

PCD Turning Inserts



Standard/Chip breaker/Wiper

Company Profile

ToolingBox (Beijing) Industrial Technology Co.,Ltd is a Chinese professional manufacturer for cutting tools. We supply solid&brazed CBN tools, Tipped PCD inserts and tools, carbide inserts and tools for woodworking and metalworking industries.

With over a decade of dedicated expertise, our company specializes in the research, development, production, promotion, and technical service of tungsten carbide cutting tools. Our product range includes woodworking carbide reversible knives, molding knives, circular cutters, oscillating knives, carbide thin razor blades, carbide scrapers, and more. These products find extensive applications in wood processing, paper printing, film and fiber industries, electronic battery cutting, and various other sectors. Renowned for our outstanding product quality and prompt deliveries, we have garnered recognition from numerous customers, leading to a significant domestic market share and exports to countries and regions, including Europe, the United States, Russia ,Mid east ,India and Southeast Asia.

Our company possesses a comprehensive set of standardized testing equipment and processes to ensure product quality. We are supported by a professional team specializing in production, technology, and sales, capable of addressing various customer-related issues. With over 100 CNC grinding machines, end mills, surface grinders, and a variety of imported inspection devices, we stand as one of the industry's largest, highest-output, most diverse, and fully-equipped enterprises in China.

We adhere to the business philosophy of "integrity in operation, superior quality, and customer-first", continuously enhancing our corporate image and product quality, reducing overall costs, shortening delivery times, and consistently improving customer satisfaction.

ToolingBox, Professional makes values!





Raw material production



Raw material inspection



Flat grinding



CNC cutting edge



CNC cutting edge



Cleaning



Inspection of the first



Inspection of the second

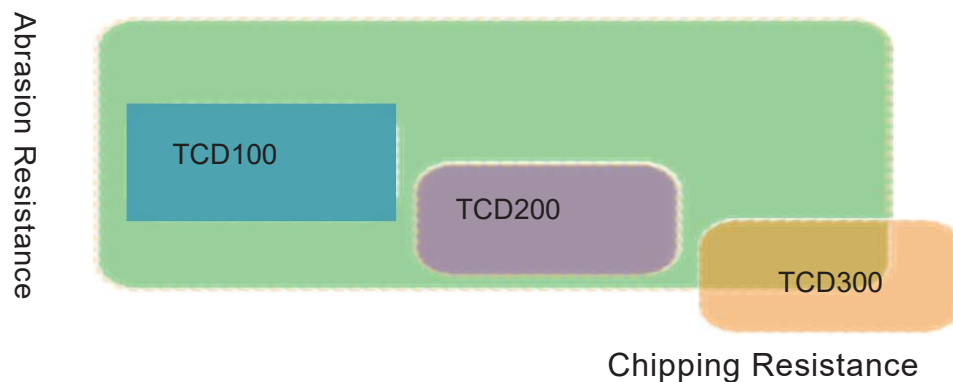
Page	05-06	PCD Material Introduction
Page	07	Cutting Direction Recommendation
Page	08-09	Rule of PCD Insert Code
Page	10-16	PCD tipped Inserts
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Page	23	Cutting Speed Recommendation
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PCD Material Introduction

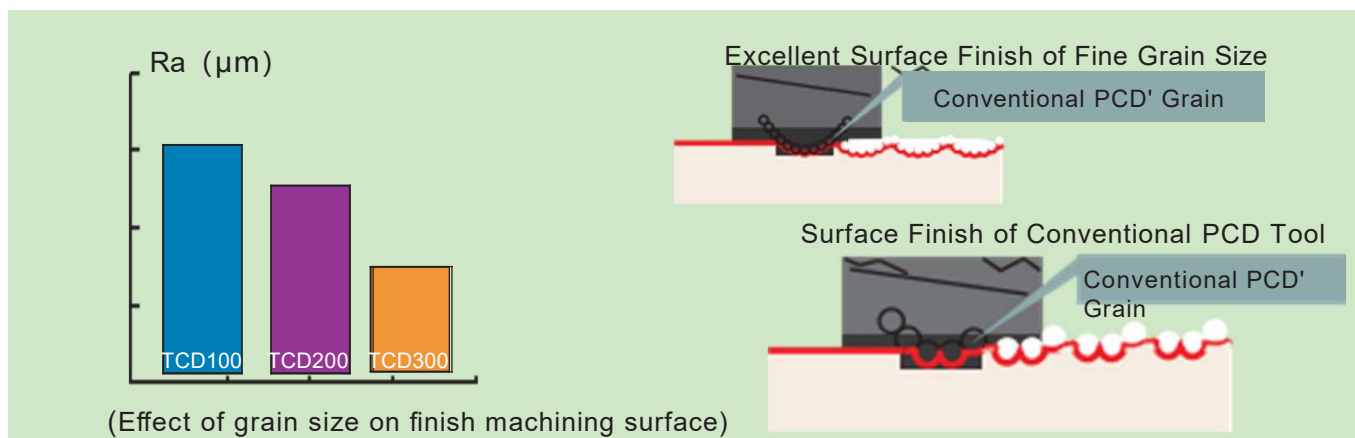
Application Recommendation

PCD Blank Grade	Particle Size (um)	Bond	Characteristics	Application
TCD100	10	metal	General PCD grade, with high impact resistance and very high wear resistance	suitable for aluminum alloy (Si<13%) and non-metal finishing turning, wood plank cutting off
TCD200	5	metal	General PCD grade, with high impact resistance and high wear resistance	suitable for ceramic, graphite, non-metal & wood turning
TCD300	2-30	metal	Excellent wear resistance, high thermal stability and high impact resistance through adopting mixed grains	suitable for aluminum alloy (Si>13%), MMC material (metal-matrix composite) based aluminum, sintered ceramic and rocks.

Micro-Structure of PCD Materials



PCD Grain Size Affects Roughness of Workpiece's Surface



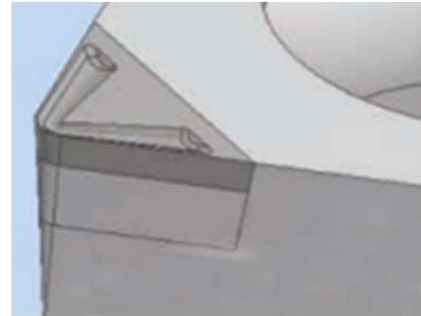
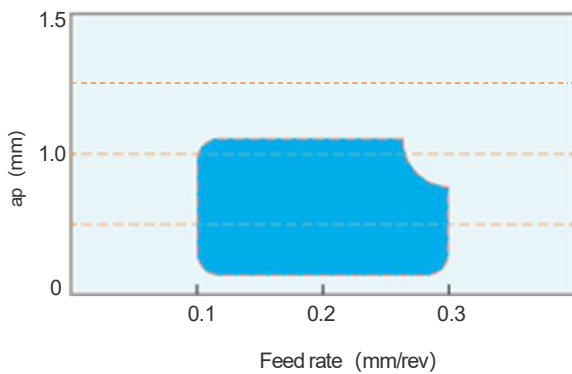
PCD Material Introduction

PCD Insert with chip-breaker /Wiper

■PCD Insert with chip-breaker

Excellent chip breaking in finishing machining

Scope of Application



Material: TCD100

Cutting conditions: $V_c=400\text{m/min}$ $f=0.1\text{mm/rev}$ $a_p=0.2\text{mm}$

Insert type: CCGW09T308



Material: TCD200

Cutting conditions: $V_c=400\text{m/min}$ $f=0.1\text{mm/rev}$ $a_p=0.5\text{mm}$

Insert type: CCGW09T308



■PCD Wiper Insert(WG)

Improve the quality of workpiece surface or processing efficiency

Effect of Wiper Insert

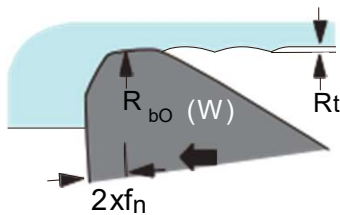
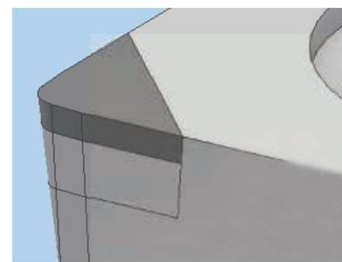
With the same R_t ,

Wiper inserts increase double feed rate($2x f_n$).

