Chen Hsong Europe


# SPEED SERIES | 128 - 468 TON TOGGLE
# SPEED-PACK SERIES | 260 - 470 TON TOGGLE

## Injection moulding machine

# SPEED SERIES 128 – 468 TON TOGGLE
## Injection moulding machine

### EUROMAP STANDARD
Hole pattern and ejector pattern according to Euromap standards*.
T-slot or other pattern possible on request.

### ULTRA HIGH SPEED, FAST RESPONSE
Top-of-the-line high-response servomotor with 2 x faster dynamic response. This results in higher repeatability, control precision and energy efficiency.

CHEN HSONG


### OIL-LESS GRAPHITE BUSHINGS
Self-lubricating bushings have no need for lubricating oil.
Result is less pollution, less wear, less costs.

### EUROPEAN COMPONENTS
Standard European components:

| | |
|---|---|
| Hydraulic valves: | Bosch Rexroth |
| Hydraulic pump: | Eckerle |
| Linear transducers: | Gefran or Novotechnik |
| Electrical components: | Siemens, Schneider, Telemechanique, PILZ |

### PRECISION HYDRAULICS
The Chen Hsong Speed series is equipped with the revolutionary, by Japanese engineers developed, technology Precision Hydraulics™ It includes the newest software simulation and control technology, which eliminates unnecessary pressure drops and offers a highly optimised hydraulic circuit.

*Hole pattern/ejector pattern may differ from standard due to platen design.

## PPC2200 CONTROLLER APPLICATION

The PPC2200 controller from B&R offers an integrated solution for the automation of the Chen Hsong injection moulding machines. High-speed applications and complete production cells can be implemented with B&R. The integrated Extremely Fast Control technology enables the sampling of rapidly changing input signals, allowing the injection process to be controlled with high precision. The 15.6”screen area with touch function enables a clear process visualization.

### OPTIMIZED INJECTION UNIT DESIGN

Standard injection unit is especially optimized for high-speed applications with higher injection speed and pressure.


### SUPER HIGH PRECISION

High precision linear transducers are used for the clamping, injection and ejector axes. All results in low-pressure mould protection. Balanced dual hydraulic cylinders and linear guide rails make a low friction mechanism for high precision injection control.

### INOVANCE SERVO DRIVE SYSTEM

The Inovance servo drive system is designed dedicated for injection moulding machines. This system provides high performance, precision, low noise and easy maintenance. For machines using this servo drive, energy saving up to 80% can be achieved.

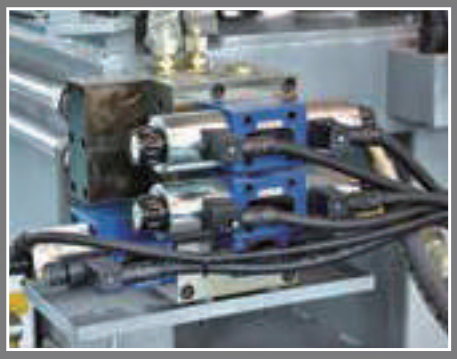
## ENERGY SAVING

The Chen Hsong machines are equipped with speed controlled servomotors.The system pressure is measured real-time by a pressure sensor. In this way, it can provide the flow according to requirement and non-functioning consumption is eliminated. This leads to lower energy consumption, high precision, low noise and low inertia.

## STANDARD AND OPTIONAL FEATURES

| CLAMPING UNIT | STANDARD | OPTION |
|---|---|---|
| Automatic mould height adjust | • | |
| Hydraulic safety device | • | |
| Core puller on moving platen | 2 | |
| Additional core pullers (up to 6 core pullers) | | • |
| Airblow on fixed and moving platen | 1 + 1 | |
| Parallel core movement | | • |
| Parallel ejector movement | | • |
| Euromap 2 platen design * | • | |
| Euromap 13 for core and ejector | • | |
| Euromap 18 for robot mounting | • | |
| Euromap 67 for robot communication | • | |
| Euromap 70 and 70.1 | | • |
| Larger maximum mould height | | • |
| Automatic toggle lubrication | • | |
| Automatic lubrication on mould height adjust | | • |
| Anti-skid plates on horizontal surfaces | • | |
| Differential boost for high-speed clamping | • | |
| Safety door with hydraulic and electrical safety interlock protection | • | |
| High tensile chrome-plated tie bars | • | |
| Oil-less bushings for toggle system | | • |
| Ejection-on-fly / core-pull-on-fly | | • |
| **OTHERS** | | |
| Up to 16 zones integrated hotrunner System (Euromap 14 standard) | | • |
| Power sockets 3-phase 400V 32A and 16A | One each | |
| Power sockets 2-phase 240V 16A | 2 | |
| Waterflow regulators (more available upon request) | 6 circuits | |

*Hole pattern/ejector pattern may differ from standard due to platen design.



| INJECTION UNIT | STANDARD | OPTION |
|---|---|---|
| Ceramic heater bands | • | |
| Nitrated screw and barrel | • | |
| Bi-metallic screw and barrel | | • |
| PET or PVC screw features | | • |
| PVC and UPVC-specialized injection units | | • |
| Back pressure control | • | |
| Barrel shut-off nozzle | | • |
| Hydraulic/pneumatic sequential injection (up to12 valves) | | • |
| Linear transducer on injection stroke | • | |
| Linear transducer on injection unit stroke | • | |
| Screw speed indicator | • | |
| Controlled feeding zone cooling | • | |
| Automatic PID temperature control | • | |
| Barrel isolation | | • |
| Central lubrication points | • | |
| Anti-skid plates on horizontal surfaces | • | |
| Parallel plasticizing | | • |
| Broken thermocouple detection alarm | • | |
| Blocked nozzle and overflow detection | • | |
| (Locking type) screw tip set | • | |

| CONTROLLER | | |
|---|---|---|
| B&R controller | • | |
| 15.6”HD TFT display with touch function | • | |
| LED backlight | • | |
| Free programmable cores | • | |
| Free I/O Configuration | • | |
| Sequence editor | • | |
| High-precision mould safety | • | |
| PowerLink -based Extremely Fast Control technology | • | |
| Ethernet interface for teleservice via internet | • | |
| USB interface | • | |
| Euromap 67 interface | • | |
| Industry 4.0 | | • |
| OPC-UA | | • |

