

SECOND INTERVAL

INSERVICE INSPECTION TEN YEAR

PROGRAM PLAN

NINE MILE POINT UNIT 1

GENERAL TEXT

PREPARED FOR

NIAGARA MOHAWK POWER CORPORATION

SYRACUSE, NEW YORK

BY

NUCLEAR ENERGY SERVICES, INC.

DANBURY, CONNECTICUT 06810

Superseded per pres. 1 to Inservice Inspection Second Interval Program

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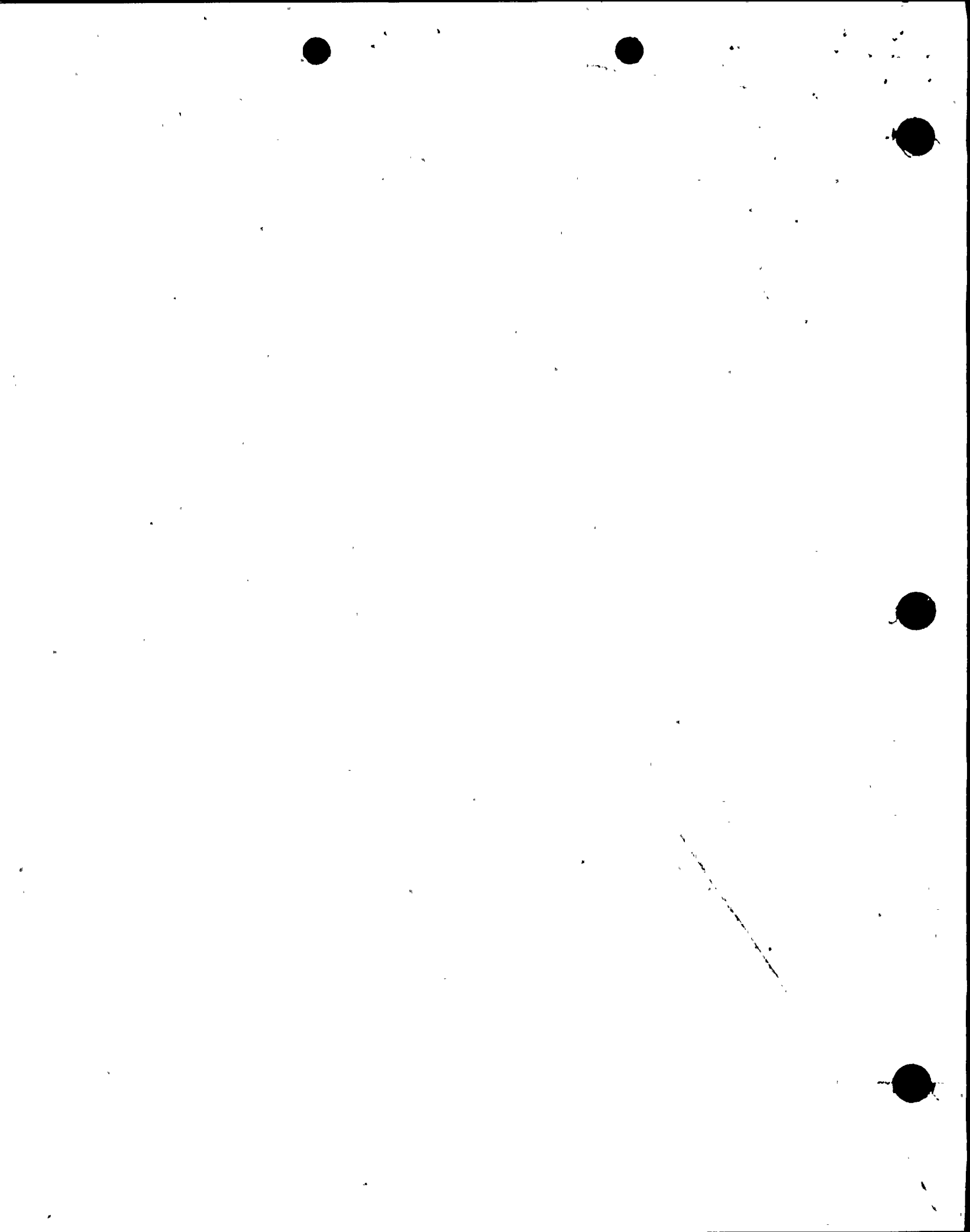


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1. INTRODUCTION**1.1 GENERAL RESPONSIBILITIES**

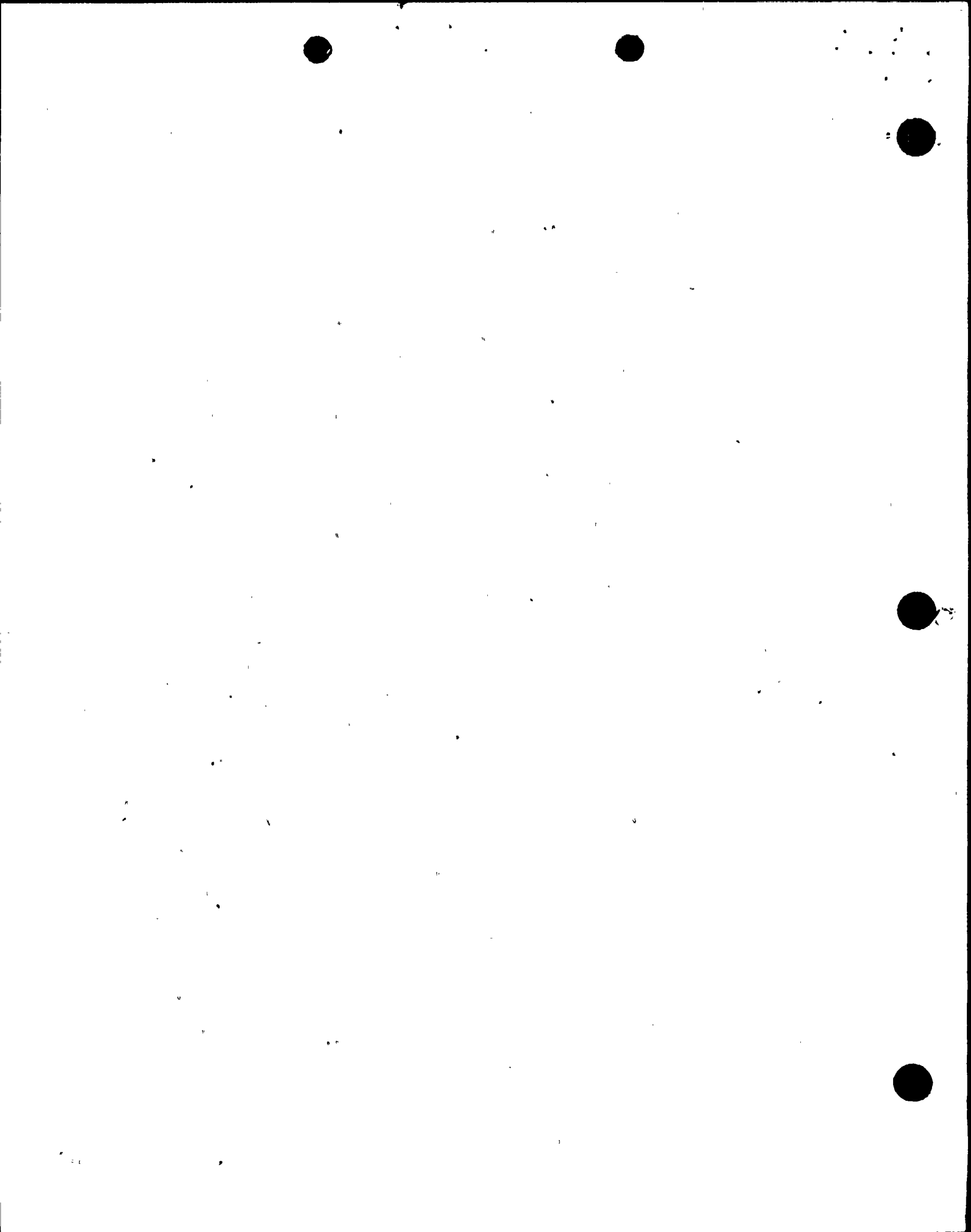
The Niagara Mohawk Power Corporation has assigned Nuclear Energy Services the following responsibilities as stated in IWA-1400 of the Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda.

