



# Eberle



源自 1836 年的优质锯条  
Quality saws since 1836

德国制造

## *duoflex*<sup>®</sup>

# 带锯条 Band Saw Blades

## 公司介绍

### 传统和经验

一百五十多年来，Eberle 公司在锯条技术的开发领域一直扮演着决定性的角色。它已经从 1836 年的一家小钢锯生产厂变成如今的现代化高技术公司。Eberle 带锯条在世界范围内的带锯领域中赢得了卓著的声誉。我们产品的可靠性和精度使得 Eberle 这个名字已成为了优质的同义词。

### 质量和诀窍

我们的专家知道什么是最重要的。他们从不间断地对产品进行改进，以使之满足客户不断发展的需求。我们只采用自己生产的材料，并且

在高精度的高能束焊机上生产复合钢材，因此，我们可以保证产品能够符合高质量标准。

### 您明天的伙伴

为了满足新的需求，在工业领域中，被开发的新材料不断涌现。而我们经验丰富的

工程师也同样一直在努力开发先进的加工方法，这样，当客户将来处理更复杂的合金时，我们依然能够保证 Eberle 带锯条的可靠性和高精度。



## THE BUSINESS

### TRADITION AND EXPERIENCE

For over 150 years Eberle has played a decisive role in the development of sawing technology. What started in 1836 as a small fretsaw manufacturer has turned into a modern high-technology company. Eberle band saw blades enjoy an excellent reputation among leading manufacturers of band saws worldwide. The reliability and precision of our products has made the name Eberle a synonym for high quality.

### QUALITY AND KNOW-HOW

Our specialists know what is most important. They continuously adapt our production to meet the demands you make on our

saw blades every day. We use only materials that we produce ourselves. We produce our bimetal strip steel on high-precision beam welding machines. This way we can guarantee our products meet high standards for quality.

### YOUR PARTNER FOR TOMORROW

Industry is continuously developing new materials to meet new requirements. Our experienced engineers are likewise continuously developing advanced production methods, so you the customer can continue to count on the reliability and precision of Eberle band saw blades when working with the complex alloys of the future.





# duoflex<sup>®</sup>

**duoflex 复合钢材技术**  
**duoflex-Bimetal-Technology**

两种材料-用于锯齿的高速钢(HSS)和作为基体材料的合金工具钢，通过高能束焊过程连接在一起。专门开发的基体材料含 **4%的铬**，这使得带锯条在动载荷下具有极佳的机械性能，焊接处理的结果形成了一种最适用于锯条的复合材料，其抗磨损与抗疲劳性能极其优异。

我们提供下列等级的锯条：  
**Matrix 2 / M 42 / M 51 / SP / HCP / Tristar**

Two materials, high speed steel (HSS) for the teeth and alloyed tool steel as a backing material, are joined during the beam welding process. The specially **developed backing material**, alloyed with **4% chromium**, has excellent mechanical properties under dynamic loading. This welding process results in an optimal combination of materials with respect to saw blade resistance to wear and fatigue.

**We supply blades in the following grades:**  
**Matrix 2 / M 42 / M 51 / SP / HCP / Tristar**

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复合钢材带锯条  
Bimetal Band Saw Blades

**duoflex® Matrix 2**

力量、耐久性、精度  
Power, Durability, Precision

优点:

- 锯切精度高
- 8%的含钴量使锯口具有高耐磨性能
- 即使在强震锯切场合也具有很长的寿命

ADVANTAGES:

- high cutting accuracy
- high wear resistance due to 8% cobalt content
- long life even in high-vibration cutting applications

同我们其它优质复合金属材料带锯条一样,“Matrix 2”锯条用4%铬基材料组成。因为钨与碳含量的减少,锯条的锯口在高震动作业中具有出色的性能,例如在锯切薄壁管、横截面以及成束锯切等应用中。高含钴量(8%)使锯口具有最佳的耐磨性能。该锯条具有性能优异的锯口,适用于在自动锯切工况下切割中碳合金钢以及有色金属材料。

The »Matrix 2« saw band is manufactured with the same 4% chrome backing material as all our other high-quality bimetal band saw blades. The superior properties of the tooth cutting edge during high-vibration sawing, like cutting thin-walled tubing, cross sections and bundle cutting applications, are achieved through reduced tungsten and carbon content. High cobalt content (8%) gives high cutting edge wear resistance. This saw blade, with its excellent cutting edge features, is suitable for cutting medium steel alloys, as well as non-ferrous metals in automatic sawing mode.



