Anti-vibration carbide end mills

VARICUT PRO END MILL RANGE

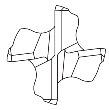
Volume 2

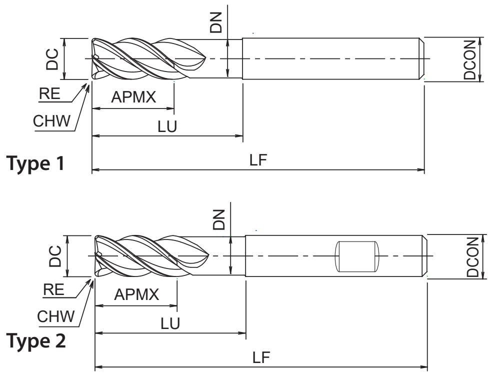
SOMTA
World Class Cutting Tools

KEY FEATURES: VARICUT PRO

VARICUT PRO

Milling | Solid carbide





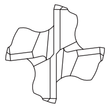
- Anti-vibration carbide end mills
- Wide variety in applications and work materials
- 4 flutes, variable helix and unequal spacing

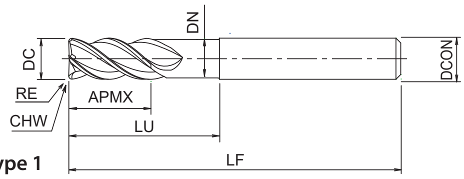
P	M	K	N	S	S	H	H
●	●	●	○	● Ti	● Ni	● 33-41 HRC	○ 42-50 HRC

CARBIDE | TiAIN | 36°~38° | h6 | SHRINK FIT | HB | DIN 6527L

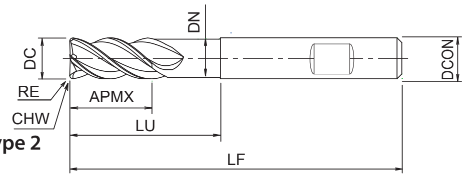
EDP	ZEFP	DC	CHW	RE	LU	LF	APMX	DCON	DN	Type
03VP0100X	4	1	0,07x45°	-	-	38	2,5	4	-	1
03VP0150X	4	1,5	0,07x45°	-	-	38	3,8	4	-	1
03VP0200X	4	2	0,1x45°	-	-	38	5	4	-	1
03VP0250X	4	2,5	0,1x45°	-	-	38	6	4	-	1
03VP0300X	4	3	0,15x45°	-	12	57	8	6	2,9	2
03VP0301X	4	3	0,15x45°	-	12	57	8	6	2,9	1
03VP0302X	4	3	-	0,2	12	57	8	6	2,9	1
03VP0303X	4	3	-	0,2	12	57	8	6	2,9	2
03VP0305X	4	3	-	0,5	12	57	8	6	2,9	1
03VP0306X	4	3	-	0,5	12	57	8	6	2,9	2
03VP0400X	4	4	0,2x45°	-	14,7	57	11	6	3,9	2
03VP0401X	4	4	0,2x45°	-	14,7	57	11	6	3,9	1
03VP0402X	4	4	-	0,2	14,7	57	11	6	3,9	1
03VP0403X	4	4	-	0,2	14,7	57	11	6	3,9	2
03VP0405X	4	4	-	0,5	14,7	57	11	6	3,9	1
03VP0406X	4	4	-	0,5	14,7	57	11	6	3,9	2
03VP0500X	4	5	0,2x45°	-	18	57	13	6	4,8	2
03VP0501X	4	5	0,2x45°	-	18	57	13	6	4,8	1
03VP0502X	4	5	-	0,2	18	57	13	6	4,8	1
03VP0503X	4	5	-	0,2	18	57	13	6	4,8	2
03VP0505X	4	5	-	0,5	18	57	13	6	4,8	1
03VP0506X	4	5	-	0,5	18	57	13	6	4,8	2
03VP0600X	4	6	0,2x45°	-	18	57	13	6	5,8	2
03VP0601X	4	6	0,2x45°	-	18	57	13	6	5,8	1
03VP0602X	4	6	-	0,2	18	57	13	6	5,8	1
03VP0603X	4	6	-	0,2	18	57	13	6	5,8	2
03VP0605X	4	6	-	0,5	18	57	13	6	5,8	1
03VP0606X	4	6	-	0,5	18	57	13	6	5,8	2
03VP0800X	4	8	0,25x45°	-	24	63	19	8	7,8	2
03VP0801X	4	8	0,25x45°	-	24	63	19	8	7,8	1
03VP0802X	4	8	-	0,2	24	63	19	8	7,8	1
03VP0803X	4	8	-	0,2	24	63	19	8	7,8	2
03VP0805X	4	8	-	0,5	24	63	19	8	7,8	1
03VP0806X	4	8	-	0,5	24	63	19	8	7,8	2
03VP1000X	4	10	0,25x45°	-	32	72	22	10	9,8	2
03VP1001X	4	10	0,25x45°	-	32	72	22	10	9,8	1
03VP1003X	4	10	-	0,3	32	72	22	10	9,8	1
03VP1004X	4	10	-	0,3	32	72	22	10	9,8	2
03VP1005X	4	10	-	0,5	32	72	22	10	9,8	1
03VP1006X	4	10	-	0,5	32	72	22	10	9,8	2
03VP1200X	4	12	0,3x45°	-	36	83	26	12	11,8	2
03VP1201X	4	12	0,3x45°	-	36	83	26	12	11,8	1
03VP1205X	4	12	-	0,5	36	83	26	12	11,8	1
03VP1206X	4	12	-	0,5	36	83	26	12	11,8	2
03VP1210X	4	12	-	1	36	83	26	12	11,8	1
03VP1211X	4	12	-	1	36	83	26	12	11,8	2
03VP1600X	4	16	0,4x45°	-	42	92	32	16	15,5	2
03VP1601X	4	16	0,4x45°	-	42	92	32	16	15,5	1