- IWA-1400 (c) The preparation of inspection plans and schedules.
- IWA-1400 (d) The preparation of written examination instructions and procedures. Also as part of the inspection plans, the preparation of system diagrams or figures identifying the extent of areas or components subject to examination.
- IWA-1400 (e) The varification of qualification to the required level of responsibility of personnel who perform the examinations which fall under responsibility of NES.
- IWA-1400 (g) The performance of the required examinations and tests.
- IWA-1400 (h) The recording of examination and test results that provide a basis for evaluation and facilitate comparison with the results of subsequent and previous examinations.
- IWA-1400 (i) The evaluation of examination and test results.

1.2 PROGRAM PLAN

The 10-year Inservice Inspection (ISI) Program Plan enclosed herein has been prepared to fulfill the ISI requirements for Nine Mile Point Nuclear Station Unit 1 (NMP-1) for the period of 1986 through 1996. This Program Plan incorporates and supercedes the following Nuclear Energy Services, Inc. (NES) documents which were generated for NMP-1:

<u>NES Document Number</u>	<u>Title</u>
81A0403	Inservice Inspection 1975 Outage
81A0405	10 Year Inservice Inspection Program Plan Book
80A0834	Program Plan Book for Augmented Inservice Inspection of Austenitic Stainless Steel Piping within the Reactor Coolant Pressure Boundary per NUREG-0313.
81A1007 thru 81A1125	Nine Mile Point Nuclear Power Station Unit 1 Inservice Inspection Program Plans

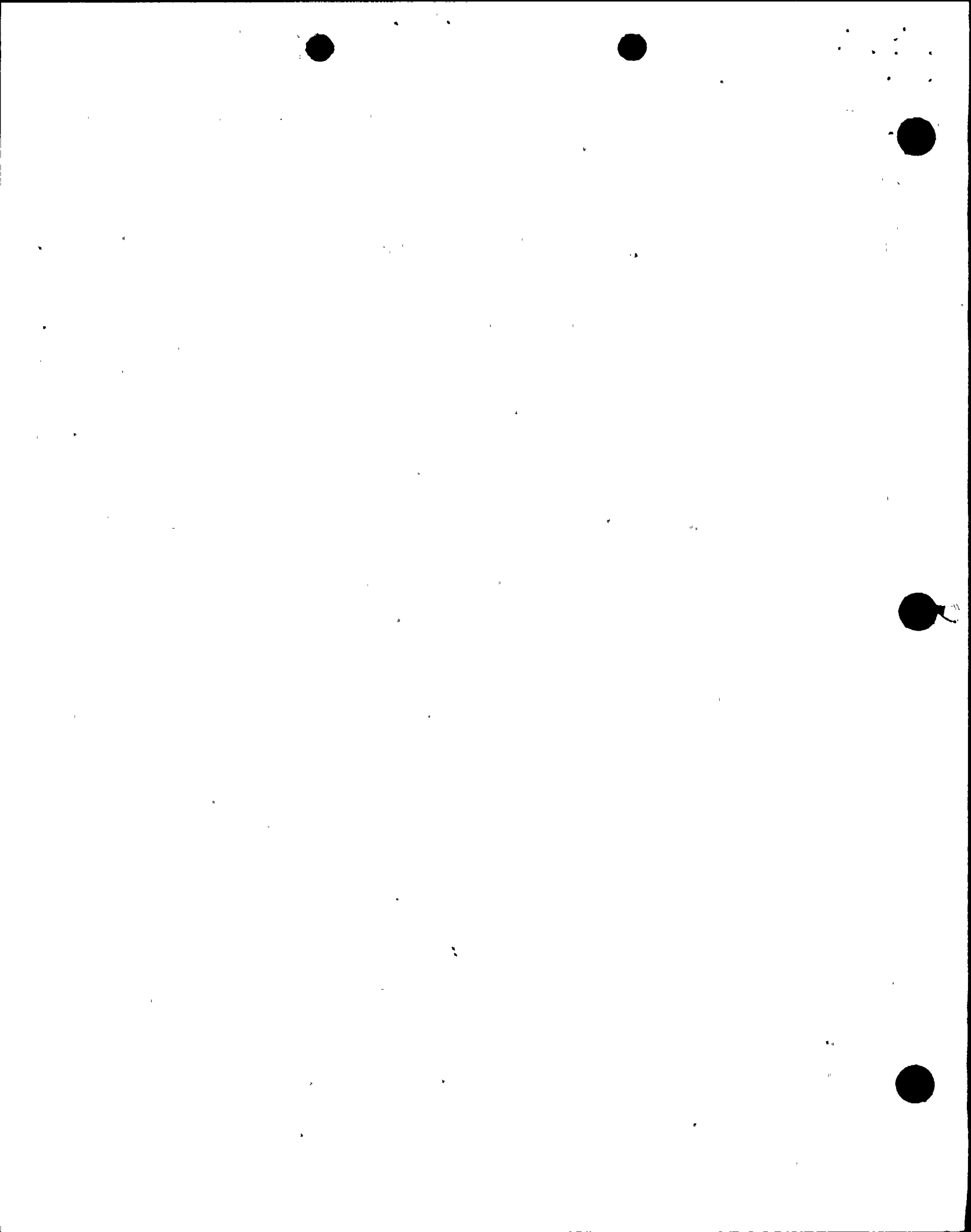


Examinations during the 1975 outage at NMP-1 were performed in accordance with NES Document 81A0403 . Subsequent outages (through 1983) were performed in accordance with NES Documents 81A0405 and 80A0834 . The examinations performed during the 1984 and 1985 outages were upgraded as follows:

- A) The examination method is in accordance with Section XI of the ASME Boiler and Pressure Vessel Code, 1980 Edition with Addenda thru Winter 1981.
- B) The examination procedures have been revised and the calibration blocks have been designed and modified or fabricated in accordance with the requirements of Section XI of the ASME Boiler and Pressure Vessel Code, 1980 Edition with Addenda thru Winter 1981.
- C) The augmented examinations have been expanded to include the requirements of the following documents:
 - 1. NUREG-0619 - "BWR Feedwater Nozzle and Control Rod Drive Return Line Nozzle Cracking."
 - 2. NUREG-0313 Revision 1 - "Technical Report on Material Selection and Processing Guidelines for BWR Coolant Pressure Boundary Piping."
 - 3. IE Bulletin No. 80-13 "Cracking in Core Spring Spargers."
- D) The classification of the Scram Discharge Volume Piping has been revised as recommended by NUREG-0803 "Generic Safety Evaluation Report Regarding Integrity of BWR Scram System Piping."

NOTE: The selection, extent and frequency of examinations of class 1 and 2 piping welds was in accordance with the requirements of Section XI of the ASME Boiler and Pressure Vessel Code, 1974 Edition with Addenda thru Summer 1975.

This Program Plan meets the requirements of Section IWA, IWB, IWC, and IWD of the ASME Boiler & Pressure Vessel Code, Section XI, 1983 Edition including Summer 1983 Addenda and all of the requirements listed in sections C and D above.



2. BASES FOR INSERVICE INSPECTION PROGRAM

2.1 QUALITY ASSURANCE

All work performed by NES at NMP-1 shall be in accordance with the following NES documents:

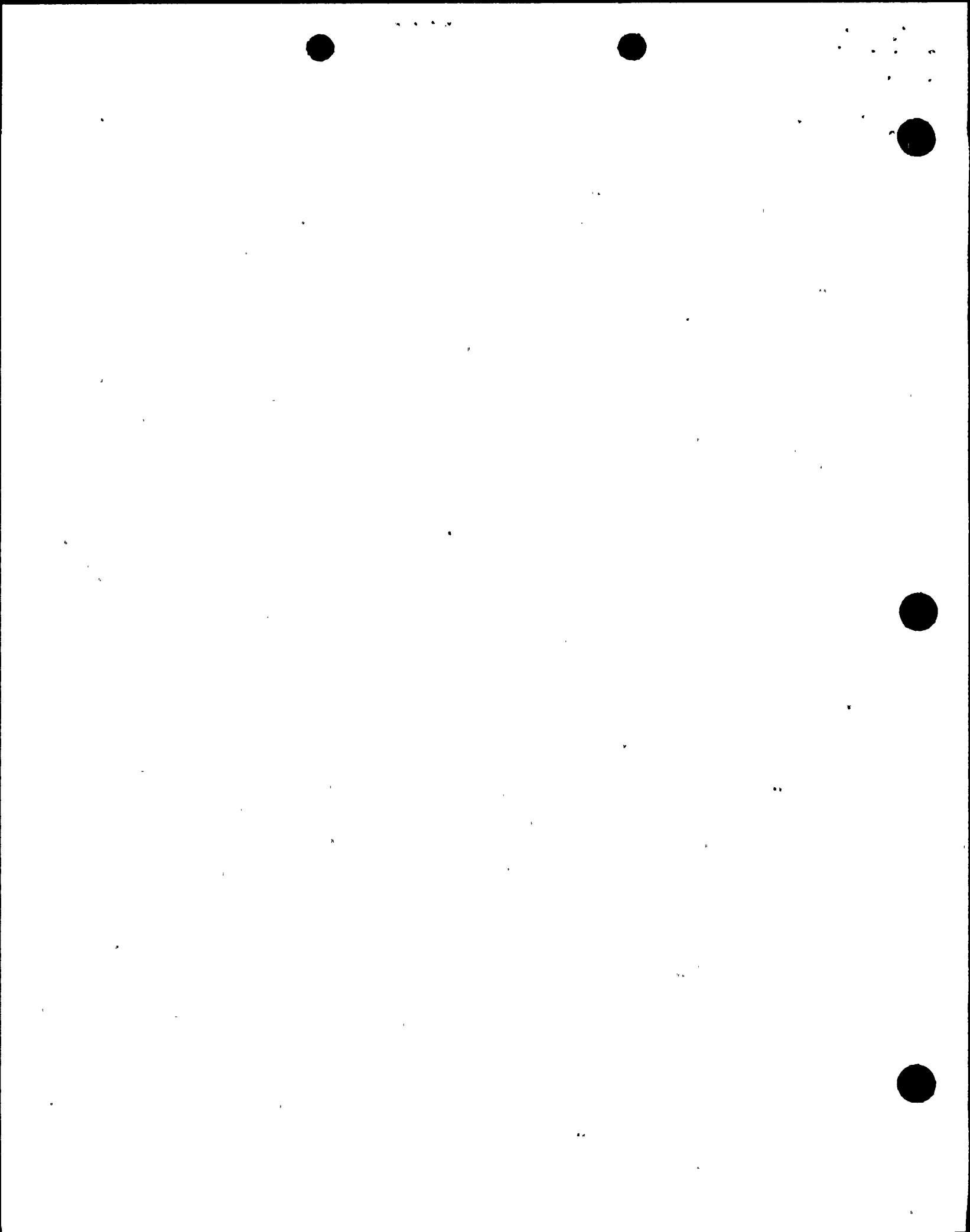
<u>Document Number</u>	<u>Title</u>
80A9021	Inservice Inspection Quality Assurance Manual
81A0402	Quality Assurance Program Plan For Niagara Mohawk Power Corporation

2.2 NRC REGULATIONS

The Code of Federal Regulations states, in 10 CFR 50.55a (g)(4), that the initial inservice examinations conducted during the first 10 years shall comply with the requirements in the editions of the code and addenda in effect no more than 12 months prior to the date of issuance of the operating license. In addition, the inservice examinations conducted during each successive 10-year interval throughout the service life of the facility shall comply to those requirements in the code and addenda in effect no more than 12 months prior to the start of each 10-year interval.