尺寸 (mm)	每英寸齿数 (tpi)			teeth per inch (tpi)			dimensions in inches
	2/3	3/4	4/6	5/8	6/10	8/12	
27 x 0.90		DCS	N/CS	N	N	N	1 1/16 x.035
34 x 1.10	DCS	DCS	CS	N			1 1/3 x.042

duoflex® M 42

– 这就是 **duoflex®**  
precision – or just **duoflex®**

优点：

- 锯切速度相对工具钢锯条增加 **30-100%**
- 锯切时间可最多减少 **50%**，使生产率更高
- 工作寿命是工具钢锯条的 **10 倍**，增加了锯切精度
- 由于以上的优点，无论是一次性作业还是连续性作业的锯切工作，都可获得更佳的成本效益

ADVANTAGES:

- **30 – 100% increase in cutting speed compared to tool steel band saw blades**
- **up to 50% reduction in cutting time, resulting in higher productivity**
- **operating life 10 times that of tool steel bands increased cutting accuracy**
- **These advantages result in more cost-efficient cutting operations both for one-time applications and serial production.**

含有钴合金的带锯条

此型高性能的带锯尤其适用于所有类型的金属连续锯切。  
锯齿用 **8% 钴** 和 **10% 钼** 的高速合金钢制成。

Bimetal Band Saw Blade with Cobalt

This high-performance saw band is especially suitable for **serial cutting of all types of metals**. The teeth are made of alloyed high speed steel with **8% cobalt** and **10% molybdenum**.

尺寸 (mm)	每英寸齿数(tpi)										teeth per inch (tpi)										dimensions in inches
	0.75	1.25	2	3	4	6	8	10	14	18	0.75/1.25	1.4/2	2/3	3/4	4/6	5/8	6/10	8/12	10/14		
6 × 0.90					CW	CW		N	N										N	1/4 x.035	
10 × 0.90					CW	CW		N	N										N	3/8 x.035	
13 × 0.65						CW		N	N	N							N	N	N	1/2 x.025	
13 × 0.90				CW	CW	CW	N	N	N									N	N	1/2 x.035	
20 × 0.90				CS	CS	N/CS	N	N	N						CS	N	N	N	N	3/4 x.035	
27 × 0.90				DCS	CS	N/CS	N	N	N				DCS	DCS	N/CS	N	N	N	N	1 1/16 x.035	
34 × 1.10			DCS	DCS	CS	CS							DCS	DCS	N/CS	N	N	N		1 1/3 x.042	
41 × 1.30			DCS	DCS	CS	CS						DCS	DCS	DCS	N/CS	N				1 5/8 x.050	
54 × 1.30													DCS	DCS	CS					2 1/8 x.050	
54 × 1.60		DCS	DCS	DCS								DCS	DCS	DCS	CS					2 1/8 x.063	
67 × 1.60		DCS	DCS	DCS							DCS	DCS	DCS							2 5/8 x.063	
80 × 1.60	DCS	DCS									DCS	DCS	DCS							3 1/8 x.063	

可根据客户的特殊要求生产特殊齿型。

Special tooth sets and wide sets are available to meet your requirements.

齿型说明详见第 11/12 页。  
For a description of tooth forms, see page 11/12.



复合钢材带锯条  
Bimetal Band Saw Blades



与 M42 相比的优点：

- 工作寿命更长
- 锯切精度提高在锯切机械加工性差的材料 (如镍钛合金) 时，同样具有成本效益。

ADVANTAGES OVER M42:

- longer operating life
- increased cutting accuracy  
allows cost-efficient cutting of materials with low machinability, such as nickel and titanium alloys