| Injection unit | Unit | SPEED 128 | | SPEED 168 | | SPEED 208 | |
|---|---|---|---|---|---|---|---|
| Swept Volume | cm $^3$ | 136 | 183 | 209 | 271 | 304 | 38 |
| Injection Weight (PS) | g | 124 | 167 | 190 | 246 | 276 | 34 |
| Screw Diameter | mm | 31 | 36 | 36 | 41 | 41 | 4 |
| Screw L/D Ratio | L/D | 24.4 | 21.0 | 23.9 | 21.0 | 23.6 | 2 |
| Injection Pressure (Max) | kgf/cm $^2$ | 2,548 | 1,890 | 2,451 | 1,890 | 2,118 | 1,6 |
| Injection Rate (PS) | g/s | 226 | 305 | 305 | 396 | 396 | 49 |
| Screw Rotation Speed (Max) | rpm | 300 | | 300 | | 300 | |
| Screw Stroke | mm | 180 | | 205 | | 230 | |
| Nozzle contact force | t | 4.2 | | 4.2 | | 6.2 | |
| Nozzle Stroke | mm | 275 | | 290 | | 330 | |
| Clamping unit | | | | | | | |
| Clamping Force (Max) | t | 128 | | 168 | | 208 | |
| Opening Stroke | mm | 380 | | 450 | | 510 | |
| Maximum Daylight | mm | 830 | | 970 | | 1,060 | |
| Space BetweenTie Bars (HxV) | mm | 410 x 410 | | 470 x 470 | | 530 x 530 | |
| Max. MouldThickness | mm | 450 | | 520 | | 550 | |
| Min. MouldThickness | mm | 150 | | 170 | | 180 | |
| Ejector Stroke | mm | 120 | | 140 | | 150 | |
| Ejector Force | mm | 3.4 | | 4.2 | | 6.7 | |
| Flange Position | mm | 125 | | 125 | | 160 | |
| Others | | | | | | | |
| System Pressure | MPa | 17.5 | | 17.5 | | 17.5 | |
| Pump Motor | kW | 34 | | 40 | | 40 | |
| Electrical Heating | kW | 10.5 | | 13 | | 16.5 | |
| Temperature Control Zones | Zones | 3 + nozzle | | 3 + nozzle | | 3 + nozzle | |
| OilTank Capacity | L | 230 | | 270 | | 360 | |
| Machine dimensions (LxWxH) | m | 4.8 x 1.2 x 1.9 | | 5.2 x 1.3 x 2.0 | | 5.8 x 1.4 x 2.1 | |
| Machine weight | t | 4.2 | | 5.5 | | 7.5 | |

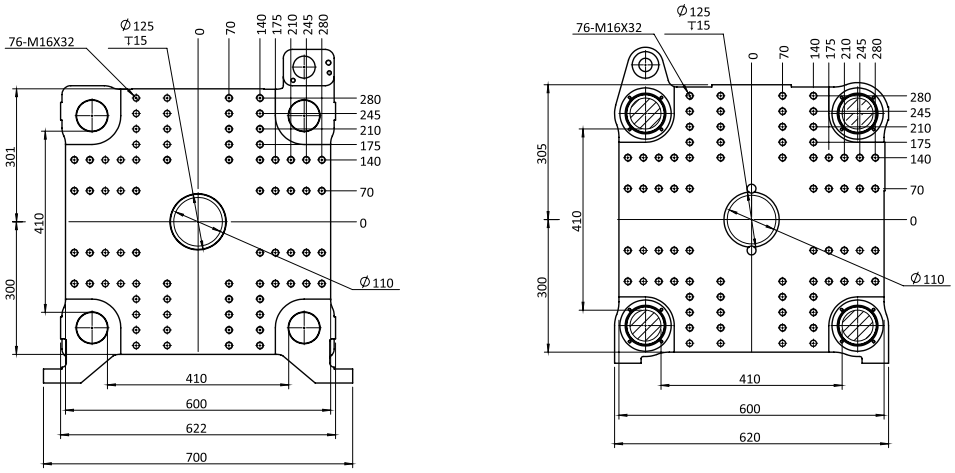
All technical data and features are subjected to change without notice.

| | SPEED 258 | | SPEED 328 | | SPEED 398 | | SPEED 468 | |
|---|---|---|---|---|---|---|---|---|
| 82 | 304 | 382 | 432 | 552 | 947 | 1.181 | 947 | 1.181 |
| 48 | 276 | 348 | 393 | 502 | 862 | 1.075 | 862 | 1.075 |
| 46 | 41 | 46 | 46 | 52 | 60 | 67 | 60 | 67 |
| 1.0 | 23.6 | 21.0 | 23.7 | 21.0 | 23.5 | 21.0 | 23.5 | 21.0 |
| 683 | 2,119 | 1,683 | 2,419 | 1,893 | 1,867 | 1,497 | 1,867 | 1,497 |
| 99 | 396 | 499 | 499 | 637 | 848 | 1.058 | 848 | 1.058 |
| | 300 | | 300 | | 300 | | 300 | |
| | 230 | | 260 | | 335 | | 335 | |
| | 6.2 | | 6.2 | | 9.1 | | 9.1 | |
| | 330 | | 380 | | 440 | | 440 | |
| | | | | | | | | |
| | 258 | | 328 | | 398 | | 468 | |
| | 560 | | 660 | | 720 | | 820 | |
| | 1,140 | | 1,340 | | 1,450 | | 1,670 | |
| | 580 x 580 | | 680 x 680 | | 730 x 730 | | 830 x 830 | |
| | 580 | | 680 | | 730 | | 850 | |
| | 190 | | 225 | | 250 | | 300 | |
| | 150 | | 180 | | 215 | | 220 | |
| | 6.7 | | 11.1 | | 11.1 | | 16.6 | |
| | 160 | | 160 | | 160 | | 200 | |
| | | | | | | | | |
| | 17.5 | | 17.5 | | 17.5 | | 17.5 | |
| | 40 | | 40 + 34 | | 40 + 40 | | 40 + 40 | |
| | 16.5 | | 21 | | 33.7 | | 33.7 | |
| | 3 + Nozzle | | 3 + Nozzle | | 4 + Nozzle | | 4 + Nozzle | |
| | 380 | | 600 | | 760 | | 950 | |
| | 6.0 x 1.5 x 2.2 | | 7.2 x 1.8 x 2.3 | | 8.0 x 1.9 x 2.3 | | 8.7 x 2.0 x 2.3 | |
| | 8.5 | | 13.5 | | 17 | | 21 | |

# SPEED SERIES | 128-468

## Injection moulding machine

### SPEED 128

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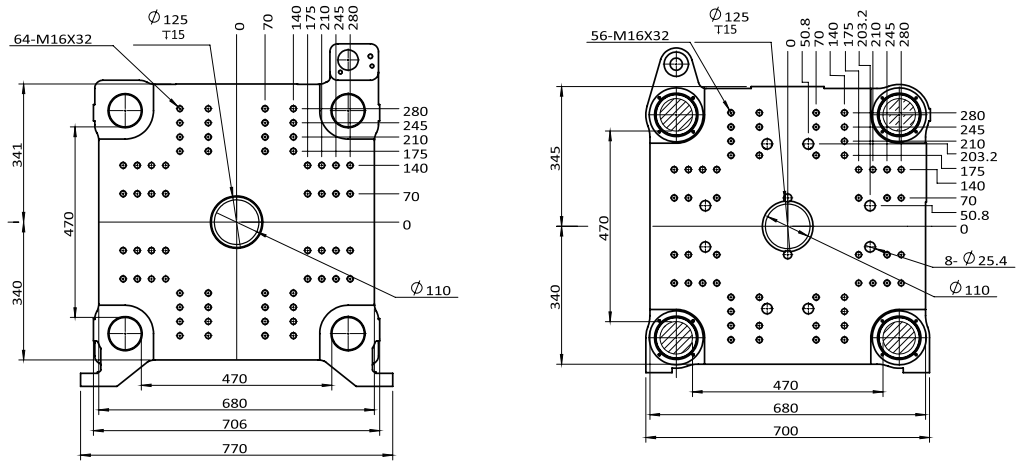