The quality group classification system for radioactive water- and steam-containing components important to the safety of water-cooled nuclear power plants is established by NRC Regulatory Guide 1.26, "Quality Group Classification and Standards" defines the Quality Group Classification System consisting of four Quality Groups, A, B, C and D. The definition of Quality Group A (Class 1) is provided by 10 CFR 50.2 (v) under "Reactor Coolant Pressure Boundary". The definitions of Groups B, C and D are provided by Regulatory Guide 1.26.

Code Cases approved for use by NRC Regulatory Guide 1.147, and applicable to the edition and addenda of the Code being used, may be utilized were it is found necessary or desirable.



2.3 METHODS OF EXAMINATION

Visual, surface, and volumetric examination methods will be used for the Inservice Inspection (ISI) at NMP-1.

The visual (VT) examination method is divided into three categories: VT-1, VT-2, VT-3. VT-1 examinations are conducted to determine the condition of the part, component or surface examined, including such conditions as cracks, wear, corrosion, erosion or physical damage. The VT-2 examinations are conducted to locate evidence of leakage from pressure retaining components or abnormal leaks from components during a system pressure, functional or hydrostatic test. VT-3 examinations are conducted to determine the general mechanical and structural conditions of components and their supports.

The surface examination method will be either a liquid penetrant (PT) examination or a magnetic particle (MT) examination. Surface examinations are used to identify the presence of cracks or discontinuities open to the examination surface. Generally, a PT examination is performed although an MT examination may be used in lieu of a PT examination.

The volumetric examination method will be either an ultrasonic pulse echo (UT) examination or radiographic (RT) examination. Volumetric examinations are used to identify the presence of subsurface discontinuities. UT examinations are generally performed although a RT examination may be used in lieu of a UT examination.

All examinations will be performed in accordance with procedures written to the requirements of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda. A listing of the examination procedures to be used at NMP-1 is in Table 2-2.



TABLE 2-2

NDE PROCEDURES

<u>Document No.</u>	<u>Title</u>
80A2308	UT Examination General Requirements
80A2818	UT Examination Procedure for Stainless Steel Pipe for IGSCC
80A2819	Liquid Penetrant Examination Procedure
80A2821	General Magnetic Particle Examination Procedure
80A2822	UT Examination Procedure for RPV
80A2823	UT Examination Procedure for RPV and Closure Head Inner Radii
80A2824	UT Examination Procedure for Closure Head
80A2825	UT Examination Procedure for Bolts, Studs and Nuts
80A2826	UT Examination Procedure for RPV to Nozzle Welds
80A2827	UT Examination Procedure for Closure Head Nozzle to Flange Weld
80A4012	UT Examination Procedure for RPV Nozzle to Safe-end Welds
80A4013	UT Examination Procedure for E.C. Dome and Nozzle Welds
80A4014	UT Examination Procedure for Ferritic Piping Welds
80A7439	UT Examination Procedure for Control Rod Drive Housings
80A7441	Visual Examination Procedure



2.4 SCHEDULE

Paragraphs IWB-2400 and IWC-2400 of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda identifies percent required examinations to be performed during an inspection period. Inspection Program B is utilized for NMP-1. Table 2-3 delineates Inspection Program B as stated in Section XI, 1983 Edition with Summer 1983 Addenda.

2.5 SELECTION CRITERIA

The selection, extent and frequency of examination, except for Class 2 piping welds, is in accordance with Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda. The selection, extent and frequency of examinations for class 2 piping welds is in accordance with the requirements of Code Case N-408 Alternative Rules for Examination of Class 2 Piping Section XI, Division 1. Use of Section XI of the ASME Boiler and Pressure Vessel Code for the selection, extent and frequency of class 1 and 2 piping weld examinations is allowed or required by 10 CFR 50.55a(b)(2).