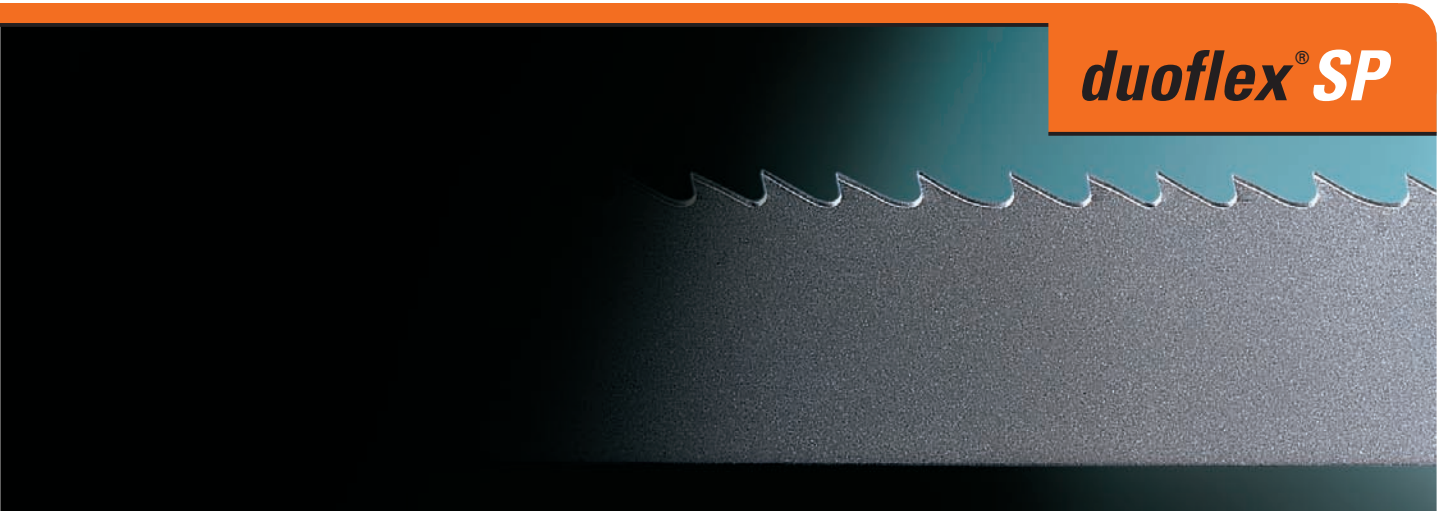
含有钴、钨合金的带锯

作为我们的顶级带锯，专为重载锯切设备而设计。含 **10% 钴** 和 **10% 钨** 的合金大大地增加了高速钢齿的锯切性能。同时，这些合金元素显著地增加了锯条的耐热性及抗疲劳性。

Bimetal Band Saw Blade with Cobalt and Tungsten

Our top-of-the-line blade is designed for use in **heavy duty cutting applications**. The cutting performance of the high speed steel teeth is **greatly increased** through alloying with **10% cobalt** and **10% tungsten**. These alloying elements substantially increase heat resistance as well as fatigue resistance.

尺寸 (mm)	每英寸齿数 (tpi)			teeth per inch (tpi)			dimensions in inches
	1.25	0.75/1.25	1.4/2	2/3	3/4	4/6	
27 x 0.90				DCS	DCS	CS	1 1/16 x .035
34 x 1.10				DCS	DCS	CS	1 1/3 x .042
41 x 1.30				DCS	DCS		1 5/8 x .050
54 x 1.60			DCS	DCS	DCS		2 1/8 x .063
67 x 1.60	DCS	DCS	DCS	DCS			2 5/8 x .063
80 x 1.60	DCS	DCS	DCS				3 1/8 x .063



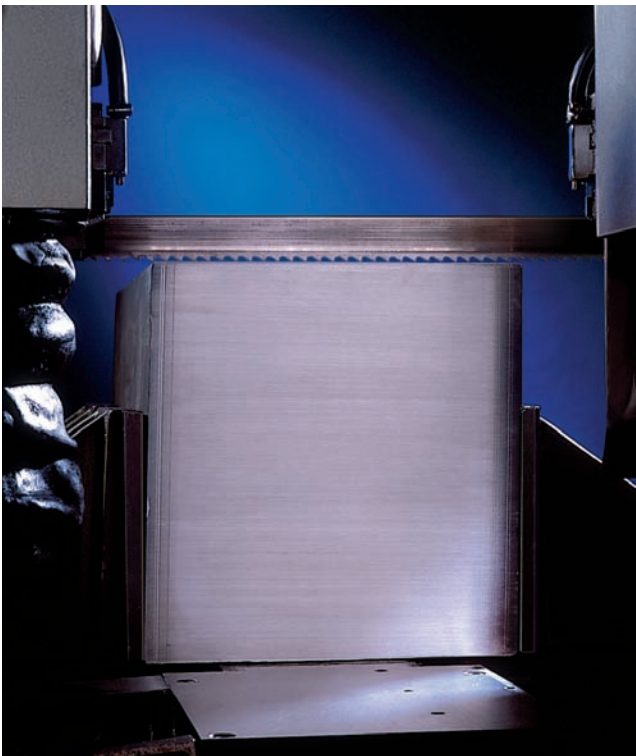
## 新一代产品： *duoflex<sup>®</sup> SP*

得益于经过优化的齿形以及专门开发的基体材料，确保了此型带锯不仅精度可靠，而且具有极长的使用寿命。利用新近开发的 duoflexSP 型带锯，锯切高合金材料和稀有合金，诸如 CrNi、耐蚀耐热镍基合金、蒙乃尔高强度耐蚀镍铜合金或镍铬钛耐热合金等，其成本效益得到了显著提高。

## The New Generation: *duoflex<sup>®</sup> SP*

The optimized tooth geometry and the **specially-developed backing material** guarantee an **extremely long service life** with consistently **reliable precision**. With the newly-developed duoflex SP the cutting of high alloy materials and exotic alloys, such as CrNi, Hastelloy, Monel or Nimonic, becomes even more cost-efficient.

