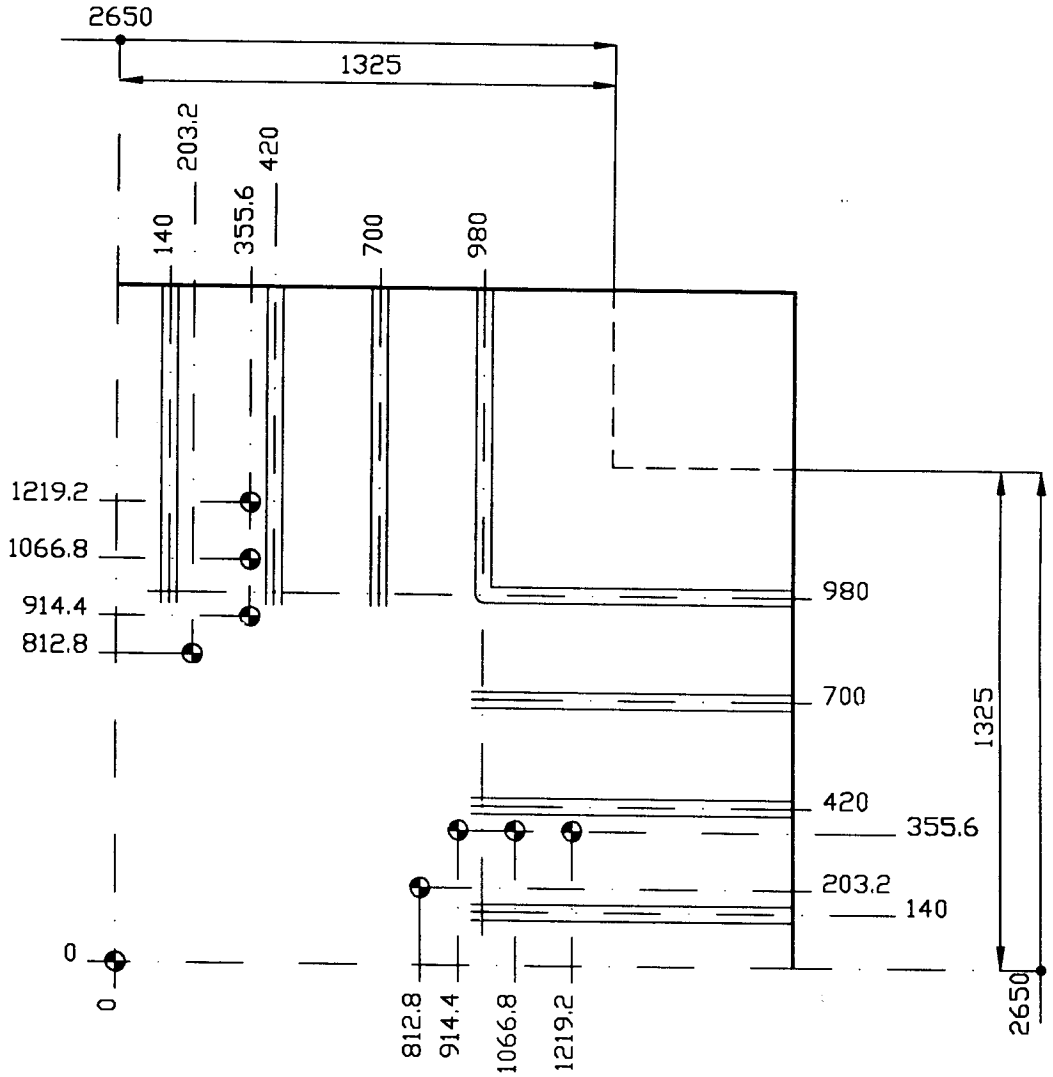
S 2650/2650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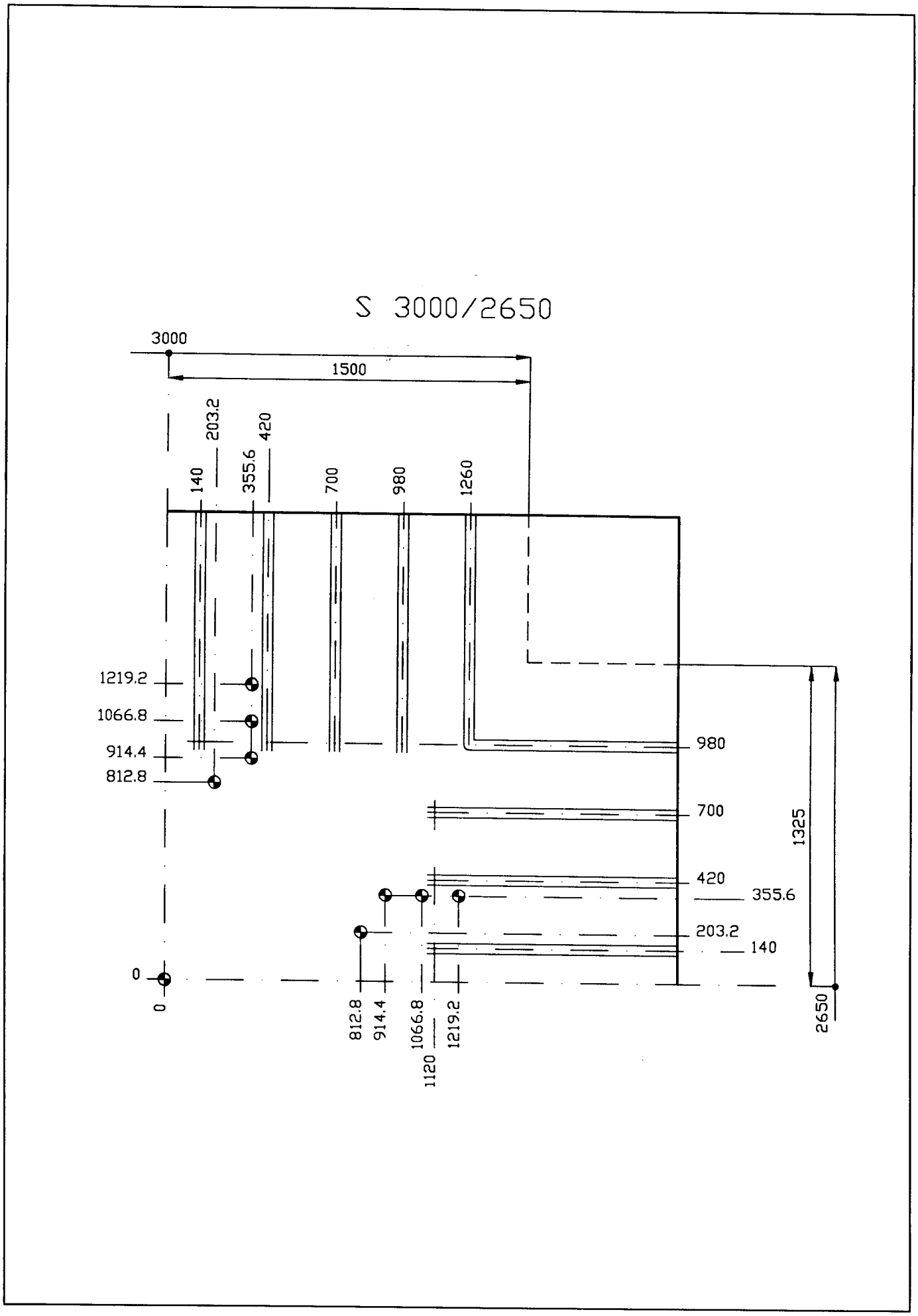
