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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | **Measurement of roundness by Dial gauge deflections of 6-mm Diameter Copper (Cu) Round Bar After Straightening** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Mean values of Dial Gauge Deflection Readings after straightening of 6 mm Copper (Cu) round bar x 0.01 mm** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Angles in Degrees** | | | | | | | | | | | | | | | | | | | | | | | |  |
| **Length in cm** | **0o** | **15o** | **30o** | **45o** | **60o** | **75o** | **90o** | **105o** | **120o** | **135o** | **150o** | **165o** | **180o** | **195o** | **210o** | **225o** | **240o** | **255o** | **270o** | **285o** | **300o** | **315o** | **330o** | **345o** | **STD**  **DEV (mm)** |
| 16.0 | 301.5 | 297.0 | 288.0 | 275.5 | 262.5 | 251.0 | 239.5 | 246.0 | 248.0 | 252.0 | 276.0 | 287.0 | 270.0 | 265.0 | 246.0 | 236.0 | 241.5 | 256.0 | 269.0 | 284.0 | 296.0 | 302.5 | 308.5 | 310.5 | 0.237 |
| 20.0 | 281.0 | 283.0 | 277.0 | 274.0 | 267.0 | 250.5 | 238.0 | 243.0 | 221.5 | 213.5 | 226.0 | 243.0 | 251.0 | 256.0 | 237.0 | 238.0 | 240.0 | 252.0 | 260.0 | 268.0 | 274.5 | 279.5 | 282.5 | 283.5 | 0.2119 |
| 25.0 | 268.0 | 276.0 | 272.0 | 269.0 | 263.0 | 256.0 | 236.0 | 244.0 | 232.5 | 232.5 | 235.5 | 239.0 | 241.0 | 241.5 | 244.5 | 245.0 | 245.0 | 242.5 | 241.0 | 240.5 | 239.0 | 247.5 | 237.0 | 245.5 | 0.1289 |
| 30.0 | 256.0 | 259.0 | 264.0 | 263.0 | 257.0 | 248.0 | 243.5 | 247.0 | 249.5 | 245.0 | 252.0 | 253.5 | 252.0 | 251.0 | 248.0 | 243.5 | 237.0 | 230.0 | 234.0 | 236.0 | 232.0 | 241.0 | 247.0 | 255.0 | 0.0934 |
| 35.0 | 243.0 | 248.0 | 253.0 | 257.0 | 253.0 | 238.5 | 245.5 | 250.5 | 254.5 | 256.5 | 256.0 | 254.5 | 256.0 | 254.0 | 247.0 | 240.5 | 236.0 | 231.0 | 231.0 | 230.0 | 223.0 | 238.0 | 245.0 | 248.0 | 0.099 |
| 40.0 | 234.0 | 236.0 | 243.0 | 241.0 | 244.0 | 250.0 | 248.0 | 254.0 | 255.0 | 253.0 | 252.0 | 251.0 | 253.0 | 254.0 | 252.5 | 243.5 | 238.0 | 238.0 | 242.0 | 247.0 | 234.0 | 234.0 | 241.0 | 241.0 | 0.0715 |
| 45.0 | 233.0 | 228.0 | 238.0 | 237.0 | 246.0 | 251.0 | 255.0 | 255.0 | 261.0 | 251.0 | 255.0 | 258.0 | 263.0 | 264.0 | 265.5 | 252.5 | 245.0 | 245.0 | 246.0 | 249.0 | 243.0 | 240.0 | 235.0 | 232.0 | 0.1069 |
| 50.0 | 235.0 | 229.0 | 227.0 | 236.0 | 234.0 | 252.0 | 254.0 | 257.0 | 265.0 | 258.0 | 262.0 | 265.0 | 264.0 | 263.0 | 266.0 | 264.0 | 260.0 | 252.0 | 234.0 | 242.0 | 241.0 | 245.0 | 234.0 | 236.0 | 0.1343 |