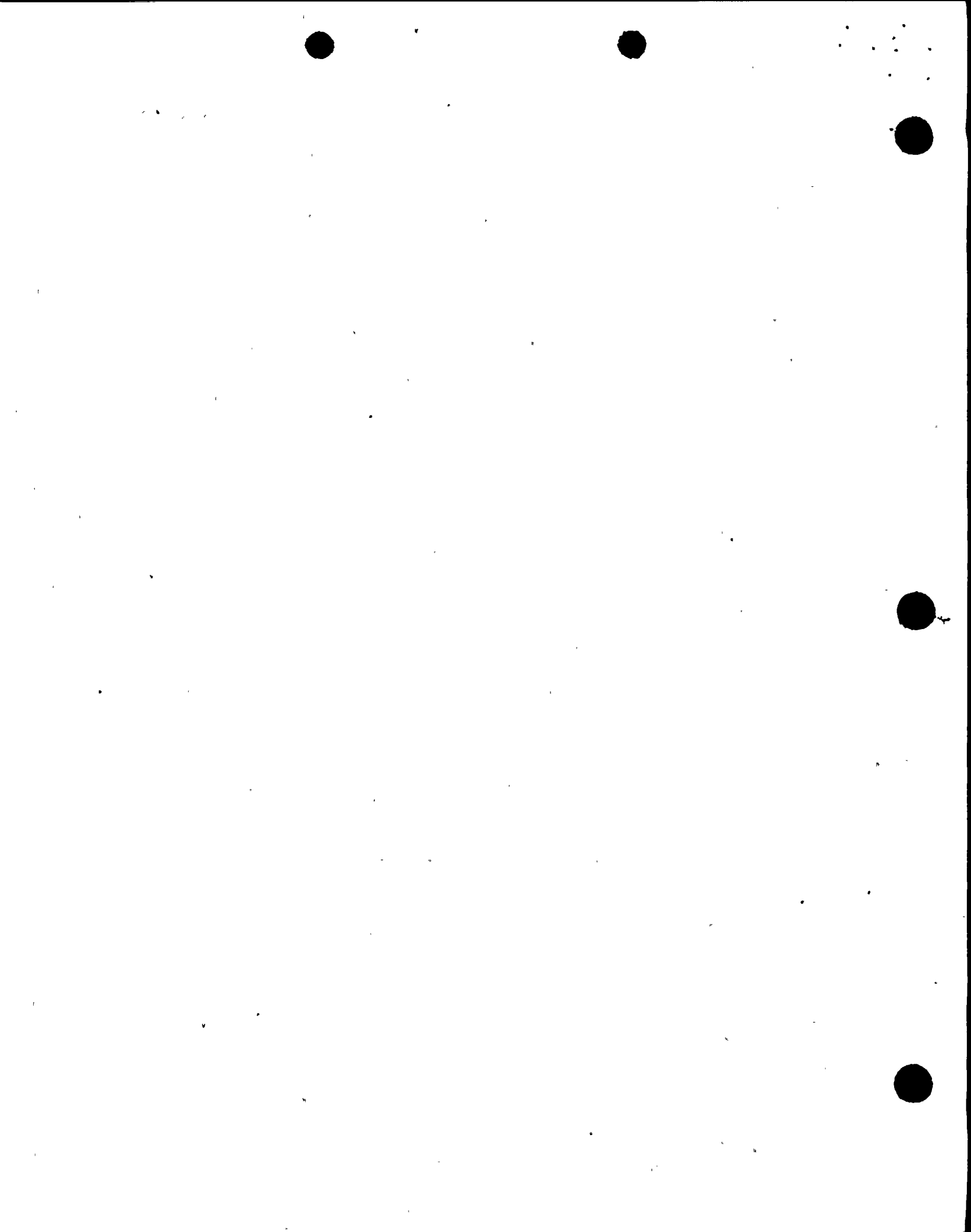
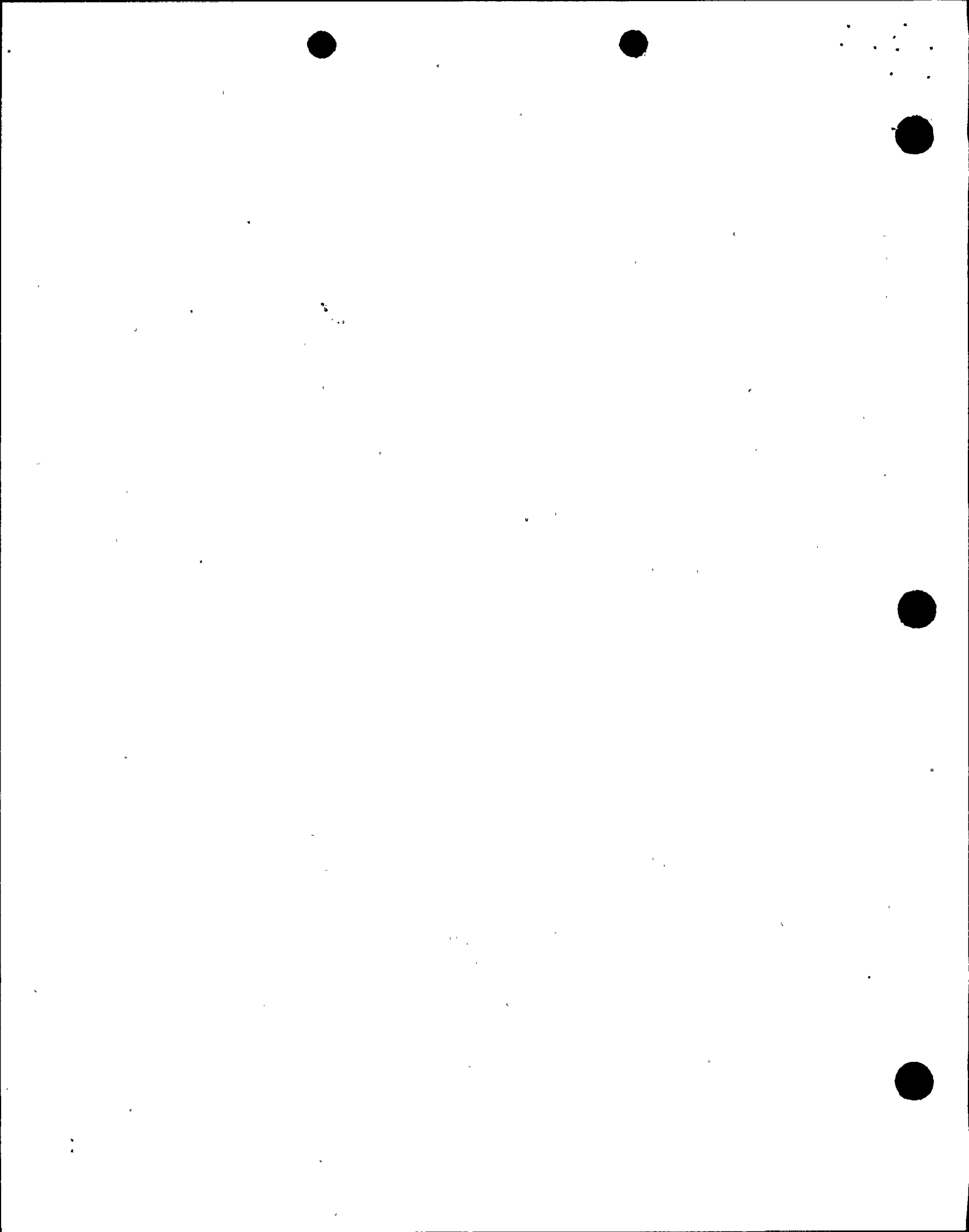


TABLE 2-3
 Inspection Program B
 Schedule

Inspection Interval	Inspection Period*	Calendar Years of Plant Service	% Examinations Credited	
			Minimum	Maximum
1	1	3	16	34
	2	7	50	67
	3	10	100	100
2	1	13	16	34
	2	17	50	67
	3	20	100	100
3	1	23	16	34
	2	27	50	67
	3	30	100	100
4	1	33	16	34
	2	37	50	100
	3	40	100	100

* Modifications to this schedule may occur as allowed by IWA-2400(c) of Section XI.



2.6 AUGMENTED REQUIREMENTS

Augmented examinations are those examinations that are specified in documents other than Section XI of the ASME Boiler and Pressure Vessel Code. The augmented examinations are included in this Program Plan because of the requirements of the documents listed in item D of paragraph 1. A brief summary of the requirements of each document is listed below:

2.6.1 NUREG-0619

For inservice inspection, an external ultrasonic examination of all feedwater nozzle safe ends, bores and inside blend radii will be performed at every second scheduled refueling outage. The same areas will receive an internal liquid penetrant examination at every sixth scheduled refueling outage (on or after 90 startup/shutdown cycles.) In addition the feedwater spargers will receive a visual inspection at every fourth scheduled refueling outage.

2.6.2 NUREG-0313 Revision 1

Both "Nonconforming Nonservice Sensitive" and "Nonconforming Service Sensitive" welds exist at NMP-1. The former have been scheduled for examination every 80 months, the latter, at each scheduled plant outage but not more frequently than every 6 months.

In addition the requirements of Generic Letter 84-11 have been met in regards to the inspection of "nonconforming nonservice sensitive piping".