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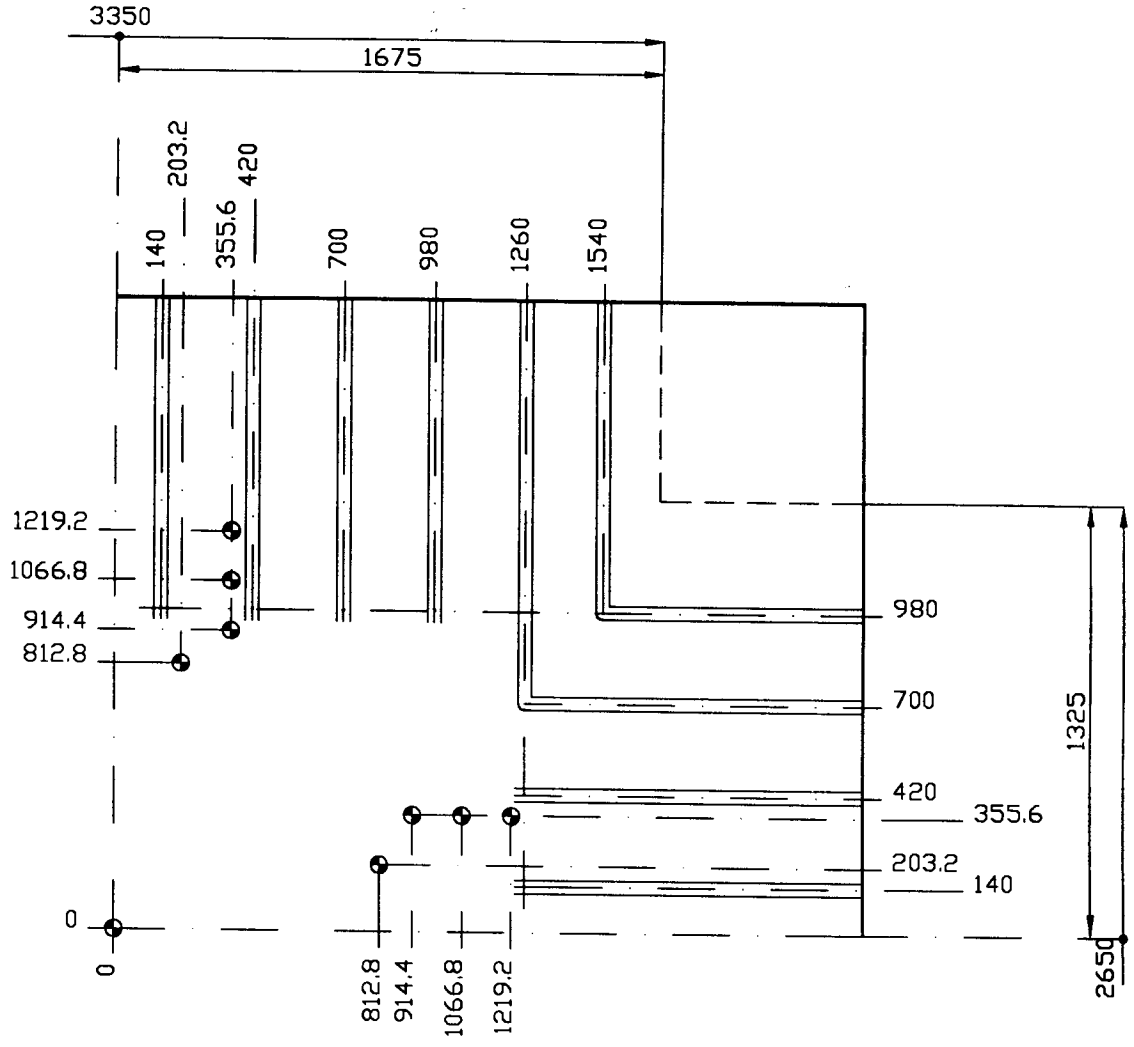