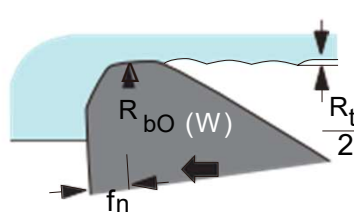
Under the same f_n ,

Wiper inserts improve the surface quality($\frac{R_a}{2}$).

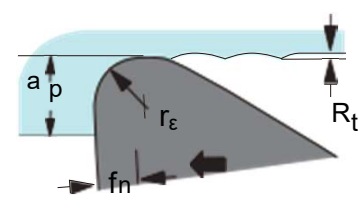
Standard corner radius



High Efficiency

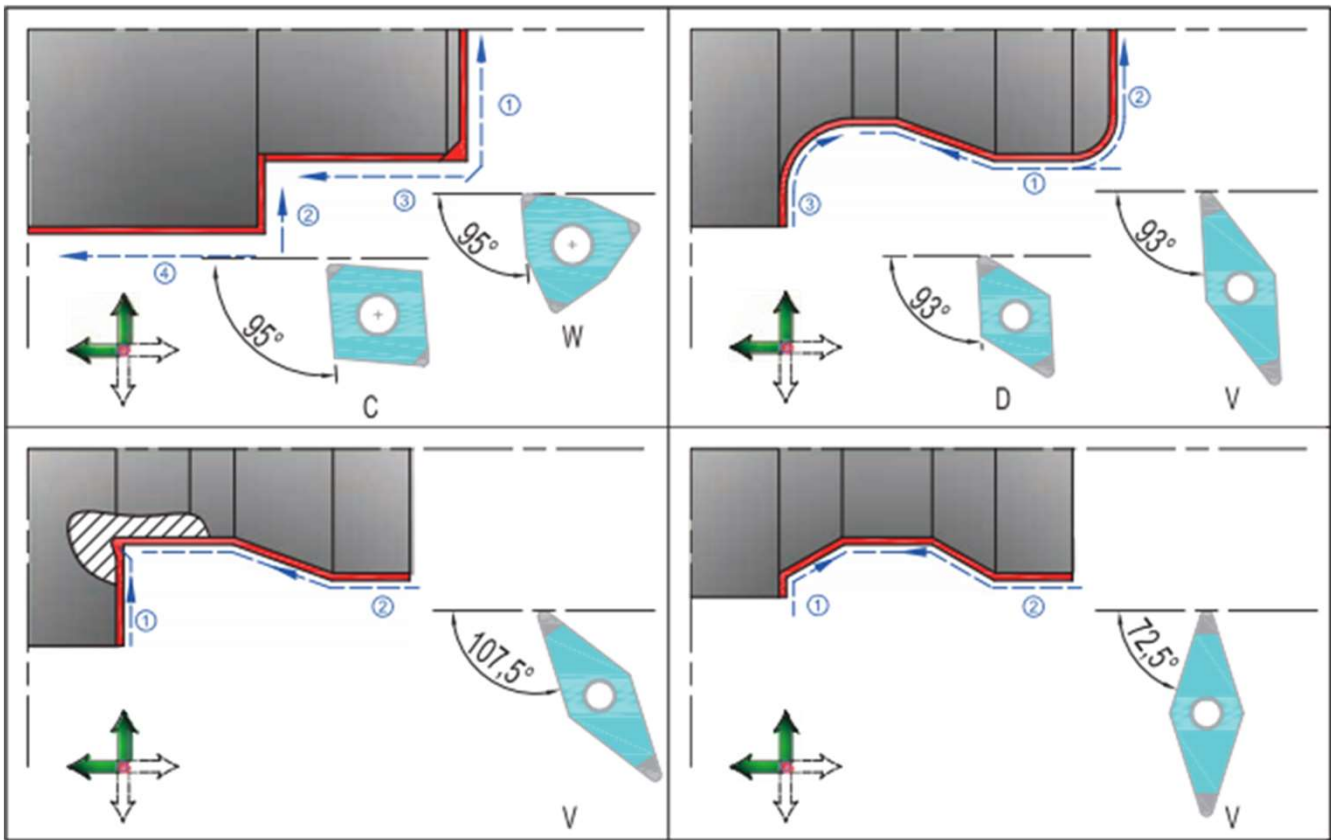


High Quality Surface

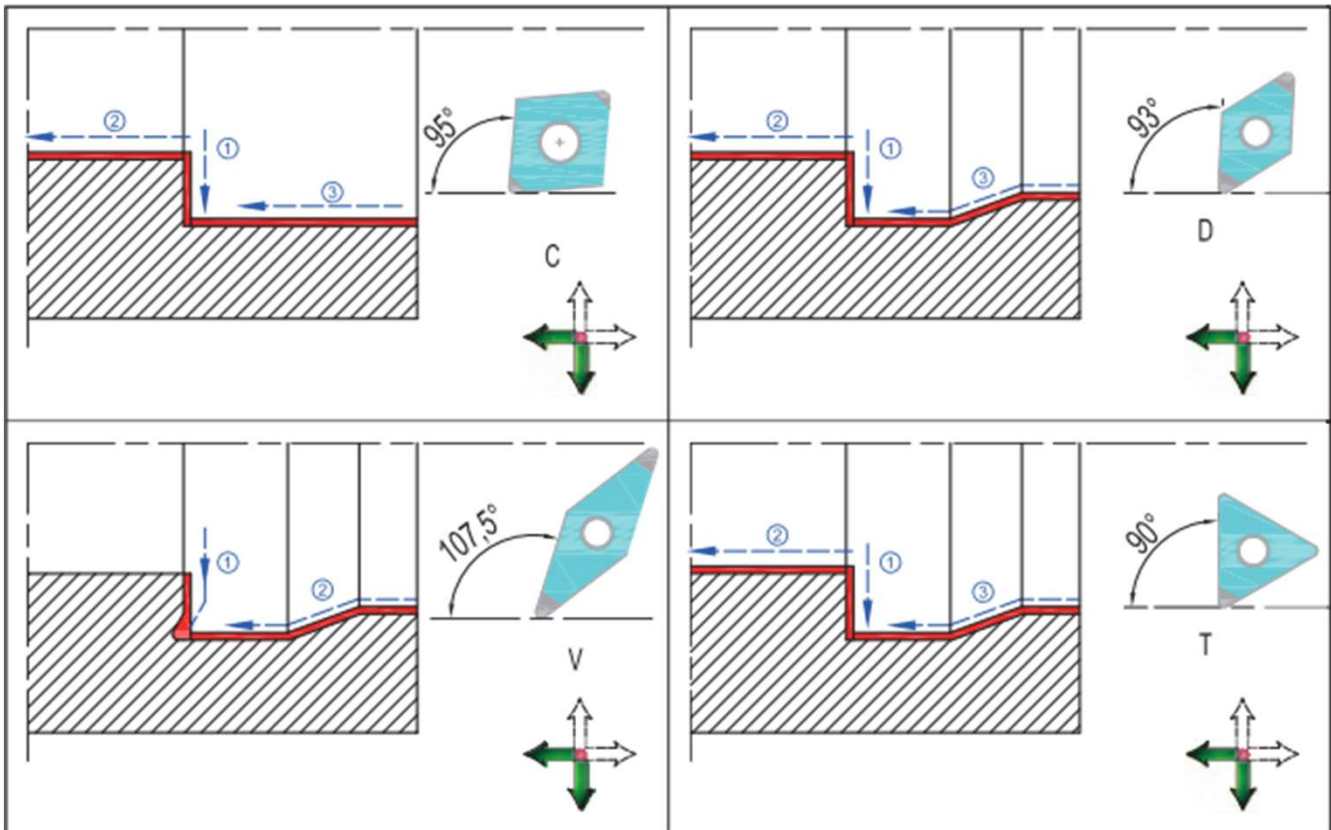


Recommended cutting direction for turning no-ferrous with PCDtools

■ External machining



■ Internal machining



ISO	C	C	G	W	12	04	08	-	TP	N
	1	2	3	4	5	6	7		8	9

1
insert shape

A		R	
B		S	
C		T	
D		V	
		W	

2
clearance angle

B		N	
C		P	
D			

4
machining and fastening feature

A		N		W	
B		Q		T	

X Drawing or Precise description of indexable inserts required

3
tolerances, ISO[mm]

	d	m	s
	A ±0.025	±0.005	±0.025
	C ±0.025	±0.013	±0.025
	E ±0.025	±0.025	±0.025
	F ±0.013	±0.005	±0.025
	G ±0.025	±0.025	±0.130
	H ±0.013	±0.013	±0.025
	J ±0.05~±0.15	±0.005	±0.025
	K ±0.05~±0.15	±0.013	±0.025
	L ±0.05~±0.15	±0.025	±0.025
	M ±0.05~±0.15	±0.08~±0.20	±0.130

5
insert size




Inner circle diameter		C	D	R	S	T	V	W
IC mm	Code	Code	Code	Code	Code	Code	Code	Code
3.97	1.2				03	06		03
5					08			
5.56	1.8				07	09		
6			06					
6.35	2	1/4"	06	07	06		11	11
8			08		08			05
9.525	3	3/8"	09	11	09	09	16	16
10				10				
12				12				
12.7	4	1/2"	12	15	12	12	22	22
15.875	5	5/8"	16		15	15	27	
16				16				12
19.05	6	3/4"	19		19	19	33	
20				20				
25								
25.4	8	1"	25		25			
31.75	10	1-1/4"						



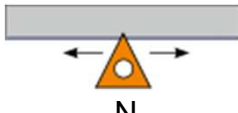
ANS

C	C	G	W	4	3	2	-	TP	N
1	2	3	4	5	6	7		8	9

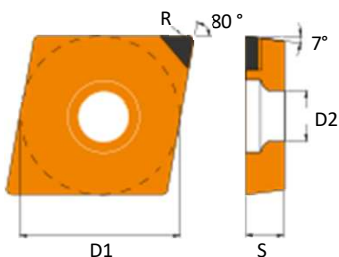
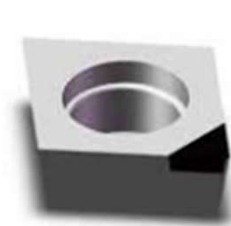
6 thickness			
ISO		ANSI	
01	1.59	1	1/16
T1	1.98	1.2	0.75
02	2.38	1.5	3/32
T2	2.78	-	-
