



## Feedscrew Material Options

### Tool Steels:

BMS offers feedscrews manufactured from D-2, H-13 and CPM-9V. These materials offer excellent wear resistant characteristics and work well when processing filled resins. A drawback for tool steel feedscrews is that they cannot be repaired.

### Alloy Steels:

AISI 4140 and Nitralloy 135M are the alloy material that BMS offers for most general purpose molding applications. The alloy steels are surface treated to match the feedscrew to the application for improved performance.

### Stainless Steels:

For corrosive or corrosive and abrasive applications BMS offers different grades of stainless steels to suit.

### Specialty Steels:

BMS offers an extensive listing of specialty steels to better match the feedscrew material to the application in which it will be used. Contact BMS with your specific application and allow us to make recommendations. Some of the common specialty steels include Hastelloy C276 and Inconel 718.

## Hard Surfacing Options

### Stellite #6:

Stellite #6 is the most popular wear resistant materials used on feedscrew flights. Stellite #6 is a cobalt based material and has a hardness of 38 - 45 Rc. It is a good choice for general purpose and lightly filled resins.

### Colmonoy #56:

Colmonoy #56 is a better choice when processing glass filled resins. Colmonoy #56 is a nickel based material and has a hardness of 49 - 56 Rc.

## Surface Treatment Options

### Chrome Plating:

Chrome plating is the most common surface treatment used on feedscrews. Chrome plating offers a hardness of 68 - 72 Rc and is a good choice for any general purpose molding application. A heavier thickness of chrome plating is available for applications requiring corrosion protection.

### Nitriding:

Nitriding of the feedscrew will provide a case hardness of 62 - 72 Rc, and a case depth of .020" - .025". Nitriding is a low cost option that will extend the life of the feedscrew for general purpose and lightly filled resin applications.

### Tungsten Carbide Coating:

BMS offers a Tungsten Carbide Coating for use in extreme molding conditions. The coating is applied using an Advanced High Velocity Spray System that actually bonds the coating to the base material. The thickness of the applied Tungsten Carbide is approximately .001" - .050", dependent on the application, and provides a hardness of 62 - 70 Rc. After the coating has been applied to the feedscrew, it is then polished to a surface finish of 16-32 RMS. The Tungsten Carbide Coating is an excellent choice for feedscrews exposed to filled or engineered resins, rubbers or other abrasive compounds.

Base Screw Materials			
Material	Flights Hardsurfacing	Treatment/Coating	Hardness Rc
Alloy Steels			
4140 HT	Stellite #6	Chrome	45
4140 HT	Stellite #12	Chrome	48
4140 HT	Colmonoy #56	Chrome	56
Nitalloy 135M	Colmonoy #56	Nitride	62
Tool Steels			
CPM-9V	N/A	Heat Treating	52 - 54
CPM-9V	N/A	Nitride	60 - 62
D-2	N/A	Heat Treating	58 - 60
D-2	N/A	Nitride	62 - 64
H-13	N/A	Heat Treating	
H-13	N/A	Nitride	
Stainless Steel			
17-4 PH	N/A	N/A	41 - 43
Specialty Steels			
Hastelloy C276	Colmonoy #56	N/A	43 - 45
Inconel 718	N/A	Heat Treating	50

# New Feedscrews

Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Alliance	2.000	11:1	28.5								
	2.500	12:1	37								
	3.000	12:1	43								
	4.000	15:1	26.25								
Arburg	18mm	25:1	23								
	18mm	26:1	23								
	18mm	14:1	13.1875								
	18mm	18:1	15.748								
	22mm	20:1	22.906								
	22mm	20:1	22.8125								
	22mm	20:1	20.188								
	22mm	14:1	15.281								
	22mm	13:1	14.813								
	25mm	25:1	27.9375								
	25mm	29:1	30.5								
	25mm	17:1	19.25								
	25mm	21:1	22.8125								
	25mm	21:1	22.85								
	25mm	22:1	38.625								
	25mm	21:1	23.5								
	25mm	20:1	22.75								
	25mm	25:1	27.938								
	30mm	21:1	27.776								
	30mm	21:1	27.835								
	30mm	27:1	30.375								
	30mm	15:1	20.125								
	30mm	19:1	22.625								
	30mm	18:1	22.688								
	30mm	18:1	28.625								
	35mm	17:1	27.688								
35mm	20:1	27.563									
40mm	17:1	27.562									
45mm	17:1	27.25									
55mm	16:1	61.5									
Autojector	.750	21:1	21.75								
	1.000	15:1	20.188								
	1.250	13:1	21.75								
	1.500	18:1	28.625								
	1.500	20:1	36.375								
Battenfeld	14mm	20:1	29.094								
	18mm	24:1	26.813								
	22mm	21:1	24.469								