VARICUT PRO





Type 1



Type 2

- Anti-vibration carbide end mills
- Wide variety in applications and work materials
- 4 flutes, variable helix and unequal spacing

P ●	M ●	K ●	N ○	S ● Ti	S ● Ni	H ● 33-41 HRC	H ○ 42-50 HRC

CARBIDE	TiAlN	36°~38°	h6	SHRINK FIT	HB	DIN 6527L

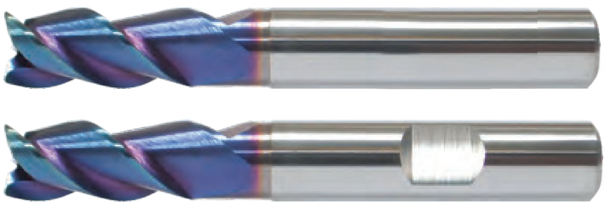
EDP	ZEFP	DC	CHW	RE	LU	LF	APMX	DCON	DN	Type
03VP1610X	4	16	-	1	42	92	32	16	15,5	1
03VP1611X	4	16	-	1	42	92	32	16	15,5	2
03VP1620X	4	16	-	2	42	92	32	16	15,5	1
03VP1621X	4	16	-	2	42	92	32	16	15,5	2
03VP2000X	4	20	0,4x45°	-	48	104	38	20	19,5	2
03VP2001X	4	20	0,4x45°	-	48	104	38	20	19,5	1
03VP2010X	4	20	-	1	48	104	38	20	19,5	1
03VP2011X	4	20	-	1	48	104	38	20	19,5	2
03VP2020X	4	20	-	2	48	104	38	20	19,5	1
03VP2021X	4	20	-	2	48	104	38	20	19,5	2

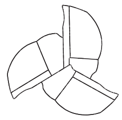
Description	Code
Solid Carbide 4 Flute VariCut Pro End Mill Set	03VP0000X
THIS SET CONTAINS:	
5mm - 03VP0500X, 6mm - 03VP0600X, 8mm - 03VP0800X,	
10mm - 03VP1000X, 12mm - 03VP1200X	

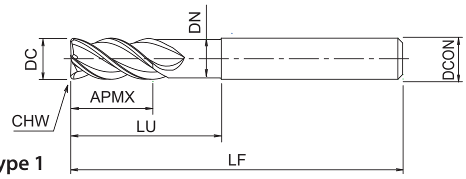
Description	Code
Solid Carbide 4 Flute VariCut Pro End Mill Set	03VP0001X
THIS SET CONTAINS:	
6mm - 03VP0600X, 8mm - 03VP0800X, 10mm - 03VP1000X,	
12mm - 03VP1200X, 16mm - 03VP1600X	

VARICUT PRO 3FL NEW

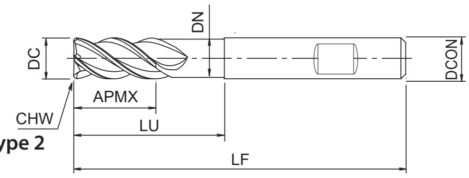
Milling | Solid carbide







Type 1



Type 2

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- Wide variety in applications and work materials
- 3 flutes, variable helix and unequal spacing