03	3.18	2	1/8
T3	3.97	2.5	5/32
04	4.76	3	3/16
05	5.56	3.5	7/32
06	6.36	4	1/4
07	7.94	5	5/16
09	9.52	6	3/8

7 corner radius r mm, inch			
ISO		ANSI	
01	r=0.1	0.1	1/25
02	r=0.2	0	2/25
04	r=0.4	1	1/64
08	r=0.8	2	1/32
12	r=1.2	3	3/64
16	r=1.6	4	1/16
24	r=2.4	6	3/32
32	r=3.2	8	1/8
0 from imperial units to mm M0 For diameters in metric units			

8 insert form	
	1N pcd inserts with one corner
	CB pcd inserts with chip breaker
	FE full edge pcd inserts

9 cutting direction	
	R
	L
	N

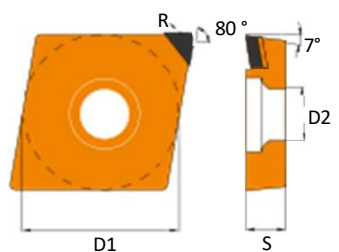
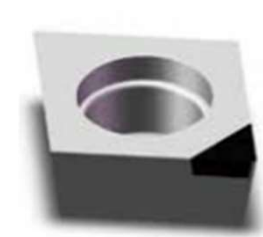
CCG W/CC MW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCGW060204-1N	6.35	2.8	2.38	0.4
CCGW060208-1N				0.8
CCMW060202-1N	6.35	2.8	2.38	0.2
CCMW060204-1N				0.4
CCMW060208-1N				0.8
CCGW09T302-1N	9.525	4.4	3.97	0.2
CCGW09T304-1N				0.4
CCGW09T308-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCMW09T304-1N	9.525	4.4	3.97	0.4
CCMW09T308-1N				0.8
CCGW120404-1N	12.7	5.5	4.76	0.4
CCGW120408-1N				0.8
CCGW120412-1N				1.2
CCMW120404-1N	12.7	5.5	4.76	0.4
CCMW120408-1N				0.8
CCMW120412-1N				1.2

CCG T/C CMT



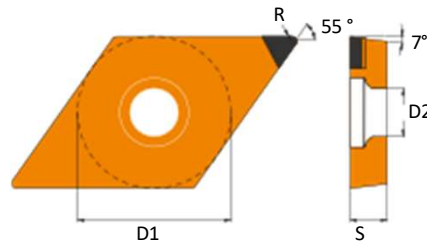
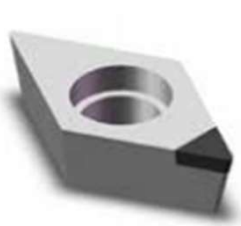
Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCGT060204-1N	6.35	2.8	2.38	0.4
CCGT060208-1N				0.8
CCMT060202-1N	6.35	2.8	2.38	0.2
CCMT060204-1N				0.4
CCMT060208-1N				0.8
CCGT09T302-1N	9.525	4.4	3.97	0.2
CCGT09T304-1N				0.4
CCGT09T308-TP				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCMT09T304-1N	9.525	4.4	3.97	0.4
CCMT09T308-1N				0.8
CCGT120404-1N	12.7	5.5	4.76	0.4
CCGT120408-1N				0.8
CCGT120412-1N				1.2
CCMT120404-1N	12.7	5.5	4.76	0.4
CCMT120408-1N				0.8
CCMTW120412-TP				1.2