2.6.3 IE Bulletin 80-13

A visual inspection of the Core Spray Spargers and the segment of piping between the inlet nozzle and the vessel shroud will be performed at each scheduled refueling outage.



2.7 EVALUATION CRITERIA

Evaluation of reportable indications detected during ISI shall be made in accordance with Article IQA-3000 of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda. Indications detected may be evaluated by other nondestructive methods to assist in the determination (size, shape, location and orientation) before final disposition is made.

2.8 RECORDS AND REPORTS

A system of records of the inservice inspection, plans, schedules, calibration blocks, examination results and reports, and any corrective actions required and taken will be developed and maintained at the site in accordance with Article IWA-6000 of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda. Control of the inspection data generated at the NMP-1 site shall be in accordance with the documents identified in paragraph 2.1

Upon completion of an ISI outage, a detailed summary report shall be prepared in accordance with Article IWA-6220 of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda. As a minimum, the summary report shall include the following:

- (a) A summary of all inspections made referencing the test and calibration records, and other documents that support the tests. This summary will also certify that all the tests were performed in accordance with all the applicable codes and specifications.
- (b) Copies of all calibration records, examination records, examination readouts, examination results and isometrics properly catalogued and cross referenced.
- (c) Copies of latest approved revision of all procedures used.
- (d) Evaluation of the reportable indications with respect to determining acceptance or rejection in accordance with IWA-3000 of Section XI.
- (e) Examination personnel certifications.



(f) Photographs will be included where required for clarification of access or to show significant observations and/or indications.

2.9 PERSONNEL QUALIFICATION RECORDS

Personnel performing examinations at NMP-1 shall be certified in accordance with the following NES documents (as applicable):

Document Number

Title

80A9068

Procedure for Training and Certification
of Nondestructive Examination Personnel

80A9069

Nuclear Inservice Inspection Procedure
for the Certification of Visual
Examination Personnel



3. INSERVICE INSPECTION PROGRAM PLAN

The 10 year ISI Program Plan for NMP-1 is comprised of this document (The General Text) and individual documents for each system. Table 3-1 lists the individual system documents. The following is a generic discussion of the contents of the individual system documents.

TABLE 3-1
 SYSTEM DOCUMENT LIST

<u>Document #</u>	<u>Title</u>
81A1145	ISI Program Plan: General Text
81A1146	ISI Program Plan: Reactor Pressure Vessel
81A1147	ISI Program Plan: Main Steam System
81A1148	ISI Program Plan: Feedwater System
81A1149	ISI Program Plan: Reactor Head Spray and Vent
81A1150	ISI Program Plan: Shutdown Cooling System
81A1151	ISI Program Plan: Emergency Cooling System
81A1152	ISI Program Plan: Core Spray System
81A1153	ISI Program Plan: Reactor Recirculation System
81A1154	ISI Program Plan: Liquid Poison System
81A1155	ISI Program Plan: Control Rod Drive System
81A1156	ISI Program Plan: Closed Loop Cooling System
81A1157	ISI Program Plan: Reactor Water Clean-up System
81A1158	ISI Program Plan: Diesel Generator System
81A1159	ISI Program Plan: Emergency Service Water System
81A1160	ISI Program Plan: Containment Spray System
81A1161	ISI Program Plan: Sampling and Instrumentation Lines
81A1162	ISI Program Plan: Fuel Pool Cooling System
81A1163	ISI Program Plan: Inert Gas Purge and Fill System



3.1 SYSTEM CLASSIFICATION

The NMP-1 system drawings have been reviewed by NES and Quality Group A, B and C boundaries have been established in accordance with 10 CFR 50.2(v) and Regulatory Guide 1.26.

The Boundary Diagrams are provided with each system document to show the following:

- Quality Group A nonexempt
- Quality Group B nonexempt
- Quality Group B exempt
- Quality Group C nonexempt

For clarity, all piping 1" and less have not been marked since in all cases the piping is exempt.