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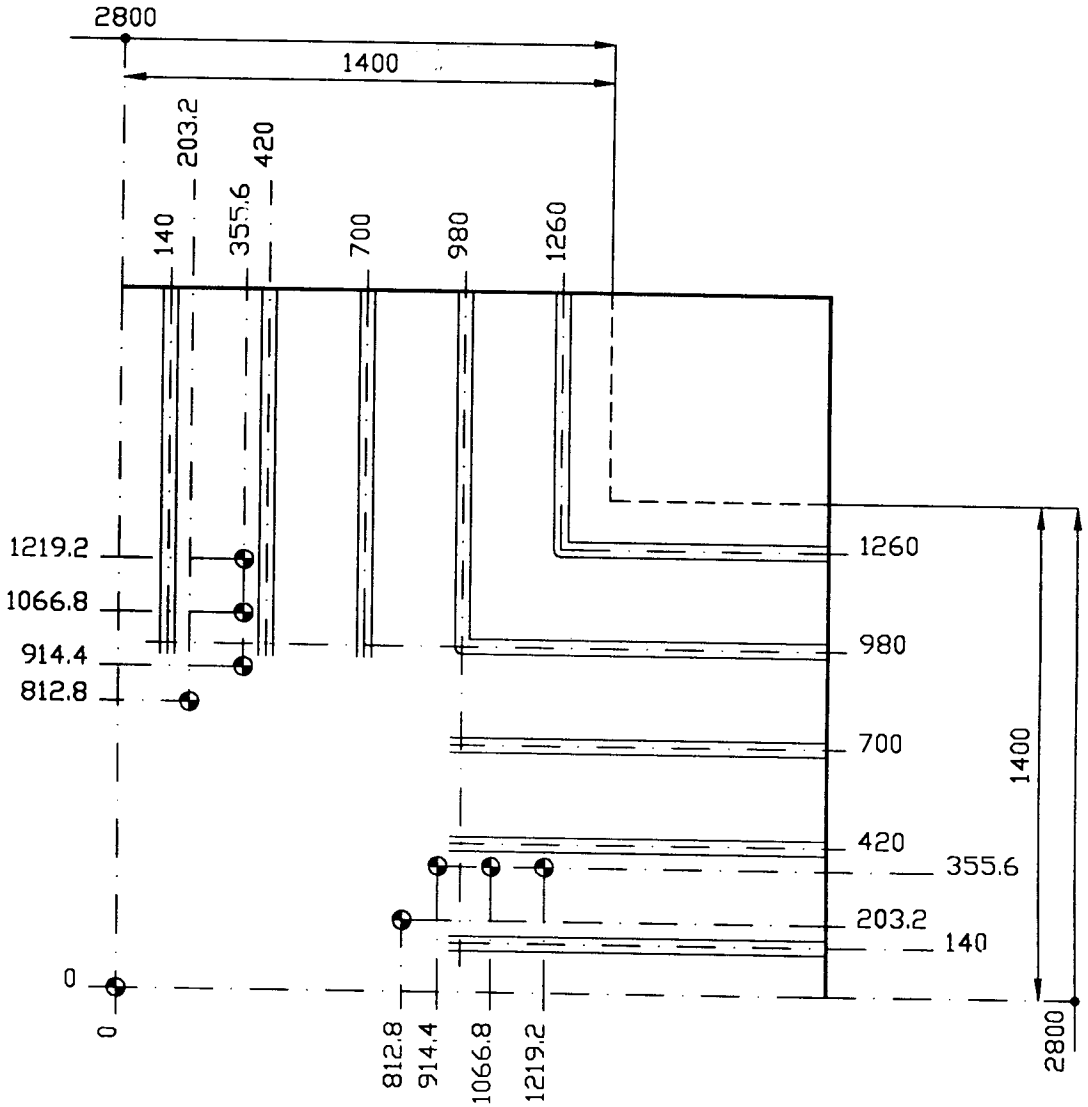
S 2800/2800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