P ● | M ● | K ● | N ○ | S ● Ti | S ● Ni | H ● 33-41 HRC | H ○ 42-50 HRC

CARBIDE | TiAlN | 43°~45° | h6 | SHRINK FIT | HB | DIN 6527L

EDP	ZEFP	DC	CHW	LU	LF	APMX	DCON	DN	Type
033VP0300X	3	3	0,15x45°	14	57	8	6	2,8	2
033VP0301X	3	3	0,15x45°	14	57	8	6	2,8	1
033VP0400X	3	4	0,2x45°	17	57	11	6	3,8	2
033VP0401X	3	4	0,2x45°	17	57	11	6	3,8	1
033VP0500X	3	5	0,2x45°	17	57	13	6	4,8	2
033VP0501X	3	5	0,2x45°	17	57	13	6	4,8	1
033VP0600X	3	6	0,2x45°	19	57	13	6	5,7	2
033VP0601X	3	6	0,2x45°	19	57	13	6	5,7	1
033VP0800X	3	8	0,25x45°	25	63	19	8	7,7	2
033VP0801X	3	8	0,25x45°	25	63	19	8	7,7	1
033VP1000X	3	10	0,25x45°	29	72	22	10	9,5	2
033VP1001X	3	10	0,25x45°	29	72	22	10	9,5	1
033VP1200X	3	12	0,3x45°	36	83	26	12	11,5	2
033VP1201X	3	12	0,3x45°	36	83	26	12	11,5	1
033VP1400X	3	14	0,3x45°	36	83	26	14	13,5	2
033VP1401X	3	14	0,3x45°	36	83	26	14	13,5	1
033VP1600X	3	16	0,4x45°	45	92	32	16	15,5	2
033VP1601X	3	16	0,4x45°	45	92	32	16	15,5	1
033VP2000X	3	20	0,4x45°	55	104	38	20	19,5	2
033VP2001X	3	20	0,4x45°	55	104	38	20	19,5	1

CUTTING DATA

Parameters based on ideal conditions. Please adjust parameters accordingly to real applications and flute count of tool.