尺寸 (mm)	每英寸齿数 (tpi)    teeth per inch (tpi)			dimensions in inches
	1/1.3	2/3	3/4	
34 x 1.10		CSP	CSP	1 1/3 x .042
41 x 1.30		CSP	CSP	1 5/8 x .050
54 x 1.60	CSP	CSP		2 1/8 x .063
67 x 1.60	CSP	CSP		2 5/8 x .063



齿型说明详见第 11/12 页。  
For a description of tooth forms, see page 11/12.



硬质合金带锯条  
Carbide Tipped Band Saw Blades

**duoflex® Tristar**



此型锯条具有硬质合金刀口，专门用于锯切机械加工性差的材料，如：铸件、非金属材料以及无机建材等。Eberle “Tristar” – 高效益及高可靠性的机械加工。

Carbide tipped band saw blades for low machinable materials such as castings, non-metallic materials, and mineral-based building materials. Eberle »Tristar« - for cost-efficient machinability with high reliability.

尺寸 (mm)	每英寸齿数 (tpi)      teeth per inch (tpi)						dimensions in inches
	2	3	0.75/1.25	1/1.3	1.4/2	2/3	
27 x 0.90	•	•				•	1 1/16 x .035
34 x 1.10	•	•				•	1 1/3 x .042
41 x 1.30	•	•			•	•	1 5/3 x .050
54 x 1.30	•						2 1/8 x .050
54 x 1.60	•		•	•	•	•	2 1/8 x .063
67 x 1.60			•	•	•		2 5/8 x .063
80 x 1.60			•	•			3 1/8 x .063

**duoflex® HCP**

高速锯切、切面光滑、工作寿命长以及极低的噪音 – 这就是我们创新以及超前的开发计划所带来的成果。Eberle “HCP” 尽管每次作业的成本低廉，但可以加工难以锯切的材料及高合金材料。

High cutting speed, outstanding surface finish quality and long operating life with the most quiet operation possible – the results of an innovative and forward-looking development program. Eberle »HCP« handles hard-to-cut and high alloy materials with a low cost-per-cut.

尺寸 (mm)	每英寸齿数 (tpi)      teeth per inch (tpi)						dimensions in inches
	2	3	0.75/1.25	1/1.3	1.4/2	2/3	
27 x 0.90	•	•				•	1 1/16 x .035
34 x 1.10	•	•				•	1 1/3 x .042
41 x 1.30	•	•			•	•	1 5/8 x .050
54 x 1.30	•						2 1/8 x .050
54 x 1.60	•		•	•	•	•	2 1/8 x .063
67 x 1.60			•	•	•		2 5/8 x .063
80 x 1.60			•	•			3 1/8 x .063



## 工具钢带锯条 Tool Steel Band Saw Blades

# Optima® Flex

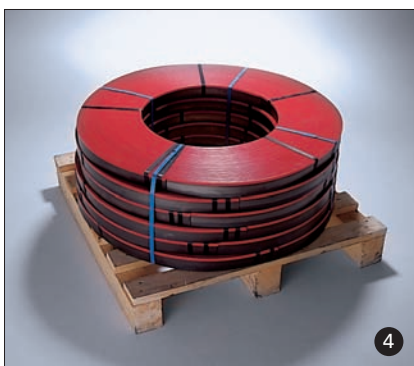
利用经特殊淬火及回火的合金钢制造。建议用于要求连续生产的车间。最适用于锯切结构钢、合金工具钢、高速钢以及塑性材料。

Made from specially hardened and tempered alloyed steel. Recommended for use in workshops and for serial production. **Most suitable for cutting structural steels, alloyed tool steels and high speed steels as well as plastic materials.**

尺寸 (mm)	每英寸齿数(tpi)					teeth per inch (tpi)					dimensions in inches
	3	4	6	7	8	10	14	18	22		
3 x 0.65							N	N	N	1/8 x.025	
4 x 0.65						N	N	N	N	5/32 x.025	
6 x 0.65			CS		N	N	N	N	N	1/4 x.025	
8 x 0.65			CS		N	N	N	N	N	5/16 x.025	
10 x 0.65			CS		N	N	N			3/8 x.025	
13 x 0.65			CS		N	N	N			1/2 x.025	
16 x 0.65			CS				N			5/8 x.025	
16 x 0.80			CS			N				5/8 x.032	
20 x 0.80			CS		N	N				3/4 x.032	
25 x 0.90	CS	CS	CS	N	N	N	N			1 x.035	

齿型说明详见第 11/12 页。  
For a description of tooth forms, see page 11/12.