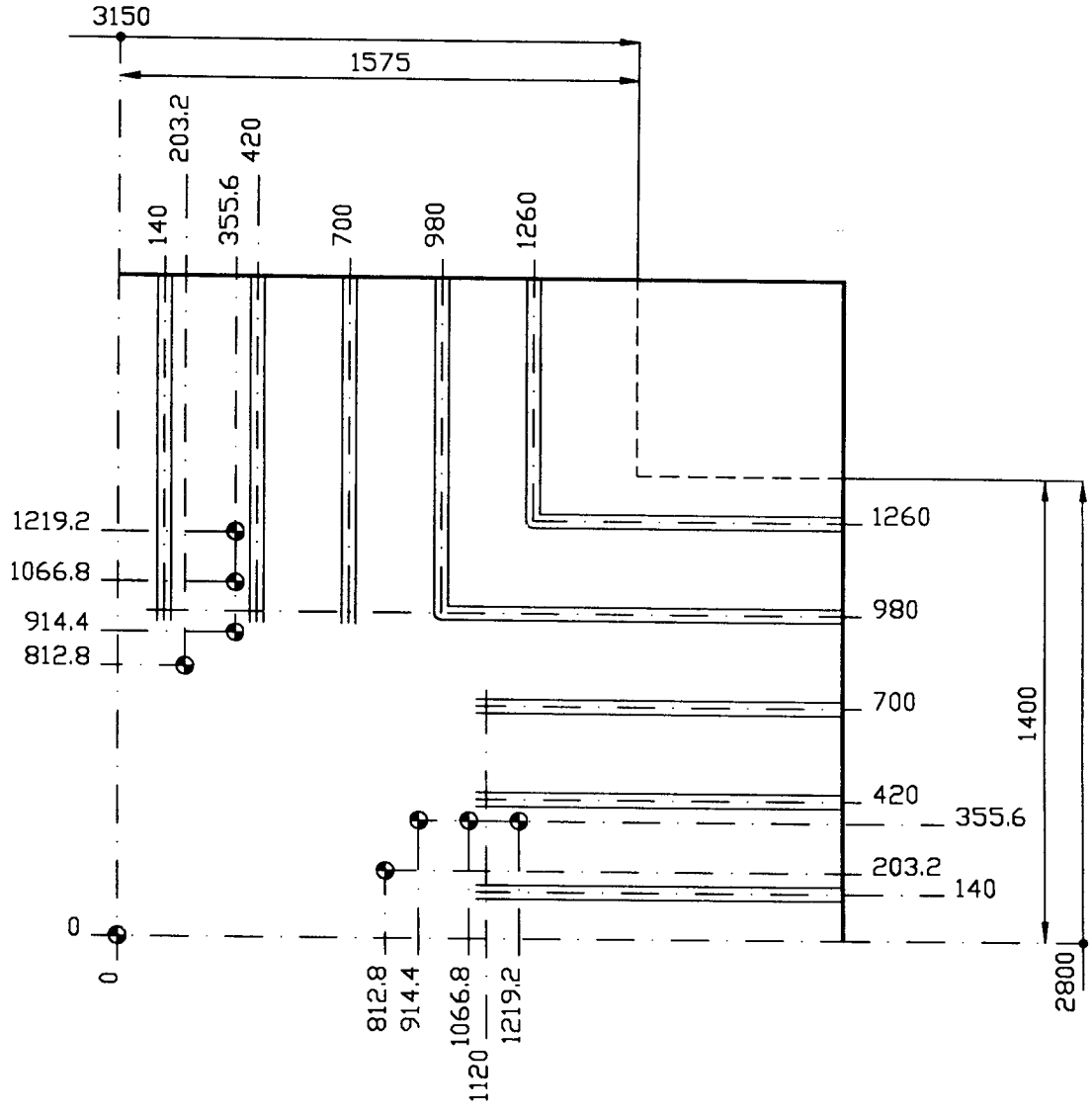
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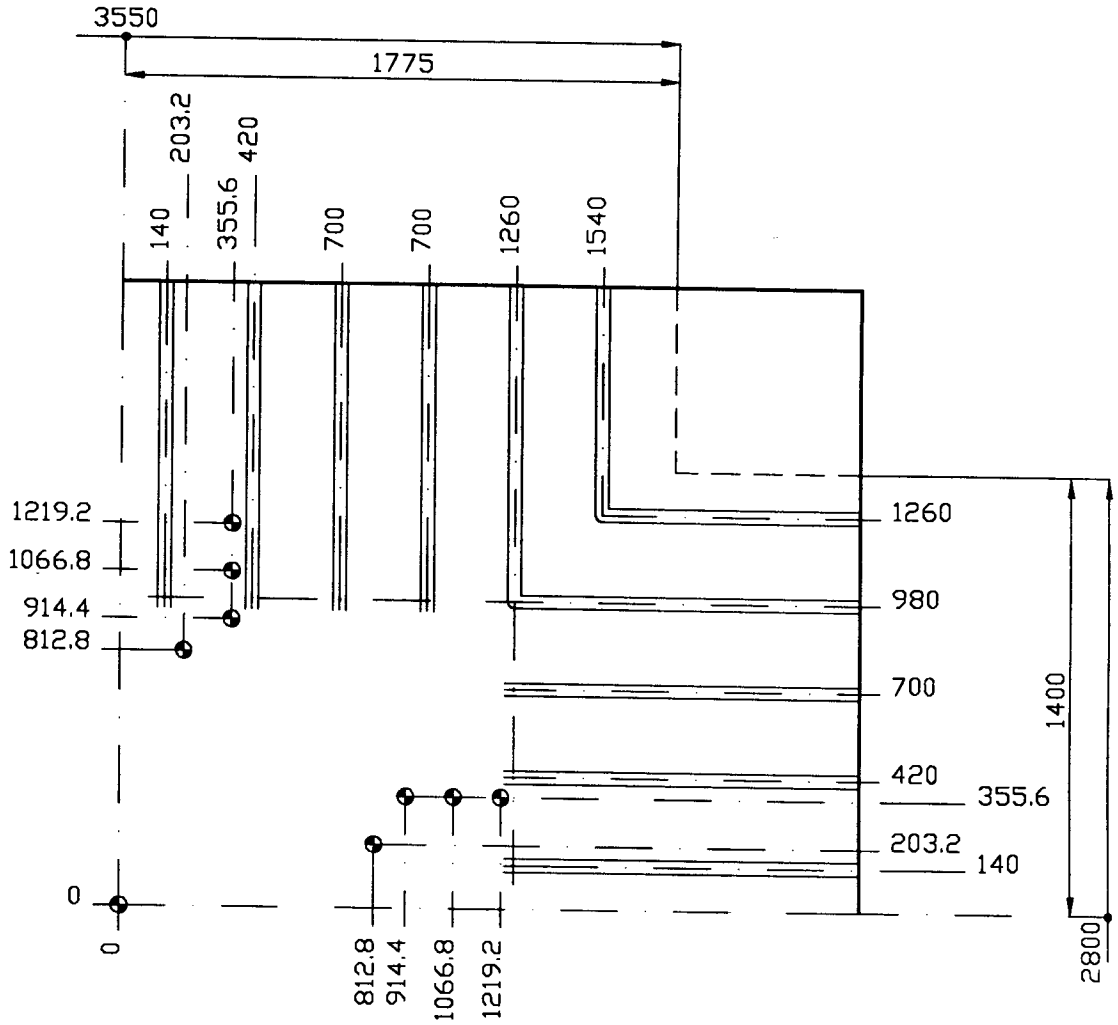