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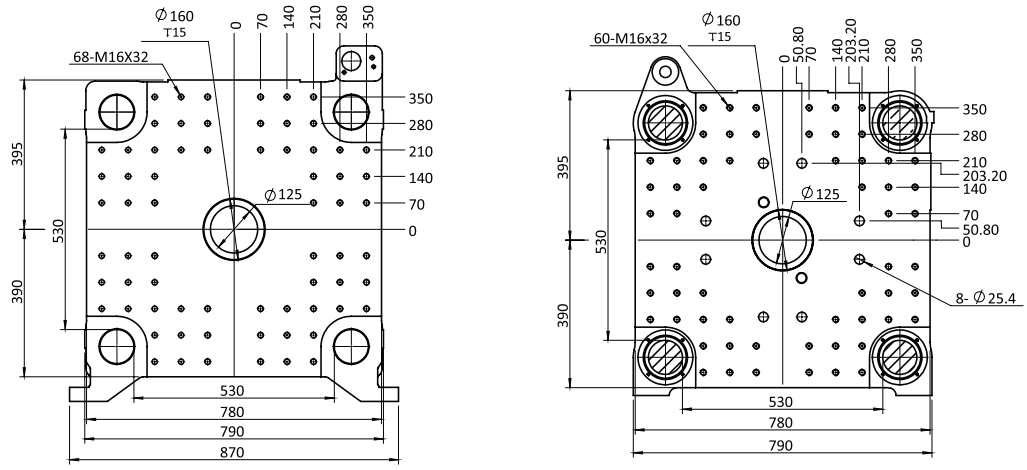

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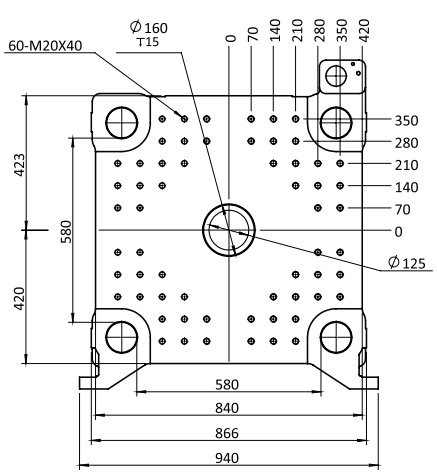


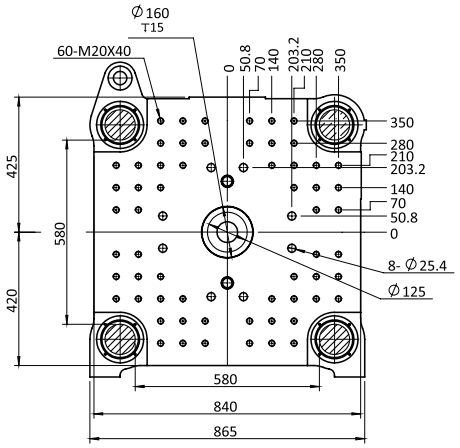


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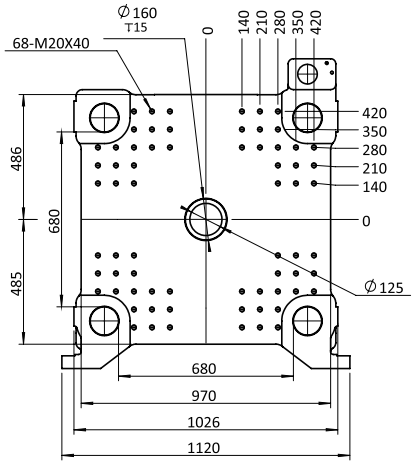


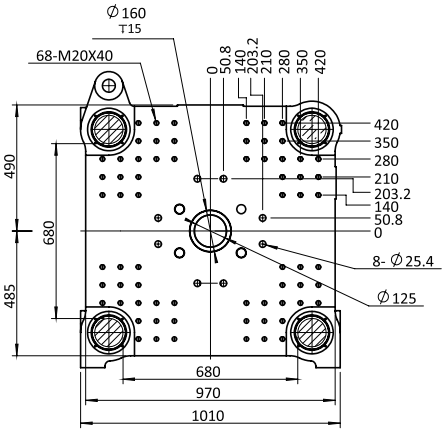


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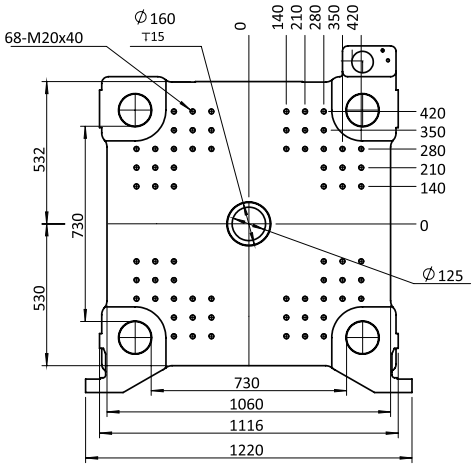