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# New Feedscrews

Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Battenfeld	25mm	19:1	24.42								
	25mm	12:1	16.55								
	25mm	18:1	31.469								
	30mm	19:1	24.094								
	35mm	20:1	41.142								
	35mm	20:1	41.142								
	35mm	20:1	41.142								
	40mm	12:1	30.315								
	45mm	13:1	37.657								
	45mm	12:1	37.125								
	45mm	22:1	65								
	50mm	12:1	30.472								
	55mm	18:1	55.390								
	60mm	20:1	32.563								
	70mm	20:1	72.75								
	75mm	20:1	52.5								
	90mm	19:1	77.813								
	96mm	11:1	60.937								
	100mm	11:1	69.375								
	120mm	18:1	154.625								
130mm	11:1	83.175									
150mm	18:1	113.750									
Bekum	60mm	21:1	53.875								
	70mm	25:1	69.750								
	100mm	21:1	99.750								
Beloit	1.500	22:1	47.938								
	1.750	---	55.75								
	2.125	---	65.068								
	2.500	16:1	50.5								
Berlin	3.00	22:1	88								
	1.250	25:1	35.844								
Betol	32mm	25:1	33.5								
Boy	18mm	20:1	25.827								
	22mm	21:1	25.594								
	22mm	14:1	15.5								
	24mm	19:1	25.563								
	24mm	28:1	30.0625								
	24mm	18:1	25.5625								
	24mm	14:1	15.5								
	24mm	13:1	21.437								
28mm	20:1	31									

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Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Boy	28mm	25:1	31.5								
	28mm	12:1	21.8								
	28mm	16:1	25.25								
	28mm	18:1	25.406								
	32mm	30:1	36.45								
	32mm	23:1	31.313								
	36mm	25:1	44.063								
	38mm	18:1	31.438								
Bucher	25mm	21:1	30.875								
	60mm	14:1	45.250								
Cincinnati	1.3125	20:1	36.5								
	1.3125	21:1	36.5								
	1.3125	14:1	30.281								
	1.625	20:1	42.688								
	1.625	20:1	44.656								
	1.625	20:1	44.88								
	1.625	16:1	36.25								
	2.000	20:1	53.76								
	2.000	16:1	42.937								
	2.250	20:1	60.075								
	2.500	20:1	63.062								
	2.500	16:1	53								
	2.500	20:1	63.07								
	2.500	27:1	80.375								
	2.750	20:1	69.67								
	3.250	20:1	81.09								
	3.500	20:1	88.219								
	3.750	20:1	81.187								
	4.500	20:1	111.375								
	4.500	22:1	111.38								
	4.500	21:1	116.57								
	4.500	20:1	117.5								
	4.500	28:1	142.88								
	4.500	18:1	101.625								
	6.000	20:1	120.63								
	20mm	22.2:1	22.875								
	22mm	20:1	22.688								
	25mm	20:1	28.125								
26mm	21.5:1	33.661									
28mm	20:1	33.687									
32mm	20:1	37.953									

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Cincinnati	32mm	20:1	33.156								
	35mm	18:1	43.080								
	36mm	20:1	38.385								
	40mm	19:1	43.063								
	42mm	20:1	36.875								
	44mm	20:1	45.250								
	45mm	20:1	45.281								
	45mm	22:1	52.677								
	50mm	22:1	59.188								
	55mm	24:1	66.75								
	70mm	18:1	66.2								
	100mm	22:1	111.693								
Davis Standard	1.250	24:1	36								
	1.500	24:1	35.812								
	2.500	24:1	76.187								
	2.500	18:1	49.062								
	3.500	24:1	103.50								
Egan	4.500	30:1	145.375								
	1.750	15:1	35.380								
	2.500	24:1	66.225								
	2.500	16:1	50.375								
	3.000	20:1	75.25								
	3.500	20:1	89.375								
	3.500	20:1	91.850								
	3.750	16:1	79.687								
Egan Lester	4.500	19.4:1	112.312								
	6.00	24:1	172								
	2.000	20:1	51.375								
Engel	2.000	20:1	48								
	18mm	23.4	2.437								
	22mm	16:1	19.055								
	25mm	22:1	27.5								
	25mm	14:1	19.055								
	25mm	25:1	36.614								
	25mm	24:1	36.563								
	25mm	22:1	27.594								
	30mm	20:1	31.813								
	30mm	19:1	27.559								
	20mm	20:1	31								
30mm	19:1	29									