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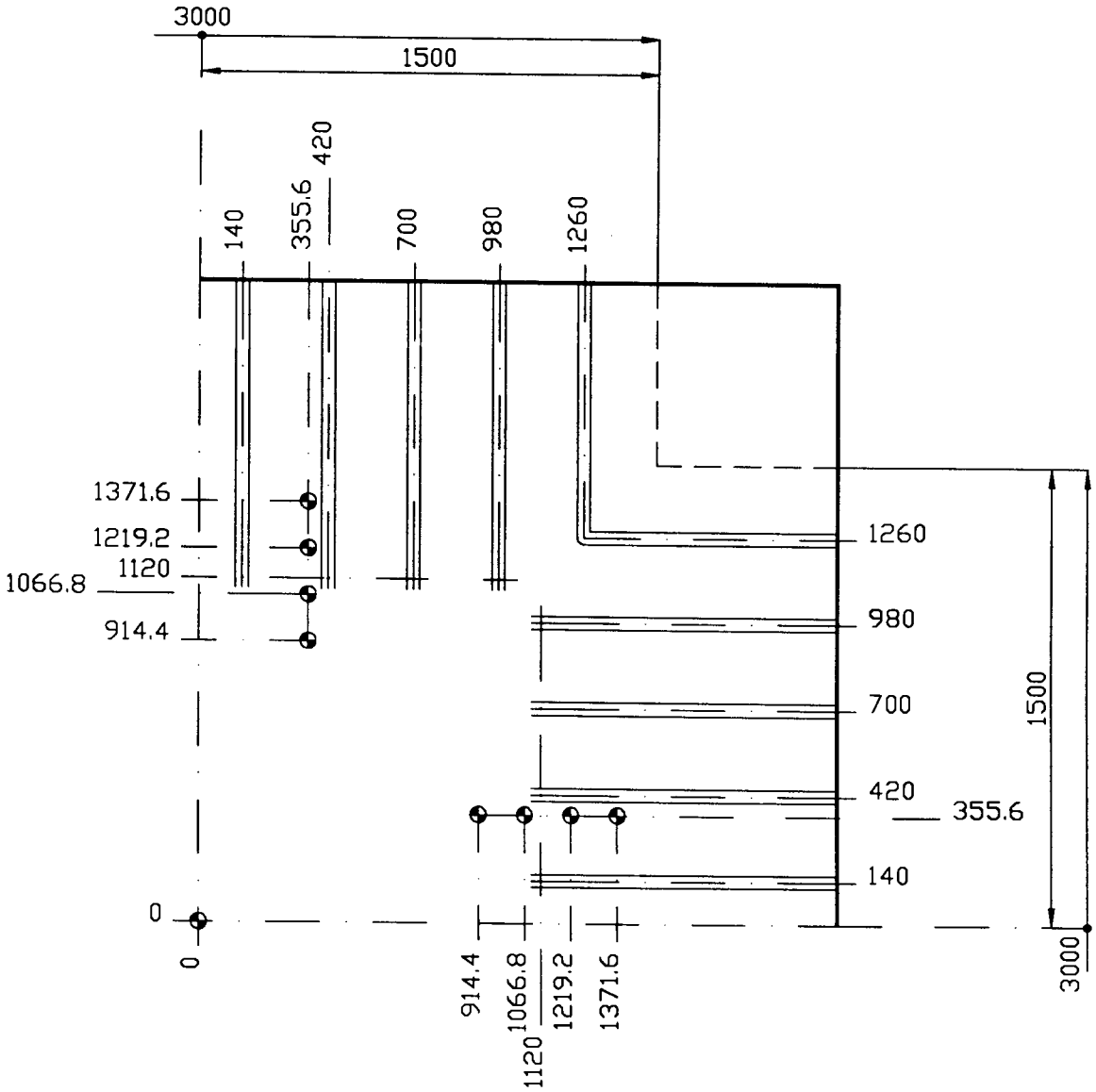
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