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STANDARD

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3551-1

First edition
1992-07-01

**Rotary core diamond drilling equipment —
System A —**

**Part 1:
Metric units**

Sample Document

Matériel de forage rotatif au diamant avec carottage — Système A —

Partie 1: Unités métriques

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Reference number
ISO 3551-1 : 1992 (E)

Contents

| | Page |
|--|-----------|
| 1 Scope | 1 |
| 2 Normative references | 1 |
| 3 Designation | 1 |
| 4 Materials | 1 |
| 5 Dimensions and tolerances | 2 |
| Tables | |
| 1 Identification symbols | 3 |
| 2 Mechanical properties | 3 |
| 3 System of dimensional identification letters | 5 |
| 4 Nomenclature and basic dimensions for drill rods and casings and their related diamond set items | 6 |
| 5 Nomenclature and basic dimensions for core barrels and their related diamond set items | 7 |
| 6 to 8 "W" design drill rod and coupling | 8-11 |
| 9 to 14 "W" design flush-jointed casing | 13-19 |
| 9 and 15 to 19 "X" design flush-coupled casing | 13, 20-24 |
| 20 to 27 "WF" design double-tube core barrel | 26-34 |
| 28 to 31 "WG" design single-tube core barrel | 36-40 |
| 32 to 35 "WG" design double-tube core barrel | 43-47 |
| 36 to 42 "WM" design double-tube core barrel | 49-57 |
| 43 and 44 "WT" design single-tube core barrel (BWT, NWT, HWT) | 59, 60 |
| 45 and 46 "WT" design single- and double-tube core barrel (BWT, NWT, HWT) | 62, 63 |
| 47 to 50 "WT" design double-tube core barrel (BWT, NWT, HWT) | 65-69 |
| 51 to 57 "WT" design double-tube core barrel (RWT, EWT, AWT) | 71-79 |

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 3551-1 was prepared by Technical Committee ISO/TC 82, *Mining*, Sub-Committee SC 6, *Diamond core drilling equipment*.

ISO 3551 consists of the following parts, under the general title *Rotary core diamond drilling equipment — System A*:

- *Part 1: Metric units*
- *Part 2: Inch units*

Introduction

This part of ISO 3551 is published in parallel with ISO 3552-1 : 1992, *Rotary core diamond drilling equipment — System B — Part 1: Metric units*. The two International Standards cover rotary core diamond drilling equipment.

The two systems are referred to as System A and System B but this is not of any significance since the two systems are not intended as replacements for each other. The system to be adopted by the user will depend on his drilling requirements. The two sets of equipment are not interchangeable. System A is characterized by a series of hole sizes oriented to standard pipe sizes, with relatively wide "nesting", relatively greater reduction in hole diameters as the depth of hole increases, and employing relatively heavy casings between hole sizes. System B is characterized by a series of hole sizes specifically designed to "nest" closely, permitting relatively small reductions in hole diameters as the depth of the hole increases, and employing relatively thin casings between hole sizes. It should not be assumed that, for comparable hole sizes, the physical properties of similar elements of the two systems are equal.

NOTE — Another system (System C) is described in ISO 8866 : 1991, *Rotary core diamond drilling equipment — System C*. It is characterized by a series of nesting hole providing small clearances between the hole wall and the equipment, making it possible to use thin-walled casing tubes. System C is considered to be a separate system to be applied in parallel with systems A and B; it is not interchangeable with these systems.

System A was originally drawn up and standardized in inches, and the conversion was subsequently made into metric units; therefore, in the event of a dispute, the values expressed in inches (System A expressed in inches is dealt with in ISO 3551-2) shall be taken as the authentic values.

Rotary core diamond drilling equipment — System A —

Part 1: Metric units

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1 Scope

This part of ISO 3551 establishes the nomenclature and lays down the leading dimensions to ensure interchangeability within the limits of System A of the following equipment:

- a) drill rods and couplings;
- b) casings, casing couplings, casing bits, casing shoes, drive shoes and casing reaming shells;
- c) core barrels, core bits, core lifters and reaming shells.