| 55.0 | 237.0 | 234.0 | 236.0 | 237.0 | 233.5 | 243.0 | 257.0 | 260.0 | 262.0 | 262.0 | 265.0 | 268.0 | 262.0 | 261.0 | 268.0 | 265.0 | 261.0 | 256.0 | 254.5 | 232.0 | 208.0 | 243.0 | 237.0 | 239.0 | 0.1546 |
| 60.0 | 245.0 | 242.0 | 239.0 | 236.0 | 237.0 | 245.0 | 256.0 | 259.0 | 270.0 | 265.0 | 268.0 | 267.0 | 264.0 | 259.0 | 264.0 | 264.0 | 263.0 | 260.0 | 261.0 | 256.0 | 242.5 | 241.0 | 243.0 | 245.0 | 0.1125 |
| 65.0 | 242.0 | 246.0 | 243.0 | 241.0 | 245.0 | 241.0 | 251.0 | 255.0 | 261.0 | 261.5 | 267.0 | 264.0 | 263.0 | 261.0 | 259.0 | 262.0 | 260.0 | 263.0 | 267.5 | 250.5 | 241.0 | 238.0 | 241.0 | 240.0 | 0.1023 |
| 70.0 | 234.0 | 238.0 | 241.0 | 245.0 | 248.0 | 246.0 | 248.0 | 252.0 | 254.0 | 261.5 | 265.0 | 262.0 | 261.0 | 263.0 | 258.0 | 261.0 | 262.0 | 261.0 | 268.0 | 246.0 | 239.0 | 237.0 | 237.0 | 235.0 | 0.1102 |
| 75.0 | 226.0 | 225.0 | 237.0 | 238.0 | 239.0 | 242.0 | 244.0 | 249.0 | 256.0 | 258.0 | 255.0 | 259.0 | 264.0 | 261.0 | 257.0 | 258.0 | 259.0 | 264.5 | 246.5 | 243.0 | 236.0 | 232.0 | 227.0 | 224.0 | 0.1324 |
| 80.0 | 221.0 | 223.0 | 229.0 | 234.0 | 238.0 | 243.0 | 241.5 | 246.0 | 258.0 | 261.0 | 259.0 | 258.0 | 262.0 | 259.0 | 256.0 | 262.0 | 262.5 | 243.0 | 241.0 | 237.0 | 226.0 | 224.0 | 223.0 | 223.0 | 0.151 |
| 86.0 | 233.0 | 236.0 | 235.0 | 237.0 | 242.0 | 246.5 | 259.5 | 261.0 | 259.0 | 255.0 | 258.0 | 256.0 | 258.0 | 257.0 | 258.0 | 263.0 | 247.5 | 242.0 | 236.0 | 236.0 | 235.0 | 233.0 | 235.0 | 234.0 | 0.1114 |

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|  | **Measurement of roundness by Dial gauge deflections of 8-mm Diameter Copper (Cu) Round Bar After Straightening** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Mean values of Dial Gauge Deflection Readings after straightening of 8 mm Copper (Cu) round bar x 0.01 mm** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Angles in Degrees** | | | | | | | | | | | | | | | | | | | | | | | |  |
| Length in cm | 0o | 15o | 30o | 45o | 60o | 75o | 90o | 105o | 120o | 135o | 150o | 165o | 180o | 195o | 210o | 225o | 240o | 255o | 270o | 285o | 300o | 315o | 330o | 345o | STD  DEV (mm) |
| 11.5 | 174 | 174 | 174 | 174 | 173 | 171 | 171 | 172 | 174 | 174 | 172 | 169 | 164 | 161 | 157 | 156 | 156 | 155 | 157 | 159 | 163 | 165 | 168 | 173 | 0.0715 |
| 13 | 173 | 171 | 173 | 172 | 172 | 172 | 172 | 173 | 175 | 174 | 171 | 168 | 162 | 159 | 156 | 154 | 156 | 154 | 157 | 159 | 163 | 165 | 167 | 172 | 0.0727 |