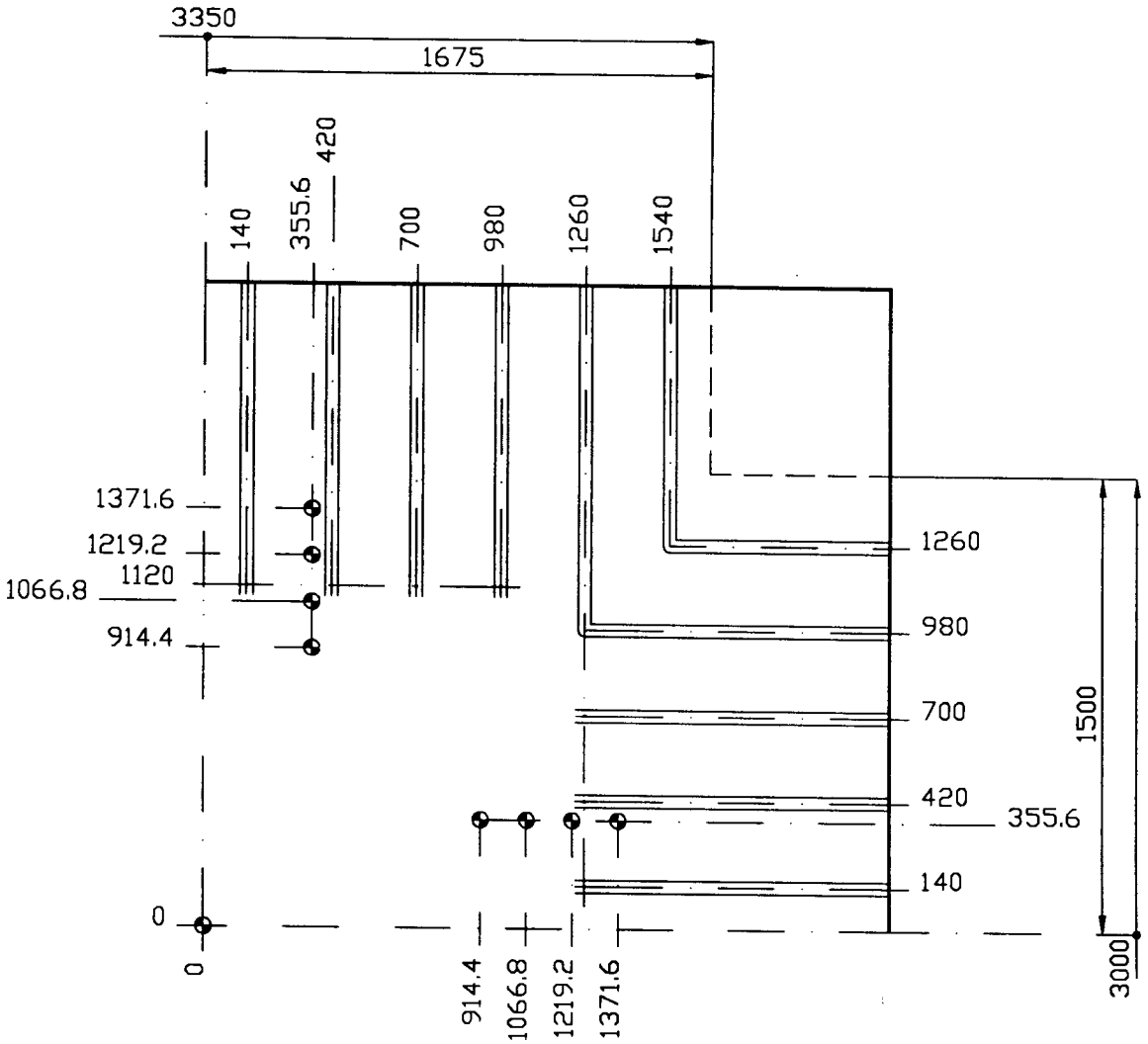
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