It specifies the characteristics of a range of equipment for drilling holes having diameters from 30 mm to 200 mm and yielding cores having diameters from 18,5 mm to 165 mm.

NOTE — The title of this part of ISO 3551 specifies diamond core drilling, but it is also possible to use other cutting materials.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 3551. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 3551 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 263 : 1973, *ISO inch screw threads — General plan and selection for screws, bolts and nuts — Diameter range 0.06 to 6 in.*

ISO 5864 : 1978, *ISO inch screw threads — Allowances and tolerances.*

BS 1580 : 1962, *Specification for Unified screw threads — Parts 1 and 2: Diameters 1/4 in and larger.*

API 7, *Rotary shouldered connection, internal flush type (IF).*

3 Designation

Items manufactured in accordance with this part of ISO 3551 shall be designated by its number followed by the symbols as listed in table 1.

4 Materials

Materials used in the manufacture of the equipment specified in this part of ISO 3551 shall have the mechanical properties specified in table 2, though for special purposes other materials may be used by agreement between manufacturer and purchaser.

The method by which the mechanical properties of tubes are obtained is left to the manufacturer.

5 Dimensions and tolerances

5.1 Dimensions

All dimensions and tolerances shall be in accordance with tables 4 to 57. All dimensions given in this part of ISO 3551, unless otherwise stated, are in millimetres (see Introduction).

NOTES

- 1 In System A, maximum and minimum values are included for all dimensions.
- 2 All these items have a right-hand thread. Where a left-hand thread is necessary, it is stipulated for each individual case in the footnotes to the figure or to the corresponding table.
- 3 Radius (or chamfer) of the thread profile crest and radius in thread root corners are to be chosen by the manufacturers (determined by national standards of manufacturers' countries).

5.2 Conformity

In those industries where drilling depths are measured in metres, the rod and casing lengths shall be 3 m, 1,5 m or 0,75 m; but when drilling in conformity with American Dia-

mond Core Drill Manufacturers Association (DCDMA) and Canadian Diamond Drilling Association (CDDA) standards, the lengths of rods and casings may be 120 in, 60 in or 30 in.

5.3 Eccentricity

The eccentricity is defined as the distance between the centres of the outside and inside diameters and shall not exceed 10 % of the nominal wall thickness Q . The eccentricity is calculated according to the formula

$$\frac{Q_{\max} - Q_{\min}}{2 Q_{\text{nom}}} \times 100$$

where Q_{\max} and Q_{\min} are values of the wall thickness measured in the same section.

5.4 Straightness

When measured over the whole length of the tube by rolling against a straightedge, the maximum deviation shall not be greater than 1 in 1 200.

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Table 1 – Identification symbols

| | | | | | | | | | | |
|--|-----|-----|-----|-----|-----|-----|-----|-----|-----|-----|
| Drill rods (see tables 4, 6, 7 and 8) | RW | EW | AW | BW | NW | HW | — | — | — | — |
| Casing — flush coupled (see tables 4, 9 and 15 to 19) | RX | EX | AX | BX | NX | HX | PX | SX | UX | ZX |
| Casing — flush jointed (see tables 4 and 9 to 14) | RW | EW | AW | BW | NW | HW | PW | SW | UW | ZW |
| “WF” design, face discharge core barrel (see figure 6) | — | — | — | — | — | HWF | PWF | SWF | UWF | ZWF |
| “WG” design, internal discharge core barrel (see figures 7 and 8) | — | EWG | AWG | BWG | NWG | HWG | — | — | — | — |
| “WM” design, internal discharge core barrel*) (see figure 9) | — | EWM | AWM | BWM | NWM | — | — | — | — | — |
| “WT” design, thin wall, internal discharge core barrel (see figures 10, 11 and 12) | RWT | EWT | AWT | BWT | NWT | HWT | — | — | — | — |

*) These may be used with face discharge bits.