| 15 | 170 | 172 | 173 | 171 | 173 | 172 | 174 | 172 | 172 | 171 | 167 | 163 | 158 | 155 | 155 | 156 | 155 | 155 | 158 | 162 | 164 | 165 | 167 | 170 | 0.0696 |
| 17 | 175 | 173 | 175 | 174 | 176 | 175 | 172 | 175 | 174 | 169 | 166 | 163 | 158 | 155 | 154 | 158 | 161 | 163 | 165 | 164 | 165 | 163 | 170 | 173 | 0.0691 |
| 19 | 174 | 174 | 174 | 173 | 175 | 173 | 174 | 172 | 169 | 165 | 163 | 161 | 157 | 156 | 155 | 157 | 164 | 165 | 164 | 165 | 167 | 169 | 172 | 173 | 0.065 |
| 22 | 173 | 175 | 174 | 172 | 175 | 176 | 172 | 170 | 166 | 163 | 160 | 162 | 159 | 157 | 156 | 158 | 165 | 166 | 163 | 166 | 164 | 167 | 170 | 174 | 0.0622 |
| 25 | 176 | 177 | 175 | 173 | 172 | 175 | 173 | 168 | 165 | 164 | 161 | 159 | 161 | 160 | 156 | 155 | 159 | 163 | 165 | 162 | 163 | 170 | 173 | 175 | 0.0692 |
| 28 | 172 | 173 | 173 | 171 | 172 | 173 | 174 | 169 | 166 | 163 | 162 | 158 | 158 | 159 | 156 | 161 | 163 | 164 | 162 | 165 | 166 | 168 | 170 | 173 | 0.0572 |
| 31 | 171 | 172 | 173 | 173 | 172 | 174 | 172 | 168 | 165 | 162 | 163 | 159 | 159 | 157 | 155 | 158 | 160 | 163 | 164 | 163 | 162 | 165 | 168 | 172 | 0.0582 |
| 34 | 168 | 169 | 171 | 172 | 174 | 175 | 175 | 171 | 169 | 163 | 162 | 157 | 158 | 160 | 156 | 156 | 157 | 161 | 163 | 162 | 165 | 167 | 169 | 170 | 0.0621 |
| 37 | 166 | 168 | 170 | 171 | 169 | 174 | 176 | 173 | 170 | 167 | 164 | 161 | 160 | 159 | 157 | 155 | 156 | 158 | 162 | 163 | 164 | 165 | 167 | 168 | 0.0588 |
| 40 | 164 | 163 | 164 | 167 | 170 | 173 | 173 | 170 | 171 | 167 | 165 | 164 | 163 | 162 | 158 | 159 | 157 | 160 | 164 | 162 | 163 | 161 | 163 | 165 | 0.0443 |
| 43 | 158 | 159 | 162 | 164 | 165 | 165 | 166 | 164 | 167 | 165 | 164 | 162 | 159 | 158 | 157 | 156 | 154 | 156 | 163 | 160 | 161 | 156 | 157 | 160 | 0.0382 |
| 46 | 157 | 156 | 158 | 159 | 164 | 166 | 167 | 165 | 166 | 159 | 162 | 158 | 160 | 159 | 157 | 158 | 154 | 157 | 159 | 158 | 157 | 155 | 154 | 156 | 0.0387 |
| 49 | 159 | 157 | 159 | 158 | 160 | 163 | 168 | 166 | 165 | 159 | 158 | 160 | 160 | 162 | 159 | 157 | 156 | 155 | 158 | 155 | 154 | 156 | 155 | 158 | 0.0364 |
| 52 | 157 | 153 | 155 | 159 | 157 | 160 | 164 | 163 | 164 | 159 | 159 | 158 | 161 | 159 | 158 | 156 | 154 | 158 | 159 | 157 | 155 | 154 | 153 | 155 | 0.0316 |
| 55 | 155 | 155 | 154 | 158 | 156 | 158 | 163 | 164 | 163 | 157 | 158 | 159 | 160 | 161 | 159 | 157 | 154 | 155 | 160 | 155 | 157 | 155 | 154 | 153 | 0.0315 |
| 57.5 | 165 | 164 | 168 | 164 | 166 | 176 | 172 | 167 | 165 | 163 | 162 | 158 | 159 | 157 | 158 | 157 | 160 | 164 | 163 | 161 | 162 | 164 | 162 | 158 | 0.0468 |