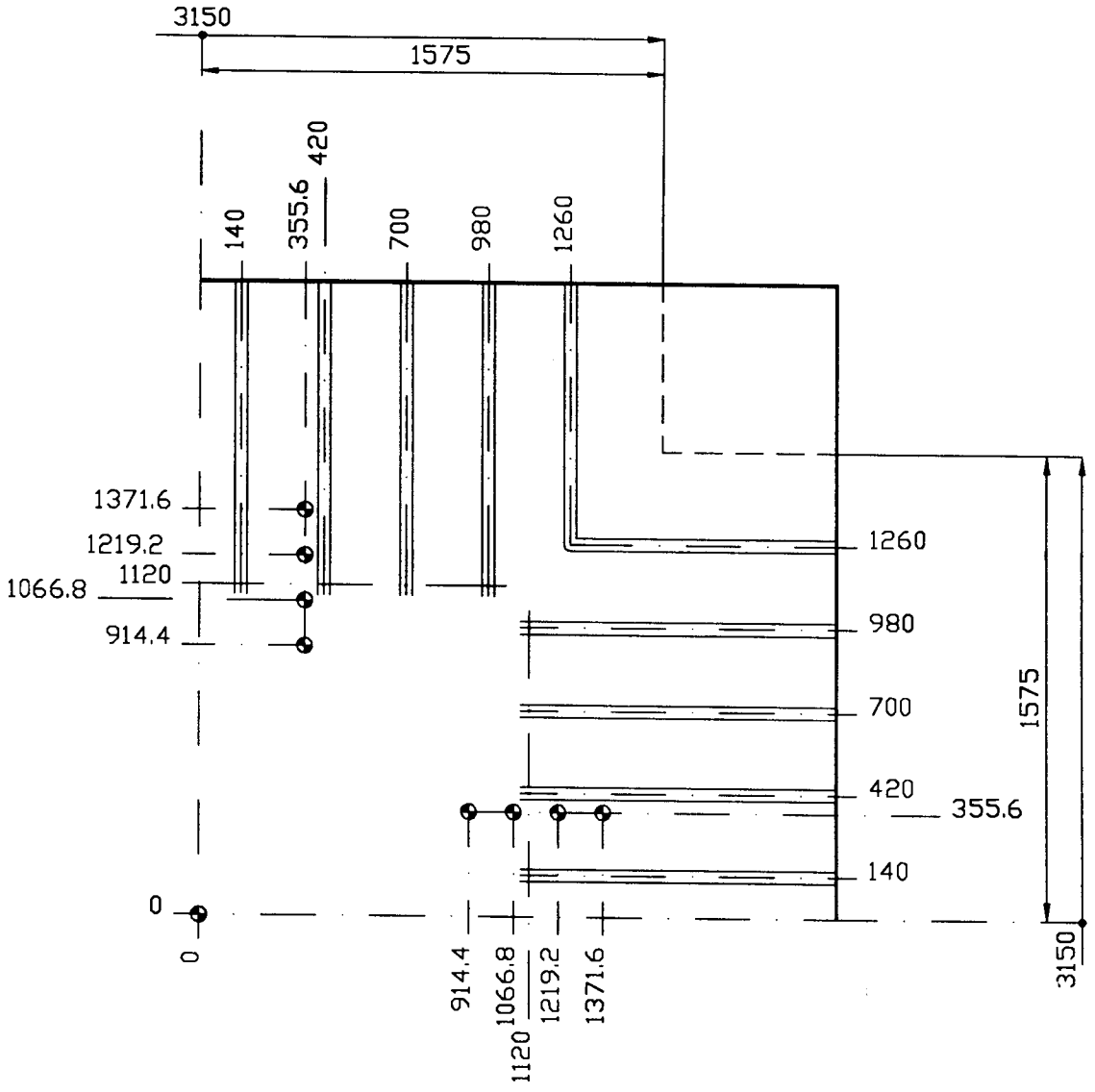
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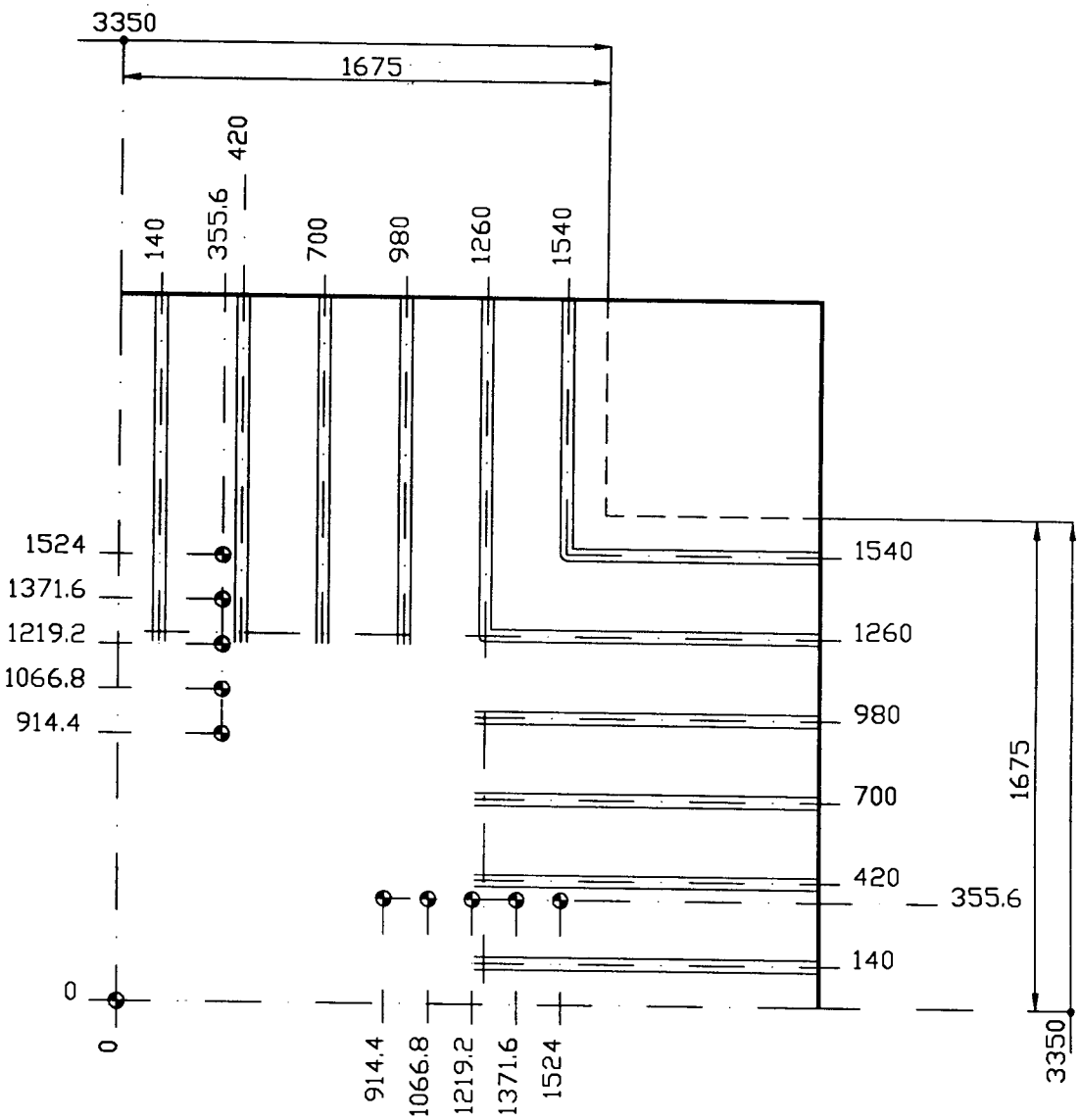