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# New Feedscrews

Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Engel	30mm	20:1	29								
	30mm	14:1	38.75								
	35mm	21:1	36.437								
	35mm	21:1	36.375								
	35mm	15:1	38.875								
	35mm	21:1	43								
	35mm	18:1	37.5								
	45mm	16:1	36.375								
	50mm	23:1	61.024								
	50mm	14:1	41.5								
	50mm	12:1	37.4								
	55mm	21.2:1	58.250								
	60mm	22:1	69.961								
	60mm	18:1	51.094								
	70mm	21.3:1	78								
80mm	20:1	75.750									
150mm	20:1	142.750									
Entwistle	1.250	20:1	30.875								
	1.500	24:1	44.25								
Farrel	1.625	---	43.85								
	2.000	21:1	51.938								
	2.000	19:1	50.781								
	2.800	23:1	87.5								
	6.000	22:1	162.75								
Fischer	80mm	13:1	81								
	80mm	19:1	68.375								
Gluco	1.000	16:1	18.875								
	1.000	16:1	19.375								
	1.000	---	19.188								
	1.000	16:1	19.375								
	1.000	---	25.188								
	1.000	23:1	31.938								
	1.250	16:1	27.15								
	1.500	16:1	26.547								
	1.500	18:1	32.262								
	1.500	16:1	26.547								
	1.750	11:1	33.25								
	2.000	---	40.5								
Goldstar	55mm	20:1	57.874								

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Hayssen	1.750	---	43.313								
	2.000	20:1	50.188								
	2.000	---	46.938								
	2.000	---	40.406								
	2.250	---	50.406								
HPM	1.188	20:1	41.07								
	1.188	20:1	48.19								
	1.375	22:1	41.62								
	1.375	18:1	36.156								
	1.375	21:1	54.687								
	1.500	18:1	35.188								
	1.625	20:1	46.625								
	2.000	---	67.062								
	2.000	20:1	54.687								
	2.000	16:1	44.75								
	2.3125	20:1	65.562								
	2.500	18:1	50.375								
	2.500	20:1	66.75								
	2.500	20:1	64.875								
	3.000	20:1	79.25								
	3.500	24:1	88.75								
	3.500	16:1	74.1								
	3.500	20:1	93								
3.500	20:1	95.302									
4.00	20:1	131.250									
4.500	24:1	145.625									
5.250	20:1	136.62									
Impco	1.750	23:1	54.125								
	1.750	18:1	47.188								
	2.000	24:1	52.5								
	2.000	20:1	43.75								
	2.500	18:1	58.312								
	2.500	24:1	77.125								
	2.800	20:1	89.5								
	4.250	21:1	106								
	5.250	20:1	119.625								
	46mm	21:1	60.219								
	46mm	20:1	60.219								
Jomar	1.375	33:1	55								
	2.000	30:1	74.938								
	2.500	---	75								
JSW	20mm	17:1	18.625								

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Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
JSW	32mm	20.9:1	37.688								
	40mm	20:1	41.656								
	40mm	20:1	41.693								
	40mm	20:1	42.670								
	46mm	20:1	47.401								
	51mm	18:1	47.401								
	58mm	18:1	54.527								
	66mm	18:1	85.938								
	72mm	18:1	68.150								
	84mm	18:1	78.543								
	86mm	15:1	68.150								
	99mm	20:1	78.543								
	120mm	20:1	115.750								
	130mm	20:1	126								
Kawaguchi	25mm	19:1	26								
	28mm	16:1	24.656								
	28mm	16:1	23.938								
	30mm	19:1	31.063								
	34mm	19:1	33.661								
	36mm	19:1	36.625								
	40mm	19:1	37.125								
	42mm	20:1	45.625								
	50mm	19:1	50.625								
	50mm	18:1	44.29								
	58mm	18:1	52.5								
	60mm	21:1	63.875								
	70mm	---	62.625								
	72mm	20:1	76.375								
	80mm	20:1	84.375								
100mm	19:1	105.812									
Killion	.750	24:1	21.063								
	1.500	24:1	41.096								
Klockner Windsor	18mm	24:1	28.5								
	30mm	26:1	41.469								
	60mm	---	72.047								
Krauss Maffei	35mm	15:1	29.375								
	40mm	16:1	34.646								
Lester	1.500	26:1	51.344								
	2.000	---	53.5								
	2.000	---	59.625								
	2.500	20:1	64								
	2.500	20:1	63.625								