| 61.2 | 168 | 166 | 171 | 166 | 168 | 174 | 173 | 164 | 163 | 161 | 163 | 158 | 156 | 158 | 158 | 158 | 161 | 165 | 162 | 160 | 161 | 163 | 164 | 166 | 0.0481 |
| 64.3 | 163 | 162 | 169 | 165 | 171 | 170 | 169 | 163 | 162 | 160 | 161 | 160 | 158 | 159 | 157 | 155 | 157 | 159 | 163 | 164 | 162 | 164 | 162 | 164 | 0.0421 |
| 67.5 | 164 | 164 | 168 | 166 | 170 | 169 | 168 | 163 | 162 | 161 | 162 | 158 | 159 | 158 | 158 | 156 | 157 | 158 | 162 | 162 | 161 | 163 | 165 | 166 | 0.0397 |
| 70.5 | 163 | 163 | 165 | 163 | 163 | 164 | 166 | 162 | 163 | 160 | 159 | 157 | 158 | 159 | 159 | 158 | 158 | 158 | 163 | 161 | 162 | 164 | 163 | 164 | 0.0266 |
| 73.5 | 162 | 161 | 164 | 164 | 166 | 165 | 163 | 164 | 162 | 158 | 160 | 158 | 160 | 162 | 162 | 164 | 160 | 159 | 161 | 163 | 162 | 163 | 164 | 165 | 0.023 |
| 77 | 160 | 160 | 163 | 165 | 168 | 166 | 158 | 165 | 163 | 160 | 159 | 159 | 162 | 164 | 164 | 165 | 164 | 161 | 162 | 163 | 164 | 165 | 166 | 165 | 0.026 |
| 80.2 | 156 | 157 | 158 | 163 | 165 | 163 | 160 | 163 | 162 | 161 | 160 | 162 | 163 | 163 | 164 | 164 | 162 | 163 | 163 | 164 | 164 | 164 | 162 | 158 | 0.0243 |
| 83.2 | 157 | 156 | 160 | 162 | 163 | 161 | 164 | 167 | 164 | 163 | 163 | 165 | 164 | 166 | 165 | 168 | 165 | 168 | 164 | 161 | 159 | 158 | 155 | 159 | 0.0365 |
| 86.2 | 152 | 153 | 155 | 157 | 159 | 157 | 156 | 159 | 161 | 164 | 164 | 167 | 167 | 168 | 169 | 167 | 165 | 164 | 165 | 162 | 163 | 162 | 160 | 157 | 0.0476 |
| 90.2 | 151 | 149 | 148 | 146 | 150 | 154 | 160 | 164 | 165 | 166 | 170 | 173 | 174 | 173 | 172 | 170 | 168 | 168 | 166 | 166 | 165 | 162 | 161 | 156 | 0.0868 |

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|  | **Measurement of roundness by Dial gauge deflections of 10-mm Diameter Copper (Cu) Round Bar After Straightening** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Mean values of Dial Gauge Deflection Readings after straightening of 10 mm Copper (Cu) round bar x 0.01 mm** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Angles in Degrees** | | | | | | | | | | | | | | | | | | | | | | | |  |
| **Length in cm** | **0o** | **15o** | **30o** | **45o** | **60o** | **75o** | **90o** | **105o** | **120o** | **135o** | **150o** | **165o** | **180o** | **195o** | **210o** | **225o** | **240o** | **255o** | **270o** | **285o** | **300o** | **315o** | **330o** | **345o** | **STD**  **DEV (mm)** |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 13 | 143 | 140 | 138 | 137 | 136 | 135 | 135 | 136 | 137 | 138 | 140 | 142 | 145 | 146 | 148 | 150 | 151 | 152 | 152 | 152 | 151 | 149 | 147 | 145 | 0.062 |