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Table 2 – Mechanical properties

| Component | Tensile strength, R_m , min. | Yield stress, R_e , min. | Percentage elongation after fracture A , min. |
|---|-----------------------------------|-------------------------------|--|
| | N/mm ² (MPa) | N/mm ² (MPa) | % |
| Parallel wall rods | 620 | 525 | 12 |
| Upset or forged ends of rods | 500 | 310 | 18 |
| Casing and casing coupling sizes R to H | 620 | 525 | 12 |
| Casing and casing coupling sizes P to Z | 500 | 310 | 18 |
| Drill-rod couplings and adaptors | 700 | 495 | 15 |
| All other components | Not specified | | |

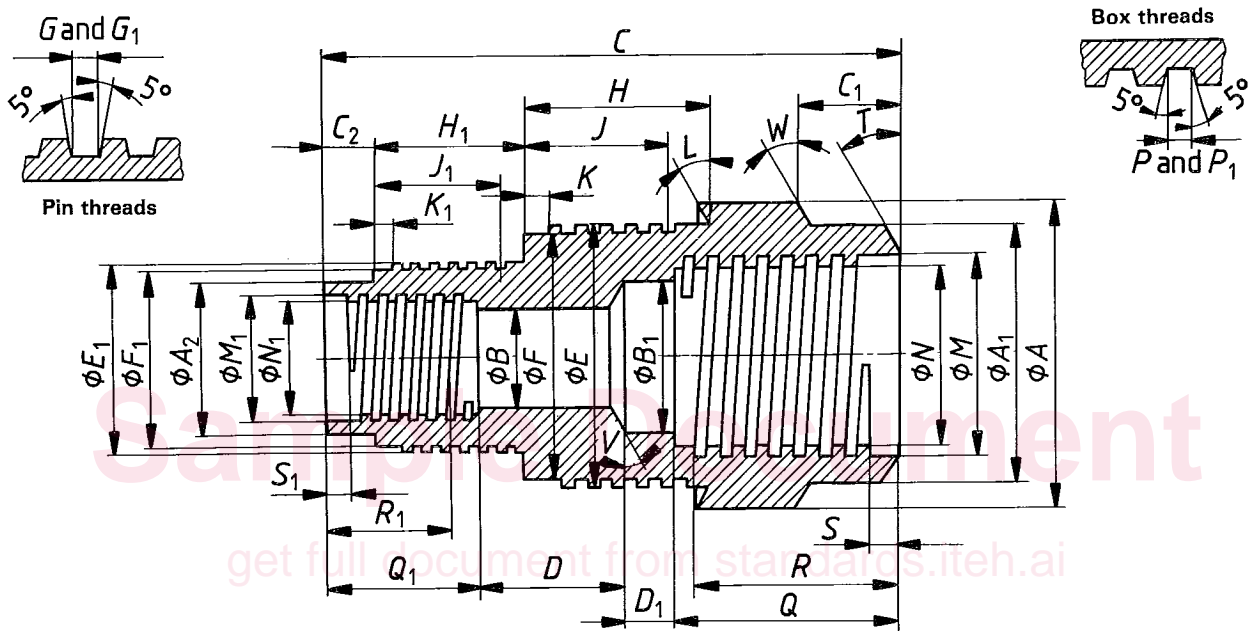


Figure 1 — System of dimensional identification letters

Table 3 — System of dimensional identification letters

| | |
|---|--|
| <i>A, A₁</i> , etc. | Outside diameters — <i>A</i> being largest; <i>A₁, A₂</i> , etc. progressively smaller |
| <i>B, B₁</i> , etc. | Inside diameters — <i>B</i> being smallest; <i>B₁, B₂</i> , etc. progressively larger |
| <i>C, C₁</i> , etc. | External lengths — <i>C</i> being longest; <i>C₁, C₂</i> , etc. progressively shorter |
| <i>D, D₁</i> , etc. | Internal lengths — <i>D</i> being longest; <i>D₁, D₂</i> , etc. progressively shorter |
| <i>E, E₁</i> , etc. | Major diameter of pin threads — <i>E</i> being largest; <i>E₁, E₂</i> , etc. smaller |
| <i>F, F₁</i> , etc. | Minor diameter of pin threads <i>F</i> being largest; <i>F₁, F₂</i> , etc. smaller |
| Thread pitch (Threads per inch) | Pin threads |
| <i>G, G₁</i> , etc. | Width at root of pin thread |
| <i>H, H₁</i> , etc. | Length of outside diameter machined for external threading |
| <i>J, J₁</i> , etc. | Minimum thread length for pin threads |
| <i>K, K₁</i> , etc. | Length of relief at the starting-point of pin threads |
| <i>L, L₁</i> , etc. | Angle of bevel for pin thread shoulder |
| <i>M, M₁</i> , etc. | Major diameter of box threads — <i>M</i> being largest; <i>M₁, M₂</i> , etc. smaller |
| <i>N, N₁</i> , etc. | Minor diameter of box threads — <i>N</i> being largest; <i>N₁, N₂</i> , etc. smaller |
| Thread pitch (Threads per inch) | Box threads |
| <i>P, P₁</i> , etc. | Width at root of box threads |
| <i>Q, Q₁</i> , etc. | Length of inside diameter machined for internal threading |
| <i>R, R₁</i> , etc. | Minimum thread length for box threads |
| <i>S, S₁</i> , etc. | Length of counterbore at the starting-point of box threads |
| <i>T, T₁</i> , etc. | Angle of bevel for box thread shoulder |
| <i>U, U₁</i> , etc. | Included angles — internal and external |
| <i>V, V₁</i> , etc. | Internal angles — not pertaining to threaded connections |
| <i>W, W₁</i> , etc. | External angles — not pertaining to threaded connections |
