91

× * 23 L> 16+4+2+1

 $2^{4} + 2^{2} + 2 + 2^{6}$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 2^{6}$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 2^{6}$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$ $2^{4} + 2^{2} + 2^{6} + 1$