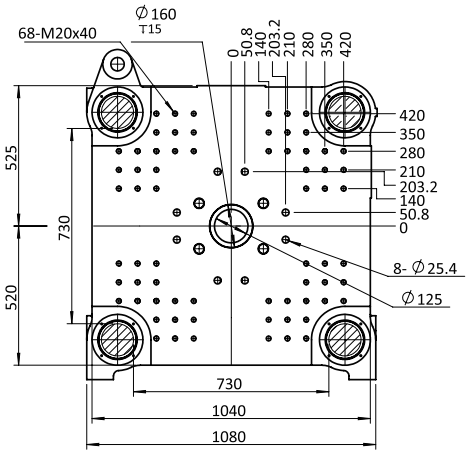


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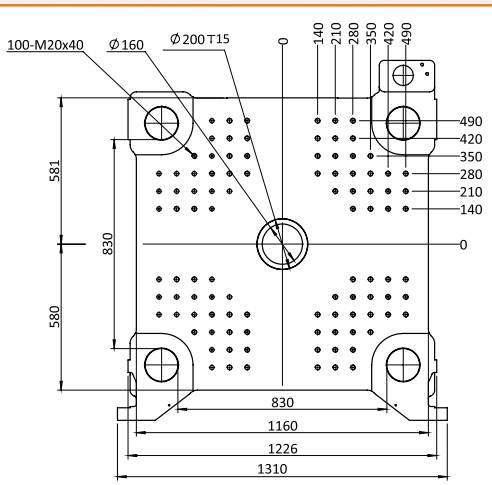
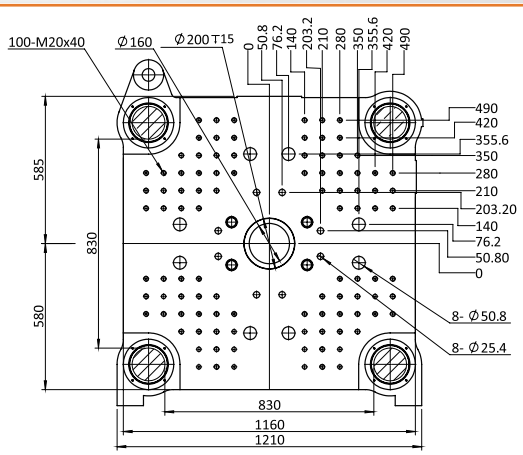
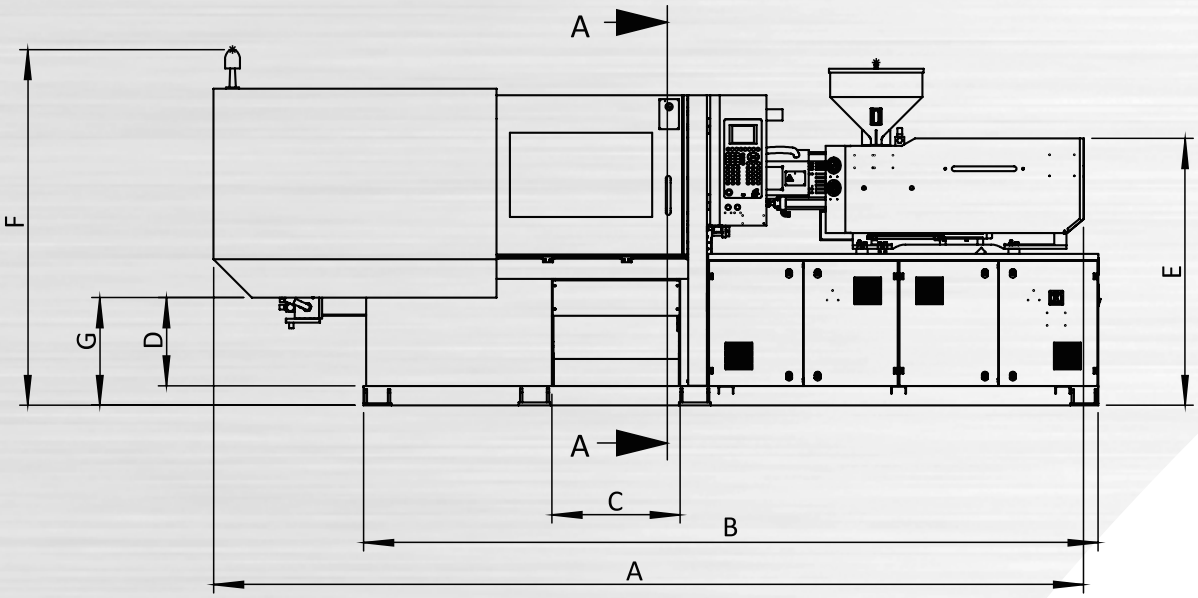
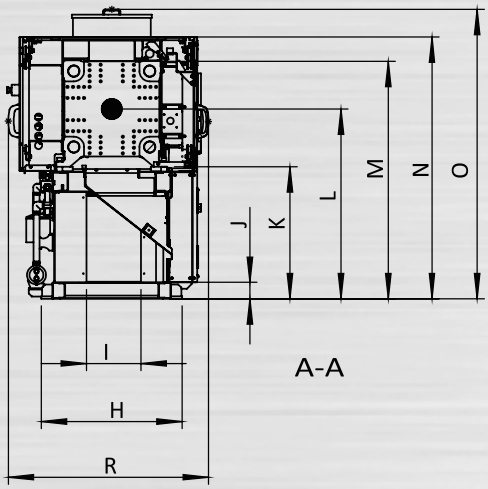


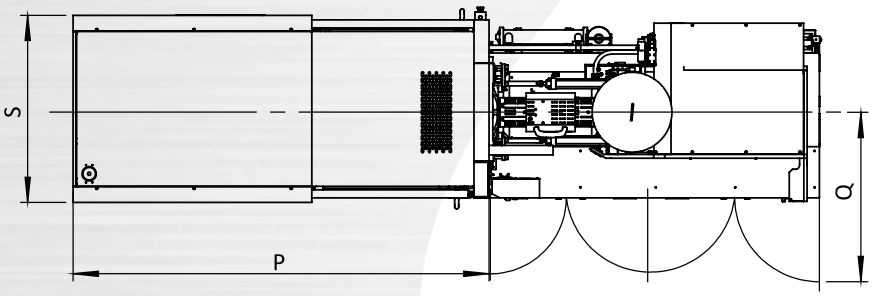



# SPEED SERIES | 128-328

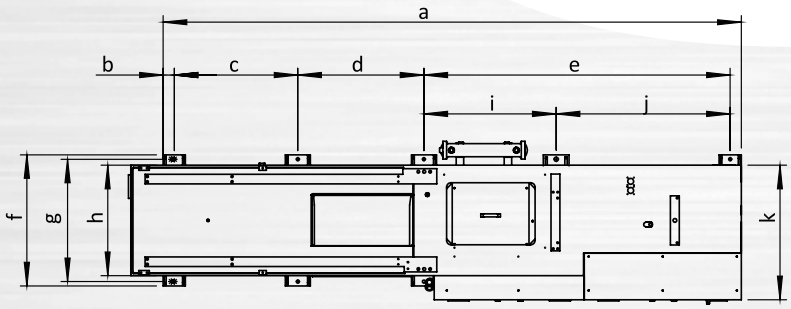
## Injection moulding machine



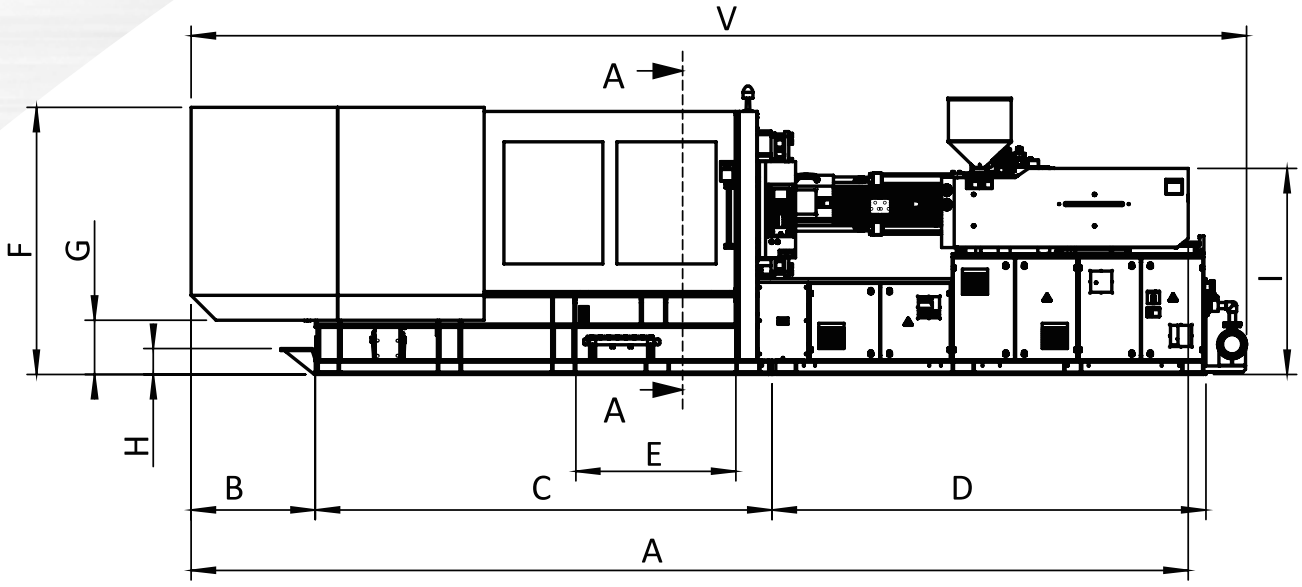

| SYMBOL / MODEL | SPEED 128 | SPEED 168 | SPEED 208 | SPEED 258 | SPEED 328 |
|---|---|---|---|---|---|
| A | 4440 | 4888 | 5450 | 5641 | 6423 |
| B | 3920 | 4200 | 4787 | 4917 | 5940 |
| C | 684 | 770 | 859 | 859 | 1075 |
| D | 471 | 461 | 481 | 471 | 510.5 |
| E | 1425 | 1465 | 1562 | 1607 | 1650 |
| F | 1898.5 | 1978.5 | 2105.5 | 2198 | 2315 |
| G | 575 | 565 | 592 | 577 | 630.5 |
| H | 890 | 940 | 1070 | 1140 | 1370 |
| I | 345 | 395 | 525 | 595 | 850 |
| J | 104 | 104 | 106 | 106 | 120 |
| K | 835 | 835 | 862 | 862 | 820 |
| L | 1200 | 1240 | 1317 | 1362 | 1400 |
| M | 1501 | 1581 | 1712 | 1785 | 1866 |
| N | 1655 | 1735 | 1862 | 1955 | 2060 |
| O | 1830 | 1870 | 1962 | 2007 | 2050 |
| P | 2630 | 2864.5 | 3197.5 | 3388 | 3948.5 |
| Q | 1073.5 | 1122 | 1253.5 | 1287 | 1503 |
| R | 1266 | 1301 | 1500 | 1576 | 1780 |
| S | 1184 | 1219 | 1418 | 1494 | 1780 |