Order Note

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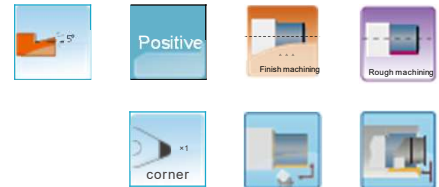
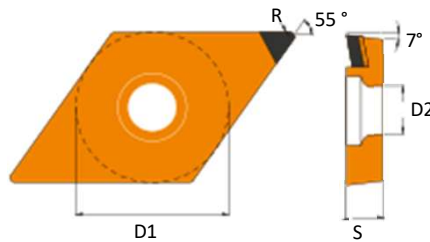
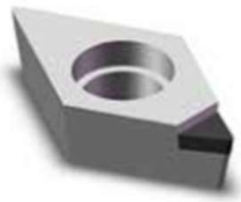
DC GW/DC MW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGW070202-1N	6.35	2.8	2.38	0.2
DCGW070204-1N				0.4
DCGW070208-1N				0.8
DCMW070202-1N	6.35	2.8	2.38	0.2
DCMW070204-1N				0.4
DCMW070208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGW11T304-1N	9.525	4.4	3.97	0.4
DCGW11T308-1N				0.8
DCGW11T312-1N				1.2
DCMW11T304-1N	9.525	4.4	3.97	0.4
DCMW11T308-1N				0.8
DCMW11T312-1N				1.2

D CGT/D CMT



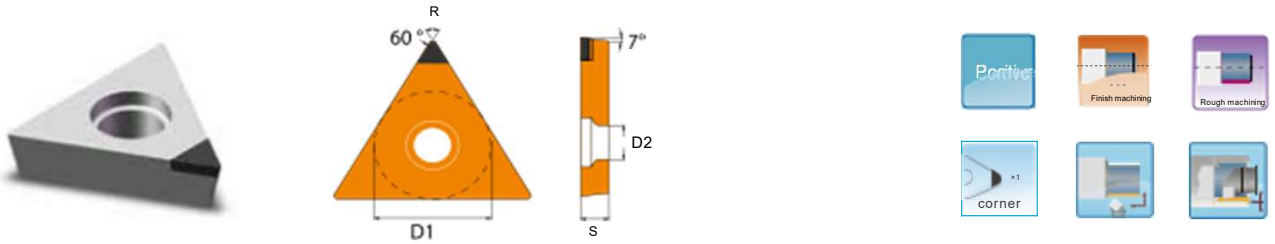
Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGT070202-1N	6.35	2.8	2.38	0.2
DCGT070204-1N				0.4
DCGT070208-1N				0.8
DCMT070202-1N	6.35	2.8	2.38	0.2
DCMT070204-1N				0.4
DCMT070208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGT11T304-1N	9.525	4.4	3.97	0.4
DCGT11T308-1N				0.8
DCGT11T312-1N				1.2
DCMT11T304-1N	9.525	4.4	3.97	0.4
DCMT11T308-1N				0.8
DCMT11T312-1N				1.2

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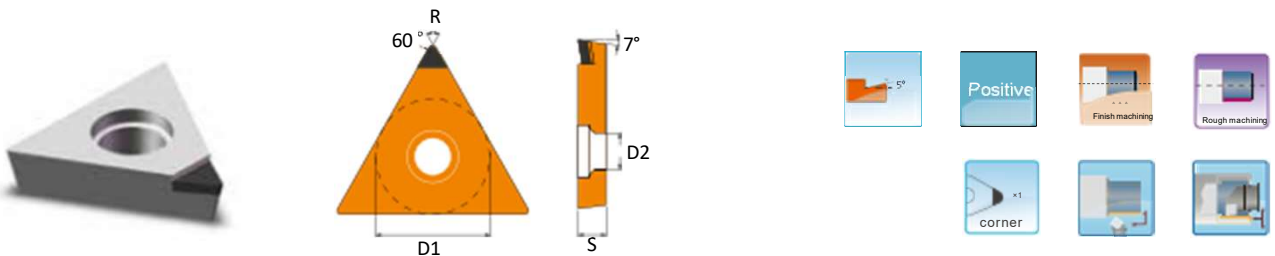
TCG W/TCMW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCGW090204-1N	5.56	2.5	2.38	0.4
TCGW090208-1N				0.8
TCMW090204-1N	5.56	2.5	2.38	0.4
TCMW090208-1N				0.8
TCGW110204-1N	6.35	2.8	2.38	0.4
TCGW110208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCMW110204-1N	6.35	2.8	2.38	0.4
TCMW110208-1N				0.8
TCGW16T304-1N	9.525	4.4	3.97	0.4
TCGW16T308-1N				0.8
TCMW16T304-1N	9.525	4.4	3.97	0.4
TCMW16T308-1N				0.8

TCGT/TCMT



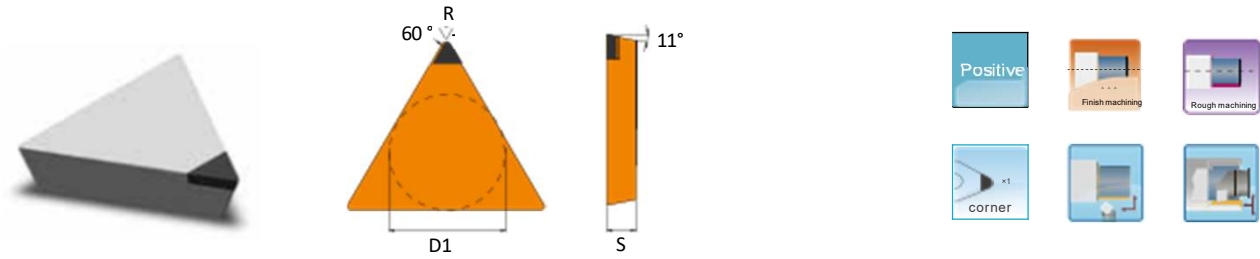
Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCGT090204-1N	5.56	2.5	2.38	0.4
TCGT090208-1N				0.8
TCMT090204-1N	5.56	2.5	2.38	0.4
TCMT090208-1N				0.8
TCGT110204-1N	6.35	2.8	2.38	0.4
TCGT110208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCMT110204-1N	6.35	2.8	2.38	0.4
TCMT110208-1N				0.8
TCGT16T304-1N	9.525	4.4	3.97	0.4
TCGT16T308-1N				0.8
TCMT16T304-1N	9.525	4.4	3.97	0.4
TCMT16T308-1N				0.8

Order Note

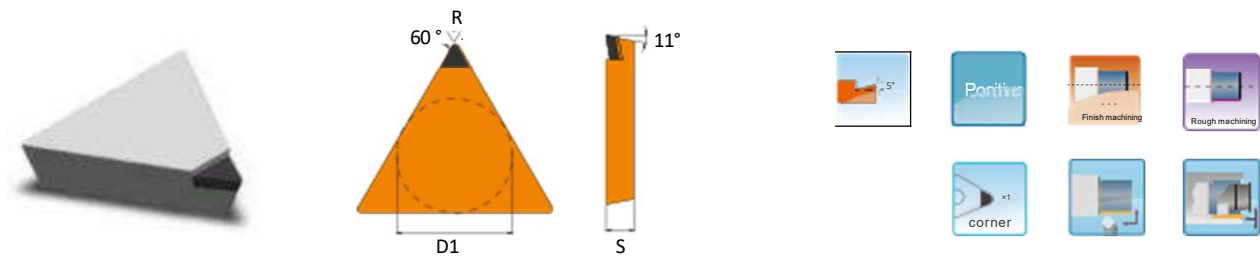
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TP GN/TP MN