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Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Lombard	2.500	20:1	81.188								
	2.750	25:1	97.313								
Meiki	32mm	26:1	40.563								
	40mm	23:1	50.75								
	65mm	21:1	72.813								
Mir	38mm	15:1	33.150								
	45mm	20:1	46.259								
	50mm	21:1	52.677								
	55mm	13:1	41.989								
	100mm	22:1	115.354								
Mitsubishi	22mm	20:1	23.375								
	28mm	20:1	30.125								
Moslo	1.625	18:1	41.625								
	2.000	18:1	50.625								
Natco	2.250	18:1	51.219								
	2.250	18:1	51.687								
	70mm	18:1	64.440								
	90mm	18:1	80.125								
	105mm	---	90.875								
Negri Bossi	135mm	18:1	119								
	32mm	---	35.236								
	38mm	---	34.251								
	38mm	20:1	32.598								
	50mm	20:1	46.063								
New Britain	1.625	18:1	40.125								
	1.750	18:1	46.5								
	1.750	17.7:1	42.266								
	2.000	15:1	45.750								
	2.000	17.5:1	50.562								
	2.500	24:1	62.5								
	2.500	18:1	58.250								
	2.500	14:1	42.625								
	3.250	---	77.453								
	28mm	---	23.5								
	36mm	27:1	35.25								
	36mm	16:1	23.625								
	36mm	18:1	28.656								
	36mm	16:1	23.625								
	42mm	16:1	23.438								
45mm	14:1	33.188									

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Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
New Britain	55mm	12:1	33.313								
	55mm	17:1	45								
	55mm	18:1	40.688								
	55mm	12:1	33.4375								
	55mm	12:1	33.313								
	58mm	20:1	47.875								
	70mm	16:1	48.062								
	70mm	15:1	48								
Newbury	1.000	19:1	23.813								
	1.000	14:1	18.438								
	1.00	14:1	18.5								
	1.250	19:1	25								
	1.250	15:1	24.5								
	1.250	18:1	28								
	1.250	13:1	21.75								
	1.250	14:1	21.75								
	1.375	15:1	27.312								
	1.375	20:1	33.44								
	1.500	14:1	28.625								
	1.750	19:1	42.5								
	1.750	15:1	35.313								
	1.750	14:1	31.625								
	2.000	22:1	41.938								
	2.000	22:1	41.844								
2.000	14:1	31.75									
2.250	22:1	55.625									
2.250	16:1	41.687									
Niigata	25mm	22:1	25.875								
	30mm	19:1	25.987								
	45mm	18:1	36.375								
Nissei	19mm	18:1	18.562								
	22mm	19:1	22.438								
	26mm	20:1	26.409								
	30mm	16:1	24.375								
	30mm	19:1	24.375								
	32mm	21:1	35.118								
	32mm	22:1	35.156								
	32mm	19:1	31								
	40mm	17:1	34.438								
	40mm	18:1	38.843								
	44mm	18:1	38								
45mm	17:1	38.504									

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Nissei	54mm	21:1	44.344								
	56mm	17:1	49.146								
	56mm	19:1	53.438								
	63mm	17:1	53.25								
	64mm	16.5:1	51.375								
	71mm	18:1	59.449								
	72mm	16:1	54.906								
	72mm	16:1	54.813								
NRM	2.500	18:1	81.126								
	2.500	28:1	82								
	2.500	24:1	69								
	3.500	---	96.812								
	4.500	32:1	150.438								
	4.500	24:1	117.5								
Prodex	2.000	20:1	47.437								
	2.000	25:1	59.75								
Rainville	2.500	---	79.625								
	2.500	24:1	79.5								
Reed	1.625	17:1	39.938								
	1.625	18:1	37.31								
	1.750	13:1	29.1								
	2.000	17:1	41.2812								
	2.000	24:1	43								
	2.000	12:1	29.437								
	2.000	16:1	40.375								
	2.000	16:1	40.437								
	2.125	12:1	36.5								
	2.500	18:1	57.813								
	2.500	16:1	57.875								
	2.500	20:1	61.688								
	2.500	21:1	67.844								
	2.500	16:1	50								
	2.500	17:1	51.5								
	2.750	12:1	48.688								
	3.00	17:1	69.25								
	3.000	21:1	73.312								
	3.00	16:1	59.75								
	3.00	18:1	61.305								
	3.3125	17:1	48.75								
	3.3125	11:1	48.75								
3.750	18:1	77.438									
3.750	16:1	74.75									