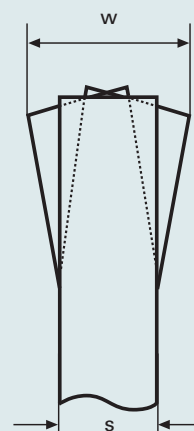
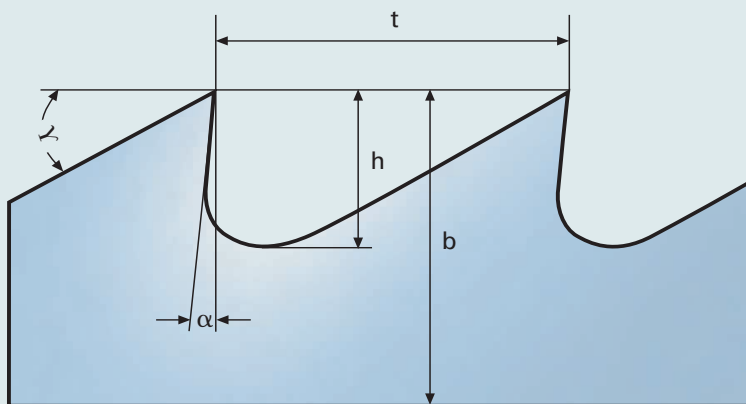
## 包装类型 Packaging Types



- 带锯条，固定于货盘  
Band saw blades fastened to a pallet
- 带锯条，平盒包装  
Band saw blades, packed in a flat box
- 锯条盘料，箱装  
Production coils in the box
- 锯条盘料，货盘  
Production coils on a pallet

## 技术信息 Technical Information

### 带锯外形尺寸 Saw Band Geometry



**b** 带宽  
**s** 带厚  
**h** 齿高  
**t** 齿距  
**α** 前角  
**Y** 后角  
**w** 设置宽度

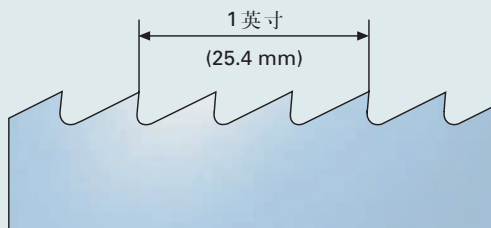
**b** band width  
**s** band thickness  
**h** tooth height  
**t** tooth pitch  
**α** rake angle  
**Y** relief angle  
**w** set width

### 齿距 Tooth Pitch

用于金属锯切的带锯齿距通常以每英寸齿数测量，其大小根据被锯切材料的横截面及种类变化。两个示例：

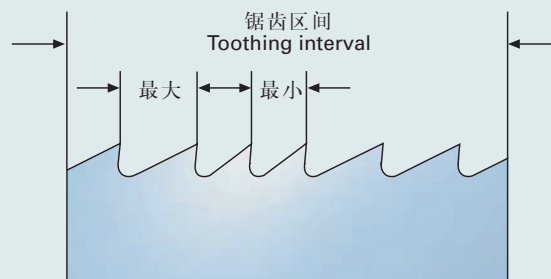
Tooth pitch, which for metal-cutting saws is usually measured in teeth per inch, varies according to the cross section and the type of material to be cut. Two examples:

#### 固定的锯齿 Constant Tooth Pitch



例如：3 tpi (△ 8.47 mm 齿距)  
Example 3 tpi (△ 8.47 mm pitch)

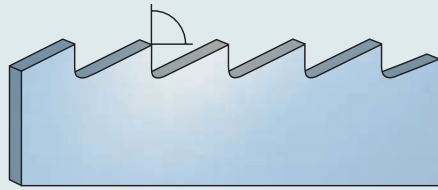
#### 变化的锯齿 Variable Tooth Pitch



例如：3/4 tpi (△ 8.47 mm 和 6.35 mm 齿距)  
Example 3/4 tpi (△ 8.47 mm and 6.35 mm pitch)

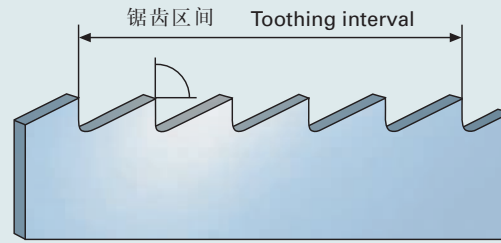
## 齿型

## Tooth Forms



N - 齿(标准)

N-tooth (standard)

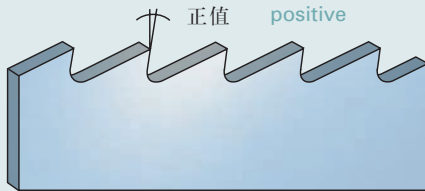


N - 齿(标准)