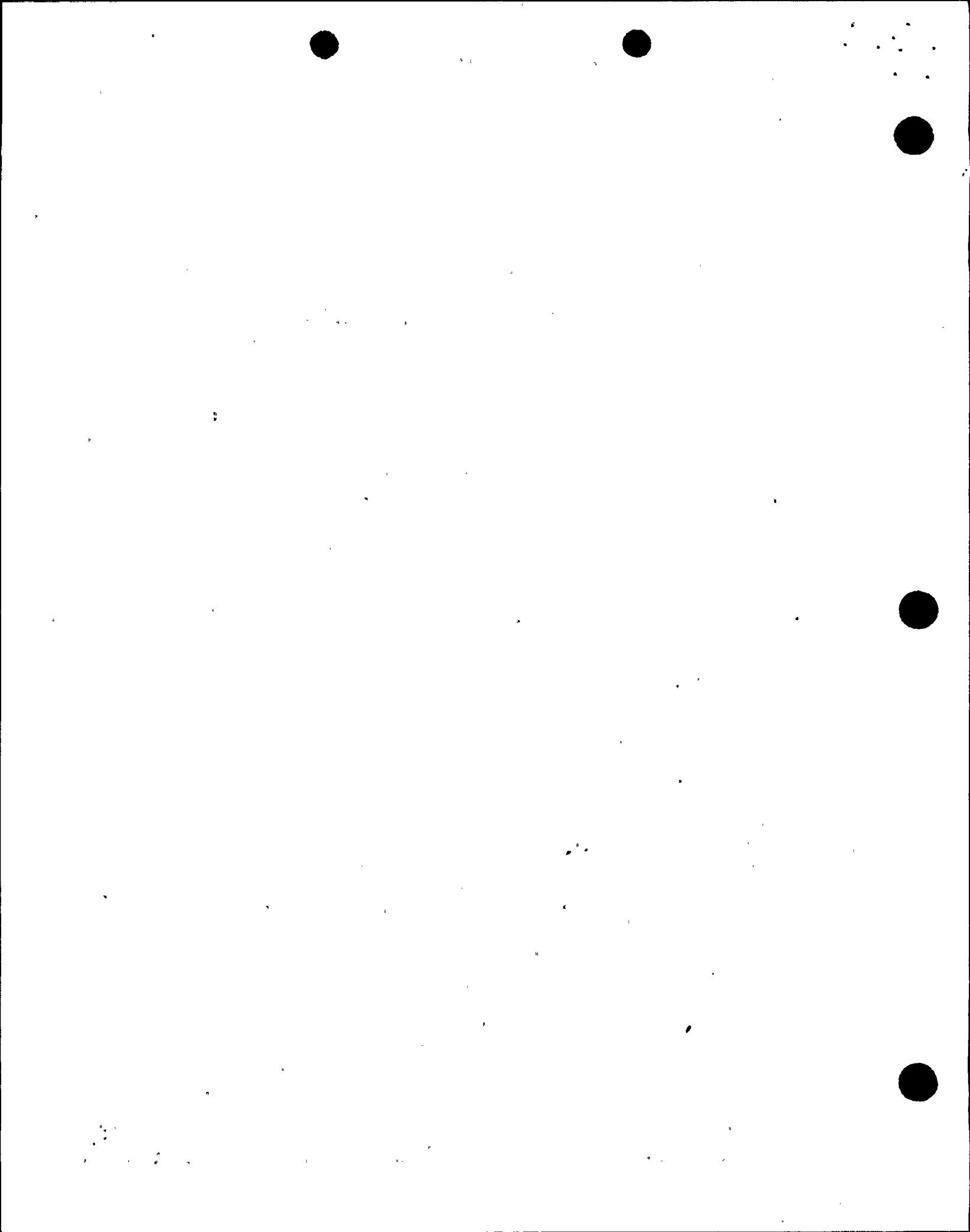
3.2 EXEMPTIONS

Section XI of the ASME Boiler and Pressure Vessel Code identifies piping and components that are exempt from volumetric and surface examinations. However, some of these require volumetric and/or surface examinations because of augmented requirements.

The following exemptions are applicable to NMP-1 as identified in Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda and supplemented by the augmented requirements as specified in Item D of paragraph 1.

3.2.1 Quality Group A

- All components and piping 1 inch nominal pipe size and smaller
- All reactor vessel lower head connections and associated piping 2 inch nominal pipe size and smaller made inaccessible by control rod drive penetrations.



3.2.2 Quality Group B

- All component connections (including nozzles in vessels and pumps), piping and associated valves, and vessels and their attachments that are 4 inch nominal pipe size and smaller are exempt per ASME Code Section XI, IWC-1221(c) and IWC-1222(b), 1983 Edition, Summer 1983 Addenda.
- All components in systems other than Shutdown Cooling, Emergency Cooling, Core Spray, and Containment Spray where both design pressure and temperature are equal to or less than 275 psig and 200oF respectively are exempt per IWC-1222(c) of the ASME Code Section XI 1983 Edition, Summer 1983 Addenda. (See Section 2.5.2)

3.2.3 Quality Group C

- Integral attachments of supports and restraints to components that are 4 inch nominal pipe size and smaller are exempt from the visual examination VT-3.
- Integral attachments of supports and restraints to components located in systems (or portions of systems) whose function is not required in support of reactor residual heat removal, containment heat removal and emergency core cooling and operate at a pressure of 275 psig or less and at a temperature of 200 F or less.

3.3 EXCEPTIONS

Exceptions are those areas that cannot be examined either in part or fully because of limitations in accessibility, material or design. Relief from examination for these areas has been requested from the NRC and a reference to the Relief Request is noted in each case.



3.4 CALIBRATION STANDARDS

Table 3-2 lists all calibration standards required for the 10 year ISI program at NMP-1. In addition, each system document lists the calibration standards required for that system.

The UT examination calibration standard design and material selection is in accordance with Subarticle III-3400 of Appendix III to Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda.

TABLE 3-2

CALIBRATION STANDARDS

<u>Title</u>	<u>Size</u>	<u>Thickness</u>	<u>Material</u>
NMP1-29-SE-1	29"	1.488"	SA182F316
NMP1-28-2.00-SS (P8R-2.055-1)	28"	2.00"	SA158CL.1 TP316
NMP1-28-1.200-SS (P8R-1.109-1)	28"	1.20"	SA358CL.1 TP316
P8R-1.260	28"	1.216"	SA240-577 TY316
NMP1-24-SE-1	24"	1.405"	SA105
NMP1-24-080-CS (PIR-1.219-1)	24"	1.236"	SA106 GR.B
NMP1-20-1.500-CS	20"	1.500"	SA234 WPB
NMP1-18-120-CS (PIR-1.375-1)	18"	1.509"	SA106 GR.B
NMP1-18-100-CS	18"	1.156"	SA106 GR.B
NMP1-18-1.156-CS	18"	1.156"	SA234 WPB
NMP1-18-1.375-CS	18"	1.375"	SA234 WPB
NMP1-16-120-CS	16"	1.219"	SA106 GR.B
NMP1-16-1.031-CS	16"	1.031"	SA234 WPB
NMP1-16-100-CS (PIR-1.013-1)	16"	1.013"	SA106 GR.B
NMP1-14-120-CS	14"	1.094"	SA234 WPB
NMP1-14-100-CS	14"	.938"	SA106 GR.B
NMP1-14-XX2-SS (P8R-.935-1)	14"	.935"	SA358 TY316
NMP1-14-XX1-SS	14"	.774"	SA358CL.1 TP304
NMP1-12-XX2-SS (P8R-.885-1)	12"	.885"	SA358 TY316
NMP1-12-XX1-SS (P8R-.720)	12"	.74"	SA358 TY304



TABLE 3-2

CALIBRATION STANDARDS
 CONT.

<u>Title</u>	<u>Size</u>	<u>Thickness</u>	<u>Material</u>
NMP1-12-.622-SS-F	12"	.622"	SA312 TY304
NMP1-10-160-SS (P8R-1.141-1)	10"	1.141"	SA376 TP316
NMP1-10-120-CS	10"	.844"	SA106 GR.B
NMP1-10-.844-CS	10"	.844"	SA234 WPB
NMP1-10-100-CS (P1R-.75-2)	10"	.75"	SA106 GR.B
NMP1-10-80-CS	10"	.594"	SA106 GR.B
NMP1-10-.594-CS	10"	.594"	SA234 WPB
NMP1-10-XX1-SS (P8R-.727-1)	10"	.535"	SA376 TP304
NMP1-10-.522-SS-F2 (P8R-.522-2)	10"	.514"	SA312 TP316
NMP1-10-.522-SS-F1 (P8R-.522-1)	10"	.473"	SA312 TP304
NMP1-10-SE-1	10"	.825"	SA105
NMP1-8-120-CS	8"	.719"	SA234 WPB
NMP1-8-80-CS	8"	.500"	SA234 WPB
NMP1-8-.352-SS (P8R-.352-1)	8"	.352"	SA312 TP304
NMP1-6-SE-2 (P8R-1.5-2)	6"	1.5"	SA376 SS304
NMP1-6-SE-1 (P8R-.75-3)	6"	.75"	SA376 TP304
NMP1-6-160-CS	6"	.719"	SA106 GR.B
NMP1-6-.596-SS	6"	.596"	SA376-304
NMP1-6-80-SS312 (P8R-.432-1)	6"	.450"	SA312 TP316L
NMP1-6-80-CS (P1R-.432-1)	6"	.432"	SA106 GR.B
NMP1-6-80-SS (P8R-.432-2)	6"	.430"	SA312 TP304
NMP1-5.5-.297-SS	5.5"	.279"	SA376-304
NMP1-4-SE-1	4"	1.22"	SA182 F304
NMP1-3.0-80-CS (P1R-.313-1)	3"	.300"	SA333 GR.B
P8R-.3-1	3"	.300"	SA312 TP304
P1F-7.1-C	-	7.125"	SA533
P1S-6.25	-	6.25"	SA193
NMP1-RFV-1 (P3F-4.60-C)	-	4.31"	SA533 GR.B CL.1
P1S-2.5	2.5"	-	SA193
NMP1-IR-9	-	2.25"	SA508 CL.2
NMP1-IR-7.5	-	2.25"	SA508 CL.2
NMP1-IR-5.5	-	2.25"	SA508 CL.2