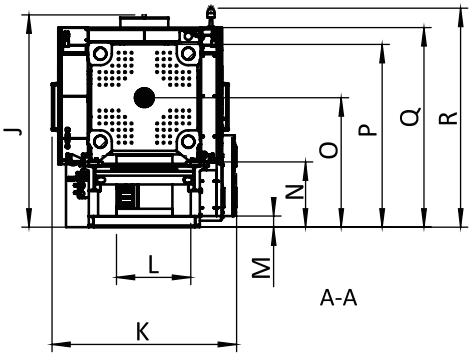


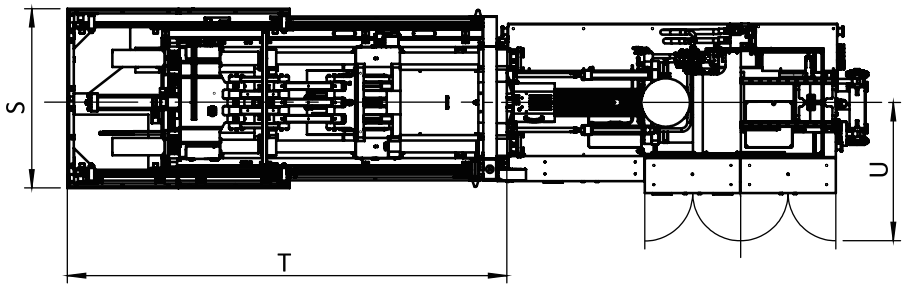

| SYMBOL / MODEL | a | b | c | d | e | f | g | h | i | j | k |
|---|---|---|---|---|---|---|---|---|---|---|---|
| SPEED 128 | 3920 | 75 | 838 | 855 | 2077 | 890 | 830 | 750 | | | 916 |
| SPEED 168 | 4200 | 75 | 977.5 | 905 | 2167.5 | 940 | 880 | 794 | | | 966 |
| SPEED 208 | 4787 | 85 | 1111 | 1025 | | 1070 | 1010 | 930 | 1181 | 1300 | 1096 |
| SPEED 258 | 4917 | 85 | 1265.5 | 1025 | | 1140 | 1080 | 1000 | 1156.5 | 1300 | 1163 |
| SPEED 328 | 5940 | 100 | 1425 | 1250 | | 1370 | 1310 | 1230 | 1635 | 1430 | 1396 |

# SPEED SERIES | 398-468

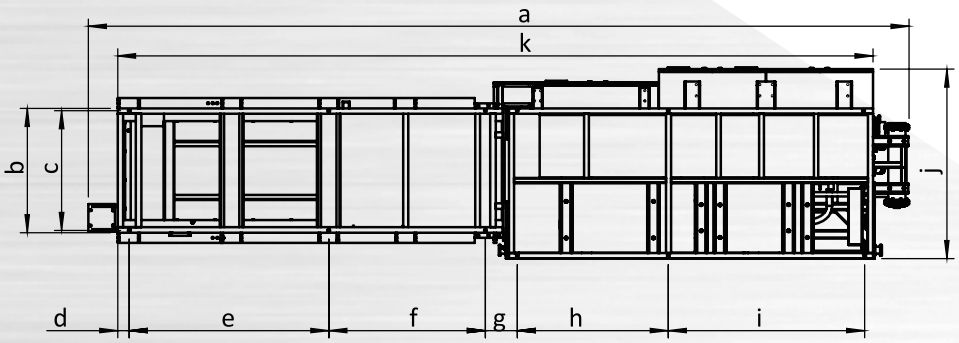
## Injection moulding machine




| SYMBOL / SYMBOL | SPEED 398 | SPEED 468 |
|---|---|---|
| A | 7310 | 7750 |
| B | 916.5 | 1027 |
| C | 3430 | 3780 |
| D | 3272 | 3588 |
| E | 1155 | 1325 |
| F | 2144.5 | 2210 |
| G | 510.5 | 450 |
| H | 216 | 215 |
| I | 1720 | 1660 |
| J | 2280 | 2160 |
| K | 1929 | 2030 |
| L | 1013 | 810 |
| M | 120 | 120 |
| N | 770 | 710 |
| O | 1400 | 1410 |
| P | 1932 | 1991 |
| Q | 2110 | 2175 |
| R | 2335 | 2385 |
| S | 1857 | 1957 |
| T | 4241.5 | 4681.5 |
| U | 1435 | 1504 |
| V | 8020 | 8795 |




| MODEL / SYMBOL | a | b | c | d | e | f | g | h | i | j | k |
|---|---|---|---|---|---|---|---|---|---|---|---|
| SPEED 398 | 7420 | 1120 | 1076 | 113 | 1775 | 1355 | 295 | 1492 | 1592 | 1825 | 6720 |
| SPEED 468 | 8025 | 1210 | 1166 | 113 | 1942 | 1525 | 310 | 1470 | 1900 | 1845 | 7368 |

# SPEED-PACK SERIES 260 – 470 TON TOGGLE
## Injection moulding machine

### EUROMAP STANDARD
Hole pattern and ejector pattern according to Euromap standards*.
T-slot or other pattern possible on request.

### ULTRA HIGH SPEED, FAST RESPONSE
Top-of-the-line high-response servomotor with 2 x faster dynamic response. This results in higher repeatability, control precision and energy efficiency.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Self-lubricating bushings have no need for lubricating
Result is less pollution, less wear, less costs.

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Standard injection unit is especially optimized for high-speed applications with higher injection speed and pressure.


### LARGER SCREW L/D

Larger screw L/D ratio for a perfect homogeneous melt.

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High precision linear transducers are used for the clamping, injection and ejector axes. All results in low-pressure mould protection. Balanced dual hydraulic cylinders and linear guide rails make a low friction mechanism for high precision injection control.