| <i>X</i> | Diamond set dimensions — external diameter |
| <i>Y</i> | Diamond set dimensions — internal diameter |
| NOTE — The following common abbreviations are sometimes used in tables in the English version for the sake of simplicity: O.D. = outside diameter I.D. = inside diameter. | |

Table 4 – Nomenclature and basic dimensions for drill rods and casings and their related diamond set items

| Drill rod | Rod tube | | Rod coupling | Casing flush coupling | Casing tube | | Casing coupling | Casing flush jointed | Casing | | Casing reaming shell | Casing bit | | Casing shoe | |
|-----------|----------------|----------------|--------------|-----------------------|------------------|------|------------------|----------------------|----------------|------------------|----------------------|------------------|------------------|-------------|----------|
| | O.D. | I.D. | | | O.D. | I.D. | | | O.D. | I.D. | | Set O.D. | Set O.D. | Set I.D. | Set O.D. |
| RW | 27,89 27,76 | 10,57 10,19 | RX | 36,63 36,50 | 30,48 30,23 | RW | 36,63 36,50 | 30,48 30,23 | not required | 37,85 37,59 | 25,53 25,27 | 37,85 37,59 | 30,18 30,05 | | |
| EW | 35,05 34,93 | 11,35 10,97 | EX | 46,28 46,02 | 38,35 38,10 | EW | 46,28 46,02 | 38,35 38,10 | 48,13 47,88 | 47,75 47,50 | 35,81 35,56 | 47,75 47,50 | 38,02 37,90 | | |
| AW | 43,89 43,64 | 16,13 15,75 | AX | 57,40 57,15 | 48,67 48,41 | AW | 57,40 57,15 | 48,67 48,41 | 60,07 59,82 | 59,69 59,44 | 45,34 45,09 | 59,69 59,44 | 48,31 48,18 | | |
| BW | 54,23 53,98 | 19,30 18,92 | BX | 73,28 73,03 | 60,58 60,33 | BW | 73,28 73,03 | 60,58 60,33 | 75,82 75,56 | 75,44 75,18 | 56,39 56,13 | 75,44 75,18 | 60,25 60,12 | | |
| NW | 66,93 66,68 | 35,18 34,80 | NX | 89,28 88,90 | 76,58 76,20 | NW | 89,28 88,90 | 76,58 76,20 | 92,33 92,08 | 91,95 91,69 | 72,26 72,01 | 91,95 91,69 | 76,12 75,87 | | |
| HW | 89,28 88,90 | 60,71 60,32 | HX | 114,68 114,30 | 100,38 100,00 | HW | 114,68 114,30 | 101,60 101,22 | not required | 117,65 117,27 | 96,06 95,81 | 117,65 117,27 | 99,82 99,57 | | |
| | | | PX | 140,74 138,66 | 127,38 123,57 | PW | 140,74 138,66 | 127,38 123,57 | not required | 143,76 143,26 | 117,86 117,48 | 143,76 143,26 | 123,44 123,06 | | |
| | | | SX | 169,55 167,00 | 152,45 147,70 | SW | 169,55 167,00 | 155,55 151,21 | not required | 172,72 172,21 | 143,26 142,88 | 172,72 172,21 | 146,94 146,56 | | |
| | | | UX | 195,12 192,23 | 179,20 176,20 | UW | 195,12 192,23 | 180,54 175,79 | not required | 198,50 197,74 | 171,83 171,32 | 198,50 197,74 | 175,64 175,13 | | |
| | | | ZX | 220,73 217,42 | 205,94 201,60 | ZW | 220,73 217,42 | 208,46 203,00 | not required | 224,16 223,39 | 197,23 196,72 | 224,16 223,39 | 201,04 200,53 | | |