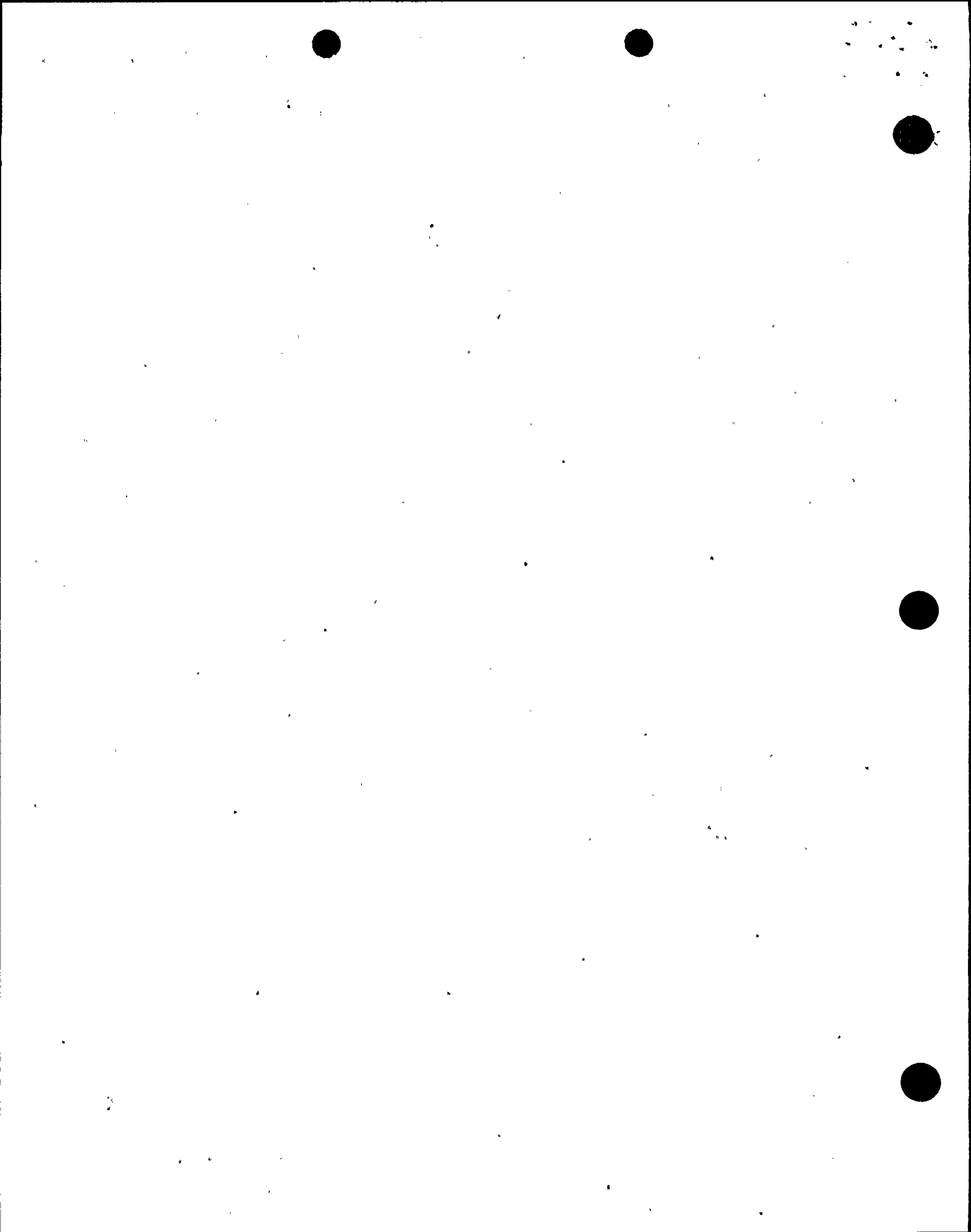


TABLE 3-2
 CALIBRATION STANDARDS

CONT.

<u>Title</u>	<u>Size</u>	<u>Thickness</u>	<u>Material</u>
NMP1-IR-3.3	-	2.25"	SA508 CL.2
NMP1-IR-1.7	-	2.25"	SA508 CL.2
P8F-1.5-1	-	1.5"	SA376 A304
P1F-1.5C	-	1.5"	SA533
P8R-.75-1	3.5"	.75"	SA376 TP304
NMP1-RPV-4 (P1-LF-1)	-	10"X7.125"	SA336 T304 Clad

3.5 PROGRAM PLAN AND SCHEDULE

The specific examination requirements for the 10 year ISI Program at NMP-1 are defined by the Program Plan and Schedule. The Program Plan and Schedule lists all examinations required by Tables IWB-2500-1, IWC-2500-1 and IWD-2500-1 of Section XI of the ASME Boiler and Pressure Vessel Code, 1983 Edition with Summer 1983 Addenda.

In addition Class 2 piping welds are selected and examined to the requirements of Code Case N-408, "Alternative Rules for Examination of Class 2 Piping" Section XI, Division 1.

The Program Plan and Schedule includes the component identification, description, ASME Boiler and Pressure Vessel Code examination category and item number, (as identified in Section XI, 1983 Edition with Summer 1983 Addenda) code examination method (visual, surface and/or volumetric), examination procedure number, and calibration block number (if applicable).

NOTE: Longitudinal welds on piping and fittings are designated with the suffixes "U" (Upstream of the reference circumferential welds) and "D" (Downstream of the reference circumferential weld). In case of double-seamed fittings, "U1" and "D1" denote longitudinal welds on the long side of the component.

3.6 ISOMETRICS AND SKETCHES

The isometrics and sketches show the physical location and identification numbers for all examination areas.



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