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| Airblow on fixed and moving platen | 1 + 1 | |
| Parallel core movement | | • |
| Parallel ejector movement | | • |
| Euromap 2 platen design * | • | |
| Euromap 13 for core and ejector | • | |
| Euromap 18 for robot mounting | • | |
| Euromap 67 for robot communication | • | |
| Euromap 70 and 70.1 | | • |
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| Automatic toggle lubrication | • | |
| Automatic lubrication on mould height adjust | | • |
| Anti-skid plates on horizontal surfaces | • | |
| Differential boost for high-speed clamping | • | |
| Safety door with hydraulic and electrical safety interlock protection | • | |
| High tensile chrome-plated tie bars | • | |
| Oil-less bushings for toggle system | | • |
| Ejection-on-fly / core-pull-on-fly | | • |
| **OTHERS** | | |
| Up to 16 zones integrated hotrunner System (Euromap 14 standard) | | • |
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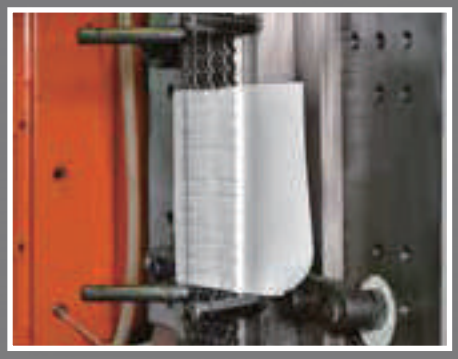
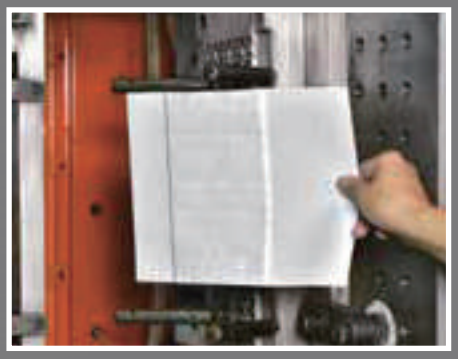

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| Bi-metallic screw and barrel | | • |
| PET or PVC screw features | | • |
| PVC and UPVC-specialized injection units | | • |
| Back pressure control | • | |
| Barrel shut-off nozzle | | • |
| Hydraulic/pneumatic sequential injection (up to12 valves) | | • |
| Linear transducer on injection stroke | • | |
| Linear transducer on injection unit stroke | • | |
| Screw speed indicator | • | |
| Controlled feeding zone cooling | • | |
| Automatic PID temperature control | • | |
| Barrel isolation | | • |
| Central lubrication points | • | |
| Anti-skid plates on horizontal surfaces | • | |
| Parallel plasticizing | | • |
| Broken thermocouple detection alarm | • | |
| Blocked nozzle and overflow detection | • | |
| (Locking type) screw tip set | • | |

| CONTROLLER | | |
|---|---|---|
| B&R controller | • | |
| 15.6”HD TFT display with touch function | • | |
| LED backlight | • | |
| Free programmable cores | • | |
| Free I/O Configuration | • | |
| Sequence editor | • | |
| High-precision mould safety | • | |
| PowerLink -based Extremely Fast Control technology | • | |
| Ethernet interface for teleservice via internet | • | |
| USB interface | • | |
| Euromap 67 interface | • | |
| Industry 4.0 | | • |
| OPC-UA | | • |

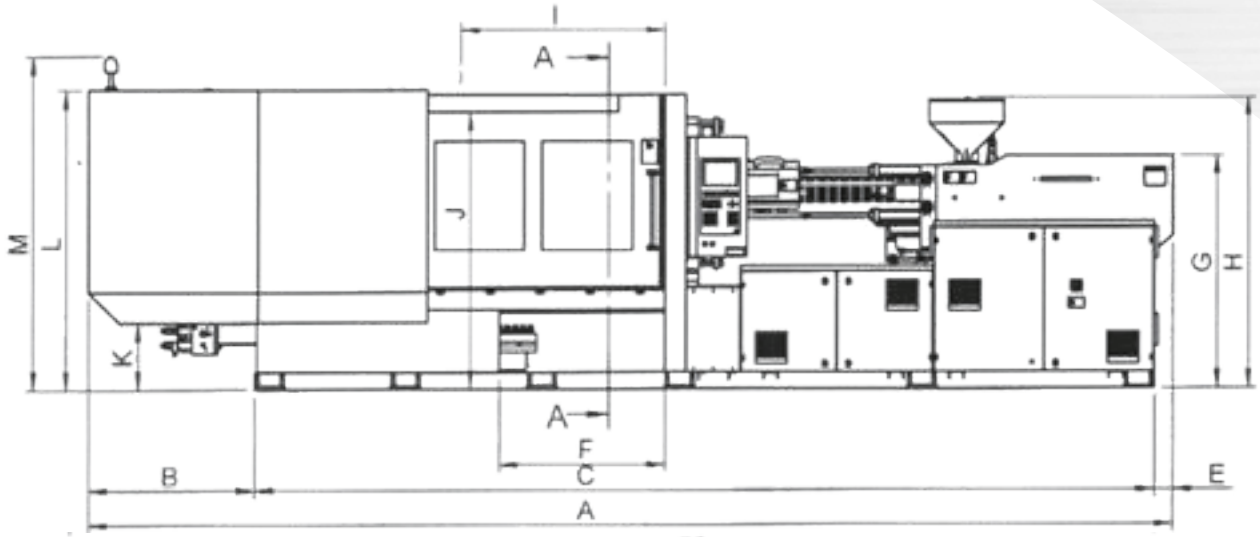
| Injection unit | Unit | SPEED-PACK 260 | | SPEED-P |
|---|---|---|---|---|
| Swept Volume | cm $^3$ | 136 | 183 | 432 |
| Injection Weight (PS) | g | 124 | 167 | 393 |
| Screw Diameter | mm | 31 | 36 | 46 |
| Screw L/D Ratio | L/D | 24.4 | 21.0 | 26.0 |
| Injection Pressure (Max) | kgf/cm $^2$ | 2,549 | 1,890 | 2,084 |
| Injection Rate (PS) | g/s | 309 | 417 | 681 |
| Injection Speed (PS) | mm/s | 450 | | 4 |
| Screw Rotation Speed (Max) | rpm | 300 | | 3 |
| Screw Stroke | mm | 180 | | 2 |
| Nozzle contact force | t | 4.2 | | |
| Nozzle Stroke | mm | 275 | | 3 |
| **Clamping unit** | | | | |
| Clamping Force (Max) | t | 260 | | 3 |
| Opening Stroke | mm | 560 | | 6 |
| Maximum Daylight | mm | 1,140 | | 1, |
| Space BetweenTie Bars (HxV) | mm | 580 x 580 | | 670 |
| Max. MouldThickness | mm | 580 | | 6 |
| Min. MouldThickness | mm | 190 | | 2 |
| Ejector Stroke | mm | 150 | | 1 |
| Ejector Force | t | 6.7 | | 1 |
| Centerring | mm | 160 | | 1 |
| **Others** | | | | |
| System Pressure | MPa | 17.5 | | 1 |
| Pump Motor | kW | 40 | | 40 |
| Electrical Heating | kW | 10.5 | | |
| Temperature Control Zones | Zones | 3 + Nozzle | | 4 + N |
| OilTank Capacity | L | 330 | | 7 |
| Machine dimensions (LxWxH) | m | 5.9 x 1.6 x 2.2 | | 7.2 x 1 |
| Machine weight | t | 7.5 | | 1 |