ap = 1.0 x d
ae = 0.4 x d
Side Milling = fz

ap = 1.0 x d
ae = 1.0 x d
Slot Milling = fz x 0.7

● Recommended
○ Suitable

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

Material		Ø / Vc m/min	1 fz (mm/tooth)	1.5 fz (mm/tooth)	2 fz (mm/tooth)	2.5 fz (mm/tooth)	3 fz (mm/tooth)	4 fz (mm/tooth)	5 fz (mm/tooth)	6 fz (mm/tooth)	8 fz (mm/tooth)	10 fz (mm/tooth)	12 fz (mm/tooth)	16 fz (mm/tooth)	20 fz (mm/tooth)
● 1.1 Free Cutting Steel	< 120 HB	158	0.012-0.021	0.015-0.024	0.017-0.028	0.018-0.030	0.019-0.031	0.023-0.038	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143
● 1.2 Structural Steel	< 200 HB	153	0.012-0.021	0.015-0.024	0.017-0.028	0.018-0.030	0.019-0.031	0.023-0.038	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143
● 1.3 Plain Carbon Steel	< 250 HB	135	0.008-0.014	0.010-0.017	0.012-0.020	0.014-0.023	0.016-0.026	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 1.4 Alloy Steel	< 250 HB	125	0.008-0.014	0.008-0.014	0.008-0.014	0.009-0.016	0.011-0.018	0.017-0.029	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108
● 1.5 Low Alloy Steel	250 - 350 HB	125	0.008-0.014	0.008-0.014	0.008-0.014	0.009-0.016	0.011-0.018	0.017-0.029	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108
● 1.6 Low Alloy Steel	> 350 HB	120	0.008-0.014	0.008-0.014	0.008-0.014	0.009-0.016	0.011-0.018	0.017-0.029	0.020-0.034	0.025-0.041	0.034-0.056	0.041-0.068	0.047-0.078	0.057-0.095	0.065-0.108
● 2.1 Free Machining Stainless Steel	< 250 HB	97	0.009-0.016	0.010-0.017	0.011-0.018	0.013-0.021	0.015-0.025	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 2.2 Austenitic Stainless Steel	< 320 HB	97	0.009-0.016	0.010-0.017	0.011-0.018	0.013-0.021	0.015-0.025	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 2.3 Ferritic and Martensitic Stainless Steel	< 300 HB	75	0.006-0.009	0.008-0.013	0.010-0.016	0.010-0.017	0.011-0.018	0.013-0.022	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081
● 2.4 Precipitation Hardened Stainless Steel	320 - 410 HB	72	0.006-0.009	0.008-0.013	0.010-0.016	0.010-0.017	0.011-0.018	0.013-0.022	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081
● 3.1 Lamellar Graphite Cast Iron	< 150 HB	135	0.012-0.021	0.015-0.024	0.017-0.028	0.018-0.030	0.019-0.031	0.023-0.038	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143
● 3.2 Lamellar Graphite Cast Iron	150 - 300 HB	130	0.012-0.021	0.015-0.024	0.017-0.028	0.018-0.030	0.019-0.031	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 3.3 Nodular Graphite, Malleable Cast Iron	< 200 HB	135	0.008-0.014	0.010-0.017	0.012-0.020	0.014-0.023	0.016-0.026	0.023-0.038	0.027-0.045	0.033-0.055	0.045-0.075	0.054-0.090	0.062-0.103	0.076-0.126	0.086-0.143
● 3.4 Nodular Graphite, Malleable Cast Iron	200 - 300 HB	128	0.008-0.014	0.008-0.014	0.008-0.014	0.009-0.016	0.011-0.018	0.015-0.026	0.018-0.030	0.023-0.038	0.031-0.051	0.037-0.061	0.042-0.070	0.052-0.086	0.058-0.096
● 4.1 Titanium unalloyed	< 200 HB	65	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.018	0.013-0.021	0.015-0.026	0.018-0.030	0.023-0.038	0.031-0.051	0.037-0.061	0.042-0.070	0.052-0.086	0.058-0.096
● 4.2 Titanium alloyed	< 270 HB	57	0.008-0.014	0.008-0.014	0.008-0.014	0.011-0.018	0.013-0.022	0.013-0.022	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081
● 4.3 Titanium alloyed	270 - 350 HB	50	0.008-0.014	0.008-0.014	0.008-0.014	0.011-0.018	0.013-0.022	0.013-0.022	0.016-0.026	0.019-0.031	0.026-0.043	0.031-0.051	0.035-0.059	0.044-0.073	0.049-0.081
● 5.1 Nickel unalloyed	< 150 HB	50	0.011-0.018	0.012-0.020	0.013-0.022	0.014-0.024	0.015-0.026	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 5.2 Nickel alloyed	< 270 HB	45	0.011-0.018	0.012-0.020	0.013-0.022	0.014-0.024	0.015-0.026	0.019-0.032	0.023-0.038	0.027-0.045	0.037-0.061	0.044-0.074	0.050-0.084	0.062-0.104	0.071-0.118
● 5.3 Nickel alloyed	270 - 350 HB	27	0.007-0.011	0.008-0.013	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.018	0.013-0.021	0.015-0.025	0.021-0.035	0.025-0.041	0.029-0.048	0.035-0.059	0.040-0.066
○ 6.1 Copper	< 100 HB	240	0.011-0.019	0.016-0.026	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125
○ 6.2 Beta Brass, Bronze	< 200 HB	230	0.011-0.019	0.016-0.026	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125
○ 6.3 Alpha Brass	< 200 HB	230	0.011-0.019	0.016-0.026	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100	0.068-0.113	0.075-0.125
○ 6.4 High Strength Bronze	< 470 HB	180	0.006-0.009	0.008-0.013	0.009-0.016	0.011-0.019	0.013-0.022	0.016-0.027	0.019-0.031	0.026-0.044	0.026-0.044	0.030-0.050	0.030-0.050	0.034-0.056	0.038-0.063
○ 7.1 Aluminium Magnesium unalloyed	< 100 HB	438	0.013-0.022	0.017-0.028	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625
○ 7.2 Aluminium Alloy < 5% Si	< 150 HB	178	0.013-0.022	0.017-0.028	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625
○ 7.3 Aluminium Alloy 5 to 10% Si	< 120 HB	110	0.013-0.022	0.017-0.028	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625
○ 7.4 Aluminium Alloy > 10% Si		100	0.013-0.022	0.017-0.028	0.020-0.033	0.023-0.038	0.026-0.043	0.032-0.053	0.038-0.063	0.075-0.125	0.150-0.250	0.150-0.250	0.150-0.250	0.225-0.375	0.375-0.625
○ 8.1 Duroplastics (short chipping)		240	0.006-0.009	0.007-0.012	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091
○ 8.2 Thermoplastics (long chipping)		235	0.006-0.009	0.007-0.012	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091
○ 8.3 Fibre Reinforced Synthetic Materials		95	0.006-0.009	0.007-0.012	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.019	0.014-0.023	0.017-0.028	0.023-0.038	0.027-0.045	0.033-0.055	0.044-0.073	0.055-0.091

ap = 1.5 x d
ae = 0.2 x d
Side Milling = fz

ap = 0.5 x d
ae = 1.0 x d
Slot Milling = fz x 0.7

● Recommended
○ Suitable

Parameters based on ideal conditions.
Please adjust parameters accordingly to real applications.