Table 5 — Nomenclature and basic dimensions for core barrels and their related diamond set items

| Core barrel designs | | | | Coring bits | | Reaming shells | Kerf width mm | Kerf area cm ² | Core area cm ² | Hole area cm ² | Core-to-hole ratio % | Nominal core size | Nominal hole size |
|---------------------|-----|-----|-----|------------------|------------------|------------------|---------------|---------------------------|---------------------------|---------------------------|----------------------|-------------------|-------------------|
| WF | WG | WM | WT | Set I.D. | Set O.D. | Set O.D. | | | | | | | |
| | | | RWT | 18,80 18,54 | 29,59 29,34 | 29,97 29,72 | 5,59 | 4,25 | 2,74 | 6,99 | 39,1 | 18,5 | 30 |
| | EWG | EWM | | 21,59 21,34 | 37,46 37,21 | 37,85 37,59 | 8,13 | 7,55 | 3,62 | 11,17 | 32,4 | 21,5 | 38 |
| | | | EWT | 23,11 22,86 | 37,46 37,21 | 37,85 37,59 | 7,37 | 7,03 | 4,15 | 11,17 | 37,1 | 23 | 38 |
| | AWG | AWM | | 30,23 29,97 | 47,75 47,50 | 48,13 47,88 | 8,94 | 10,99 | 7,12 | 18,1 | 39,3 | 30 | 48 |
| | | | AWT | 32,66 32,41 | 47,75 47,50 | 48,13 47,88 | 7,72 | 9,79 | 8,32 | 18,1 | 45,9 | 32,5 | 48 |
| | BWG | BWM | | 42,16 41,91 | 59,69 59,44 | 60,07 59,82 | 8,94 | 14,34 | 13,88 | 28,22 | 49,1 | 42 | 60 |
| | | | BWT | 44,58 44,32 | 59,69 59,44 | 60,07 59,82 | 7,75 | 12,7 | 15,52 | 28,22 | 55 | 44,5 | 60 |
| | NWG | NWM | | 54,86 54,61 | 75,44 75,18 | 75,82 75,56 | 10,46 | 21,46 | 23,53 | 44,99 | 52,2 | 54,5 | 76 |
| | | | NWT | 58,88 58,62 | 75,44 75,18 | 75,82 75,56 | 8,46 | 17,88 | 27,11 | 44,99 | 60 | 58,5 | 76 |
| HWF | HWG | | | 76,33 76,07 | 98,98 98,60 | 99,36 99,11 | 11,51 | 31,74 | 45,61 | 77,34 | 59 | 76 | 99 |
| | | | HWT | 81,08 80,82 | 98,98 98,60 | 99,36 99,11 | 9,14 | 25,88 | 51,46 | 77,34 | 66,5 | 81 | 99 |
| PWF | | | | 92,33 91,95 | 120,27 119,76 | 120,78 120,40 | 14,22 | 47,53 | 66,68 | 114,21 | 58,4 | 92 | 121 |
| SWF | | | | 112,95 112,57 | 145,67 145,16 | 146,18 145,80 | 16,61 | 67,52 | 99,86 | 167,39 | 59,7 | 112,5 | 146 |
| UWF | | | | 140,08 139,57 | 174,12 173,36 | 174,75 174,24 | 17,32 | 85,59 | 153,56 | 239,15 | 64,2 | 140 | 175 |
| ZWF | | | | 165,48 164,97 | 199,52 198,76 | 200,15 199,64 | 17,32 | 99,43 | 214,41 | 313,84 | 68,3 | 165 | 200 |