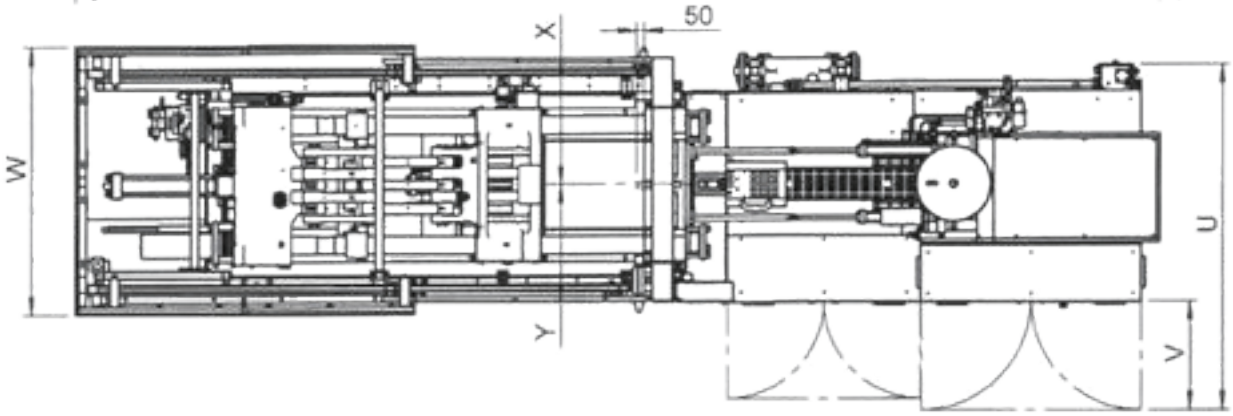
All technical data and features are subjected to change without notice.

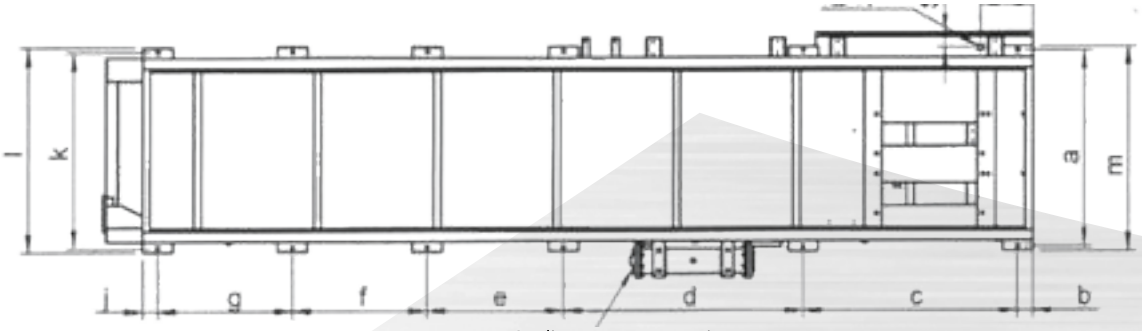
| ACK 330 | SPEED-PACK 400 | | SPEED-PACK 470 | |
|---|---|---|---|---|
| 552 | 552 | 735 | 552 | 735 |
| 502 | 502 | 669 | 502 | 669 |
| 52 | 52 | 60 | 52 | 60 |
| 26.0 | 26.0 | 26.0 | 26.0 | 26.0 |
| 1,631 | 1,631 | 1,225 | 1,631 | 1,225 |
| 870 | 966 | 1,287 | 966 | 1,287 |
| 450 | 500 | | 500 | |
| 300 | 300 | | 300 | |
| 260 | 260 | | 260 | |
| 6.2 | 6.2 | | 6.2 | |
| 380 | 380 | | 380 | |
| | | | | |
| 330 | 400 | | 470 | |
| 660 | 720 | | 820 | |
| 340 | 1,450 | | 1,670 | |
| x 670 | 720 x 720 | | 830 x 830 | |
| 680 | 730 | | 850 | |
| 225 | 250 | | 300 | |
| 130 | 165 | | 170 | |
| 11.1 | 11.1 | | 16.6 | |
| 160 | 160 | | 170 | |
| | | | | |
| 17.5 | 17.5 | | 17.5 | |
| + 34 | 40 + 40 | | 40 + 40 | |
| 31 | 31 | | 31 | |
| Nozzle | 4 + Nozzle | | 4 + Nozzle | |
| 700 | 760 | | 850 | |
| .8 x 2,2 | 8.0 x 1.9 x 2.2 | | 8.8 x 2.0 x 2.3 | |
| 13.5 | 15.8 | | 18.5 | |

# SPEED-PACK SERIES | 260-330

## Injection moulding machine

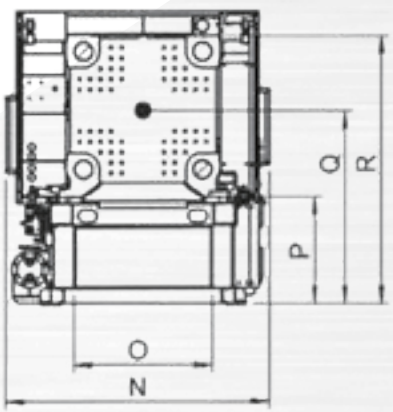


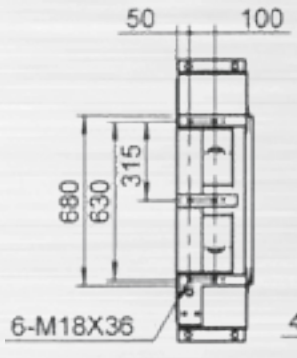



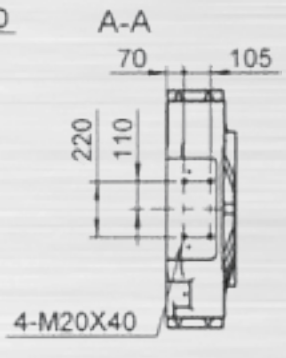

Cooling water connection

| | PACK 260 | PACK 330 |
|---|---|---|
| A | 5883 | 7162 |
| B | 966 | 1099 |
| C | 4917 | 5940 |
| E | / | 123 |
| F | 859 | 1097 |
| G | 1582 | 1550 |
| H | 1992 | 1935 |
| I | 1024 | 1264 |
| J | 1816 | 1843 |
| K | 596 | 444 |
| L | 1991 | 1989 |
| M | 2217 | 2215 |
| N | 1500 | 1752 |
| O | 770 | 920 |
| P | 862 | 720 |
| Q | 1362 | 1300 |
| R | 1785 | 1800 |
| S | 95 | 105 |
| T | 350 | 350 |
| U | 1895 | 2280 |
| V | 605 | 738 |
| W | 1494 | 1780 |
| X | 768 | 838 |
| Y | 666 | 771 |