Designation	D1 [MM]	D2 [MM]	S [MM]	R
TPGN110302-1N	6.35	-	3.18	0.2
TPGN110304-1N				0.4
TPGN110308-1N				0.8
TPMN110302-1N	6.35	-	3.18	0.2
TPMN110304-1N				0.4
TPMN110308-1N				0.8

TP GX/TP MX

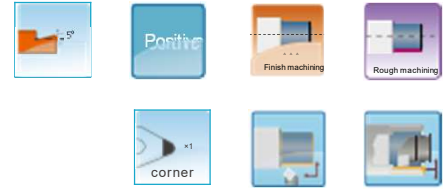
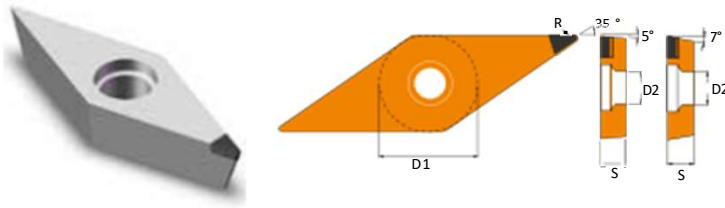


Designation	D1 [MM]	D2 [MM]	S [MM]	R
TPGX110302-1N	6.35	-	3.18	0.2
TPGX110304-1N				0.4
TPGX110308-1N				0.8
TPMX110302-1N	6.35	-	3.18	0.2
TPMX110304-1N				0.4
TPMX110308-1N				0.8

Order Note

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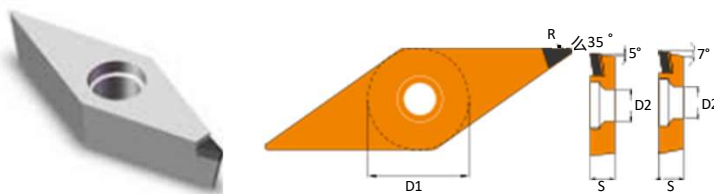
VB GW/VC GW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
VBGW110302-1N	6.35	2.9	3.18	0.2
VBGW110304-1N				0.4
VBGW110308-1N				0.8
VBGW160404-1N	9.525	4.4	4.76	0.4
VBGW160408-1N				0.8
VBGW160412-1N				1.2

Designation	D1 [MM]	D2 [MM]	S [MM]	R
VCGW110302-1N	6.35	2.9	3.18	0.2
VCGW110304-1N				0.4
VCGW110308-1N				0.8
VCGW160404-1N	9.525	4.4	4.76	0.4
VCGW160408-1N				0.8
VCGW160412-1N				1.2

VB GT/VC GT



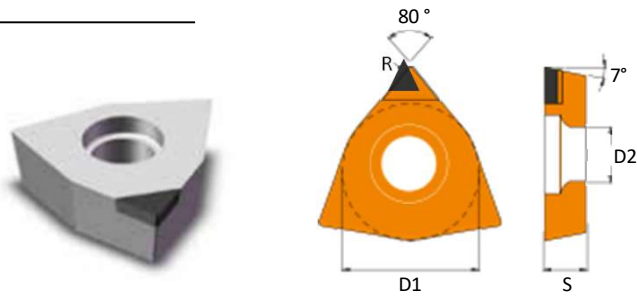
Designation	D1 [MM]	D2 [MM]	S [MM]	R
VBGT110302-TP	6.35	2.9	3.18	0.2
VBGT110304-TP				0.4
VBGT110308-TP				0.8
VBGT160404-TP	9.525	4.4	4.76	0.4
VBGT160408-TP				0.8
VBGT160412-TP				1.2

Designation	D1 [MM]	D2 [MM]	S [MM]	R
VCGT110302-TP	6.35	2.9	3.18	0.2
VCGT110304-TP				0.4
VCGT110308-TP				0.8
VCGT160404-TP	9.525	4.4	4.76	0.4
VCGT160408-TP				0.8
VCGT160412-TP				1.2

Order Note

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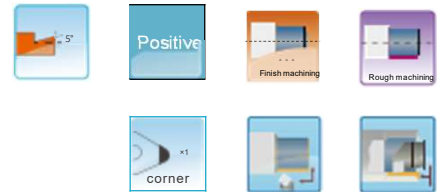
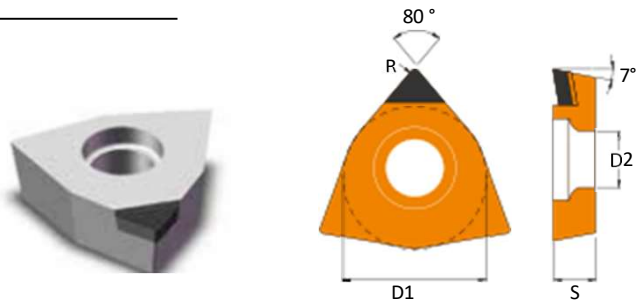
WCGW/WCMW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGW040202-1N	6.35	2.8	2.38	0.2
WCGW040204-1N				0.4
WCGW040208-1N				0.8
WCMW040202-1N	6.35	2.8	2.38	0.2
WCMW040204-1N				0.4
WCMW040208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGW06T302-1N	9.525	4.4	3.97	0.2
WCGW06T304-1N				0.4
WCGW06T308-1N				0.8
WCMW06T302-1N	9.525	4.4	3.97	0.2
WCMW06T304-1N				0.4
WCMW06T308-1N				0.8

WCGT/WCMT



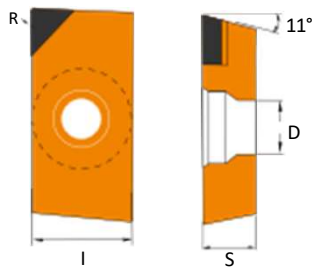
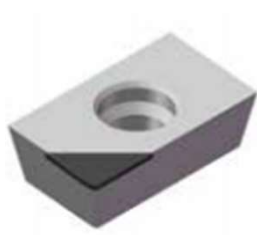
Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGT040202-1N	6.35	2.8	2.38	0.2
WCGT040204-1N				0.4
WCGT040208-1N				0.8
WCMT040202-1N	6.35	2.8	2.38	0.2
WCMT040204-1N				0.4
WCMT040208-1N				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGT06T302-1N	9.525	4.4	3.97	0.2
WCGT06T304-1N				0.4
WCGT06T308-1N				0.8
WCMT06T302-1N	9.525	4.4	3.97	0.2
WCMT06T304-1N				0.4
WCMT06T308-1N				0.8

Order Note

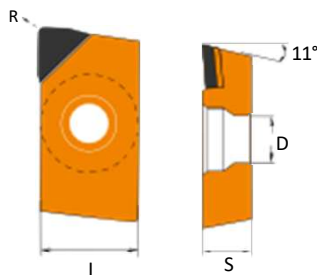
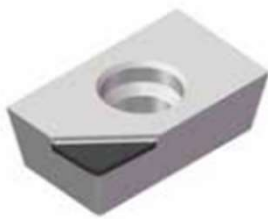
- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

APKW



Designation	I [MM]	D [MM]	S [MM]	R
APKW110302-1N	6.35	2.8	3.18	0.2
APKW110304-1N				0.4
APKW110308-1N				0.8
APKW160302-1N	9.525	4.4	3.18	0.2
APKW160304-1N				0.4
APKW160308-TP				0.8