Material		Ø / Vc m/min	1 fz (mm/tooth)	1.5 fz (mm/tooth)	2 fz (mm/tooth)	2.5 fz (mm/tooth)	3 fz (mm/tooth)	4 fz (mm/tooth)	5 fz (mm/tooth)	6 fz (mm/tooth)	8 fz (mm/tooth)	10 fz (mm/tooth)	12 fz (mm/tooth)	16 fz (mm/tooth)	20 fz (mm/tooth)
● 1.1 Free Cutting Steel	< 120 HB	158	0.009-0.016	0.012-0.020	0.015-0.025	0.018-0.030	0.021-0.034	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 1.2 Structural Steel	< 200 HB	153	0.009-0.016	0.012-0.020	0.015-0.025	0.018-0.030	0.021-0.034	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 1.5 Low Alloy Steel	250 - 350 HB	125	0.009-0.016	0.009-0.016	0.009-0.016	0.013-0.022	0.017-0.028	0.023-0.038	0.030-0.050	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.083-0.138	0.083-0.138
● 1.6 Low Alloy Steel	> 350 HB	120	0.009-0.016	0.009-0.016	0.009-0.016	0.013-0.022	0.017-0.028	0.023-0.038	0.030-0.050	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.083-0.138	0.083-0.138
● 2.2 Austenitic Stainless Steel	< 320 HB	97	0.006-0.009	0.008-0.013	0.009-0.016	0.010-0.017	0.011-0.019	0.017-0.028	0.023-0.038	0.030-0.050	0.034-0.056	0.045-0.075	0.049-0.081	0.060-0.100	0.064-0.106
● 2.4 Precipitation Hardened Stainless Steel	320 - 410 HB	72	0.006-0.009	0.006-0.009	0.006-0.009	0.008-0.013	0.009-0.016	0.014-0.023	0.018-0.030	0.023-0.038	0.026-0.044	0.032-0.053	0.038-0.063	0.056-0.094	0.064-0.106
● 3.1 Lamellar Graphite Cast Iron	< 150 HB	135	0.009-0.016	0.012-0.020	0.015-0.025	0.018-0.030	0.021-0.034	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 3.2 Lamellar Graphite Cast Iron	150 - 300 HB	130	0.009-0.016	0.012-0.020	0.015-0.025	0.018-0.030	0.021-0.034	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 3.3 Nodular Graphite, Malleable Cast Iron	< 200 HB	135	0.009-0.016	0.009-0.016	0.009-0.016	0.013-0.022	0.017-0.028	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 3.4 Nodular Graphite, Malleable Cast Iron	200 - 300 HB	128	0.009-0.016	0.009-0.016	0.009-0.016	0.013-0.022	0.017-0.028	0.033-0.055	0.045-0.075	0.056-0.094	0.064-0.106	0.075-0.125	0.075-0.125	0.090-0.150	0.090-0.150
● 4.1 Titanium unalloyed	< 200 HB	65	0.008-0.014	0.009-0.015	0.010-0.017	0.012-0.019	0.013-0.022	0.015-0.025	0.019-0.031	0.023-0.038	0.026-0.044	0.034-0.056	0.038-0.063	0.060-0.100	0.075-0.125
● 5.1 Nickel unalloyed	< 150 HB	50	0.006-0.009	0.007-0.012	0.008-0.014	0.009-0.015	0.009-0.016	0.011-0.019	0.018-0.030	0.021-0.035	0.026-0.044	0.030-0.050	0.034-0.056	0.056-0.094	0.064-0.106
● 9.1 Hardened Steel	< 32 HRC	120	0.006-0.009	0.008-0.013	0.009-0.016	0.012-0.020	0.015-0.025	0.023-0.038	0.030-0.050	0.045-0.075	0.060-0.100	0.068-0.113	0.075-0.125	0.083-0.138	0.083-0.138
● 9.2 Hardened Steel	33 - 41 HRC	95	0.006-0.009	0.006-0.009	0.006-0.009	0.008-0.013	0.009-0.016	0.019-0.031	0.026-0.044	0.038-0.063	0.049-0.081	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100
○ 9.3 Hardened Steel	42 - 50 HRC	90	0.006-0.009	0.006-0.009	0.006-0.009	0.008-0.013	0.009-0.016	0.019-0.031	0.026-0.044	0.038-0.063	0.049-0.081	0.053-0.088	0.053-0.088	0.060-0.100	0.060-0.100

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