300T Robot arm position

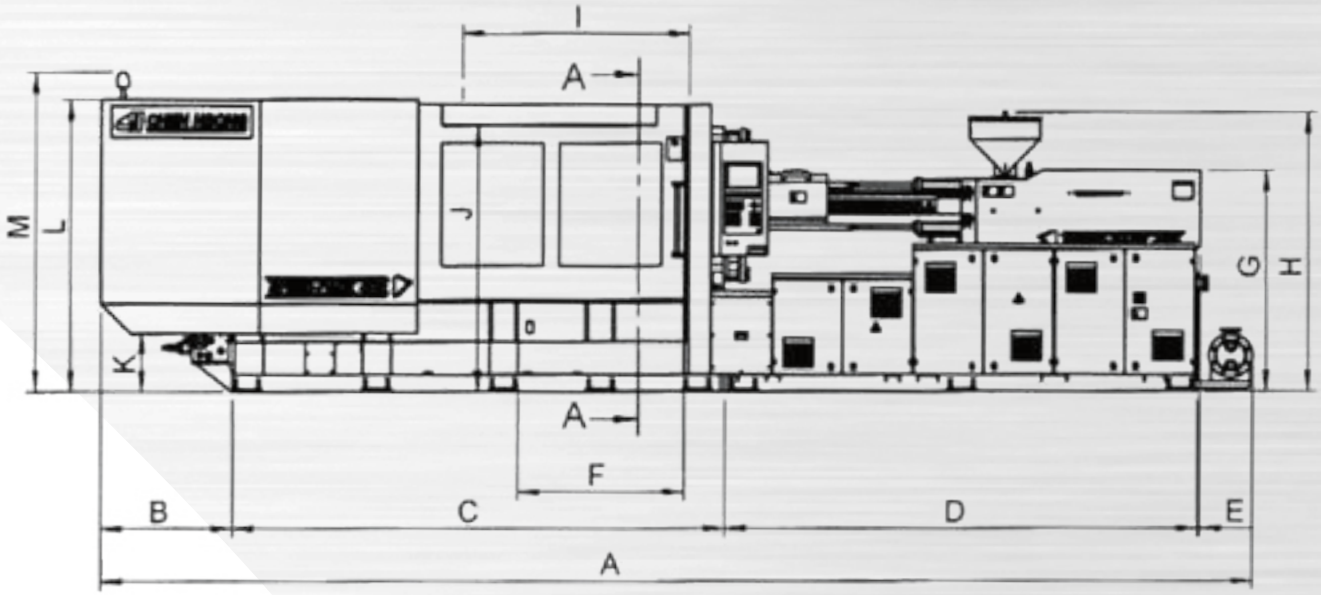


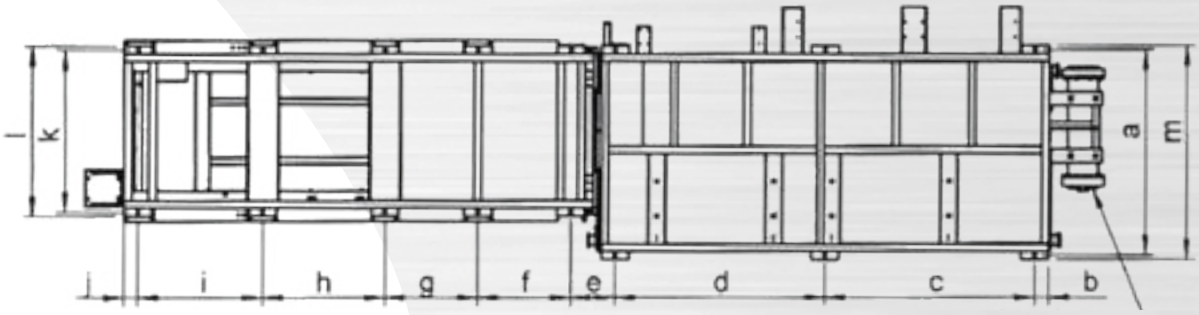

260T Robot arm position

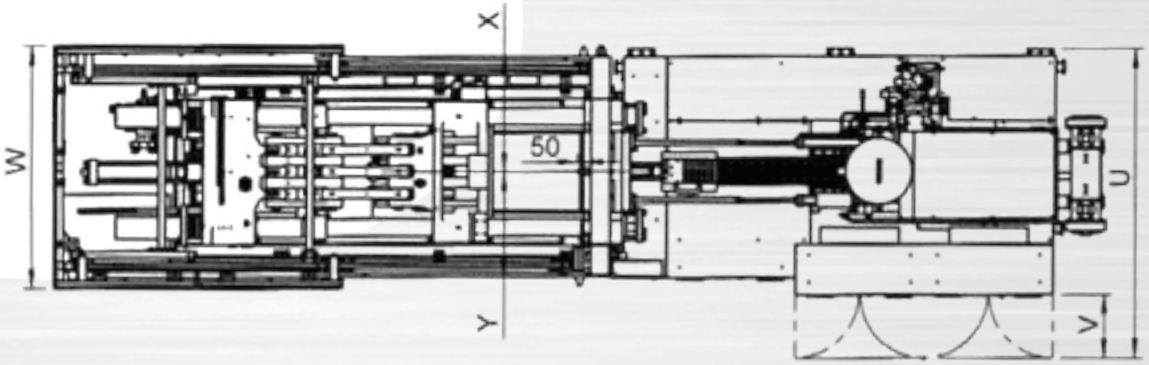
| | PACK 260 | PACK 330 |
|---|---|---|
| a | 1080 | 1370 |
| b | 85 | 1370 |
| c | 1300 | 1310 |
| d | 1156.5 | 100 |
| e | 1025 | 900 |
| f | / | 900 |
| g | 1265.5 | 910 |
| j | 85 | 1600 |
| k | 1080 | 1430 |
| l | 1140 | 100 |
| m | 1140 | 1310 |
| n | 1 1/4' | 1 1/4' |

# SPEED-PACK SERIES | 400-470

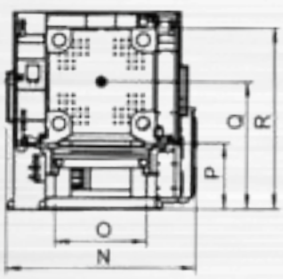
## Injection moulding machine



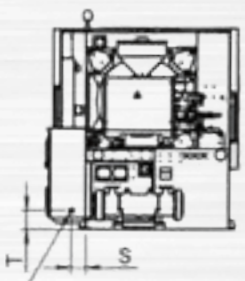



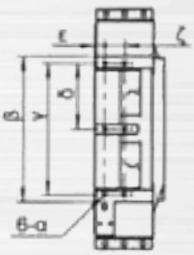

| | PACK 400 | PACK 470 |
|---|---|---|
| A | 8020 | 8777 |
| B | 917 | 1032 |
| C | 3430 | 3775 |
| D | 3290 | 3572 |
| E | 16 | / |
| F | 1155 | 1325 |
| G | 1550 | 1550 |
| H | 1952 | 1952 |
| I | 1578 | 1799 |
| J | 1862 | 1952 |
| K | 411 | 338 |
| L | 2045 | 2098 |
| M | 2235 | 2288 |
| N | 1915 | 2016 |
| O | 920 | 918 |
| P | 670 | 600 |
| Q | 1300 | 1300 |
| R | 1845 | 1900 |
| S | 140 | 140 |
| T | 190 | 190 |
| U | 2370 | 2408 |
| V | 485 | 533 |
| W | 1857 | 1957 |
| X | 833 | 938 |
| Y | 803 | 848 |




A-A




Power inlet




Robot arm position

| | PACK 400 | PACK 470 |
|---|---|---|
| α | M20X40 | M20X40 |
| β | 740 | 880 |
| γ | 670 | 840 |
| δ | 335 | 420 |
| ε | 50 | 60 |
| ζ | 100 | 120 |

| | PACK 400 | PACK 470 |
|---|---|---|
| a | 1500 | 1520 |
| b | 100 | 100 |
| c | 1522 | 190 |
| d | 1522.5 | 1442 |
| e | 320 | 330 |
| f | 675 | / |
| g | 675 | 1525 |
| h | 885 | 975 |
| i | 905 | 1005 |
| j | 100 | 100 |
| k | 1180 | 1270 |
| l | 1240 | 1330 |
| m | 1560 | 1580 |
| n | 2’ | 2’ |

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