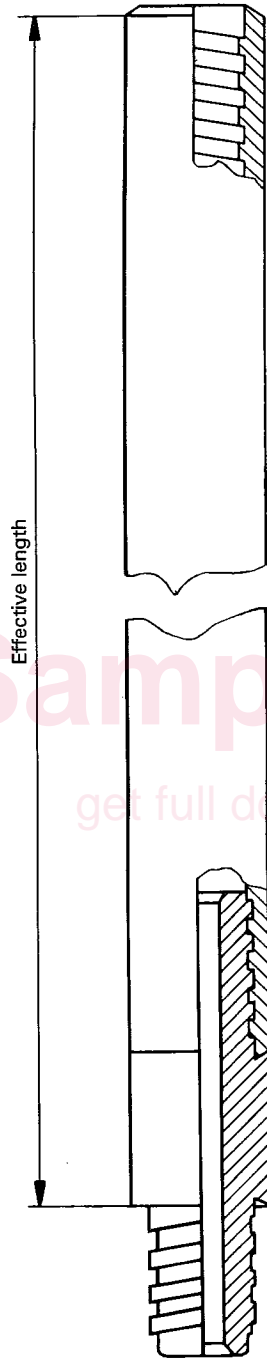


Table 6 – Drill rod and coupling – Main dimensions

| Identification symbol | Rod O.D. | Coupling I.D. | Effective lengths (see figure 2) |
|--|----------|---------------|----------------------------------|
| RW | 27,8 | 10,4 | 3 000, 1 500 or 750 |
| EW | 35 | 11,2 | |
| AW | 43,8 | 15,9 | |
| BW | 54,1 | 19,1 | |
| NW | 66,8 | 35 | |
| HW | 89,1 | 60,5 | |
| NOTES | | | |
| 1 Thread may be left-hand if required. | | | |
| 2 For detailed dimensions, see tables 7 and 8. | | | |