APKT

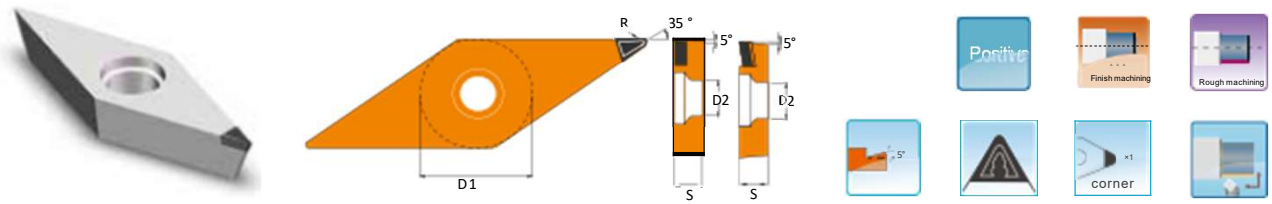


Designation	I [MM]	D [MM]	S [MM]	R
APKT110302-1N	6.35	2.8	3.18	0.2
APKT110304-1N				0.4
APKT110308-1N				0.8
APKT160302-1N	9.525	4.4	3.18	0.2
APKT160304-1N				0.4
APKT160308-1N				0.8

Order Note

- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

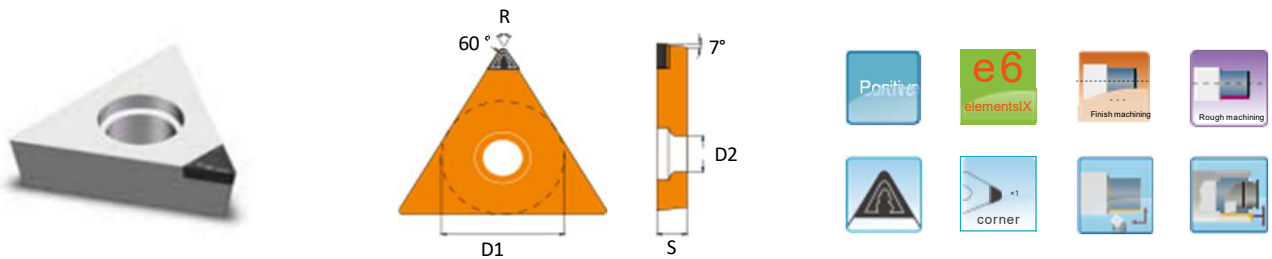
VBGW(T)/BMW(T)



Designation	D1 [MM]	D2 [MM]	S [MM]	R
VBGW160404-1N-CB	9.525	4.4	4.76	0.4
VBGW160408-1N-CB				0.8
VBGW160412-1N-CB				1.2
VBMW160404-1N-CB	9.525	4.4	4.76	0.4
VBMW160408-1N-CB				0.8
VBMW160412-1N-CB				1.2

Designation	D1 [MM]	D2 [MM]	S [MM]	R
VBGT160404-1N-CB	9.525	4.4	4.76	0.4
VBGT160408-1N-CB				0.8
VBGT160412-1N-CB				1.2
VBMT160404-1N-CB	9.525	4.4	4.76	0.4
VBMT160408-1N-CB				0.8
VBMT160412-1N-CB				1.2

TCGW/TCMW



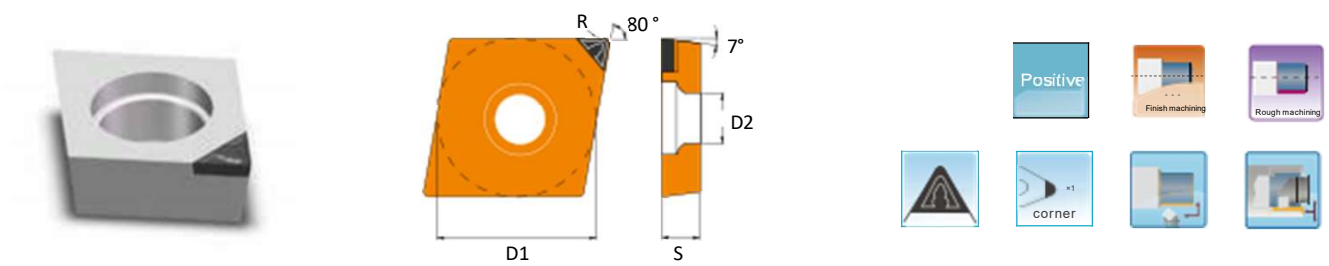
Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCGW090204-TPB	5.56	2.5	2.38	0.4
TCGW090208-TPB				0.8
TCMW090204-TPB	5.56	2.5	2.38	0.4
TCMW090208-TPB				0.8
TCGW110204-TPB	6.35	2.8	2.38	0.4
TCGW110208-TPB				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCMW110204-TPB	6.35	2.8	2.38	0.4
TCMW110208-TPB				0.8
TCGW16T304-TPB	9.525	4.4	3.97	0.4
TCGW16T308-TPB				0.8
TCMW16T304-TPB	9.525	4.4	3.97	0.4
TCMW16T308-TPB				0.8

Order Note

- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

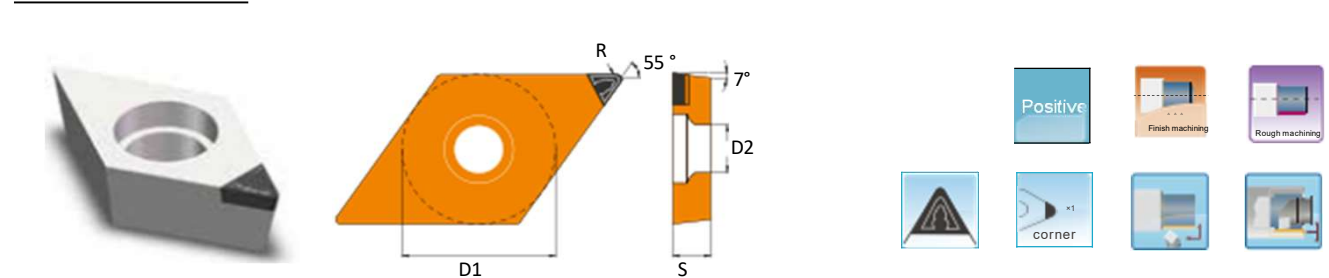
CCG W/CC MW



Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCGW060204-1N-CB	6.35	2.8	2.38	0.4
CCGW060208-1N-CB				0.8
CCMW060202-1N-CB	6.35	2.8	2.38	0.2
CCMW060204-1N-CB				0.4
CCMW060208-1N-CB				0.8
CCGW09T302-1N-CB	9.525	4.4	3.97	0.2
CCGW09T304-1N-CB				0.4
CCGW09T308-1N-CB				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCMW09T304-1N-CB	9.525	4.4	3.97	0.4
CCMW09T308-1N-CB				0.8
CCGW120404-1N-CB	12.7	5.5	4.76	0.4
CCGW120408-1N-CB				0.8
CCGW120412-1N-CB				1.2
CCMW120404-1N-CB	12.7	5.5	4.76	0.4
CCMW120408-1N-CB				0.8
CCMW120412-1N-CB				1.2