N-tooth (standard)

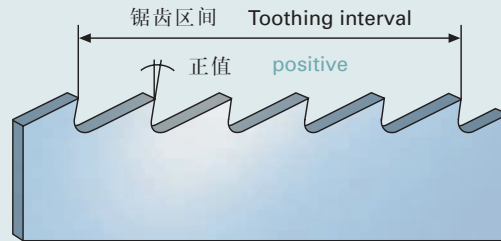
正常锯齿最适用于锯切含碳量高的小片材料，比如工具钢或铸铁。它适用于广泛的应用，包括薄横切锯和薄壁切面的材料。

The normal tooth is best suited for sawing of small-chip materials with high carbon content, such as tool steel or cast iron. It is suitable for a wide range of applications, including thin cross-cuts and materials with thin-walled cross sections.



CS - 齿(钩形)

CS-tooth (hook)

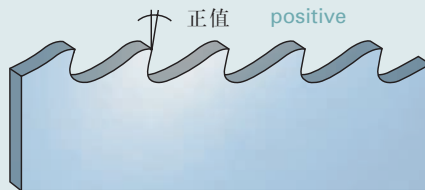


变化的 CS - 齿

variable CS-tooth

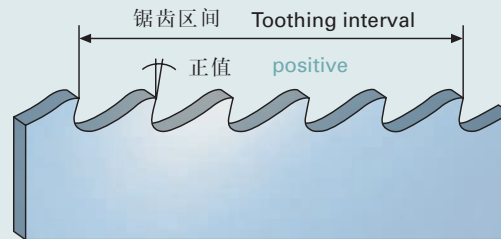
带有正前角的钩形齿能用于所有种类的钢材，尤其适用于长片和难以锯切的材料，例如结构钢、淬火钢以及高合金材料。

The hook tooth with a positive rake angle can be used for all kinds of steel, especially for long-chip and hard-to-cut materials, for example construction steel and hardened steel, as well as high alloy materials.



DCS - 齿

DCS-tooth



变化的 DCS - 齿

variable DCS-tooth

带有修正齿形的高性能钩形齿适用于锯切机械加工性能差的高合金钢，及稀有合金与Cr-Ni-Ti合金。

The special high-performance hook tooth with modified tooth geometry with low machinability high alloy steel as well as exotic alloys and Cr-Ni-Ti-alloys.

## 特殊齿形 CSP/CW Special toothings CSP/CW

**CSP** - 具有绝对正前角的齿是为 duoflex SP 尺寸范围专门开发的产品。

The **CSP**-tooth with an extremely positive rake angel is a special development for the range of dimansion duoflex SP

**CW** - 齿形尤其适用于工具制造、加工模型、主要低合金钢的锯切、铝合金以及轮廓锯切和曲线切割。

The **CW**-tooth is above all used for the manufacturing of tools, making molds, the sawing of mainly low alloy steels, aluminium-alloys, as well as for contour sawing and curved cutting.

变化的齿形使您可以用一片锯条锯切更大的截面。

Variable toothings allows cutting of larger cross sections with a single saw band.

## 技术信息 Technical Information

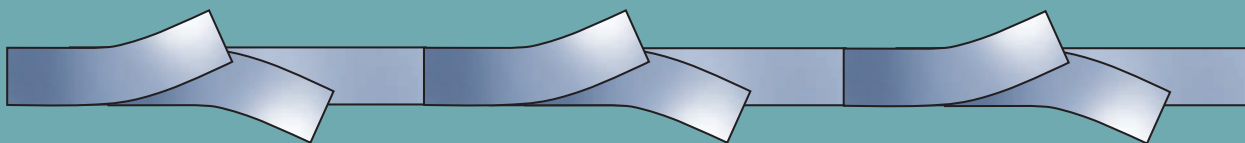
### 齿的设置 Tooth Set

“齿的设置”指锯齿横向弯曲度的规律性变化。这样可以确保锯切作业顺畅。

“Tooth set” means the alternating lateral bending of saw teeth. It enables the saw band to cut freely.

#### 前角设置

#### Raker Set

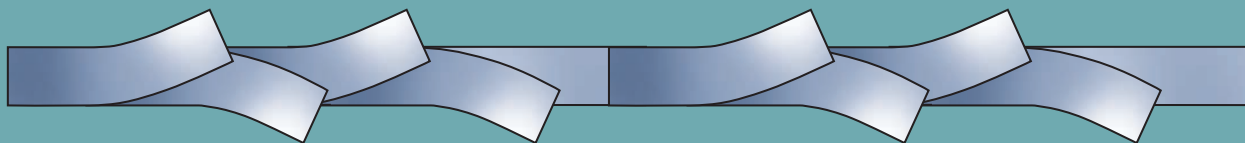


前角设置(左-右-直)可用于所有类型的钢材，尤其适用于锯切厚度在 5 mm 以上的材料。

The raker set (left-right-straight) is useful for all types of steel, especially for cutting thicknesses of 5 mm and more.