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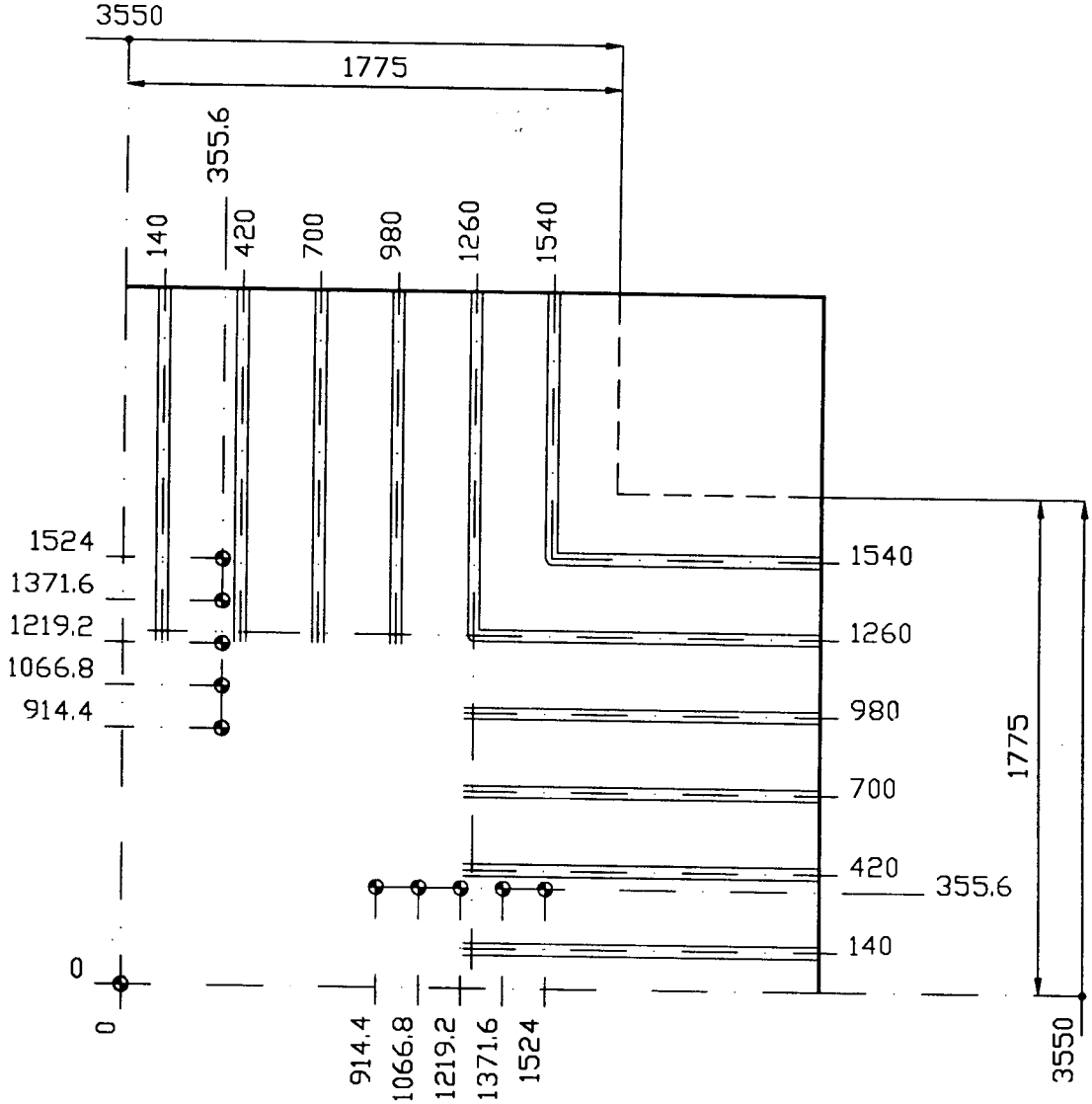
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