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Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Reed	4.500	16:1	88.25								
Sandretto	40mm	21:1	36.188								
	45mm	24:1	48.875								
	50mm	24:1	53.134								
	55mm	26.5:1	56								
	60mm	21:1	59.448								
	70mm	21:1	68.897								
	80mm	22:1	82.812								
	90mm	22.3:1	94.094								
	105mm	---	108.267								
Shinwa Seiki	28mm	21:1	32.815								
	32mm	18:1	32.815								
Sterling	2.500	21:1	61.75								
	3.500	---	97								
	3.500	23:1	90								
	3.500	26:1	102.375								
	4.500	---	154.25								
	6.000	32:1	212.37								
Stokes	1.250	19:1	29.25								
	1.250	16.7:1	29.250								
	1.250	16:1	25.625								
	1.375	---	35.875								
	1.625	17.3:1	36.812								
	1.750	16:1	39								
	1.750	---	36.312								
	2.000	18:1	42.188								
	2.000	---	38.906								
	2.000	26:1	58								
	2.000	25:1	53.625								
	2.500	---	44.688								
	2.500	20:1	56.25								
	2.500	21:1	56.375								
Sumitomo	22mm	21:1	26.160								
	24mm	25:1	38.312								
	28mm	22:1	30.315								
	45mm	19.5:1	48.625								
	50mm	22:1	58.74								
	53mm	15:1	42								
TMC	30mm	17:1	61.032								
	64mm	20:1	71.535								
	70mm	18:1	61.068								
Toshiba	25mm	20:1	28.425								

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# New Feedscrews

Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Toshiba	28mm	23:1	37.598								
	32mm	20:1	37.75								
	36mm	20:1	38.938								
	36mm	20:1	41.378								
	36mm	20:1	40.75								
	36mm	15:1	34.313								
	36mm	16:1	34.125								
	40mm	20:1	46.493								
	40mm	20:1	46.693								
	45mm	20:1	50.571								
	45mm	20:1	46.732								
	45mm	22:1	56.813								
	50mm	20:1	57.875								
	50mm	18:1	46.875								
	55mm	17.8:1	57.875								
60mm	20:1	67.205									
70mm	20:1	77.437									
Toyo	32mm	23:1	37.125								
	40mm	20:1	42.875								
	40mm	20:1	37.125								
	50mm	20:1	51.438								
Trubor	.875	21:1	24.719								
	25mm	21:1	26								
	25mm	18:1	23.79								
	31mm	20:1	33.062								
	35mm	20:1	38.156								
	41mm	20:1	44.906								
Trueblood	1.000	12:1	23.5								
	1.000	13:1	20.5								
	1.250	16:1	29.75								
	1.375	12:1	27.875								
	1.500	12:1	29.782								
	1.500	14:1	29.75								
	1.500	12:1	29.844								
	1.500	12:1	29								
	2.000	12:1	37.844								
Van Dorn	18mm	26:1	24.438								
	30mm	18:1	28.767								
	30mm	18:1	31.496								
	35mm	18:1	35.334								
38mm	18:1	36.75									

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# New Feedscrews

Machine Type	Screw Dia.	L/D	Overall Length	D-2	135M Nitride	4140 HT Stel. #6 Chrome	4140 HT Stel. #6 Nitride	4140 HT Col. 56 Chrome	4140 HT Col 56 Nitride	CPM 9V HT	Tungsten Carbide Coating
Van Dorn	40mm	21:1	43.375								
	40mm	18:1	38.25								
	40mm	32:1	60.187								
	40mm	18:1	38.189								
	50mm	---	76.875								
	50mm	32:1	55.709								
	50mm	18:1	49.375								
	57mm	18:1	54.425								
	65mm	24:1	75								
	65mm	18:1	59.625								
	69mm	18:1	62.25								
	80mm	18:1	75.687								
	90mm	18:1	85.625								
	105mm	18:1	95.866								
	105mm	18:1	95.812								
115mm	20.3:1	116.918									

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