#### 变化设置

#### Variable Set

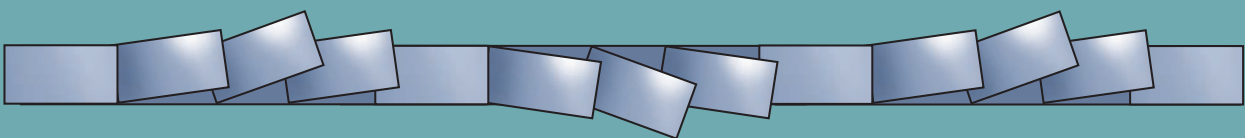


在此设置中，每个齿区间有一个未经变化的直齿。其余的齿交替地左/右弯折。此设置利于低震动和低噪音的锯切。

In a variable set there is one unset tooth per toothing interval. The rest of the teeth are bent alternately left/right. This set facilitates low-vibration and low-noise cutting.

#### 波形设置

#### Wave Set



该波形设置最适用于厚度 5 mm 以下的材料，比如金属板材、薄壁管和横截面。

The wave set is well suited for thin materials up to 3/16", such as sheet metal, thin-walled tubing and cross sections.




可根据客户的特殊要求生产特殊齿型。

Special tooth sets and wide sets are available to meet your requirements.






产品 / 应用  
Products / Applications

**duoflex<sup>®</sup> Matrix 2**

<ul style="list-style-type: none"><li>• 用于横割和成束锯切</li><li>• 很适用于锯切更小尺寸</li></ul>	<ul style="list-style-type: none"><li>• for cross cuts and bundle cutting</li><li>• well suited for cutting smaller dimensions</li></ul>	 <p>细齿距，N-齿，如： 5/8、8/12 fine tooth pitch, N-tooth, e.g. 5/8, 8/12</p>
<ul style="list-style-type: none"><li>• 用于车间</li><li>• 中合金钢</li><li>• 有色金属材料</li></ul>	<ul style="list-style-type: none"><li>• for workshops</li><li>• medium alloy steels</li><li>• non-ferrous metals</li></ul>	 <p>细至中齿距，N-齿，如： 4/6、5/8 fine to medium tooth pitch, N-tooth, e.g. 4/6, 5/8</p>
<ul style="list-style-type: none"><li>• 很适用于钢结构工件</li><li>• 实心材料</li><li>• 中合金钢</li></ul>	<ul style="list-style-type: none"><li>• well suited for steel construction work</li><li>• solid materials</li><li>• up to medium alloy steels</li></ul>	 <p>细齿距，N-齿，如： 5/8、8/12 fine tooth pitch, N-tooth, e.g. 5/8, 8/12</p>


**duoflex<sup>®</sup> M 42**

<ul style="list-style-type: none"><li>• 特殊齿形</li><li>• 适用于车间和铸造厂</li><li>• 适用于轮廓及形状的锯切</li></ul>	<ul style="list-style-type: none"><li>• special tooth form</li><li>• for workshops and foundries</li><li>• for contour and form cutting</li></ul>	 <p>特殊齿形，细齿距，如： 6、10、10/14 special tooth style, fine tooth pitch, e.g. 6, 10, 10/14</p>
<ul style="list-style-type: none"><li>• 适用于所有品种的钢材</li><li>• 实心材料的连续锯切以及成束锯切</li><li>• 适用于小至中等尺寸的物件</li></ul>	<ul style="list-style-type: none"><li>• universal application for all kinds of steel</li><li>• serial cutting of solid materials as well as bundles</li><li>• for cutting small to medium-size items</li></ul>	 <p>细齿距，N-和CS-齿形，如： 6、10、10/14 fine tooth pitch, N- and CS-tooth, e.g. 6, 10, 10/14</p>
<ul style="list-style-type: none"><li>• 适用于所有生产锯切</li><li>• 适用于从低至高的各类合金钢</li><li>• 中至大尺寸工件</li></ul>	<ul style="list-style-type: none"><li>• universal application for production cutting</li><li>• for low to high alloy steels</li><li>• medium to big workpiece dimensions</li></ul>	 <p>中至粗齿形，CS-和DCS-齿，如： 0.75/1.25、1.4/2、2/3、3/4 medium to coarse tooth, CS- and DCS-tooth, e.g., 0.75/1.25, 1.4/2, 2/3, 3/4</p>