| 16 | 142 | 140 | 139 | 137 | 135 | 135 | 135 | 136 | 137 | 138 | 140 | 143 | 145 | 147 | 148 | 150 | 152 | 153 | 154 | 154 | 153 | 151 | 149 | 146 | 0.069 |
| 19 | 144 | 142 | 140 | 139 | 137 | 136 | 136 | 136 | 137 | 139 | 140 | 143 | 145 | 147 | 149 | 150 | 151 | 152 | 153 | 153 | 153 | 151 | 150 | 148 | 0.062 |
| 22 | 145 | 143 | 141 | 139 | 138 | 137 | 137 | 137 | 138 | 140 | 141 | 143 | 145 | 147 | 148 | 150 | 152 | 153 | 154 | 154 | 154 | 152 | 150 | 148 | 0.061 |
| 25 | 149 | 147 | 145 | 143 | 141 | 141 | 141 | 141 | 142 | 143 | 145 | 147 | 148 | 150 | 152 | 153 | 155 | 156 | 157 | 157 | 156 | 155 | 154 | 152 | 0.058 |
| 28 | 153 | 150 | 148 | 145 | 143 | 142 | 141 | 142 | 143 | 144 | 145 | 146 | 148 | 150 | 152 | 153 | 155 | 156 | 158 | 158 | 159 | 155 | 152 | 152 | 0.057 |
| 31 | 154 | 152 | 150 | 148 | 146 | 145 | 144 | 144 | 144 | 144 | 145 | 147 | 149 | 150 | 151 | 152 | 154 | 153 | 152 | 154 | 157 | 157 | 156 | 155 | 0.045 |
| 34 | 152 | 151 | 149 | 148 | 146 | 145 | 144 | 144 | 144 | 144 | 145 | 146 | 147 | 148 | 150 | 151 | 153 | 153 | 154 | 154 | 155 | 155 | 155 | 154 | 0.04 |
| 37 | 155 | 154 | 152 | 151 | 150 | 148 | 147 | 146 | 145 | 145 | 146 | 146 | 146 | 147 | 148 | 149 | 150 | 151 | 153 | 154 | 155 | 155 | 156 | 155 | 0.039 |
| 40 | 170 | 170 | 170 | 169 | 168 | 166 | 165 | 162 | 160 | 159 | 158 | 158 | 158 | 158 | 159 | 160 | 162 | 163 | 165 | 166 | 167 | 169 | 170 | 171 | 0.047 |
| 43 | 173 | 173 | 173 | 172 | 172 | 169 | 167 | 165 | 163 | 161 | 159 | 159 | 159 | 159 | 160 | 160 | 161 | 163 | 165 | 167 | 169 | 170 | 172 | 173 | 0.054 |
| 46 | 177 | 178 | 180 | 180 | 181 | 179 | 177 | 174 | 171 | 167 | 163 | 159 | 156 | 155 | 154 | 154 | 155 | 157 | 159 | 161 | 164 | 168 | 172 | 175 | 0.098 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
|  | **Measurement of roundness by Dial gauge deflections of 12-mm Diameter Copper (Cu) Round Bar After Straightening** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Mean values of Dial Gauge Deflection Readings after straightening of 12 mm Copper (Cu) round bar x 0.01 mm** | | | | | | | | | | | | | | | | | | | | | | | |  |
|  | **Angles in Degrees** | | | | | | | | | | | | | | | | | | | | | | | |  |
| **Length in cm** | **0o** | **15o** | **30o** | **45o** | **60o** | **75o** | **90o** | **105o** | **120o** | **135o** | **150o** | **165o** | **180o** | **195o** | **210o** | **225o** | **240o** | **255o** | **270o** | **285o** | **300o** | **315o** | **330o** | **345o** | **STD**  **DEV (mm)** |