Figure 2 – Drill rod and coupling

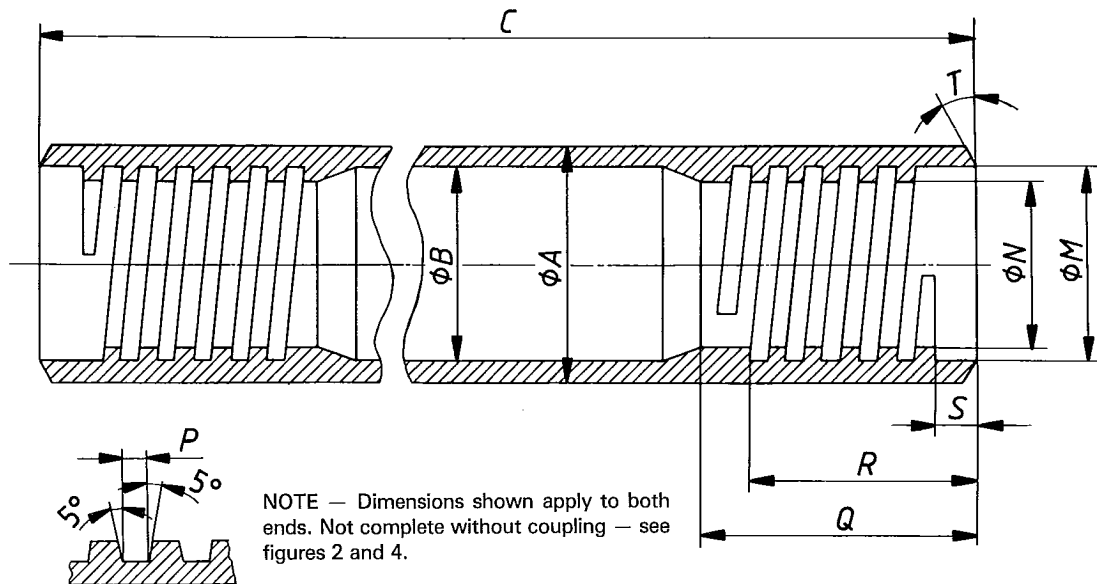


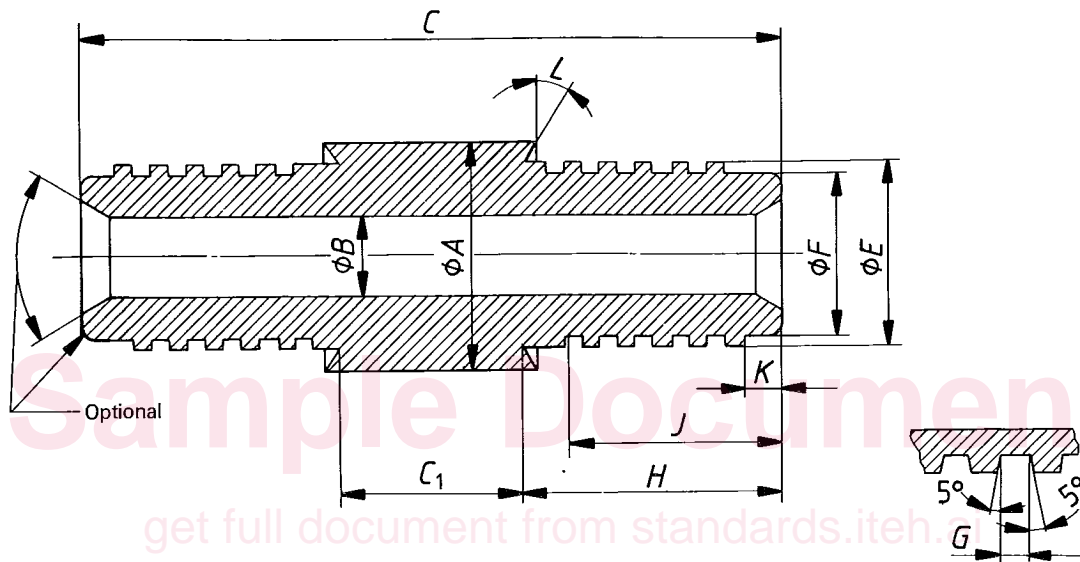
Figure 3 — “W” design drill rod — Drill rod tube (see table 7)

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Table 7 — “W” design drill rod — Drill rod tube