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<ul style="list-style-type: none"><li>• 适用于机械加工性能差的材料、不锈钢等</li><li>• Ni-和Ti-合金</li></ul>	<ul style="list-style-type: none"><li>• for materials with low machinability, stainless steel</li><li>• Ni- and Ti-alloys</li></ul>	 <p>中至粗齿距，DCS-齿，如： 1.4/2、2/3 medium to coarse tooth pitch, DCS-tooth, e.g. 1.4/2, 2/3</p>
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**duoflex<sup>®</sup> SP**

<ul style="list-style-type: none"><li>• 带有很大正前角的特殊齿形</li><li>• Cr-Ni-合金、稀有合金，如耐蚀耐热镍基合金、蒙乃尔高强度耐蚀镍铜合金、镍铬钛耐热合金等</li></ul>	<ul style="list-style-type: none"><li>• special tooth form with a very large positive rake angle</li><li>• Cr-Ni-alloys, exotic alloys such as Hastelloy, Monel, Nimonic</li></ul>	 <p>粗齿距，如： 1/1.3、2/3 coarse tooth pitch, e.g. 1/1.3, 2/3</p>
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**duoflex<sup>®</sup> Tristar**

<ul style="list-style-type: none"><li>• 有色金属材料，如铸铝、玻璃纤维、石墨和非金属材料，也用于以Co、Ni和Ti为基体的韧性合金</li></ul>	<ul style="list-style-type: none"><li>• non-ferrous materials such as cast aluminum, glass fiber, graphite and non-metallic materials; also for tough alloys based on Co, Ni and Ti</li></ul>	 <p>锯齿，如： 1.4/2、2/3 toothing, e.g. 1.4/2, 2/3</p>
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**duoflex<sup>®</sup> HCP**

<ul style="list-style-type: none"><li>• 用于中至高合金材料的高性能锯切</li></ul>	<ul style="list-style-type: none"><li>• for high-performance cutting of medium to high alloy materials</li></ul>	 <p>锯齿，如： 1.4/2、2/3、3 toothing, e.g. 1.4/2, 2/3, 3</p>
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技术信息  
 Technical Information

用于实心材料的锯齿  
 Toothing for Solids

恒定的齿形  
 实心材料直径

Constant Toothing  
 Diameter of solid material

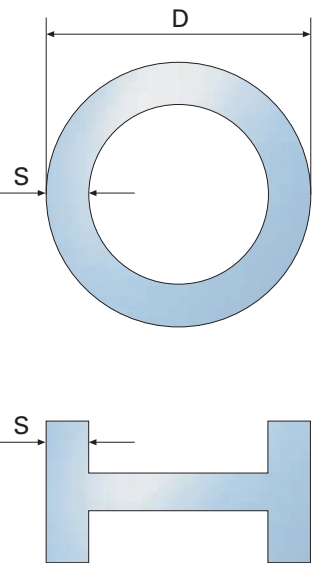
6	10	20	30	50	80	100	120	200	300	400	500	800	(mm)
22	18	14	10	8	6	4	3	2	1.25	0.75			
锯齿			齿/英寸 (tpi)			Toothing			teeth/inch (tpi)				

变化的齿距  
 实心材料直径

Variable Toothing  
 Diameter of solid material

20	30	50	80	100	200	300	500	800	(mm)
10/14	8/12	6/10	5/8	4/6	4/6	3/4	2/3	1.4/2	0.75/1.25
锯齿			齿 / 英寸 (tpi)			Toothing		teeth/inch (tpi)	

确定锯切管材和型材的正确锯齿  
 To Determine the Correct Toothing for Sawing Tubing and Profiles



D (mm)	20	40	60	80	100	150	200	300	500
S (mm)	齿距 (tpi)    Tooth pitch (tpi)								
2	14	14	14	14	10/14	10/14	10/14	10/14	8/12
3	14	10/14	10/14	8/12	8/12	8/12	6/10	6/10	6/10
4	14	10/14	10/14	8/12	8/12	6/10	6/10	5/8	4/6
5	14	10/14	10/14	8/12	6/10	6/10	5/8	4/6	4/6
6	14	10/14	8/12	8/12	6/10	5/8	5/8	4/6	4/6
8	14	8/12	6/10	6/10	6/10	5/8	5/8	4/6	4/6
10		6/10	6/10	5/8	5/8	4/6	4/6	4/6	3/4
12		6/10	5/8	4/6	4/6	4/6	4/6	3/4	3/4
15				4/6	4/6	3/4	3/4	3/4	2/3
20				4/6	4/6	3/4	3/4	3/4	2/3
30				3/4	3/4	3/4	2/3	2/3	2/3
50						2/3	2/3	2/3	1.4/2
75							2/3	1.4/2	1.4/2
100								1.4/2	0.75/1.25
150									0.75/1.25



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