DC GW/DC MW



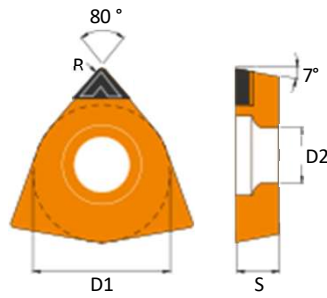
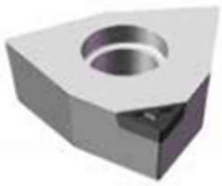
Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGW070202-1N-CB	6.35	2.8	2.38	0.2
DCGW070204-1N-CB				0.4
DCGW070208-1N-CB				0.8
DCMW070202-1N-CB	6.35	2.8	2.38	0.2
DCMW070204-1N-CB				0.4
DCMW070208-1N-CB				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
DCGW11T304-1N-CB	9.525	4.4	3.97	0.4
DCGW11T308-1N-CB				0.8
DCGW11T312-1N-CB				1.2
DCMW11T304-1N-CB	9.525	4.4	3.97	0.4
DCMW11T308-1N-CB				0.8
DCMW11T312-1N-CB				1.2

Order Note

- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

WCGW/WCMW



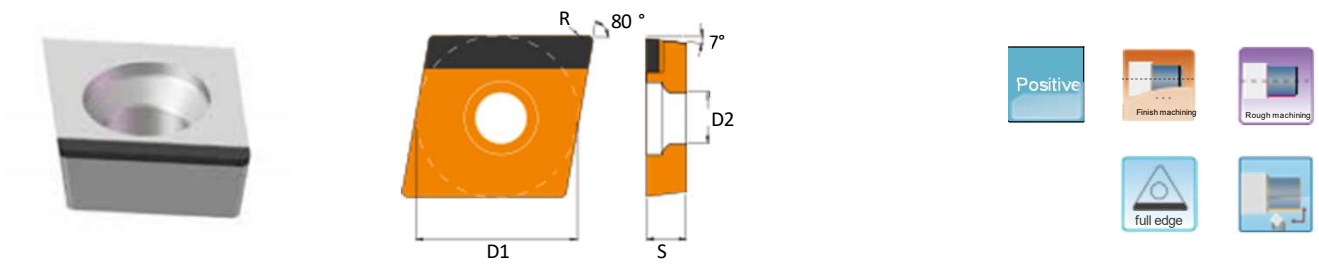
Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGW040202-1N-CB	6.35	2.8	2.38	0.2
WCGW040204-1N-CB				0.4
WCGW040208-1N-CB				0.8
WCMW040202-1N-CB	6.35	2.8	2.38	0.2
WCMW040204-1N-CB				0.4
WCMW040208-1N-CB				0.8

Designation	D1 [MM]	D2 [MM]	S [MM]	R
WCGW06T302-1N-CB	9.525	4.4	3.97	0.2
WCGW06T304-1N-CB				0.4
WCGW06T308-1N-CB				0.8
WCMW06T302-1N-CB	9.525	4.4	3.97	0.2
WCMW06T304-1N-CB				0.4
WCMW06T308-1N-CB				0.8

Order Note

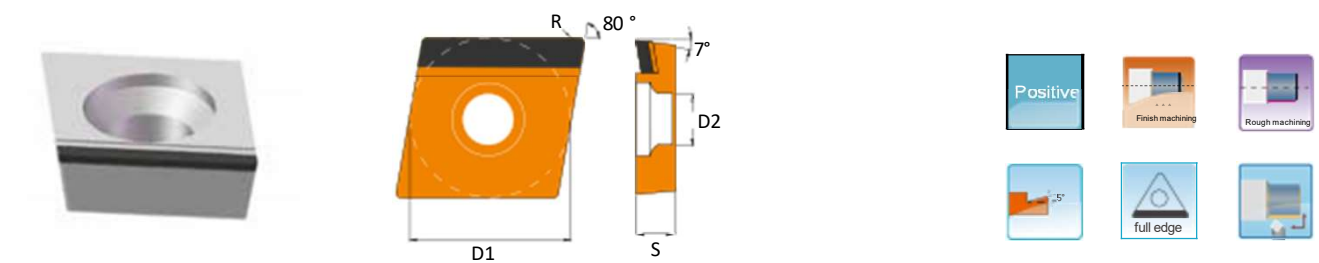
- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

CCGW-FULL EDGE



DesignationWW	D1 [MM]	D2 [MM]	S [MM]	R
CCGW060204-1N-FE	6.35	2.8	2.38	0.4
CCGW060208-1N-FE				0.8
CCGW09T308-1N-FE	9.525	4.4	3.97	0.8
CCGW09T312-1N-FE				1.2
CCGW120412-1N-FE	12.7	5.5	4.76	1.2

CCGT-FULL EDGE

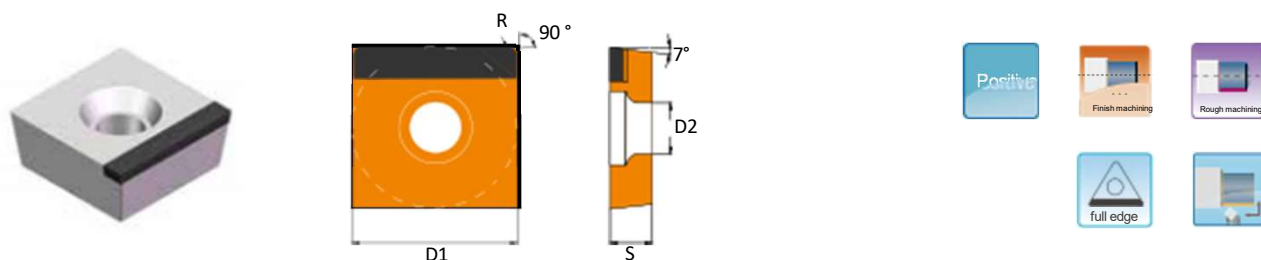


Designation	D1 [MM]	D2 [MM]	S [MM]	R
CCGT060204-1N-FE	6.35	2.8	2.38	0.4
CCGT060208-1N-FE				0.8
CCGT09T308-1N-FE	9.525	4.4	3.97	0.8
CCGT09T312-1N-FE				1.2
CCGT120412-1N-FE	12.7	5.5	4.76	1.2

Order Note

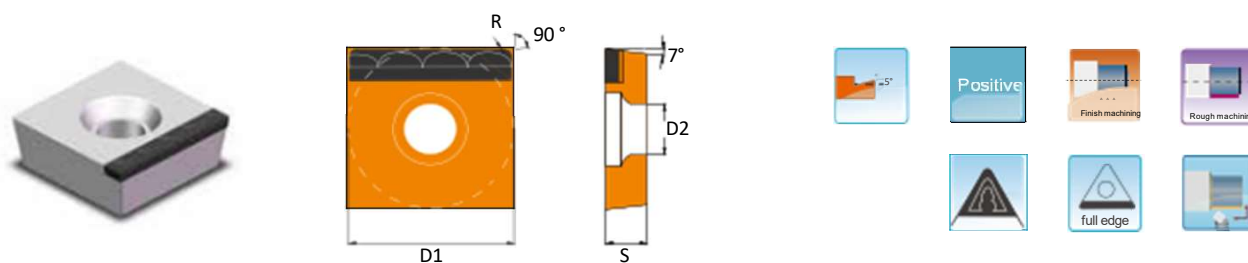
- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

SCGW-FULL EDGE



Designation	D1 [MM]	D2 [MM]	S [MM]	R
SCGW09T304-1N-FE	9.525	4.4	3.97	0.4
SCGW09T308-1N-FE				0.8
SCGW120404-1N-FE	12.7	5.16	4.76	0.4
SCGW120408-1N-FE				0.8
SCGW120412-1N-FE				1.2