| Dimension | | RW | EW | AW | BW | NW | HW |
|------------------------------------|------|-------------|--------------|--------------|--------------|--------------|--------------|
| A | max. | 27,89 | 35,05 | 43,89 | 54,23 | 66,93 | 89,28 |
| | min. | 27,76 | 34,93 | 43,64 | 53,98 | 66,68 | 88,90 |
| B ¹⁾ | max. | 18,26 | 25,4 | 34,14 | 44,45 | 57,15 | 77,77 |
| C | max. | 2 972,57 | 2 967,23 | 2 968,12 | 2 956,44 | 2 955,93 | 2 943,61 |
| | min. | 2 971,04 | 2 965,71 | 2 966,60 | 2 954,92 | 2 954,41 | 2 942,09 |
| M | max. | 21,67 | 27,13 | 35,05 | 42,93 | 56,49 | 77,06 |
| | min. | 21,62 | 27,08 | 35,00 | 42,88 | 56,44 | 77,01 |
| N | max. | 18,95 | 23,95 | 31,88 | 38,94 | 51,71 | 72,24 |
| | min. | 18,90 | 23,90 | 31,83 | 38,89 | 51,66 | 72,19 |
| Thread pitch (Threads per inch) | | 6,35 (4) | 8,466 (3) | 8,466 (3) | 8,466 (3) | 8,466 (3) | 8,466 (3) |
| P | max. | 3,18 | 4,22 | 4,22 | 4,22 | 4,22 | 4,22 |
| | min. | 3,10 | 4,11 | 4,11 | 4,11 | 4,11 | 4,11 |
| Q | min. | 39,67 | 44,45 | 53,98 | 63,5 | 76,2 | 90,47 |
| R | min. | 36,5 | 39,67 | 47,63 | 57,15 | 69,85 | 82,55 |
| S | max. | 6,6 | 8,18 | 9,78 | 9,78 | 9,78 | 9,78 |
| | min. | 6,1 | 7,67 | 9,27 | 9,27 | 9,27 | 9,27 |
| T | | 30° | 30° | 30° | 30° | 30° | 30° |

1) The dimension B is a maximum and can apply either to upset end rods or parallel wall rods for the RW size only. For all other sizes, this dimension refers to upset end rods only.



NOTE — Dimensions shown apply to both ends.

Figure 4 — "W" design drill rod — Drill-rod coupling (see table 8)

Table 8 – “W” design drill rod – Drill-rod coupling

| Dimension | | RW | EW | AW | BW | NW | HW |
|------------------------------------|------|-------------|--------------|--------------|--------------|--------------|--------------|
| <i>A</i> | max. | 27,89 | 35,05 | 43,89 | 54,23 | 66,93 | 89,28 |
| | min. | 27,69 | 34,85 | 43,54 | 53,87 | 66,55 | 88,77 |
| <i>B</i> | max. | 10,57 | 11,35 | 16,13 | 19,30 | 35,18 | 60,71 |
| | min. | 10,19 | 10,97 | 15,75 | 18,92 | 34,80 | 60,32 |
| <i>C</i> | ref. | 95,25 | 117,48 | 133,35 | 165,1 | 190,5 | 228,6 |
| <i>C</i> ₁ | max. | 28,45 | 33,78 | 32,89 | 44,58 | 45,08 | 57,4 |
| | min. | 27,94 | 33,27 | 32,39 | 44,07 | 44,58 | 56,9 |
| <i>E</i> | max. | 21,56 | 26,97 | 34,90 | 42,77 | 56,34 | 76,91 |
| | min. | 21,51 | 26,92 | 34,85 | 42,72 | 56,29 | 76,86 |
| <i>F</i> | max. | 18,85 | 23,80 | 31,72 | 38,79 | 51,56 | 72,09 |
| | min. | 18,72 | 23,67 | 31,60 | 38,66 | 51,44 | 71,96 |
| Thread pitch (Threads per inch) | | 6,35 (4) | 8,466 (3) | 8,466 (3) | 8,466 (3) | 8,466 (3) | 8,466 (3) |
| <i>G</i> | max. | 3,18 | 4,22 | 4,22 | 4,22 | 4,22 | 4,22 |
| | min. | 3,10 | 4,11 | 4,11 | 4,11 | 4,11 | 4,11 |
| <i>H</i> | max. | 33,78 | 42,21 | 50,65 | 60,63 | 73,08 | 84,43 |
| | min. | 33,27 | 41,71 | 50,14 | 60,12 | 72,57 | 83,92 |
| <i>J</i> | min. | 28,58 | 36,5 | 44,45 | 53,98 | 66,68 | 79,38 |
| <i>K</i> | max. | 1,83 | 5,0 | 6,6 | 8,18 | 9,78 | 9,78 |
| | min. | 1,32 | 4,5 | 6,1 | 7,67 | 9,27 | 9,27 |
| <i>L</i> | | 30° | 30° | 30° | 30° | 30° | 30° |