| 12 | 138 | 138 | 138 | 138 | 138 | 139 | 140 | 140 | 140 | 139 | 139 | 139 | 139 | 138 | 138 | 138 | 138 | 138 | 138 | 138 | 138 | 138 | 138 | 138 | 0.0086 |
| 15 | 137 | 136 | 136 | 135 | 135 | 135 | 136 | 136 | 136 | 136 | 136 | 136 | 137 | 136 | 136 | 136 | 137 | 137 | 137 | 136 | 136 | 136 | 136 | 136 | 0.0057 |
| 19 | 133 | 133 | 134 | 133 | 132 | 133 | 134 | 134 | 134 | 133 | 133 | 134 | 135 | 134 | 134 | 133 | 133 | 133 | 134 | 134 | 134 | 133 | 133 | 133 | 0.007 |
| 24 | 133 | 134 | 134 | 133 | 133 | 133 | 133 | 133 | 133 | 134 | 134 | 135 | 135 | 135 | 134 | 134 | 135 | 135 | 135 | 135 | 134 | 134 | 134 | 134 | 0.0078 |
| 29 | 137 | 136 | 136 | 135 | 134 | 135 | 135 | 136 | 136 | 136 | 136 | 136 | 137 | 136 | 135 | 135 | 136 | 136 | 136 | 136 | 136 | 136 | 135 | 136 | 0.0061 |
| 34 | 134 | 134 | 134 | 133 | 131 | 132 | 133 | 133 | 133 | 133 | 133 | 133 | 133 | 133 | 133 | 132 | 132 | 132 | 133 | 132 | 132 | 132 | 133 | 133 | 0.0063 |
| 39 | 136 | 136 | 136 | 135 | 134 | 135 | 136 | 136 | 135 | 135 | 135 | 135 | 136 | 136 | 136 | 135 | 135 | 135 | 135 | 135 | 135 | 135 | 134 | 135 | 0.0052 |
| 43.5 | 133 | 132 | 131 | 130 | 129 | 130 | 130 | 130 | 130 | 130 | 129 | 129 | 130 | 130 | 130 | 130 | 130 | 130 | 130 | 131 | 132 | 131 | 130 | 131 | 0.0092 |
| 49 | 131 | 130 | 130 | 129 | 129 | 129 | 129 | 129 | 129 | 128 | 128 | 129 | 129 | 129 | 129 | 128 | 127 | 127 | 128 | 129 | 130 | 129 | 129 | 129 | 0.0096 |
| 56 | 131 | 131 | 131 | 129 | 128 | 128 | 129 | 129 | 129 | 128 | 128 | 128 | 128 | 128 | 128 | 128 | 128 | 128 | 129 | 129 | 130 | 130 | 130 | 130 | 0.0102 |
| 62 | 134 | 135 | 136 | 136 | 136 | 135 | 135 | 135 | 135 | 135 | 136 | 135 | 134 | 134 | 135 | 134 | 134 | 135 | 135 | 135 | 135 | 135 | 136 | 135 | 0.0056 |
| 67 | 133 | 134 | 135 | 135 | 135 | 134 | 133 | 134 | 134 | 134 | 134 | 133 | 132 | 133 | 134 | 134 | 135 | 134 | 134 | 134 | 134 | 134 | 135 | 134 | 0.0077 |
| 72 | 136 | 137 | 138 | 138 | 138 | 137 | 137 | 137 | 137 | 137 | 137 | 136 | 135 | 136 | 137 | 137 | 137 | 137 | 136 | 136 | 136 | 137 | 137 | 137 | 0.0082 |
| 77 | 135 | 135 | 136 | 136 | 137 | 136 | 135 | 135 | 135 | 135 | 135 | 135 | 134 | 135 | 135 | 135 | 136 | 135 | 135 | 135 | 134 | 135 | 136 | 135 | 0.0059 |
| 82 | 134 | 135 | 135 | 135 | 135 | 135 | 134 | 134 | 134 | 134 | 135 | 135 | 135 | 135 | 135 | 135 | 136 | 135 | 135 | 134 | 134 | 135 | 136 | 136 | 0.0055 |