SCGW-chip breaker

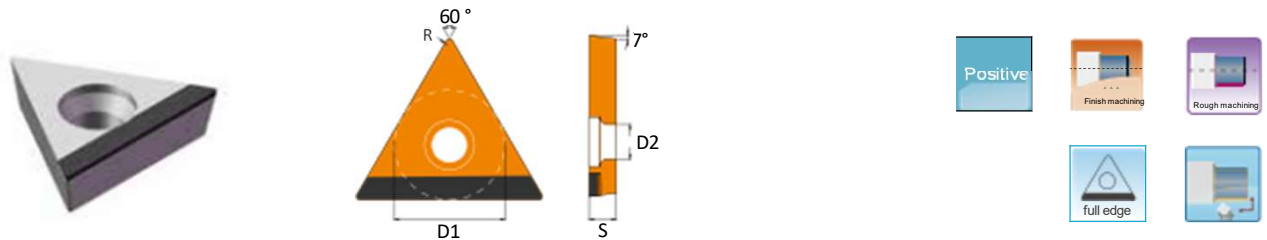


Designation	D1 [MM]	D2 [MM]	S [MM]	R
SCGW09T304-1N-FE-CB	9.525	4.4	3.97	0.4
SCGW09T308-1N-FE-CB				0.8
SCGW120404-1N-FE-CB	12.7	5.16	4.76	0.4
SCGW120408-1N-FE-CB				0.8
SCGW120412-1N-FE-CB				1.2

Order Note

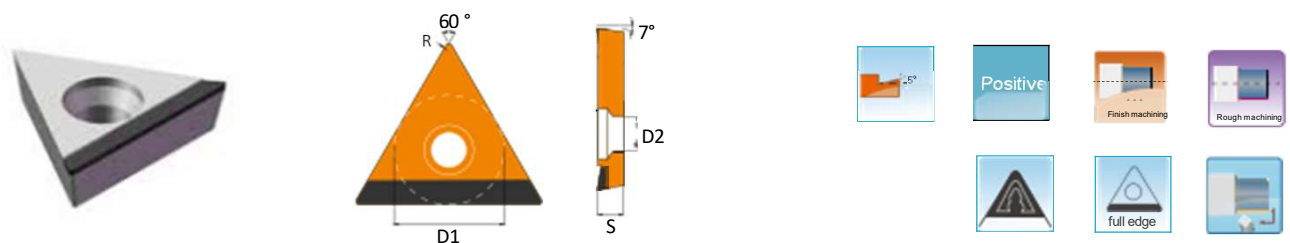
- Please refer to PCD inserts code key description.
- To place an order, please refer to the designation code.
- For the item which is not on the list pls contact our sales to get the quote.

TCGW-FULL EDGE



Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCGW090202-1N-FE	5.56	2.5	2.38	0.2
TCGW110204-1N-FE	6.35	2.8	2.38	0.4
TCGW110208-1N-FE				0.8
TCGW16T304-1N-FE	9.525	4.4	3.97	0.4
TCGW16T308-1N-FE				0.8

TCGT-FULL EDGE

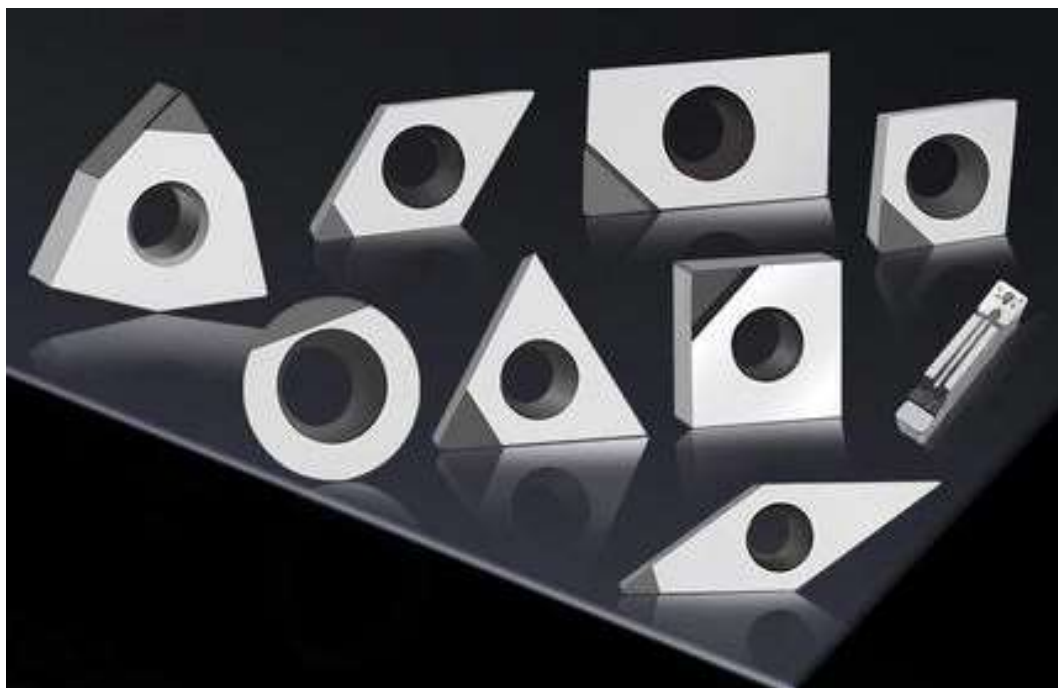


Designation	D1 [MM]	D2 [MM]	S [MM]	R
TCGT090202-1N-FE	5.56	2.5	2.38	0.2
TCGT110204-1N-FE	6.35	2.8	2.38	0.4
TCGT110208-1N-FE				0.8
TCGT16T304-1N-FE	9.525	4.4	3.97	0.4
TCGT16T308-1N-FE				0.8

Order Note

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- To place an order, please refer to the designation code.
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Cutting speed Vc(m/min)	Workpiece/Tool Holer Diameter (mm)													
	12	16	20	25	32	50	63	80	100	125	160	175	200	250
80	2123	1592	1274	1019	796	510	404	318	255	204	159	146	127	102
90	2389	1791	1433	1146	896	573	455	358	287	229	179	164	143	115
100	2654	1990	1592	1274	995	637	506	398	318	255	199	182	159	127
110	2919	2189	1752	1401	1095	701	556	438	350	280	219	200	175	140
120	3185	2389	1911	1529	1194	764	607	478	382	306	239	218	191	153
140	3715	2787	2229	1783	1393	892	708	557	446	357	279	255	223	178
160	4246	3185	2548	2038	1592	1019	809	637	510	408	318	291	255	204
180	4777	3583	2866	2293	1791	1146	910	717	573	459	358	328	287	229
200	5308	3981	3185	2548	1990	1274	1011	796	637	510	398	364	318	255
220	5839	4379	3503	2803	2189	1401	1112	876	701	561	438	400	350	280
240	6369	4777	3822	3057	2389	1529	1213	955	764	611	478	437	382	306
260	6900	5175	4140	3312	2588	1656	1314	1035	828	662	518	473	414	331
280	7431	5573	4459	3567	2787	1783	1415	1115	892	713	557	510	446	357
300		5971	4777	3822	2986	1911	1517	1194	955	764	597	546	478	382
400						2548	2022	1592	1274	1019	796	728	637	510
600						3822	3033	2389	1911	1529	1194	1092	955	764
800						5096	4044	3185	2548	2038	1592	1456	1274	1019
1000						6369	5055	3981	3185	2548	1990	1820	1592	1274



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